

06649096

MODEL 700TM M24

Model 545TM

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

Remington®
REG. U.S. PAT. & TM. OFF.

MODEL 700™ M24

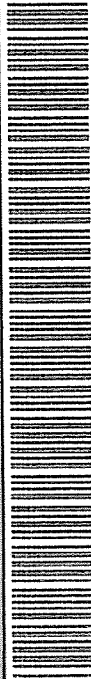
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

SERIAL NO.
C6649096

ORDER NO.
5716

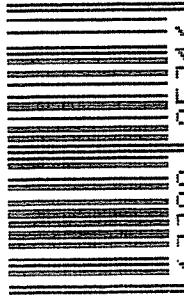
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



5716 C6649096

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6649096

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/24/91	KL
600	Proof		6/26/91	KL
607	Check Headspace		6/26/91	KL
610	Dis-assemble Gun		6/26/91	KL
612	Magnaflux Barrel Action		JUL 1 8 1991	CS
	Magnaflux Bolt		JUL 1 8 1991	CS
615	Rollmark Caliber		JUL 1 8 1991	CS
617	Drill and Tap Sight Holes		JUL 1 8 1991	FB
618	Polish Barrel		JUL 2 0 1991	WB
620	Apply Coatings (Barrel Action)		8-7-91	KL
	Apply Coating (Bolt)			KL
625	Final Assembly A) Clean inside of Bolt Assembly		8/22/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/22/91	KL
	C) Inspect Ejector Hole for Chamfer		8/22/91	KL
	D) Oil Firing Pin Ass'y		8/22/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		8/24/91	JU

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5 1/2	5			8-26-91	DH
	G) Safety Off Force	3	3	3			8-26-91	DH
	H) Trigger Pull Test & Retainability						8/24/91	JH
	I) Firing Pin Indent	.020	.020	.021			8-26-91	DH
	J) Assemble Stock						8/24/91	JH
	K) Assemble Swivel Studs						8-31-91	DH
	L) Attach Front and Rear Sight Assemblies						8/24/91	JH
	M) Iron Sight Alignment						8/24/91	JH
	N) Detach Front & Rear Sights & place in numbered container						8/24/91	JH
	O) Attach Scope to Rifle						8/24/91	JH
	P) Detach & Attach Scope 20 Times						8/24/91	JH
640	Gallery Target & Test						8-27-91	AC
	A) Time						8-27-91	AC
	B) Malfunctions						8-27-91	AC
	C) Pierced Primers						8-27-91	AC
	D) Optical Clarity of Scope						8-27-91	AC
645	Inspect for Live Ammo						8-27-91	AC
655	Final Inspection						8-31-91	DH
	A) Headspace						8-31-91	DH
	B) Trigger Pull	2.69	2.28	2.58	2.61	2.50	8/29/91	JH
	C) Function						8-31-91	DH
660	Pack						9-18-91	VF

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

SERIAL NO. 66649096DATE 8/24/91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.50	2.43	2.50	2.69	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.34	2.49	2.54	2.28	
PULL #3	2.58	2.53	2.56	2.58	
PULL #4	2.53	2.54	2.44	2.51	
PULL #5	2.45	2.45	2.48	2.50	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.66	3.31		
PULL #2	3.36	3.31		
PULL #3	3.36	3.34		
PULL #4	3.29	3.35		
PULL #5	3.27	3.35		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.63	4.51		4.56
PULL #2	4.53	4.37		4.52
PULL #3	4.67	4.53		4.51
PULL #4	4.66	4.44		4.59
PULL #5	4.60	4.42		4.57
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649096
28 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.202277
1 TO	2	.290016
1 TO	3	.368676
1 TO	4	.135624
1 TO	5	.399362

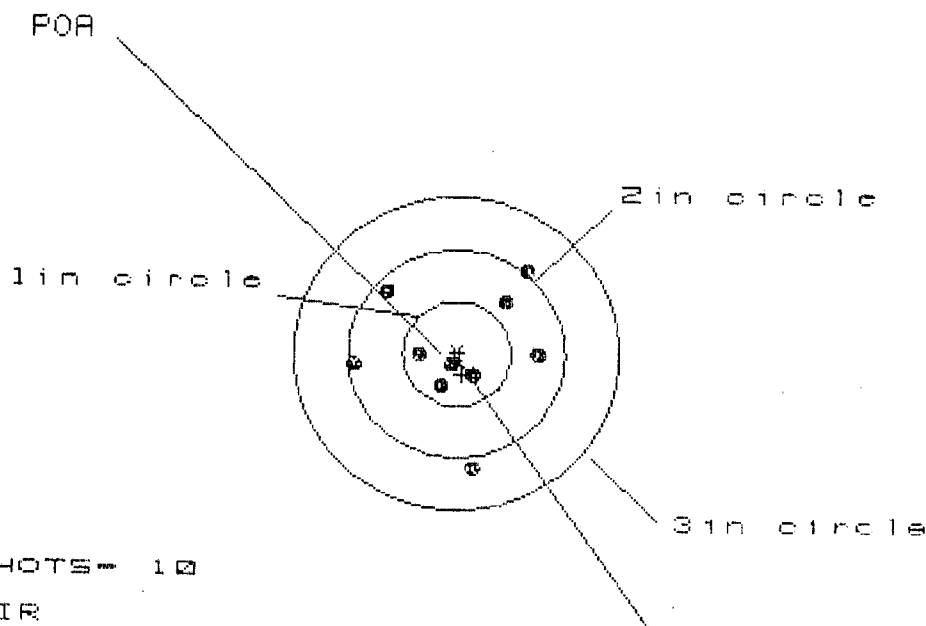
54 <----POR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.263
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1348
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .295533
THE AMR FOR THIS RIFLE IS: .8408

27 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649056

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 4

2 in = 7

3 in = 10

HS = 1.740

VS = 1.932

GS = 2.013

CENTROID #

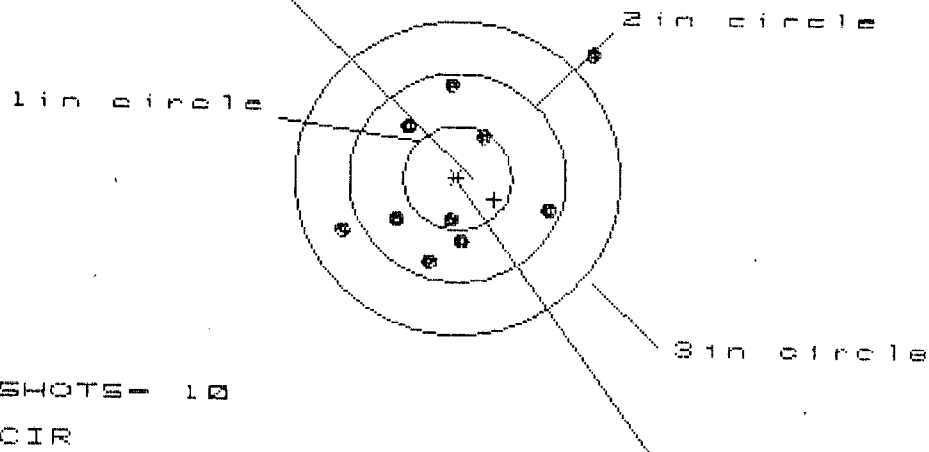
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.742	.756	.843
MINIMUM X	-.997	-.984	-.897
MAXIMUM Y	.821	.697	.535
MINIMUM Y	-1.111	-.450	-.363
CENTROID X	-.050	-.063	-.150
CENTROID Y	.196	.320	.233
POA TO CENTROID in.	.202	.326	.277
MIN RADIUS	.082	.197	.123
MEAN RADIUS	.652	.616	.544
MAX RADIUS	1.118	1.016	.912
HORIZONTAL SPREAD	1.740	1.740	1.740
VERTICAL SPREAD	1.932	1.147	.898
EXTREME SPREAD	2.013	1.930	1.742
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

27 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649096

CENTERFIRE PATTERNS # 2

POA



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 8

3 in = 9

HS= 2.217

VS= 2.053

GS= 2.836

PATTERN #

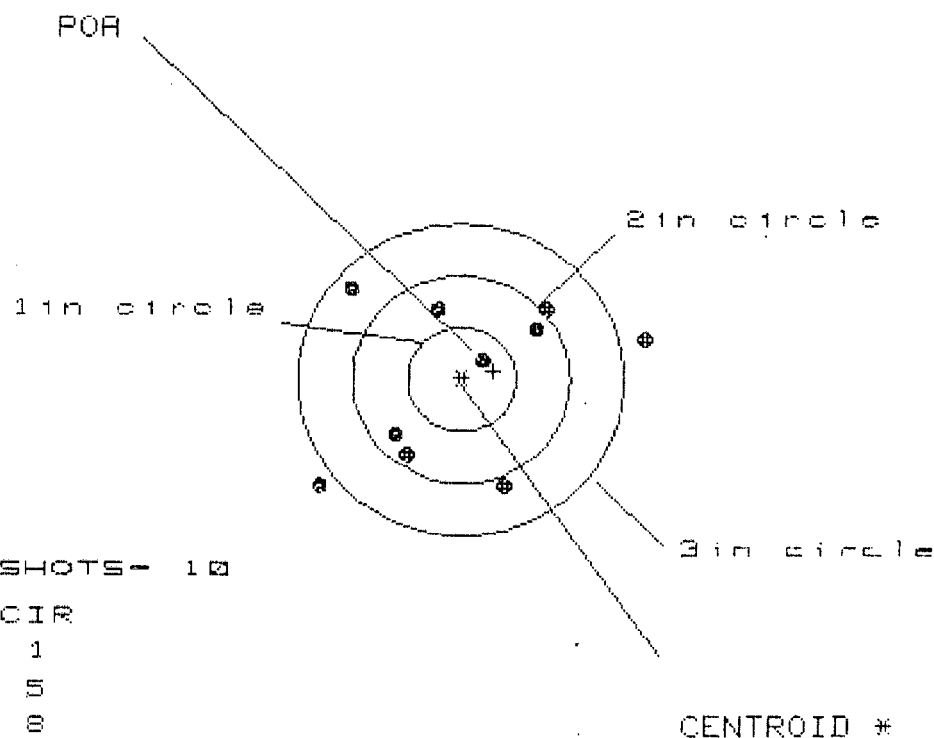
2

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.190	.964	.852
MINIMUM X	-1.027	-.895	-.535
MAXIMUM Y	1.238	1.061	1.012
MINIMUM Y	-.815	-.677	-.727
CENTROID X	-.340	-.472	-.360
CENTROID Y	.199	.061	.111
POA TO CENTROID in.	.394	.476	.377
MIN RADIUS	.418	.287	.327
MEAN RADIUS	.836	.706	.673
MAX RADIUS	1.717	1.064	1.012
HORIZONTAL SPREAD	2.217	1.859	1.387
VERTICAL SPREAD	2.053	1.738	1.738
EXTREME SPREAD	2.836	1.871	1.750
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		9	

27 Aug 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 2.939

VS= 1.946

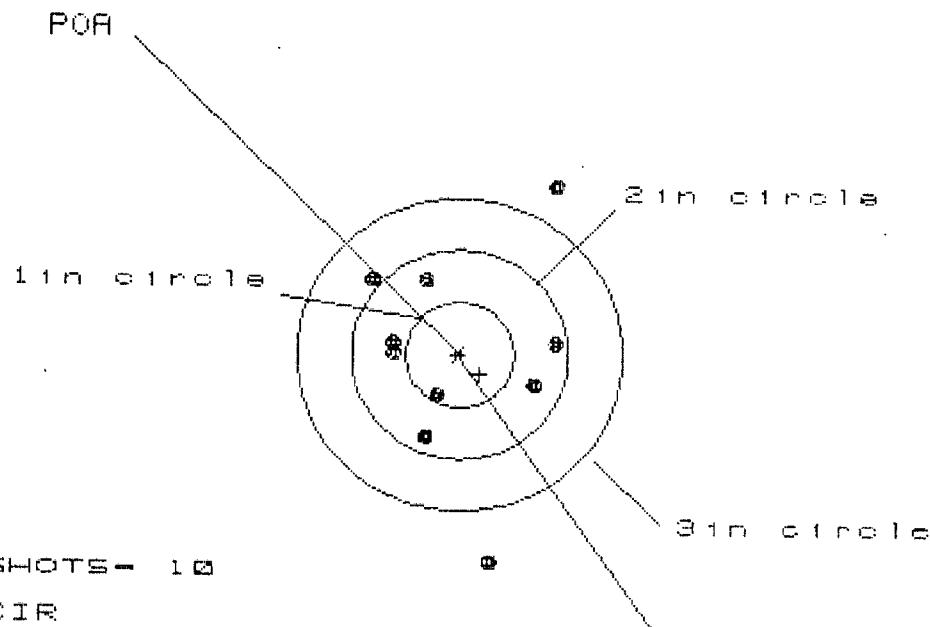
GS= 3.250

PATTERN #	13	14	15
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.653	.974	.836
MINIMUM X	-1.286	-1.102	-.948
MAXIMUM Y	.909	.948	.823
MINIMUM Y	-1.037	-.998	-1.122
CENTROID X	-.291	-.475	-.337
CENTROID Y	-.083	-.122	.003
POA TO CENTROID in.	.302	.490	.337
MIN RADIUS	.251	.413	.230
MEAN RADIUS	1.032	.957	.863
MAX RADIUS	1.690	1.487	1.256
HORIZONTAL SPREAD	2.939	2.076	1.784
VERTICAL SPREAD	1.946	1.946	1.945
EXTREME SPREAD	3.250	2.701	2.402
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 8

HS= 1.752

VS= 3.606

GS= 3.664

PATTERN #

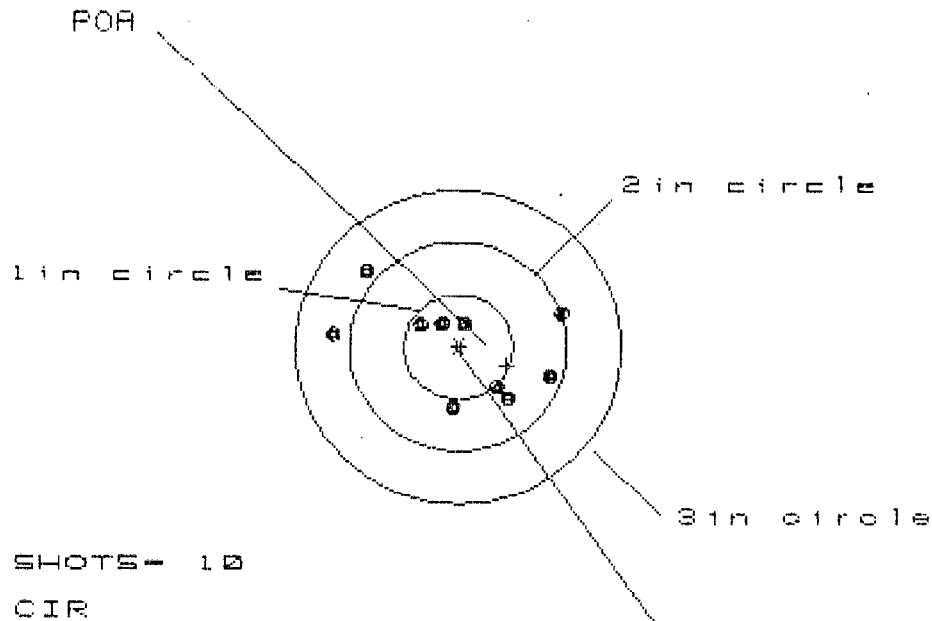
4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.931	.963	1.038
MINIMUM X	-.821	-.789	-.669
MAXIMUM Y	1.653	1.437	.722
MINIMUM Y	-1.952	-1.016	-.837
CENTROID X	-.185	-.217	-.337
CENTROID Y	.183	.400	.221
POA TO CENTROID in.	.261	.455	.403
MIN RADIUS	.410	.570	.408
MEAN RADIUS	.994	.881	.729
MAX RADIUS	1.973	1.729	1.045
HORIZONTAL SPREAD	1.752	1.752	1.787
VERTICAL SPREAD	3.606	2.453	1.559
EXTREME SPREAD	3.664	2.751	1.823
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 8

3 in = 10

HS = 2.100

VS = 1.304

GS = 2.114

CENTROID *

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.916	.784	.655
MINIMUM X	-1.184	-1.031	-.625
MAXIMUM Y	.684	.696	.440
MINIMUM Y	-.620	-.608	-.521
CENTROID X	-.449	-.317	-.188
CENTROID Y	.179	.167	.080
POA TO CENTROID in.	.483	.359	.205
MIN RADIUS	.244	.275	.272
MEAN RADIUS	.690	.626	.538
MAX RADIUS	1.189	1.244	.789
HORIZONTAL SPREAD	2.100	1.815	1.280
VERTICAL SPREAD	1.304	1.304	.961
EXTREME SPREAD	2.114	2.014	1.362
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		