

C6611703

MODEL 700™ M24

Model **545**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

 		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700TM H24		SERIAL NO. C6611703
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		ORDER NO. 5716



5716 C6611703



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C 6611703**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	1/15/91	KS
600	Proof		1/15/91	KS
607	Check Headspace		1/15/91	KS
610	Dis-assemble Gun		1/15/91	KS
612	Magnaflux Barrel Action		1 18 91	KR
	Magnaflux Bolt	1 18 91		KR
615	Rollmark Caliber	1 18 91		28
617	Drill and Tap Sight Holes	1 24 91		FB
618	Polish Barrel	1 24 91		WB
620	Apply Coatings (Barrel Action)		2-15-91	JA
	Apply Coating (Bolt)			
625	Final Assembly		3/8/91	KL
	A) Clean inside of Bolt Assembly		3/8/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		3/8/91	KL
	C) Inspect Ejector Hole for Chamfer		3/8/91	KL
	D) Oil Firing Pin Ass'y		3/8/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		3/25/91	WB

op. #	BARBER - M24 0034537 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			3-28-91	AC
	G) Safety Off Force	2	2	2			3-28-91	AC
	H) Trigger Pull Test & Retainability						3/28/91	WLB
	I) Firing Pin Indent	.020	.021	.020			3-28-91	AC
	J) Assemble Stock						4/8/91	KS
	K) Assemble Swivel Studs						4-10-91	D/H
	L) Attach Front and Rear Sight Assemblies						4/8/91	KS
	M) Iron Sight Alignment						4/8/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/8/91	KS
	O) Attach Scope to Rifle						4/8/91	KS
	P) Detach & Attach Scope 20 Times						4/8/91	KS
640	Gallery Target & Test						4/9/91	KS
	A) Time						4/9/91	KS
	B) Malfunctions						4/9/91	KS
	C) Pierced Primers						4/9/91	KS
	D) Optical Clarity of Scope						4/9/91	KS
645	Inspect for Live Ammo						4/9/91	KS
655	Final Inspection							
	A) Headspace						4-10-91	D/H
	B) Trigger Pull	2.56	2.32	2.22	2.36	2.38	4/10/91	JCL
	C) Function						4-10-91	D/H
660	Pack						4-10-91	

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6611703

DATE 3/25/81

TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.51	2.52	2.56	2.54	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.54	2.52	2.58	2.32	
PULL #3	2.54	2.52	2.58	2.22	
PULL #4	2.53	2.49	2.60	2.36	
PULL #5	2.51	2.50	2.61	2.38	
TOTAL	12.63	12.55	12.93		
AVG.	2.53	2.51	2.58		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.25	3.04		
PULL #2	3.22	3.20		
PULL #3	3.25	3.26		
PULL #4	3.26	3.19		
PULL #5	3.21	3.21		
TOTAL	16.19	15.90		
AVG.	3.24	3.18		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.16	4.24		4.24
PULL #2	4.22	4.09		4.30
PULL #3	4.17	4.20		4.24
PULL #4	4.20	4.20		4.26
PULL #5	4.17	4.20		4.24
TOTAL	20.92	20.93		21.28
AVG.	4.18	4.18		4.25

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611703
9 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.261633
1 TO	2	.278407
1 TO	3	.249722
1 TO	4	.0372156
1 TO	5	.260946

$\frac{x}{y}$

-----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .127
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0004
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .127001
THE AMR FOR THIS RIFLE IS: .8124

8 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611703

CENTERFIRE PATTERNS # 1

POB

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 1.987

VS= 2.922

GS= 3.053

CENTROID *

PATTERN #

:

1

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

.827

.901

.568

MINIMUM X

:

-1.160

-1.086

-.974

MAXIMUM Y

:

1.150

.953

.796

MINIMUM Y

:

-1.772

-1.253

-1.037

CENTROID X

:

.256

.182

.070

CENTROID Y

:

-.054

.143

.300

POB TO CENTROID in.

:

.262

.232

.308

MIN RADIUS

:

.396

.273

.152

MEAN RADIUS

:

.963

.805

.668

MAX RADIUS

:

1.894

1.544

1.261

HORIZONTAL SPREAD

:

1.987

1.987

1.541

VERTICAL SPREAD

:

2.922

2.206

1.833

EXTREME SPREAD

:

3.053

2.463

1.928

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

5

NUMBER IN THREE INCH CIRCLE =

9

9 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08611783

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 8

3 in = 9

HS= 2.690

VS= .960

GS= 2.761

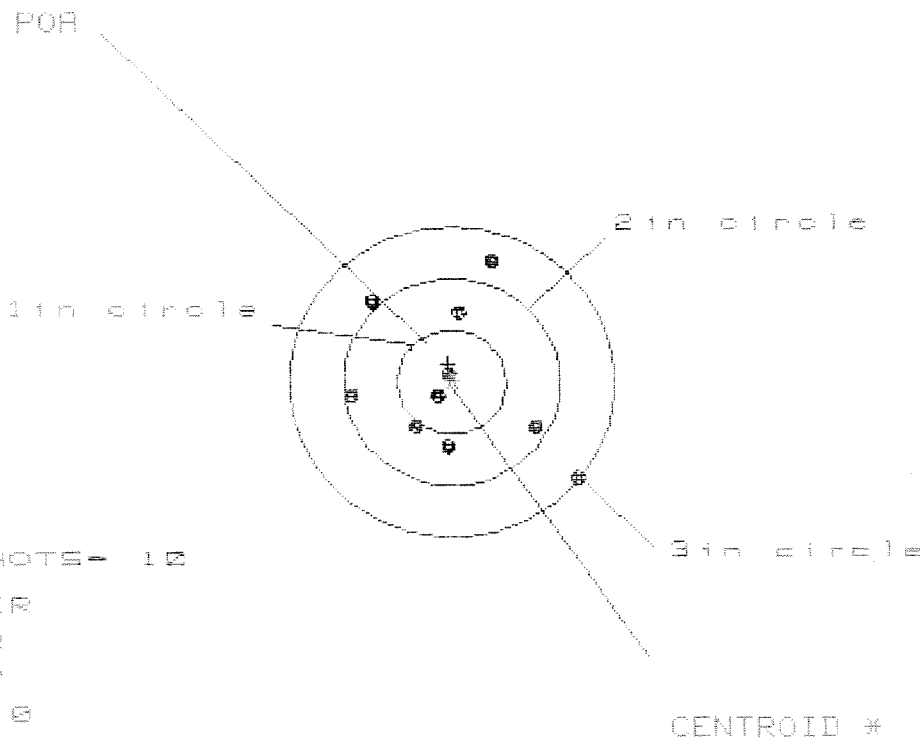
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.032	.848	.690
MINIMUM X	:	-1.658	-1.007	-.902
MAXIMUM Y	:	.452	.473	.421
MINIMUM Y	:	-.508	-.487	-.539
CENTROID X	:	.044	.228	.123
CENTROID Y	:	.128	.107	.159
POA TO CENTROID in.	:	.135	.252	.201
MIN RADIUS	:	.116	.273	.196
MEAN RADIUS	:	.730	.612	.560
MAX RADIUS	:	1.668	1.021	.928
HORIZONTAL SPREAD	:	2.690	1.855	1.591
VERTICAL SPREAD	:	.960	.960	.960
EXTREME SPREAD	:	2.761	1.872	1.603
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

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FILE:/PATTERNING/CENTERFIRE_PATT/C6611703

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 2.026

VS= 2.037

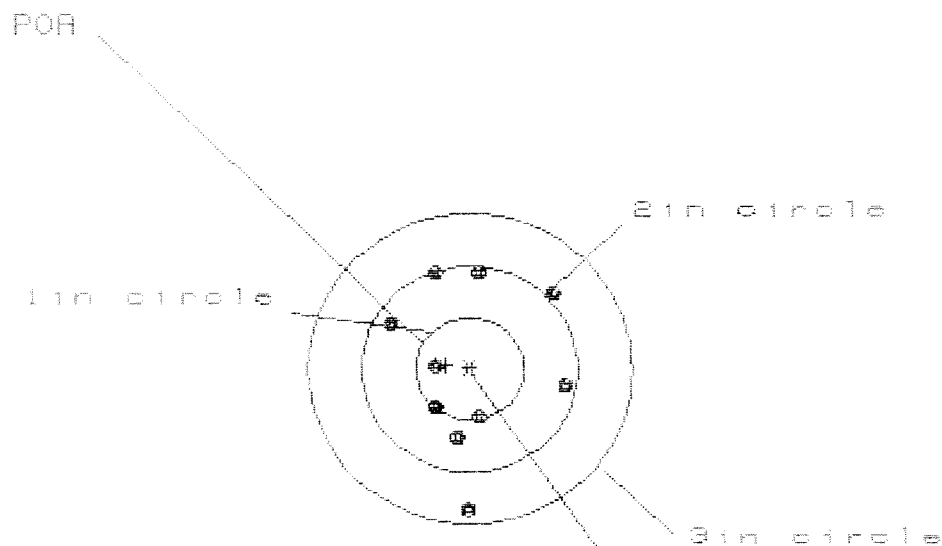
GS= 2.492

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.134	.887	.949
MINIMUM X	-.892	-.766	-.705
MAXIMUM Y	1.160	1.062	.784
MINIMUM Y	-.877	-.753	-.620
CENTROID X	.037	-.089	-.150
CENTROID Y	-.174	-.076	-.209
POA TO CENTROID in.	.178	.118	.258
MIN RADIUS	.093	.070	.085
MEAN RADIUS	.769	.683	.594
MAX RADIUS	1.434	1.170	1.022
HORIZONTAL SPREAD	2.026	1.653	1.653
VERTICAL SPREAD	2.037	1.815	1.404
EXTREME SPREAD	2.492	1.911	1.911
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	7	
NUMBER IN THREE INCH CIRCLE	=	10	

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FILE:/PATTERNING/CENTERFIRE_PATT/C86117B3

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.550

VS= 2.324

GS= 2.339

CENTROID #

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.863	.864	.958
MINIMUM X	:	-.687	-.686	-.592
MAXIMUM Y	:	.927	.772	.847
MINIMUM Y	:	-1.397	-.866	-.791
CENTROID X	:	.224	.223	.129
CENTROID Y	:	-.035	.120	.045
POA TO CENTROID in.	:	.227	.253	.137
MIN RADIUS	:	.277	.304	.189
MEAN RADIUS	:	.794	.731	.574
MAX RADIUS	:	1.397	.962	1.001
HORIZONTAL SPREAD	:	1.550	1.550	1.550
VERTICAL SPREAD	:	2.324	1.638	1.638
EXTREME SPREAD	:	2.339	1.716	1.680
NUMBER IN ONE INCH CIRCLE =		3		
NUMBER IN TWO INCH CIRCLE =		8		
NUMBER IN THREE INCH CIRCLE =		10		

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CENTERFIRE PATTERNS

5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 2

2 in = 6

3 in = 10

HS = 1.752

VS = 2.067

GS = 2.083

CENTROID #

PATTERN #

5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.665	.649	.521
MINIMUM X	-1.097	-1.023	-.678
MAXIMUM Y	1.140	1.155	1.226
MINIMUM Y	-.927	-.800	-.729
CENTROID X	.074	-.000	.128
CENTROID Y	.133	.006	-.065
POA TO CENTROID in.	.152	.006	.143
MIN RADIUS	.316	.362	.244
MEAN RADIUS	.806	.723	.650
MAX RADIUS	1.320	1.270	1.290
HORIZONTAL SPREAD	1.762	1.672	1.199
VERTICAL SPREAD	2.067	1.955	1.955
EXTREME SPREAD	2.083	2.039	1.955
NUMBER IN ONE INCH CIRCLE	= 2		
NUMBER IN TWO INCH CIRCLE	= 6		
NUMBER IN THREE INCH CIRCLE	= 10		