

C6549087

MODEL 700™ M24

Model **545**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington®

MODEL 700™ M24

UPONT
REG. U.S. PAT. & TM. OFF.

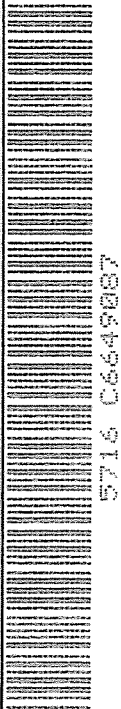
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

SERIAL NO.
C6649087

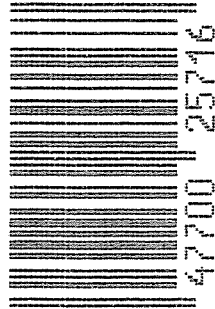
ORDER NO.
5716

20

MADE IN LION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6649087**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/25/91	KS
600	Proof		6/25/91	KS
607	Check Headspace		6/25/91	KS
610	Dis-assemble Gun		6/25/91	KS
612	Magnaflux Barrel Action		JUL 1 1991	KR
	Magnaflux Bolt		JUL 1 1991	KR
615	Rollmark Caliber		JUL 1 1991	JS
617	Drill and Tap Sight Holes		JUL 1 1991	LB
618	Polish Barrel		JUL 2 1991	WB
620	Apply Coatings (Barrel Action)		7-23-91	JS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/23/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/23/91	KS
	C) Inspect Ejector Hole for Chamfer		7/23/91	KS
	D) Oil Firing Pin Ass'y		7/23/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		7-24-91	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			7-24-91	SL
	G) Safety Off Force	5	5	5			7-24-91	SL
	H) Trigger Pull Test & Retainability						7-24-91	SL
	I) Firing Pin Indent	.021	.022	.022			7-24-91	SL
	J) Assemble Stock						7/30/91	KS
	K) Assemble Swivel Studs						8-6-91	AC
	L) Attach Front and Rear Sight Assemblies						7/30/91	KS
	M) Iron Sight Alignment						7/30/91	KS
	N) Detach Front & Rear Sights & place in numbered container						7/30/91	KS
	O) Attach Scope to Rifle						7/30/91	KS
	P) Detach & Attach Scope 20 Times						7/30/91	KS
640	Gallery Target & Test						7-31-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						7-31-91	AF
655	Final Inspection							
	A) Headspace						8-6-91	AC
	B) Trigger Pull	2.53	2.60	2.62	2.62	2.62	8-5-91	SL
	C) Function						8-6-91	AC
660	Pack						7-17-91	SL

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. C6649087

DATE 7-24-91

TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.49	2.45	2.46	2.53	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.28	2.48	2.49	2.60	
PULL #3	2.25	2.47	2.53	2.62	
PULL #4	2.52	2.50	2.55	2.62	
PULL #5	2.60	2.46	2.48	2.62	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.35	3.38		
PULL #2	3.40	3.40		
PULL #3	3.34	3.52		
PULL #4	3.39	3.38		
PULL #5	3.42	3.42		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.23	4.36		4.32
PULL #2	4.23	4.35		4.21
PULL #3	4.32	4.36		4.35
PULL #4	4.36	4.35		4.29
PULL #5	4.35	4.33		4.31
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649087
1 Jul 1991

CENTROIDAL DISTANCES

0 TO 1	.429121
1 TO 2	.302662
1 TO 3	.216178
1 TO 4	.270296
1 TO 5	.332032

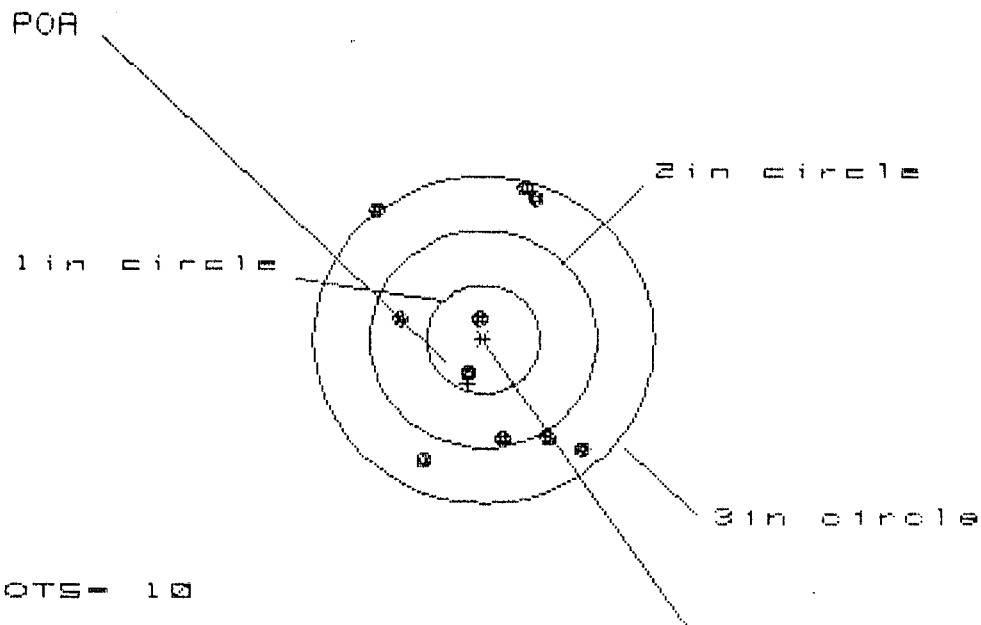
4 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0222
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2252
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .226292
THE POI FOR THIS RIFLE IS: .8158

011

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CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 10

HS= 1.761

VS= 2.516

GS= 2.784

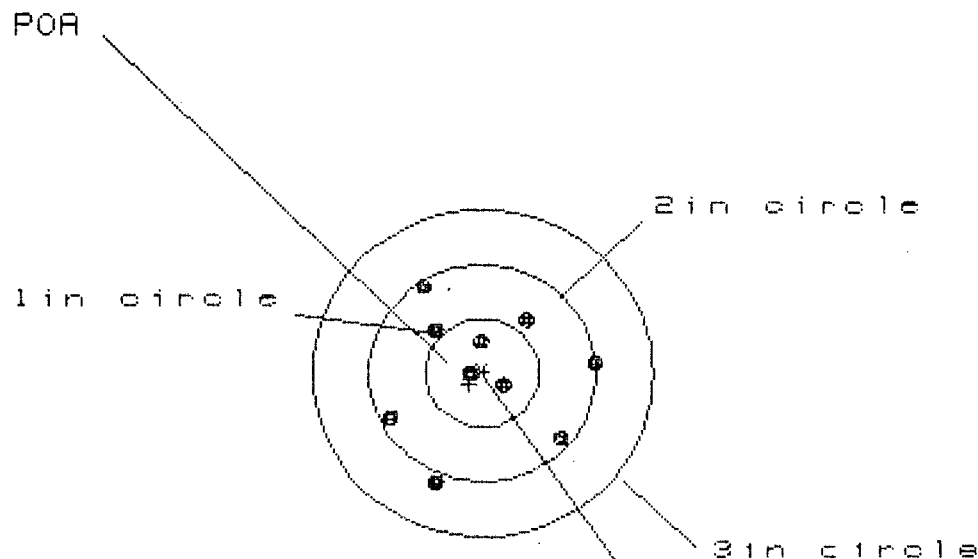
CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.827	.723	.750
MINIMUM X	:	-.934	-.888	-.861
MAXIMUM Y	:	1.401	1.529	1.631
MINIMUM Y	:	-1.115	-.987	-.796
CENTROID X	:	.136	.240	.213
CENTROID Y	:	.407	.279	.088
POA TO CENTROID in.	:	.429	.368	.230
MIN RADIUS	:	.162	.275	.165
MEAN RADIUS	:	1.013	.949	.837
MAX RADIUS	:	1.483	1.544	1.682
HORIZONTAL SPREAD	:	1.761	1.611	1.611
VERTICAL SPREAD	:	2.516	2.516	2.427
EXTREME SPREAD	:	2.784	2.656	2.633
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	10		

31 Jul 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.839

VS= 1.800

GS= 1.893

CENTROID #

PATTERN #	:	24		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.032	.985	.741
MINIMUM X	:	-.807	-.854	-.730
MAXIMUM Y	:	.769	.655	.651
MINIMUM Y	:	-1.031	-.681	-.685
CENTROID X	:	.116	.162	.038
CENTROID Y	:	.105	.219	.223
POA TO CENTROID in.	:	.156	.272	.226
MIN RADIUS	:	.086	.159	.096
MEAN RADIUS	:	.663	.603	.545
MAX RADIUS	:	1.111	.986	1.009
HORIZONTAL SPREAD	:	1.839	1.839	1.471
VERTICAL SPREAD	:	1.800	1.336	1.336
EXTREME SPREAD	:	1.893	1.893	1.796
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 1.307

VS= 2.803

GS= 2.889

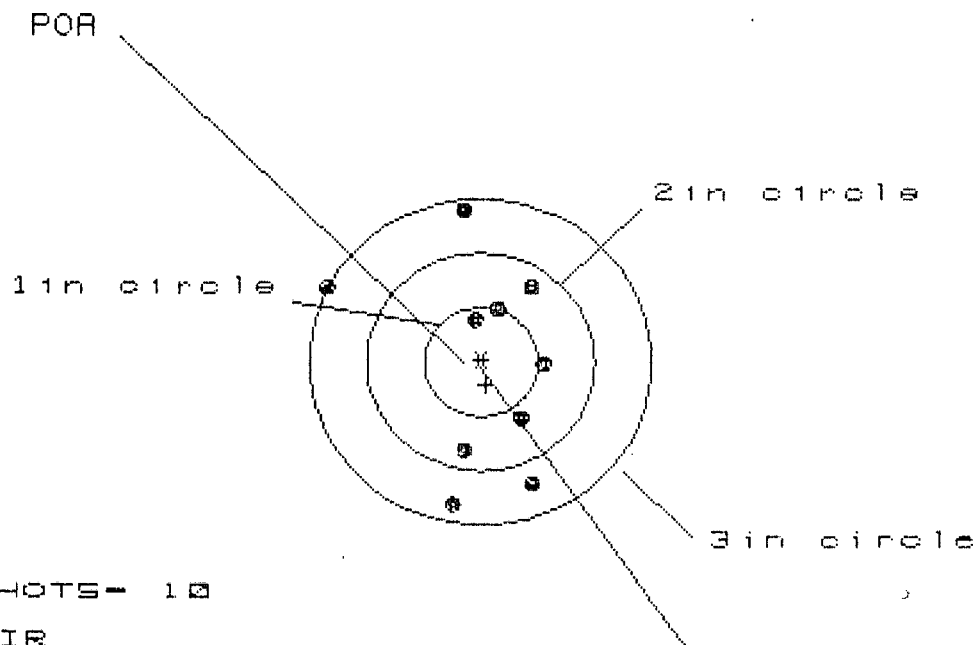
CENTROID *

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.563	.586	.529
MINIMUM X	:	-.745	-.721	-.778
MAXIMUM Y	:	1.544	1.383	1.248
MINIMUM Y	:	-1.259	-1.088	-.550
CENTROID X	:	-.006	-.030	.027
CENTROID Y	:	.244	.073	.208
POA TO CENTROID in.	:	.244	.079	.210
MIN RADIUS	:	.153	.108	.188
MEAN RADIUS	:	.773	.658	.600
MAX RADIUS	:	1.559	1.425	1.280
HORIZONTAL SPREAD	:	1.307	1.307	1.307
VERTICAL SPREAD	:	2.803	2.471	1.798
EXTREME SPREAD	:	2.889	2.598	2.089
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 10

HS= 1.865

VS= 2.712

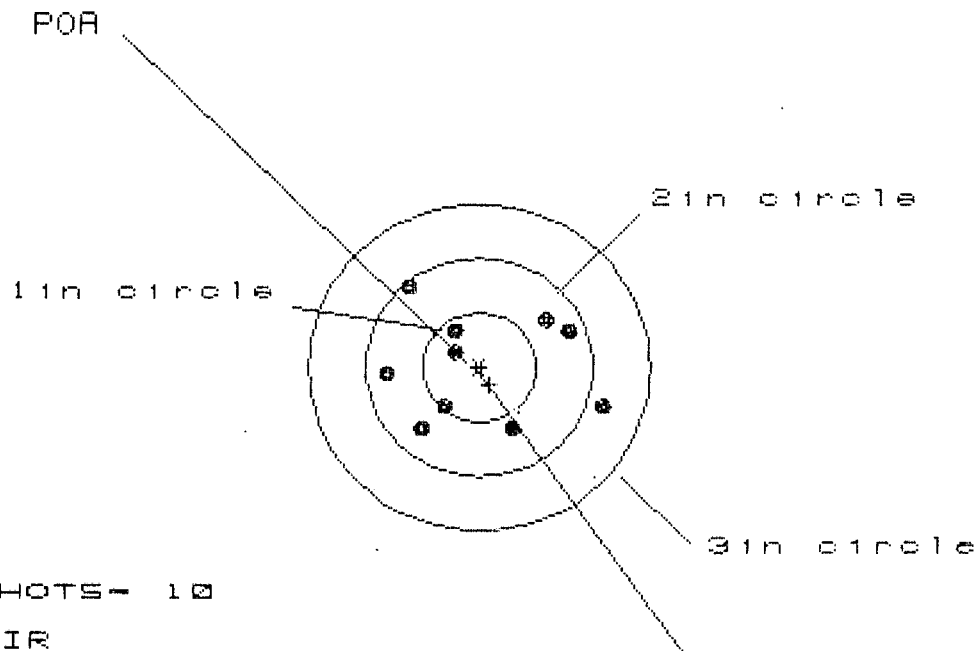
GS= 2.713

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.557	.412	.373
MINIMUM X	-1.308	-.366	-.405
MAXIMUM Y	1.379	1.454	.950
MINIMUM Y	-1.333	-1.258	-1.077
CENTROID X	-.048	.097	.136
CENTROID Y	.209	.134	-.047
POA TO CENTROID in.	.215	.166	.144
MIN RADIUS	.436	.419	.324
MEAN RADIUS	.912	.829	.734
MAX RADIUS	1.471	1.486	1.150
HORIZONTAL SPREAD	1.865	.778	.778
VERTICAL SPREAD	2.712	2.712	2.027
EXTREME SPREAD	2.713	2.713	2.124
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 3

2in = 9

3in = 10

HS= 1.952

VS= 1.366

GS= 2.074

CENTROID *

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.099	.923	.860
MINIMUM X	-.853	-.731	-.794
MAXIMUM Y	.766	.722	.477
MINIMUM Y	-.600	-.644	-.553
CENTROID X	-.087	-.209	-.146
CENTROID Y	.161	.205	.114
POA TO CENTROID in.	.183	.292	.196
MIN RADIUS	.258	.141	.250
MEAN RADIUS	.718	.644	.621
MAX RADIUS	1.167	.955	.924
HORIZONTAL SPREAD	1.952	1.654	1.654
VERTICAL SPREAD	1.366	1.366	1.030
EXTREME SPREAD	2.074	1.701	1.701
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	