

06649101

MODEL 700<sup>TH</sup> M24

Model 545 <sup>TH</sup>

Action

Barrel Length

Capacity

Order No. 5715

\*Includes 1 in chamber.

*Remington*

**Remington**  
MODEL 700™ M24

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

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

SERIAL NO.  
C6649101

ORDER NO.  
5716

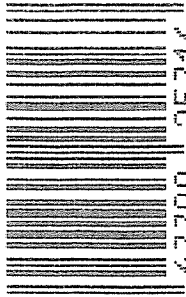
MADE IN LION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

20



5716 C6649101

UPC



0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649101

| OP. #        | OP. NAME                                                       | READINGS | DATE        | INIT |
|--------------|----------------------------------------------------------------|----------|-------------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   | 7 2 9 1  |             | RW   |
| 600          | Proof                                                          | 7 2 9 1  |             | RW   |
| 607          | Check Headspace                                                | 7 2 9 1  |             | RW   |
| 610          | Dis-assemble Gun                                               | 7 2 9 1  |             | RW   |
| 612          | Magnaflux Barrel<br>Action                                     |          | JUL 22 1991 | GS   |
|              | Magnaflux Bolt                                                 |          | JUL 22 1991 | GS   |
| 615          | Rollmark Caliber                                               |          | JUL 22 1991 | GS   |
| 617          | Drill and Tap Sight Holes                                      |          | JUL 22 1991 | LB   |
| 618          | Polish Barrel                                                  |          | 7/22/91     | WB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 7-2-91      | LB   |
|              | Apply Coating (Bolt)                                           |          |             |      |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 8/9/91      | RW   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 8/9/91      | RW   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 8/9/91      | RW   |
|              | D) Oil Firing Pin Ass'y                                        |          | 8/9/91      | RW   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 8-12-91     | JM   |

| op. #        | BARBER - M24 0064838<br>OP. NAME                                  | READINGS |       |       |      |      | DATE    | INIT |
|--------------|-------------------------------------------------------------------|----------|-------|-------|------|------|---------|------|
| 625<br>cont. | F) Safety On Force                                                | 5        | 5     | 5     |      |      | 8-12-91 | SH   |
|              | G) Safety Off Force                                               | 3        | 3     | 3     |      |      | 8-12-91 | SH   |
|              | H) Trigger Pull Test &<br>Retainability                           |          |       |       |      |      | 8-12-91 | SH   |
|              | I) Firing Pin Indent                                              | .0205    | .0205 | .0205 |      |      | 8-12-91 | SH   |
|              | J) Assemble Stock                                                 |          |       |       |      |      | 8-14-91 | RW   |
|              | K) Assemble Swivel Studs                                          |          |       |       |      |      | 8-15-91 | D/H  |
|              | L) Attach Front and Rear<br>Sight Assemblies                      |          |       |       |      |      | 8-14-91 | RW   |
|              | M) Iron Sight Alignment                                           |          |       |       |      |      | 8-14-91 | RW   |
|              | N) Detach Front & Rear<br>Sights & place in<br>numbered container |          |       |       |      |      | 8-14-91 | RW   |
|              | O) Attach Scope to Rifle                                          |          |       |       |      |      | 8-14-91 | RW   |
|              | P) Detach & Attach Scope<br>20 Times                              |          |       |       |      |      | 8-14-91 | RW   |
| 640          | Gallery Target & Test                                             |          |       |       |      |      | 8-14-91 | D/H  |
|              | A) Time                                                           |          |       |       |      |      | 8-14-91 | D/H  |
|              | B) Malfunctions                                                   |          |       |       |      |      | 8-14-91 | D/H  |
|              | C) Pierced Primers                                                |          |       |       |      |      | 8-14-91 | D/H  |
|              | D) Optical Clarity of Scope                                       |          |       |       |      |      | 8-14-91 | D/H  |
| 645          | Inspect for Live Ammo                                             |          |       |       |      |      | 8-14-91 | D/H  |
| 655          | Final Inspection                                                  |          |       |       |      |      |         |      |
|              | A) Headspace                                                      |          |       |       |      |      | 8-15-91 | D/H  |
|              | B) Trigger Pull                                                   | 2.48     | 2.52  | 2.65  | 2.23 | 2.32 | 8-14-91 | SH   |
|              | C) Function                                                       |          |       |       |      |      | 8-15-91 | D/H  |
| 660          | Pack                                                              |          |       |       |      |      | 7-17-91 | D/H  |

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6649101DATE 8-12-91TESTER JL

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.38             | 2.48                     | 2.46                           | 2.48 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.42             | 2.45                     | 2.50                           | 2.52 |                                                                        |
| PULL #3 | 2.39             | 2.40                     | 2.47                           | 2.65 |                                                                        |
| PULL #4 | 2.38             | 2.47                     | 2.44                           | 2.23 |                                                                        |
| PULL #5 | 2.40             | 2.46                     | 2.47                           | 2.32 |                                                                        |
| TOTAL   |                  |                          |                                |      |                                                                        |
| AVG.    |                  |                          |                                |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.66             | 3.47                     |  |          |
| PULL #2 | 3.54             | 3.24                     |  |          |
| PULL #3 | 3.49             | 3.55                     |  |          |
| PULL #4 | 3.50             | 3.57                     |  |          |
| PULL #5 | 3.51             | 3.49                     |  |          |
| TOTAL   |                  |                          |  |          |
| AVG.    |                  |                          |  |          |

|         | 4.00#<br>INITIAL | 4.00# AFTER<br>20 CYCLES | MAX SETTING<br>GREATER THAN 4# | RESET TO 4# FOR<br>TARGET & ACCURACY |
|---------|------------------|--------------------------|--------------------------------|--------------------------------------|
| PULL #1 | 4.42             | 4.44                     |                                | 4.61                                 |
| PULL #2 | 4.44             | 4.58                     |                                | 4.61                                 |
| PULL #3 | 4.47             | 4.47                     |                                | 4.48                                 |
| PULL #4 | 4.47             | 4.57                     |                                | 4.65                                 |
| PULL #5 | 4.51             | 4.57                     |                                | 4.54                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6649101  
23 Aug 1991

CENTROIDAL DISTANCES

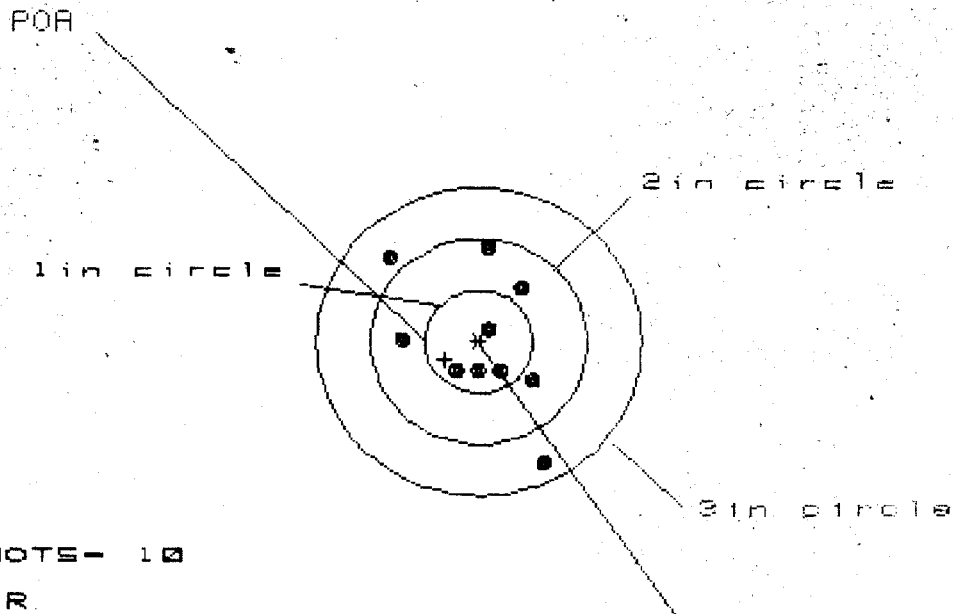
|      |   |         |
|------|---|---------|
| 0 TO | 1 | .359205 |
| 1 TO | 2 | .44801  |
| 1 TO | 3 | .153444 |
| 1 TO | 4 | .310757 |
| 1 TO | 5 | .196229 |

201 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1144  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1048  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .155140  
THE AMR FOR THIS RIFLE IS: .7984

FILE:/PATTERNING/CENTERFIRE\_PATT/06649101

## CENTERFIRE PATTERNS # 1



# OF SHOTS- 10

# IN CIR

1 in = 4

2 in = 8

3 in = 10

HS = 1.419

VS = 2.108

GS = 2.460

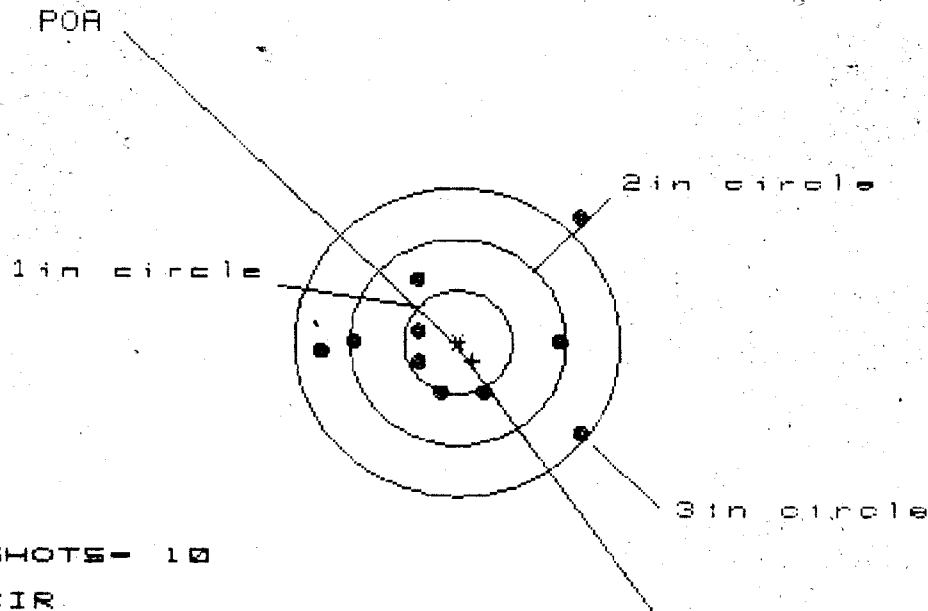
CENTROID #

| PATTERN #                     | 1      | 2     | 3     |
|-------------------------------|--------|-------|-------|
| SHOTS (BEST OF)               | 10     | 9     | 8     |
| MAXIMUM X                     | .573   | .510  | .412  |
| MINIMUM X                     | -.846  | -.782 | -.717 |
| MAXIMUM Y                     | .968   | .841  | .934  |
| MINIMUM Y                     | -1.140 | -.511 | -.418 |
| CENTROID X                    | .312   | .248  | .346  |
| CENTROID Y                    | .178   | .305  | .212  |
| POA TO CENTROID in.           | .359   | .393  | .406  |
| MIN RADIUS                    | .116   | .161  | .069  |
| MEAN RADIUS                   | .653   | .603  | .505  |
| MAX RADIUS                    | 1.276  | 1.078 | .935  |
| HORIZONTAL SPREAD             | 1.419  | 1.292 | 1.129 |
| VERTICAL SPREAD               | 2.108  | 1.352 | 1.352 |
| EXTREME SPREAD                | 2.460  | 1.800 | 1.399 |
| NUMBER IN ONE INCH CIRCLE =   | 4      |       |       |
| NUMBER IN TWO INCH CIRCLE =   | 8      |       |       |
| NUMBER IN THREE INCH CIRCLE = | 10     |       |       |

71 000 1991

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## CENTERFIRE PATTERNS # 2



# OF SHOTS- 10

# IN CIR

1 in = 2

2 in = 7

3 in = 9

HS= 2.349

VS= 2.120

GS= 2.693

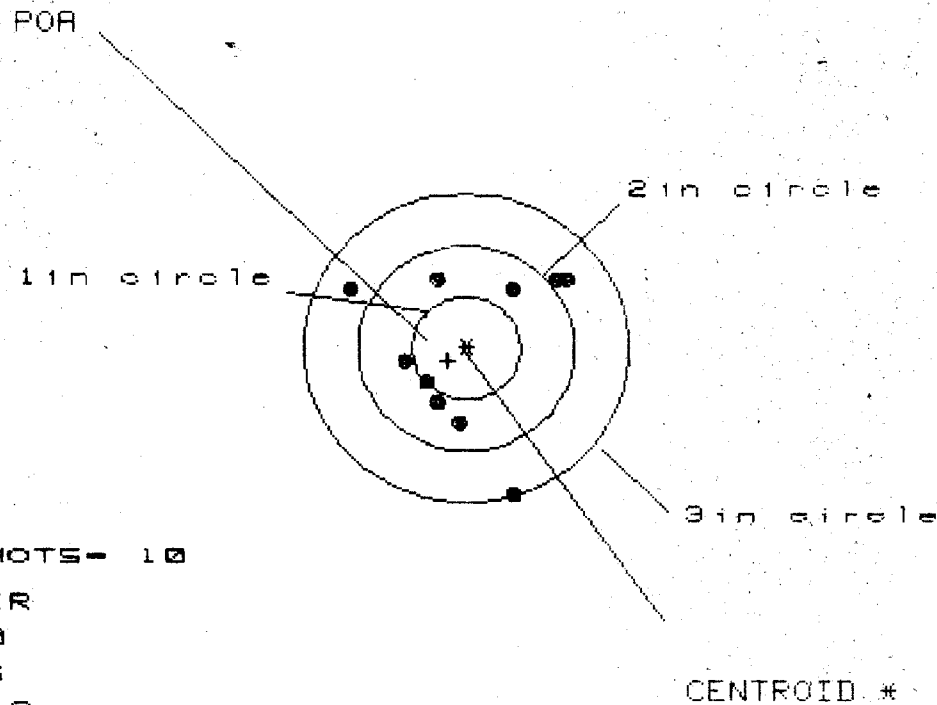
CENTROID #

| PATTERN #                   | : | 10     | 9      | 8     |
|-----------------------------|---|--------|--------|-------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | 1.132  | 1.217  | 1.189 |
| MINIMUM X                   | : | -1.217 | -1.091 | -.939 |
| MAXIMUM Y                   | : | 1.216  | .793   | .697  |
| MINIMUM Y                   | : | -.904  | -.769  | -.461 |
| CENTROID X                  | : | -.136  | -.262  | -.414 |
| CENTROID Y                  | : | .181   | .046   | .142  |
| POA TO CENTROID in.         | : | .226   | .266   | .437  |
| MIN RADIUS                  | : | .365   | .284   | .173  |
| MEAN RADIUS                 | : | .876   | .752   | .634  |
| MAX RADIUS                  | : | 1.661  | 1.439  | 1.193 |
| HORIZONTAL SPREAD           | : | 2.349  | 2.308  | 2.128 |
| VERTICAL SPREAD             | : | 2.120  | 1.562  | 1.158 |
| EXTREME SPREAD              | : | 2.693  | 2.443  | 2.134 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 7      |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |       |

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## CENTERFIRE PATTERNS # 3



# OF SHOTS- 10

# IN CIR

1 in = 0

2 in = 6

3 in = 10

HS= 1.976

VS= 2.133

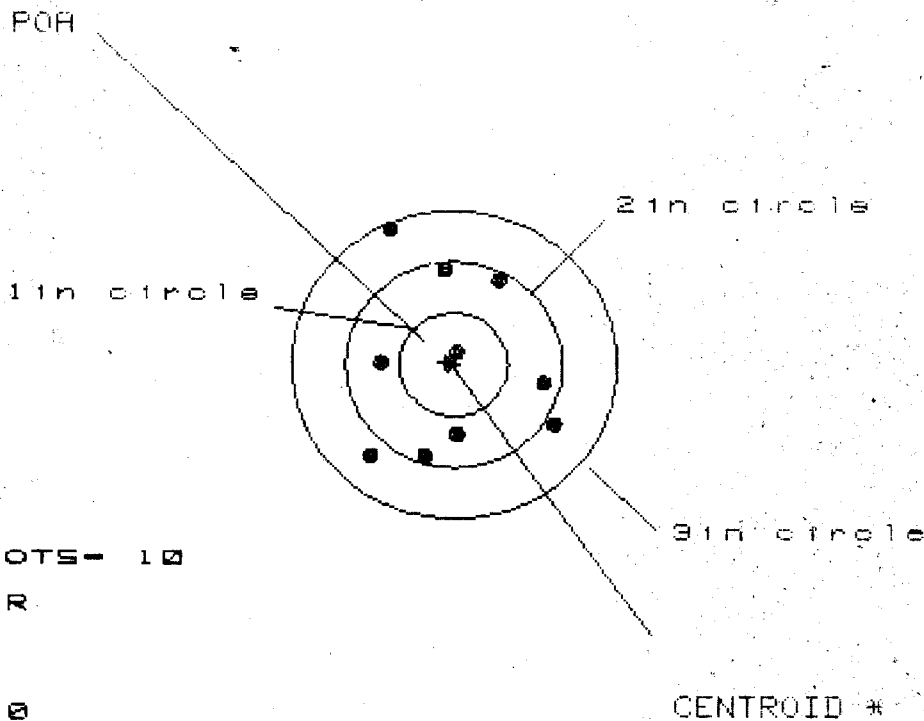
GS= 2.478

| PATTERN #                     | 1      | 2      | 3     |
|-------------------------------|--------|--------|-------|
| SHOTS (BEST OF)               | 10     | 9      | 8     |
| MAXIMUM X                     | .887   | .930   | .799  |
| MINIMUM X                     | -1.089 | -1.046 | -.609 |
| MAXIMUM Y                     | .686   | .525   | .573  |
| MINIMUM Y                     | -1.447 | -.904  | -.856 |
| CENTROID X                    | .168   | .125   | .256  |
| CENTROID Y                    | .125   | .286   | .238  |
| POA TO CENTROID in.           | .210   | .312   | .350  |
| MIN RADIUS                    | .510   | .556   | .633  |
| MEAN RADIUS                   | .879   | .804   | .765  |
| MAX RADIUS                    | 1.498  | 1.114  | .964  |
| HORIZONTAL SPREAD             | 1.976  | 1.976  | 1.408 |
| VERTICAL SPREAD               | 2.133  | 1.429  | 1.429 |
| EXTREME SPREAD                | 2.478  | 1.979  | 1.712 |
| NUMBER IN ONE INCH CIRCLE =   | 0      |        |       |
| NUMBER IN TWO INCH CIRCLE =   | 6      |        |       |
| NUMBER IN THREE INCH CIRCLE = | 10     |        |       |

28 Aug 1981

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## CENTERFIRE PATTERNS # 4



# OF SHOTS- 10

# IN CIR

1in = 1

2in = 7

3in = 10

HS= 1.747

VS= 2.228

GS= 2.462

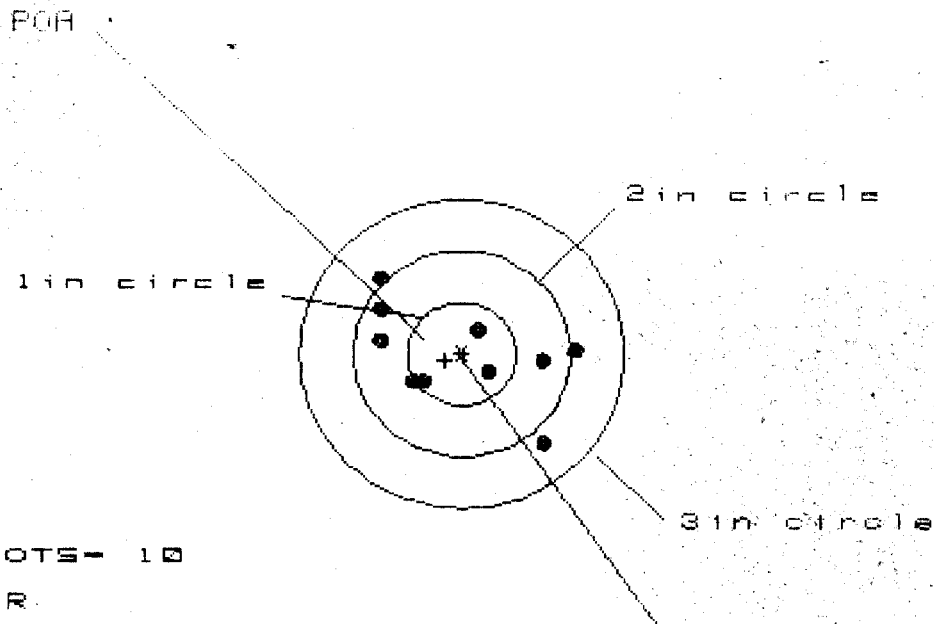
CENTROID \*

| PATTERN #                     | 10    | 9     | 8     |
|-------------------------------|-------|-------|-------|
| SHOTS (BEST OF)               | 10    | 9     | 8     |
| MAXIMUM X                     | .952  | .888  | .780  |
| MINIMUM X                     | -.795 | -.859 | -.802 |
| MAXIMUM Y                     | 1.323 | 1.050 | .961  |
| MINIMUM Y                     | -.905 | -.758 | -.847 |
| CENTROID X                    | .075  | .139  | .247  |
| CENTROID Y                    | -.023 | -.170 | -.081 |
| POA TO CENTROID in.           | .078  | .220  | .260  |
| MIN RADIUS                    | .152  | .282  | .218  |
| MEAN RADIUS                   | .877  | .807  | .759  |
| MAX RADIUS                    | 1.444 | 1.114 | .996  |
| HORIZONTAL SPREAD             | 1.747 | 1.747 | 1.582 |
| VERTICAL SPREAD               | 2.228 | 1.808 | 1.808 |
| EXTREME SPREAD                | 2.462 | 2.090 | 1.855 |
| NUMBER IN ONE INCH CIRCLE =   | 1     |       |       |
| NUMBER IN TWO INCH CIRCLE =   | 7     |       |       |
| NUMBER IN THREE INCH CIRCLE = | 10    |       |       |

02 Aug 1991

FILE: PATTERNING/CENTERFIRE\_PATT/06649101

## CENTERFIRE PATTERNS # 5



# OF SHOTS- 10

# IN CIR.

1in = 4

2in = 7

3in = 10

HS= 1.827

VS= 1.583

GS= 2.150

CENTROID \*

| PATTERN #                     | 10    | 9     | 8     |
|-------------------------------|-------|-------|-------|
| SHOTS (BEST OF)               | 10    | 9     | 8     |
| MAXIMUM X                     | 1.073 | 1.152 | 1.013 |
| MINIMUM X                     | -.754 | -.675 | -.531 |
| MAXIMUM Y                     | .722  | .626  | .624  |
| MINIMUM Y                     | -.861 | -.362 | -.364 |
| CENTROID X                    | .153  | .074  | -.070 |
| CENTROID Y                    | .063  | .159  | .161  |
| POA TO CENTROID in.           | .165  | .175  | .176  |
| MIN RADIUS                    | .243  | .231  | .335  |
| MEAN RADIUS                   | .707  | .657  | .579  |
| MAX RADIUS                    | 1.116 | 1.152 | 1.024 |
| HORIZONTAL SPEED              | 1.827 | 1.827 | 1.544 |
| VERTICAL SPEED                | 1.583 | .988  | .988  |
| EXTREME SPEED                 | 2.150 | 1.930 | 1.721 |
| NUMBER IN ONE INCH CIRCLE =   | 4     |       |       |
| NUMBER IN TWO INCH CIRCLE =   | 7     |       |       |
| NUMBER IN THREE INCH CIRCLE = | 10    |       |       |