C6523509

MODEL 700 TM M24

Model 545 TM

Action

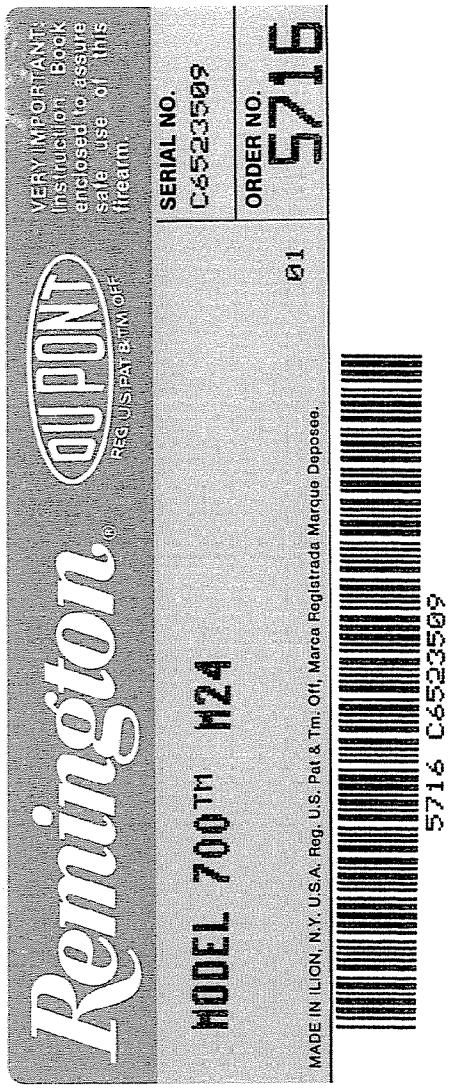
Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington


Remington
DUPONT
REG. U.S. PAT. & TM. OFF.
VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700™ M24
SERIAL NO.
C6523509
ORDER NO.
5716
01
MADE IN ILION, N.Y., U.S.A. Reg. U.S. Pat. & Tm. Off., Marca Registrada Marque Deposee.
5716 C6523509
UPC
0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523509

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10 2 90	RW
600	Proof		10 2 90	RW
607	Check Headspace		10 2 90	RW
610	Dis-assemble Gun		10 2 90	RW
612	Magnaflux Barrel Action		10-2-90	KR
	Magnaflux Bolt		10-2-90	KR
615	Rollmark Caliber		10-2-90	LL
617	Drill and Tap Sight Holes		10/4/90	EB
618	Polish Barrel RB		10/5/90	WB
620	Apply Coatings (Barrel Action)		10-20-90	TA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/22/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/22/90	RW
	C) Inspect Ejector Hole for Chamfer		10/22/90	RW
	D) Oil Firing Pin Ass'y		10/22/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11-1-90	JL

op. #	BARBER - M24 0029337 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2			11/7/90	WB
	G) Safety Off Force	2 1/2	2 3/4	2 1/2			11/7/90	WB
	H) Trigger Pull Test & Retainability						11-7-90	JH
	I) Firing Pin Indent	.0207	.0205	.0207			11/7/90	WB
	J) Assemble Stock						11/7/90	RW
	K) Assemble Swivel Studs						11-20-90	JS
	L) Attach Front and Rear Sight Assemblies						11/7/90	RW
	M) Iron Sight Alignment						11/7/90	RW
	N) Detach Front & Rear Sights & place in numbered container						11/7/90	RW
	O) Attach Scope to Rifle						11/7/90	RW
	P) Detach & Attach Scope 20 Times						11/7/90	RW
640	Gallery Target & Test						11/8/90	MF
	A) Time						"	MF
	B) Malfunctions						"	MF
	C) Pierced Primers						"	MF
	D) Optical Clearity of Scope						"	MF
645	Inspect for Live Ammo						11/8/90	MF
655	Final Inspection A) Headspace						11-20-90	JS
	B) Trigger Pull	226	230	242	231	239	11-20-90	JS
	C) Function						11-20-90	JS
660	Pack						12/10/90	MF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C6523509

DATE 11-7-90

TESTER

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.45	2.32	2.35	226	MIN. SETTING,
PULL #2	2.47	2.32	2.34	230	NO AVG. OF 5
PULL #3	2.26	2.34	2.28	242	READINGS ACCEPT-
PULL #4	2.39	2.29	2.30	231	ABLE LESS THAN 2#
PULL #5	2.50	2.42	2.33	239	
TOTAL	12.07	11.69	11.60		
AVG.	2.414	2.338	2.32		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.34		
PULL #2	3.29	3.33		
PULL #3	3.30	3.18		
PULL #4	3.28	3.50		
PULL #5	3.25	3.14		
TOTAL	16.48	16.49		
AVG.	3.296	3.298		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.33	4.23		4.22
PULL #2	4.31	4.10		4.22
PULL #3	4.33	4.32		4.20
PULL #4	4.28	4.26		4.18
PULL #5	4.24	4.18		4.21
TOTAL	21.49	21.09		21.03
AVG.	4.298	4.218		4.206

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523509
9 Nov 1990

CENTROIDAL DISTANCES

0	TO	1	.328055
1	TO	2	.17354
1	TO	3	.398741
1	TO	4	.452607
1	TO	5	.408894

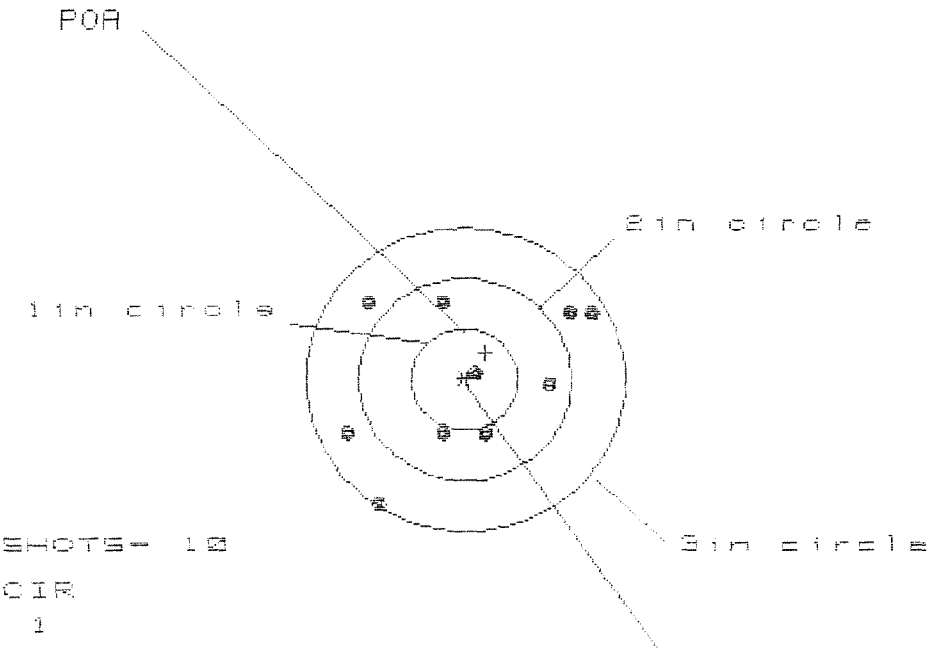
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.056
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.053
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0771038

THE AMR FOR THIS RIFLE IS: .9512

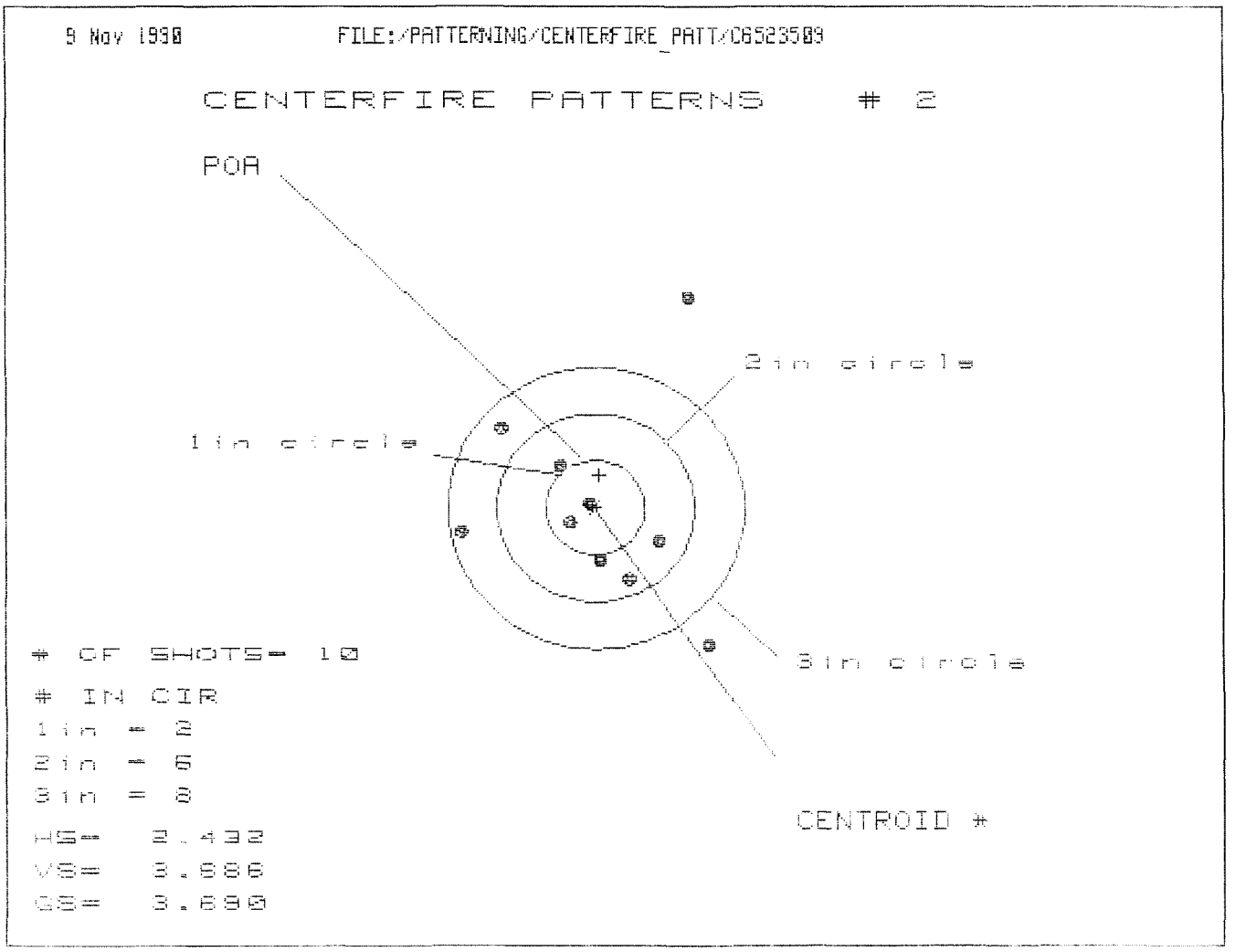
9 Nov 1998 FILE:/PATTERNING/CENTERFIRE_PATT/C6523509

CENTERFIRE PATTERNS # 1

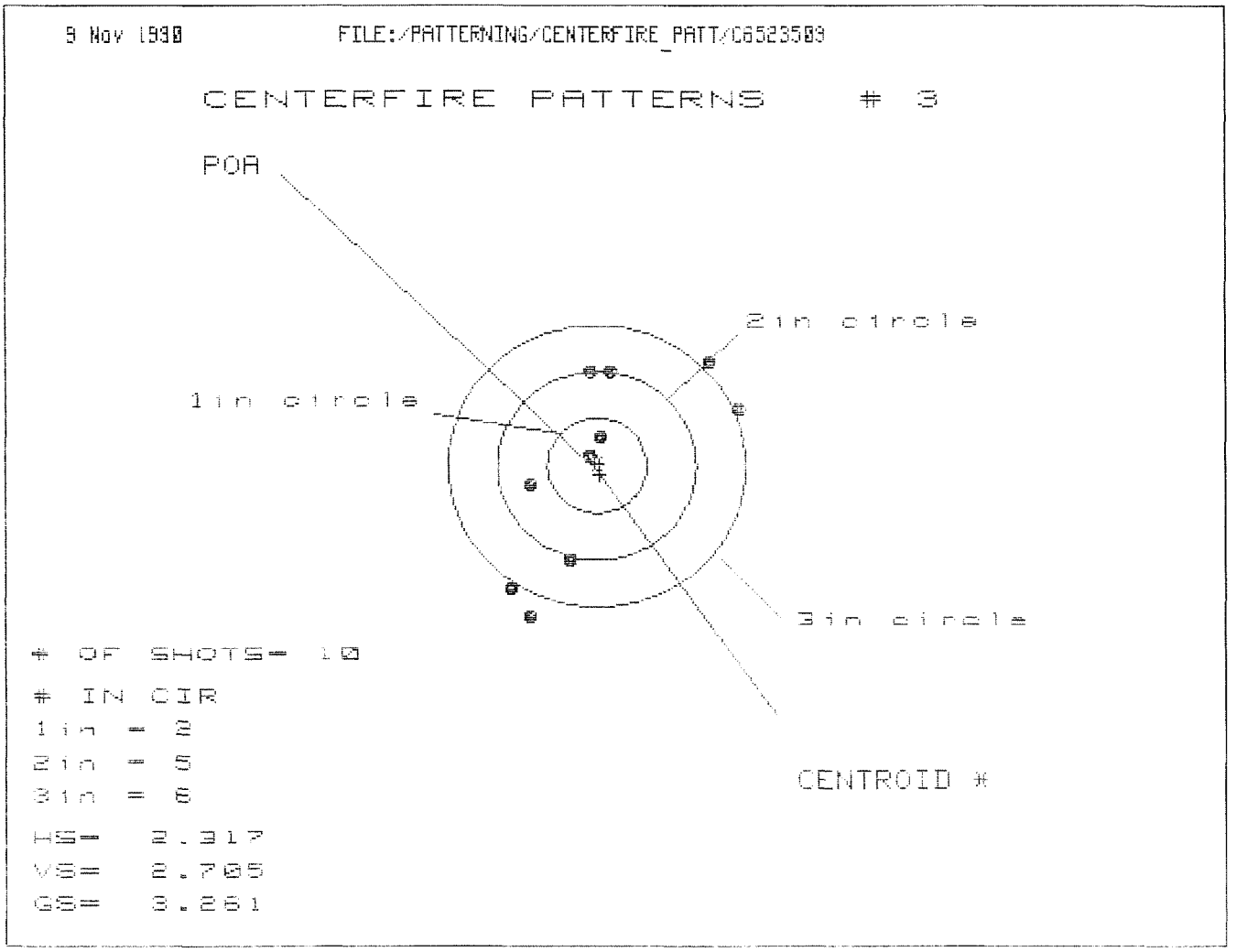


# OF SHOTS= 10
# IN CIR
1in = 1
2in = 5
3in = 9
HS= 2.399
VS= 2.065
GS= 2.762

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.178	1.088	1.010
MINIMUM X	:	-1.121	-1.211	-1.075
MAXIMUM Y	:	.792	.650	.713
MINIMUM Y	:	-1.273	-.703	-.640
CENTROID X	:	-.192	-.102	-.039
CENTROID Y	:	-.266	-.124	-.187
POA TO CENTROID in.	:	.328	.161	.303
MIN RADIUS	:	.107	.076	.131
MEAN RADIUS	:	.935	.863	.816
MAX RADIUS	:	1.509	1.375	1.226
HORIZONTAL SPREAD	:	2.299	2.299	2.084
VERTICAL SPREAD	:	2.065	1.353	1.353
EXTREME SPREAD	:	2.762	2.573	2.407
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	



PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.099	1.202	.904
MINIMUM X	:	-1.333	-1.230	-1.080
MAXIMUM Y	:	2.200	1.053	.898
MINIMUM Y	:	-1.486	-1.242	-.653
CENTROID X	:	-.038	-.141	-.291
CENTROID Y	:	-.346	-.590	-.435
POA TO CENTROID in.	:	.348	.607	.524
MIN RADIUS	:	.111	.207	.067
MEAN RADIUS	:	1.004	.822	.688
MAX RADIUS	:	2.388	1.728	1.174
HORIZONTAL SPREAD	:	2.432	2.432	1.984
VERTICAL SPREAD	:	3.686	2.295	1.561
EXTREME SPREAD	:	3.690	3.116	2.086
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	



PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.420	1.347	1.482
MINIMUM X	:	-.897	-.970	-.835
MAXIMUM Y	:	1.107	.930	.924
MINIMUM Y	:	-1.598	-1.463	-1.347
CENTROID X	:	-.027	.046	-.089
CENTROID Y	:	.097	.274	.158
POA TO CENTROID in.	:	.100	.278	.181
MIN RADIUS	:	.131	.138	.051
MEAN RADIUS	:	1.054	.953	.878
MAX RADIUS	:	1.729	1.756	1.585
HORIZONTAL SPREAD	:	2.317	2.317	2.317
VERTICAL SPREAD	:	2.705	2.393	2.271
EXTREME SPREAD	:	3.261	3.155	2.977
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		6	

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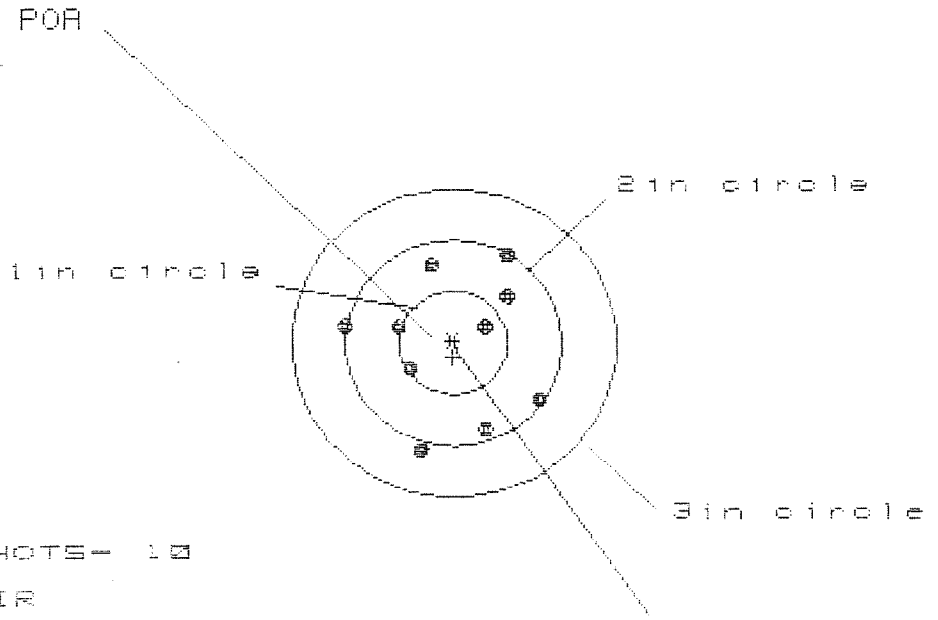
CENTERFIRE PATTERNS # 4

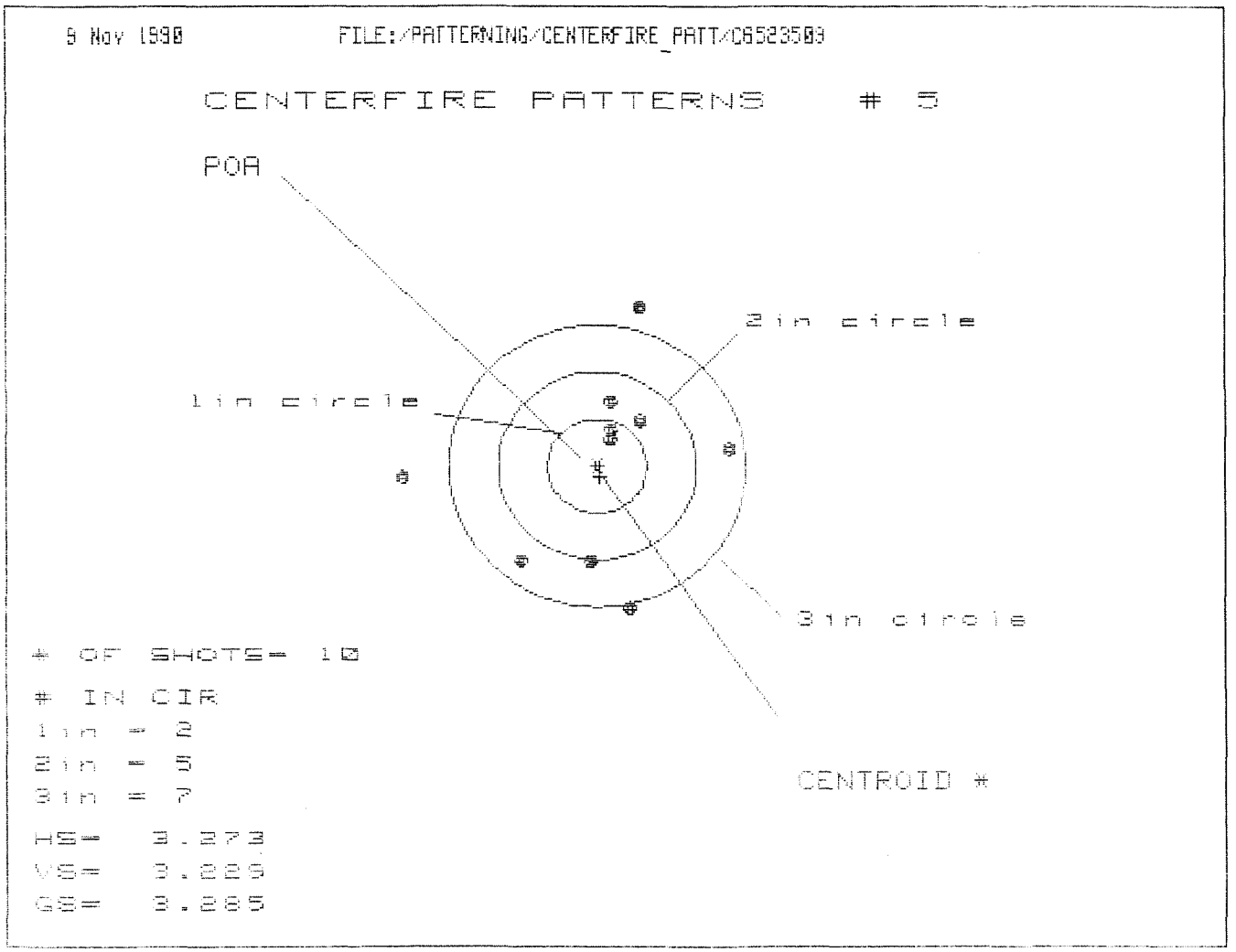


OF SHOTS= 10

# IN CIR
1in = 2
2in = 9
3in = 10

HS= 1.752
VS= 1.879
GS= 2.013

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.770	.742	.615
MINIMUM X	:	-.982	-1.010	-.687
MAXIMUM Y	:	.869	.756	.763
MINIMUM Y	:	-1.010	-.962	-.955
CENTROID X	:	.006	.034	.161
CENTROID Y	:	.141	.254	.247
POA TO CENTROID in.	:	.141	.256	.295
MIN RADIUS	:	.392	.319	.205
MEAN RADIUS	:	.768	.723	.675
MAX RADIUS	:	1.042	1.012	.964
HORIZONTAL SPREAD	:	1.752	1.752	1.252
VERTICAL SPREAD	:	1.879	1.718	1.718
EXTREME SPREAD	:	2.013	1.888	1.727
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	



PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.284	1.063	1.087
MINIMUM X	:	-1.989	-1.036	-1.012
MAXIMUM Y	:	1.702	1.690	.850
MINIMUM Y	:	-1.527	-1.539	-1.328
CENTROID X	:	-.029	.192	.168
CENTROID Y	:	.109	.121	-.090
POA TO CENTROID in.	:	.113	.227	.191
MIN RADIUS	:	.324	.285	.490
MEAN RADIUS	:	1.085	.951	.897
MAX RADIUS	:	1.992	1.700	1.337
HORIZONTAL SPREAD	:	3.273	2.099	2.099
VERTICAL SPREAD	:	3.229	3.229	2.178
EXTREME SPREAD	:	3.285	3.230	2.412
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	