

C6611709

MODEL 700™ M24

Model 545™

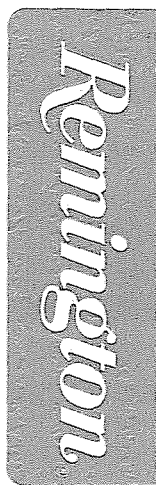
Action _____

Barrel Length _____

Capacity _____

Order No. 5715

*Includes 1 in chamber.



Remington[®]


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

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

MODEL 700TM M24

46

SERIAL NO.
C6611709

ORDER NO.
5716

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



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611709

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 28	9 1	RW
600	Proof	3 28	9 1	RW
607	Check Headspace	3 28	9 1	RW
610	Dis-assemble Gun	3 28	9 1	RW
612	Magnaflux Barrel Action	APR	2 1991	KR
	Magnaflux Bolt	APR	2 1991	11
615	Rollmark Caliber	APR	2 1991	JS
617	Drill and Tap Sight Holes	APR	5 1991	LB
618	Polish Barrel	APR	5 1991	WB
620	Apply Coatings (Barrel Action)		4-9-91	TH
	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	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			4/18/91	SH
	G) Safety Off Force	4	4	4			4/18/91	SH
	H) Trigger Pull Test & Retainability						4/17/91	SH
	I) Firing Pin Indent	1022	1022	1022			4/18/91	SH
	J) Assemble Stock						4/22/91	RW
	K) Assemble Swivel Studs						4-24-91	DH
	L) Attach Front and Rear Sight Assemblies						4/22/91	RW
	M) Iron Sight Alignment						4/22/91	RW
	N) Detach Front & Rear Sights & place in numbered container						4/22/91	RW
	O) Attach Scope to Rifle						4/22/91	RW
	P) Detach & Attach Scope 20 Times						4/22/91	RW
640	Gallery Target & Test						4-22-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						4-22-91	NF
655	Final Inspection							
	A) Headspace						4-24-91	DH
	B) Trigger Pull	2.30	2.34	2.21	2.37	2.38	4/23/91	SH
	C) Function						4-24-91	DH
660	Pack						6-18-91	NF

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

SERIAL NO. C6611709DATE 4/17/91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.28	2.32	2.20	2.30	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.29	2.36	2.60	2.34	
PULL #3	2.33	2.35	2.43	2.21	
PULL #4	2.30	2.32	2.52	2.37	
PULL #5	2.34	2.33	2.54	2.38	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.29	3.52		
PULL #2	3.42	3.43		
PULL #3	3.43	3.40		
PULL #4	3.53	3.42		
PULL #5	3.45	3.48		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.30	4.33		4.27
PULL #2	4.31	4.34		4.43
PULL #3	4.22	4.17		4.34
PULL #4	4.29	4.31		4.38
PULL #5	4.32	4.22		4.41
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611709
22 Apr 1991

CENTROIDAL DISTANCES

Ø TO	1	.182148
1 TO	2	.043566
1 TO	3	.838974
1 TO	4	.0983514
1 TO	5	.143562

4 (----POA

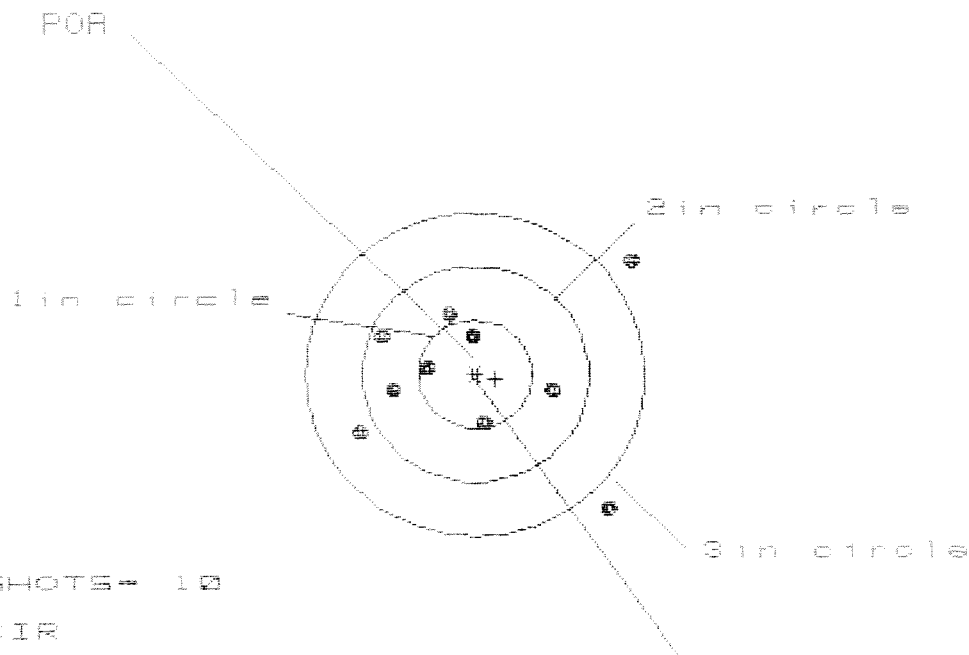
3

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0922
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0726
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .117356
THE AMR FOR THIS RIFLE IS: .773

22 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611709

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 3

2in = 7

3in = 8

CENTROID #

HS = 2.434

VS = 2.390

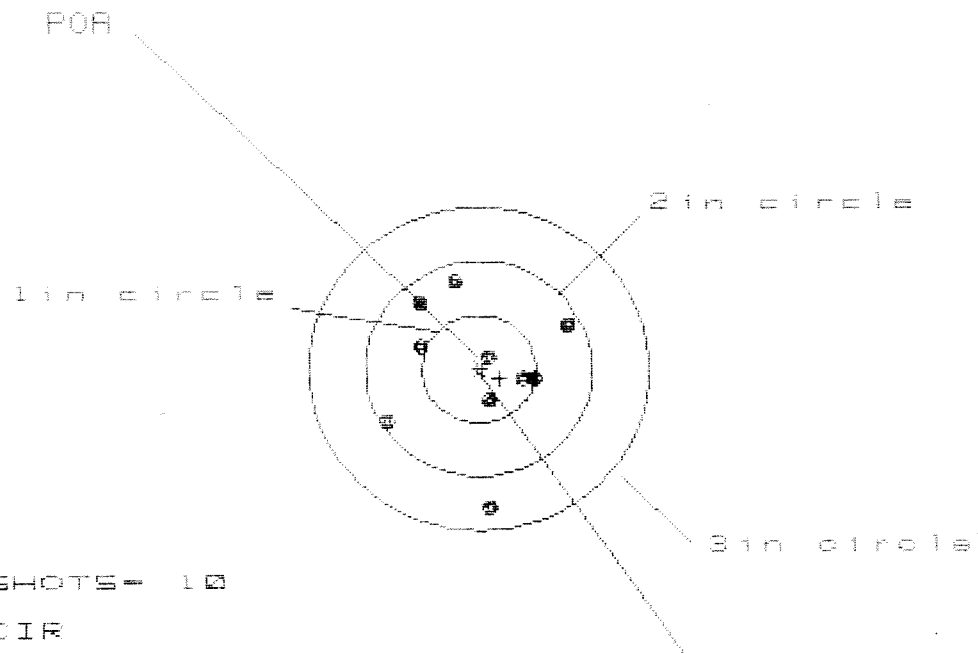
GS = 2.935

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.371	1.325	.958
MINIMUM X	-1.063	-.911	-.746
MAXIMUM Y	1.102	.681	.535
MINIMUM Y	-1.288	-1.165	-.561
CENTROID X	-.177	-.329	-.494
CENTROID Y	.043	-.080	.066
POA TO CENTROID in.	.102	.338	.499
MIN RADIUS	.354	.278	.061
MEAN RADIUS	.873	.754	.571
MAX RADIUS	1.759	1.764	.965
HORIZONTAL SPREAD	2.434	2.236	1.700
VERTICAL SPREAD	2.390	1.846	1.096
EXTREME SPREAD	2.935	2.601	1.759
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		

22 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611709

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 3

2in = 3

3in = 10

HS= 1.602

VS= 2.112

GS= 2.138

CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.816	.829	.732
MINIMUM X	:	-.786	-.773	-.601
MAXIMUM Y	:	.849	.708	.627
MINIMUM Y	:	-1.264	-.646	-.482
CENTROID X	:	-.184	-.197	-.100
CENTROID Y	:	.086	.227	.308
POA TO CENTROID in.	:	.203	.300	.323
MIN RADIUS	:	.140	.156	.162
MEAN RADIUS	:	.672	.606	.551
MAX RADIUS	:	1.268	1.008	.759
HORIZONTAL SPREAD	:	1.602	1.602	1.333
VERTICAL SPREAD	:	2.112	1.354	1.109
EXTREME SPREAD	:	2.138	1.850	1.348
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

22 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611789

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 4

2in = 8

3in = 9

HS = 1.141

VS = 2.805

GS = 2.924

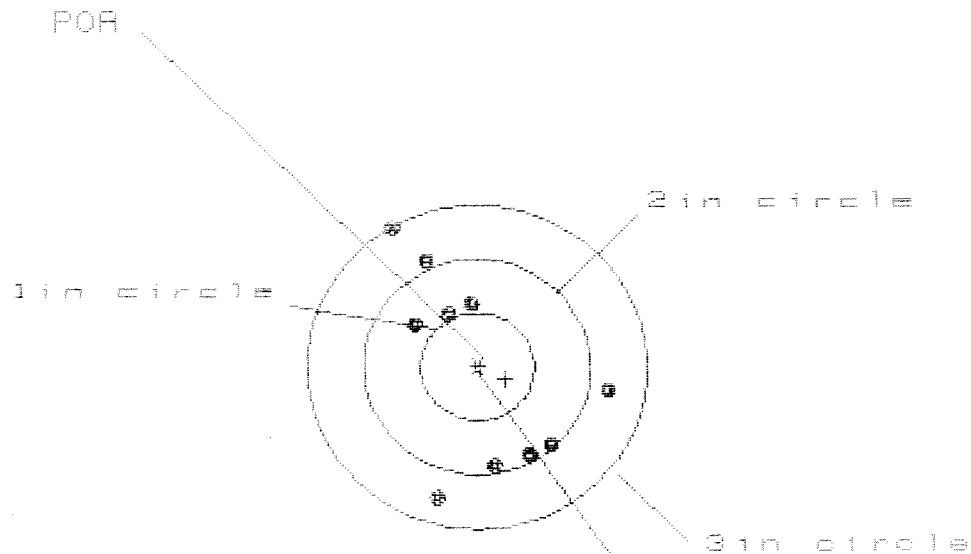
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.518	.484	.281
MINIMUM X	:	-.623	-.657	-.596
MAXIMUM Y	:	1.881	.943	.853
MINIMUM Y	:	-.924	-.715	-.710
CENTROID X	:	.197	.231	.170
CENTROID Y	:	-.708	-.917	-.827
POA TO CENTROID in.	:	.735	.945	.845
MIN RADIUS	:	.182	.276	.175
MEAN RADIUS	:	.720	.564	.521
MAX RADIUS	:	1.906	.944	.861
HORIZONTAL SPREAD	:	1.141	1.141	.877
VERTICAL SPREAD	:	2.805	1.658	1.563
EXTREME SPREAD	:	2.924	1.714	1.629
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

22 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611709

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 0

2in = 6

3in = 9

HS= 1.818

VS= 2.492

GS= 2.512

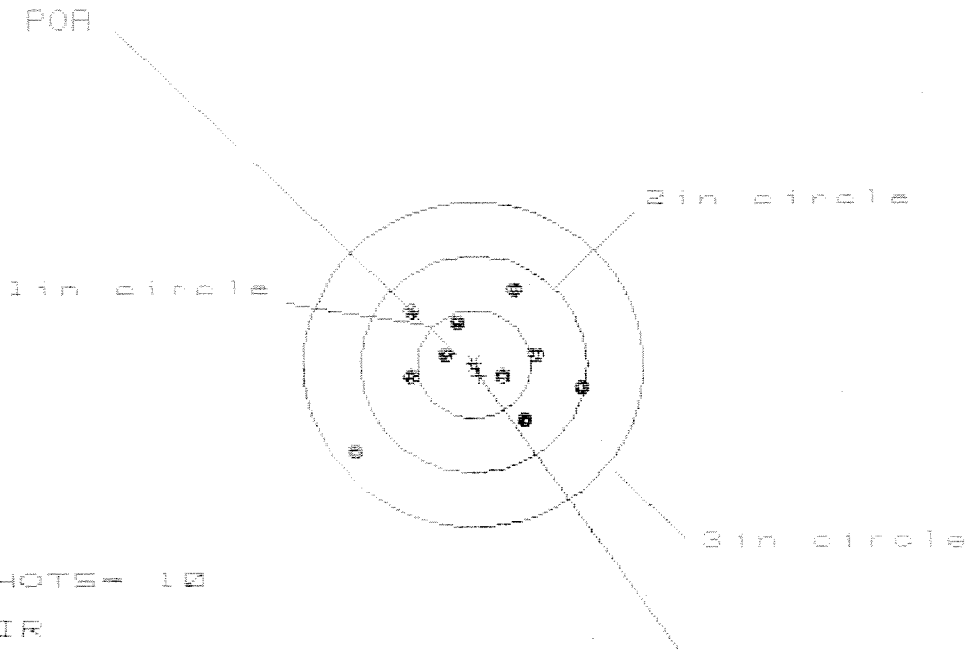
CENTROID *

PATTERN #	4	3	2
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.100	1.020	.960
MINIMUM X	-.718	-.636	-.696
MAXIMUM Y	1.322	1.159	1.031
MINIMUM Y	-1.170	-1.024	-.843
CENTROID X	-.249	-.169	-.109
CENTROID Y	.110	-.037	.091
POA TO CENTROID in.	.272	.173	.142
MIN RADIUS	.528	.695	.627
MEAN RADIUS	.956	.889	.851
MAX RADIUS	1.504	1.263	1.173
HORIZONTAL SPREAD	1.818	1.656	1.656
VERTICAL SPREAD	2.492	2.183	1.874
EXTREME SPREAD	2.512	2.183	2.059
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

22 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611789

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 3

2in = 9

3in = 10

HS= 1.979

VS= 1.502

GS= 2.066

CENTROID *

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.924	.807	.539
MINIMUM X	-1.054	-.655	-.554
MAXIMUM Y	.682	.590	.551
MINIMUM Y	-.820	-.569	-.608
CENTROID X	-.048	.069	-.032
CENTROID Y	.106	.198	.237
POA TO CENTROID in.	.117	.209	.239
MIN RADIUS	.252	.218	.277
MEAN RADIUS	.644	.555	.506
MAX RADIUS	1.336	.866	.737
HORIZONTAL SPREAD	1.978	1.462	1.093
VERTICAL SPREAD	1.502	1.159	1.159
EXTREME SPREAD	2.066	1.620	1.382
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	