

C6636254

MODEL 700™ M24

Model 545™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.



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

DUPONT

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

MODEL 700TM M24

SERIAL NO.
C6636264

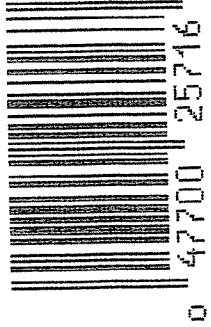
ORDER NO.
5716

20

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

5716 C6636264

UPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636264

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		5/3/91	KS
600	Proof		5/3/91	KS
607	Check Headspace		5/3/91	KS
610	Dis-assemble Gun		5/3/91	KS
612	Magnaflux Barrel Action	5 6 9 1		KCK
	Magnaflux Bolt	5 6 9 1		KCK
615	Rollmark Caliber	5 6 9 1		GL
617	Drill and Tap Sight Holes	5 15 9 1		LB
618	Polish Barrel	5 15 9 1		LB
620	Apply Coatings (Barrel Action)		5-29-91	JA
	Apply Coating (Bolt)			JA
625	Final Assembly			
	A) Clean inside of Bolt Assembly		7/15/91	JA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/15/91	JA
	C) Inspect Ejector Hole for Chamfer		7/15/91	JA
	D) Oil Firing Pin Ass'y		7/15/91	JA
	E) Adjust Trigger Pull to Min Setting and Stake		7.17.91	JA

op. #	OFF. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7	7	7			7-17-91	JK
	G) Safety Off Force	4	4	4			7-17-91	JK
	H) Trigger Pull Test & Retainability						7-17-91	JK
	I) Firing Pin Indent	.022	.0225	.0225			7-17-91	JK
	J) Assemble Stock						7/18/91	KS
	K) Assemble Swivel Studs						7-27-91	DH
	L) Attach Front and Rear Sight Assemblies						7/18/91	KS
	M) Iron Sight Alignment						7/18/91	KS
	N) Detach Front & Rear Sights & place in numbered container						7/18/91	KS
	O) Attach Scope to Rifle						7/18/91	KS
	P) Detach & Attach Scope 20 Times						7/18/91	KS
640	Gallery Target & Test						7/24/91	KT
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	KT
645	Inspect for Live Ammo						7/24/91	KT
655	Final Inspection						7-26-91	DH
	A) Headspace						7-26-91	JK
	B) Trigger Pull	2.59	2.57	2.59	2.64	2.65	7-26-91	JK
	C) Function						7-26-91	DH
660	Pack						9-19-91	NE

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6636264DATE 7-17-91TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.48	2.47	2.40	2.59	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.50	2.44	2.46	2.57	
PULL #3	2.45	2.41	2.49	2.59	
PULL #4	2.42	2.46	2.52	2.64	
PULL #5	2.31	2.41	2.40	2.65	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.21	3.22		
PULL #2	3.22	3.31		
PULL #3	3.26	3.25		
PULL #4	3.23	3.32		
PULL #5	3.25	3.30		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.25	4.39		4.36
PULL #2	4.35	4.37		4.41
PULL #3	4.33	4.38		4.37
PULL #4	4.37	4.36		4.37
PULL #5	4.30	4.29		4.40
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636264
24 Jul 1991

CENTROIDAL DISTANCES

Ø TO	1	.147567
1 TO	2	.132563
1 TO	3	.274449
1 TO	4	.147054
1 TO	5	.243212

←----FOR

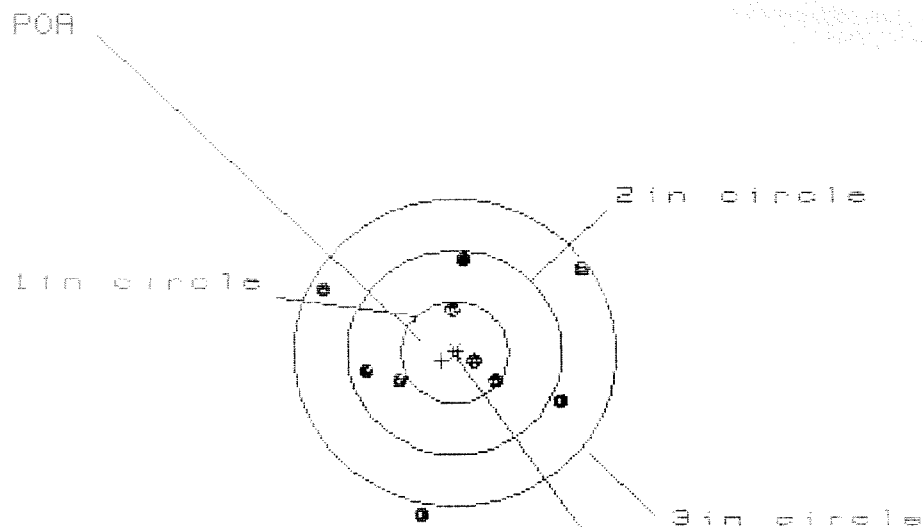
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0262
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .033
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .042136

THE AMR FOR THIS RIFLE IS: .943

24 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636264

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 3

2in = 6

3in = 9

HS= 2.413

VS= 2.492

GS= 2.872

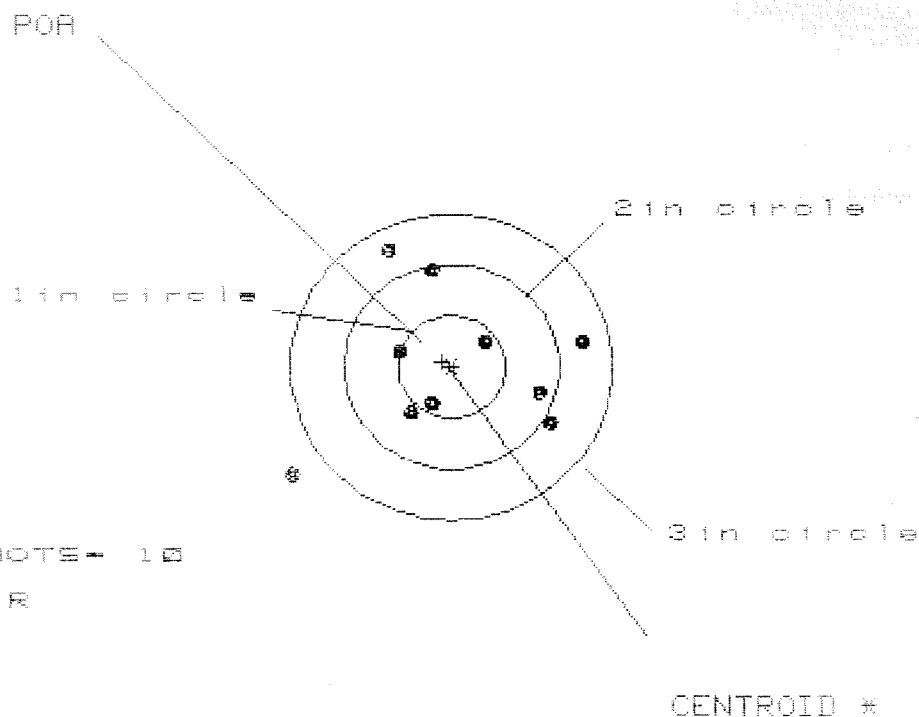
CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.214	1.178	1.110
MINIMUM X	:	-1.199	-1.235	-1.088
MAXIMUM Y	:	.910	.734	.817
MINIMUM Y	:	-1.582	-.628	-.545
CENTROID X	:	.124	.160	.013
CENTROID Y	:	.080	.256	.173
POA TO CENTROID in.	:	.147	.302	.173
MIN RADIUS	:	.168	.253	.310
MEAN RADIUS	:	.896	.811	.737
MAX RADIUS	:	1.615	1.353	1.237
HORIZONTAL SPREAD	:	2.413	2.413	2.198
VERTICAL SPREAD	:	2.492	1.362	1.362
EXTREME SPREAD	:	2.872	2.466	2.466
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	9		

24 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636264

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS= 2.753

VS= 2.285

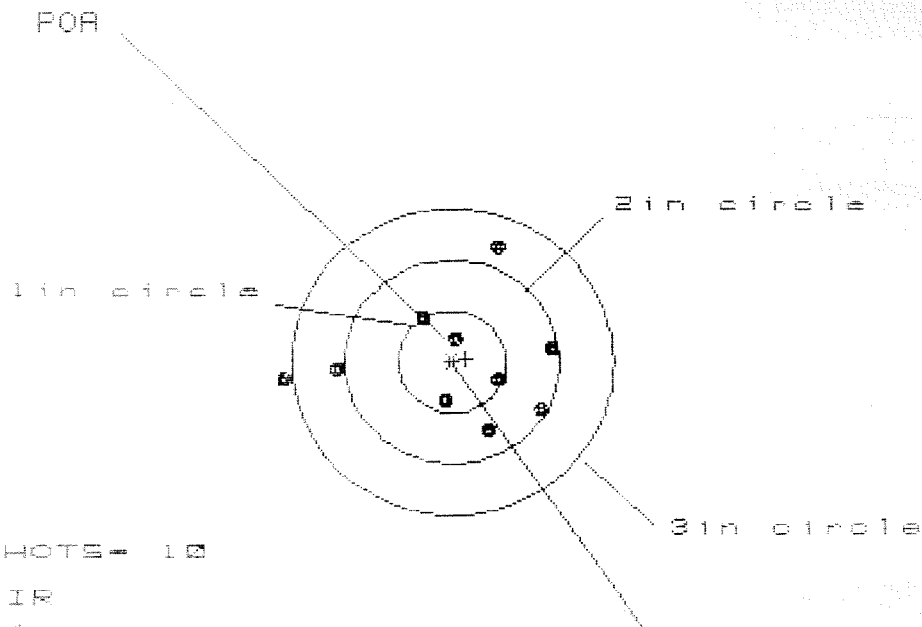
GS= 3.060

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.248	1.081	.986
MINIMUM X	-1.505	-.760	-.718
MAXIMUM Y	1.191	1.069	.920
MINIMUM Y	-1.094	-.706	-.572
CENTROID X	.086	.253	.348
CENTROID Y	-.047	.075	-.059
POA TO CENTROID in.	.098	.264	.353
MIN RADIUS	.336	.146	.217
MEAN RADIUS	.905	.788	.713
MAX RADIUS	1.861	1.312	1.018
HORIZONTAL SPREAD	2.753	1.841	1.704
VERTICAL SPREAD	2.285	1.775	1.492
EXTREME SPREAD	3.060	2.347	1.864
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

24 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B36264

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 4

2 in = 7

3 in = 9

HS = 2.488

VS = 1.821

GS = 2.510

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.932	.759	.793
MINIMUM X	-1.556	-1.227	-1.193
MAXIMUM Y	1.134	1.114	.517
MINIMUM Y	-.688	-.707	-.568
CENTROID X	-.127	.046	.012
CENTROID Y	-.031	-.012	-.151
POA TO CENTROID in.	.131	.047	.151
MIN RADIUS	.233	.249	.304
MEAN RADIUS	.800	.694	.625
MAX RADIUS	1.566	1.232	1.194
HORIZONTAL SPREAD	2.488	1.986	1.986
VERTICAL SPREAD	1.821	1.821	1.085
EXTREME SPREAD	2.510	2.001	2.001
NUMBER IN ONE INCH CIRCLE =	4	4	4
NUMBER IN TWO INCH CIRCLE =	7	7	7
NUMBER IN THREE INCH CIRCLE =	9	9	9

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FILE:/PATTERNING/CENTERFIRE_PATT/C6636264

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 0

2in = 4

3in = 7

HS = 3.221

VS = 3.250

GS = 3.602

CENTROID *

PATTERN #

:

4

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

1.318

1.457

1.236

MINIMUM X

:

-1.903

-1.764

-1.178

MAXIMUM Y

:

1.761

1.596

1.606

MINIMUM Y

:

-1.489

-.887

-.877

CENTROID X

:

.120

-.019

.202

CENTROID Y

:

.227

.392

.382

POA TO CENTROID in.:

:

.257

.393

.432

MIN RADIUS

:

.507

.437

.649

MEAN RADIUS

:

1.200

1.116

1.038

MAX RADIUS

:

1.946

1.766

1.613

HORIZONTAL SPREAD :

:

3.221

3.221

2.414

VERTICAL SPREAD :

:

3.250

2.483

2.483

EXTREME SPREAD :

:

3.602

3.229

2.537

NUMBER IN ONE INCH CIRCLE =

0

NUMBER IN TWO INCH CIRCLE =

4

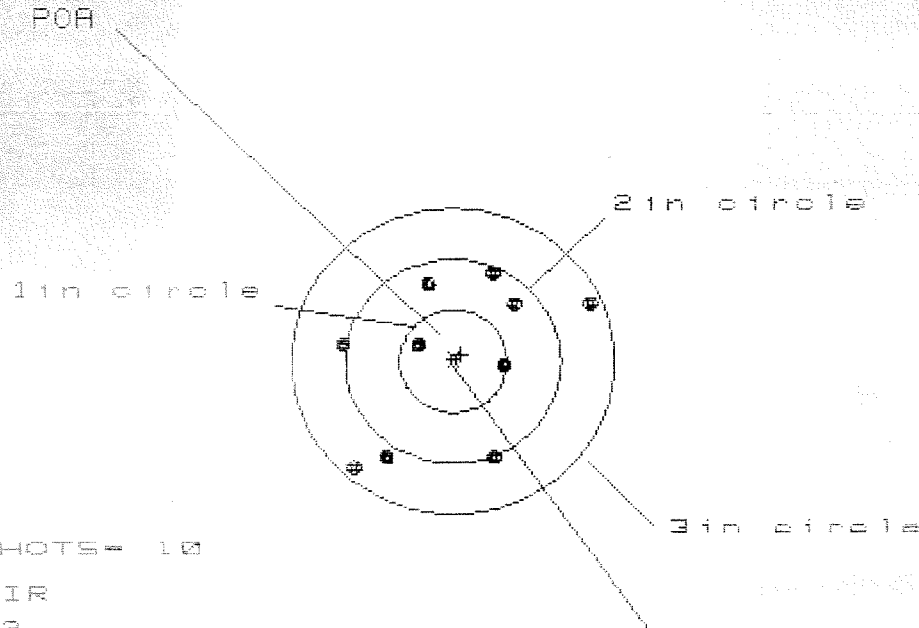
NUMBER IN THREE INCH CIRCLE =

7

24 Jul 1981

FILE:/PATTERNING/CENTERFIRE_PATT/C8636264

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 10

HE = 2.265

VS = 1.873

GS = 2.648

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.265	.694	.600
MINIMUM X	-1.000	-.859	-.953
MAXIMUM Y	.872	.931	.813
MINIMUM Y	-1.001	-.942	-1.033
CENTROID X	-.072	-.213	-.119
CENTROID Y	-.064	-.123	-.005
POA TO CENTROID in.	.096	.246	.119
MIN RADIUS	.327	.250	.262
MEAN RADIUS	.914	.861	.795
MAX RADIUS	1.373	1.206	1.171
HORIZONTAL SPREAD	2.265	1.553	1.553
VERTICAL SPREAD	1.873	1.873	1.846
EXTREME SPREAD	2.648	2.253	2.080
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	