

C6611687

MODEL 700TM M24

Model 545TM

Action

Barrel Length

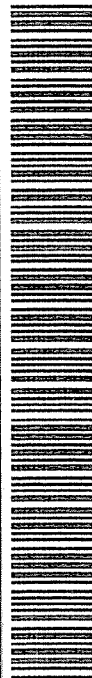
Capacity

Order No. 5715

*Includes 1 in chamber.

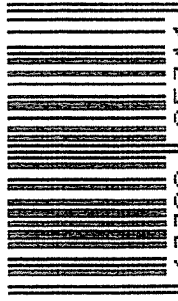
Remington

VERY IMPORTANT! Instruction Book enclosed to assure safe use of this firearm.	
Remington REG. U.S. PAT. & TM. OFF.	DUPONT REG. U.S. PAT. & TM. OFF.
MODEL 700TM M24	SERIAL NO. C6611687
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.	ORDER NO. 5716



5716 C6611687

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611687

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 28	91	RW
600	Proof	3 28	91	RW
607	Check Headspace	3 28	91	RW
610	Dis-assemble Gun	3 28	91	RW
612	Magnaflux Barrel Action	APR	2 1991	KR
	Magnaflux Bolt	APR	2 1991	TC
615	Rollmark Caliber	APR	2 1991	LS
617	Drill and Tap Sight Holes	APR	5 1991	FB
618	Polish Barrel	APR	5 1991	WB
620	Apply Coatings (Barrel Action)		4-9-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/10/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/10/91	RW
	C) Inspect Ejector Hole for Chamfer		4/10/91	RW
	D) Oil Firing Pin Ass'y		4/10/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4/17/91	JA

op. #	NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			4/17/91	SL
	G) Safety Off Force	4	4	4			4/17/91	SL
	H) Trigger Pull Test & Retainability						4/17/91	SL
	I) Firing Pin Indent	.0215	.0215	.0215			4/17/91	SL
	J) Assemble Stock						4/23/91	RW
	K) Assemble Swivel Studs						5-2-91	D/H
	L) Attach Front and Rear Sight Assemblies						4/23/91	RW
	M) Iron Sight Alignment						4/23/91	RW
	N) Detach Front & Rear Sights & place in numbered container						4/23/91	RW
	O) Attach Scope to Rifle						4/23/91	RW
	P) Detach & Attach Scope 20 Times						4/23/91	RW
640	Gallery Target & Test						4-24-91	AC
	A) Time						4-24-91	AC
	B) Malfunctions						4-24-91	AC
	C) Pierced Primers						4-24-91	AC
	D) Optical Clarity of Scope						4-24-91	AC
645	Inspect for Live Ammo						4-24-91	AC
655	Final Inspection							
	A) Headspace						5-2-91	D/H
	B) Trigger Pull	2.18	2.21	2.16	2.21	2.20	4/24/91	SL
	C) Function						5-2-91	D/H
660	Pack						6-18-91	RF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6611687

DATE 4/17/91

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.28	2.32	2.36	2.18	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.29	2.21	2.30	2.21	
PULL #3	2.39	2.24	2.22	2.16	
PULL #4	2.30	2.29	2.26	2.21	
PULL #5	2.32	2.29	2.28	2.20	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.41	3.40		
PULL #2	3.50	3.31		
PULL #3	3.42	3.34		
PULL #4	3.28	3.39		
PULL #5	3.47	3.40		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.40	4.53		4.44
PULL #2	4.39	4.40		4.45
PULL #3	4.35	4.45		4.38
PULL #4	4.48	4.41		4.38
PULL #5	4.46	4.26		4.39
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611687
24 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.0774919
1 TO	2	.475613
1 TO	3	.285414
1 TO	4	.357302
1 TO	5	.493931

$\frac{1}{5}$ <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2204
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1982
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .296411
THE AMR FOR THIS RIFLE IS: .948

24 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611667

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 0

2in = 4

3in = 10

HS = 2.573

VS = 2.038

GS = 2.609

CENTROID *

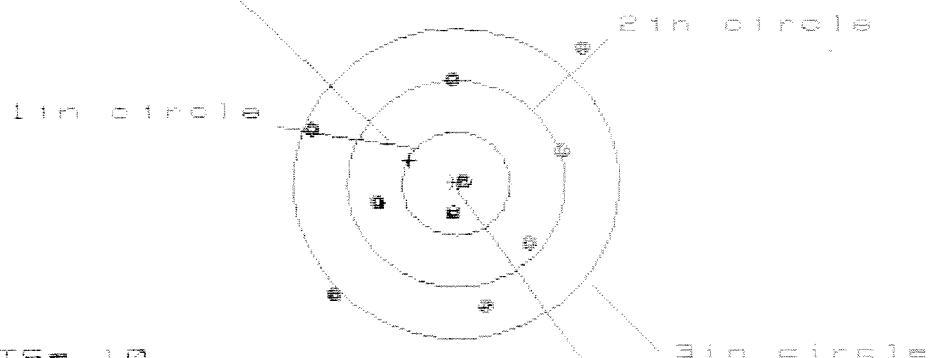
PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.444	.988	.867
MINIMUM X	-1.129	-.968	-.993
MAXIMUM Y	.787	.811	.895
MINIMUM Y	-1.258	-1.227	-1.143
CENTROID X	-.023	-.184	-.063
CENTROID Y	-.074	-.097	-.181
POA TO CENTROID in.	.077	.208	.192
MIN RADIUS	.616	.506	.638
MEAN RADIUS	1.017	.949	.921
MAX RADIUS	1.468	1.236	1.171
HORIZONTAL SPREAD	2.573	1.956	1.860
VERTICAL SPREAD	2.038	2.038	2.038
EXTREME SPREAD	2.609	2.408	2.160
NUMBER IN ONE INCH CIRCLE	= 0		
NUMBER IN TWO INCH CIRCLE	= 4		
NUMBER IN THREE INCH CIRCLE	= 10		

24 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8811687

CENTERFIRE PATTERNS # 2

FOR



OF SHOTS = 10

IN CIR

1in = 2

2in = 4

3in = 8

HS = 2.446

VS = 2.521

CS = 0.248

CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.141	1.129	1.007
MINIMUM X	:	-1.305	-1.178	-1.300
MAXIMUM Y	:	1.316	1.156	1.045
MINIMUM Y	:	-1.205	-1.058	-1.169
CENTROID X	:	.429	.302	.424
CENTROID Y	:	-.222	-.369	-.258
FOR TO CENTROID in.	:	.483	.477	.497
MIN RADIUS	:	.051	.181	.070
MEAN RADIUS	:	.984	.894	.821
MAX RADIUS	:	1.742	1.366	1.424
HORIZONTAL SPREAD	:	2.446	2.307	2.307
VERTICAL SPREAD	:	2.521	2.214	2.214
EXTREME SPREAD	:	3.248	2.525	2.362
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

24 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611687

CENTERFIRE PATTERNS : # 3

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 3

2in = 7

3in = 10

HS = 2.123

VS = 1.705

GS = 2.154

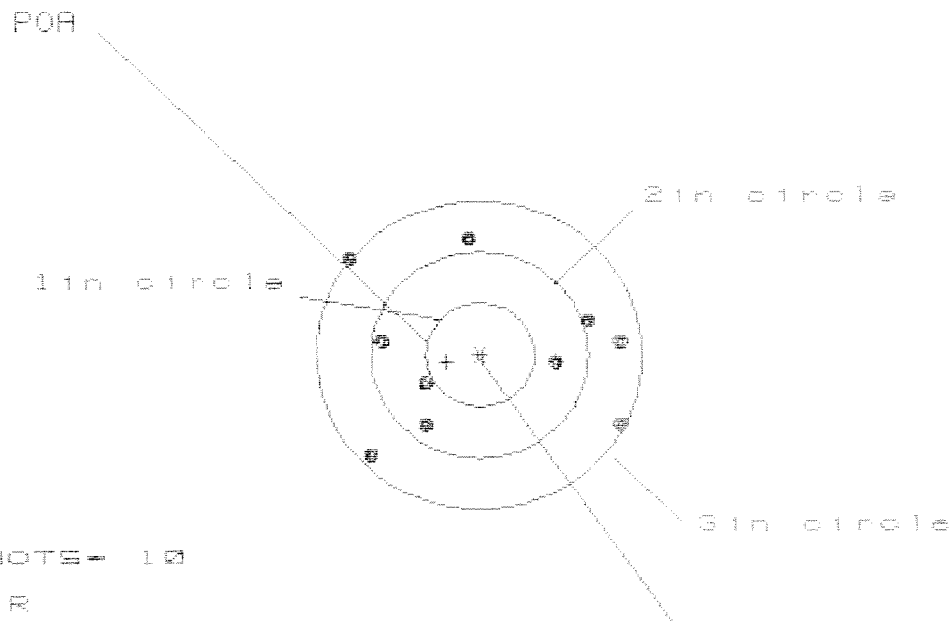
CENTROID *

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.217	1.328	.890
MINIMUM X	-.906	-.795	-.629
MAXIMUM Y	.952	.871	.879
MINIMUM Y	-.753	-.834	-.826
CENTROID X	.207	.096	-.070
CENTROID Y	-.243	-.162	-.171
POA TO CENTROID in.	.319	.188	.184
MIN RADIUS	.424	.336	.186
MEAN RADIUS	.610	.733	.611
MAX RADIUS	1.235	1.329	1.214
HORIZONTAL SPREAD	2.123	2.123	1.520
VERTICAL SPREAD	1.705	1.705	1.705
EXTREME SPREAD	2.154	2.154	1.947
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

24 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B11687

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 0

2in = 4

3in = 9

HS = 2.556

VS = 2.147

GS = 2.975

CENTROID #

PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	1.310
MINIMUM X	-1.246
MAXIMUM Y	1.137
MINIMUM Y	-1.010
CENTROID X	.304
CENTROID Y	.070
POA TO CENTROID in.	.312
MIN RADIUS	.527
MEAN RADIUS	1.092
MAX RADIUS	1.565
HORIZONTAL SPREAD	2.556
VERTICAL SPREAD	2.147
EXTREME SPREAD	2.975
NUMBER IN ONE INCH CIRCLE	0
NUMBER IN TWO INCH CIRCLE	4
NUMBER IN THREE INCH CIRCLE	9

24 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611687

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HE = 3.050

VS = 1.874

GS = 3.183

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.248	1.047	1.139
MINIMUM X	-1.810	-1.807	-1.715
MAXIMUM Y	1.135	1.082	.858
MINIMUM Y	-.739	-.792	-.656
CENTROID X	.185	.386	.294
CENTROID Y	-.522	-.469	-.685
POA TO CENTROID in.	.553	.608	.672
MIN RADIUS	.043	.165	.120
MEAN RADIUS	.837	.730	.626
MAX RADIUS	1.870	1.310	1.147
HORIZONTAL SPREAD	3.058	1.854	1.854
VERTICAL SPREAD	1.874	1.874	1.514
EXTREME SPREAD	3.183	2.046	1.991
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	