

05649154

MODEL 700™ M24

Model 545™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

Remington[®] **DUPONT**
REG. U.S. PAT. & TM. OFF.

MODEL 700TM M24

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

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

SERIAL NO.
C6649164

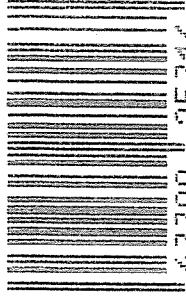
ORDER NO.
5716

20



5716 C6649164

UPC



0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GFM

GUN SERIAL #

C6649164

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		7/24/91	KL
600	Proof		7/24/91	KL
607	Check Headspace		7/24/91	KL
610	Dis-assemble Gun		7/24/91	KL
612	Magnaflux Barrel Action		AUG 7 1991	KR
	Magnaflux Bolt		AUG 7 1991	KR
615	Rollmark Caliber		AUG 7 1991	GB
617	Drill and Tap Sight Holes		AUG 7 1991	FB
618	Polish Barrel		AUG 13 1991	W.B
620	Apply Coatings (Barrel Action)		8-27-91	KL
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/29/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/29/91	KL
	C) Inspect Ejector Hole for Chamfer		8/29/91	KL
	D) Oil Firing Pin Ass'y		8/29/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		7-3-91	DH

op. #	BARBER M24 0065591	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5½	5	5½			9-3-91	D/H
	G) Safety Off Force	2½	2½	2			9-3-91	D/H
	H) Trigger Pull Test & Retainability						9-3-91	D/H
	I) Firing Pin Indent	.022	.022	.022			9-3-91	D/H
	J) Assemble Stock						9/3/91	✓
	K) Assemble Swivel Studs						9-10-91	D/H
	L) Attach Front and Rear Sight Assemblies						9/3/91	✓
	M) Iron Sight Alignment						9/3/91	✓
	N) Detach Front & Rear Sights & place in numbered container						9/3/91	✓
	O) Attach Scope to Rifle						9/3/91	✓
	P) Detach & Attach Scope 20 Times						9/3/91	✓
640	Gallery Target & Test						9-4-91	D/H
	A) Time						9-4-91	D/H
	B) Malfunctions						9-4-91	D/H
	C) Pierced Primers						9-4-91	D/H
	D) Optical Clarity of Scope						9-4-91	D/H
645	Inspect for Live Ammo						9-4-91	D/H
655	Final Inspection							
	A) Headspace						9-10-91	D/H
	B) Trigger Pull	2.49	2.55	2.44	2.55	2.47	9-6-91	✓
	C) Function						9-10-91	D/H
660	Pack						9-18-91	✓

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO

C6649164

DATE

9-3-81

TESTER

JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.52	2.45	2.53	2.49	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.52	2.48	2.52	2.55	
PULL #3	2.59	2.48	2.54	2.66	
PULL #4	2.25	2.48	2.60	2.55	
PULL #5	2.20	2.49	2.56	2.47	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.40	3.40		
PULL #2	3.41	3.42		
PULL #3	3.37	3.37		
PULL #4	3.30	3.39		
PULL #5	3.38	3.26		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.23	3.97		4.26
PULL #2	4.30	4.32		4.07
PULL #3	4.16	4.09		4.11
PULL #4	4.16	4.03		4.05
PULL #5	4.28	4.05		4.09
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06649164
4 Sep 1991

CENTROIDAL DISTANCES

0 TO 1	.162581
1 TO 2	.122674
1 TO 3	.260133
1 TO 4	.319791
1 TO 5	.377139

3
53 (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0648
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1744
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .186049
THE ADP FOR THIS RIFLE IS: .9436

4 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08649164

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

CENTROID X

OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS= 1.971

VS= 2.945

GS= 2.965

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.006	1.049	1.060
MINIMUM X	-.965	-.922	-.911
MAXIMUM Y	1.495	1.334	.940
MINIMUM Y	-1.450	-1.032	-.865
CENTROID X	.065	.022	.011
CENTROID Y	-.149	.012	-.155
POA TO CENTROID in.	.163	.025	.155
MIN RADIUS	.274	.322	.327
MEAN RADIUS	1.038	.974	.925
MAX RADIUS	1.501	1.464	1.360
HORIZONTAL SPREAD	1.971	1.971	1.971
VERTICAL SPREAD	2.945	2.366	1.805
EXTREME SPREAD	2.965	2.551	2.540
NUMBER IN ONE INCH CIRCLE	= 1		
NUMBER IN TWO INCH CIRCLE	= 4		
NUMBER IN THREE INCH CIRCLE	= 9		

4 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08649164

CENTERFIRE PATTERNS # 2

POR

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 8

3 in = 10

HS = 2.020

VS = 1.758

GS = 2.258

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.099	1.006	.658
MINIMUM X	-.921	-1.014	-.888
MAXIMUM Y	.757	.646	.652
MINIMUM Y	-1.001	-.754	-.748
CENTROID X	-.015	.078	-.048
CENTROID Y	-.056	.055	.049
POR TO CENTROID in.	.058	.095	.069
MIN RADIUS	.268	.406	.308
MEAN RADIUS	.739	.671	.619
MAX RADIUS	1.303	1.028	.906
HORIZONTAL SPREAD	2.020	2.020	1.546
VERTICAL SPREAD	1.758	1.400	1.400
EXTREME SPREAD	2.258	2.024	1.581
NUMBER IN ONE INCH CIRCLE	=	3	
NUMBER IN TWO INCH CIRCLE	=	8	
NUMBER IN THREE INCH CIRCLE	=	10	

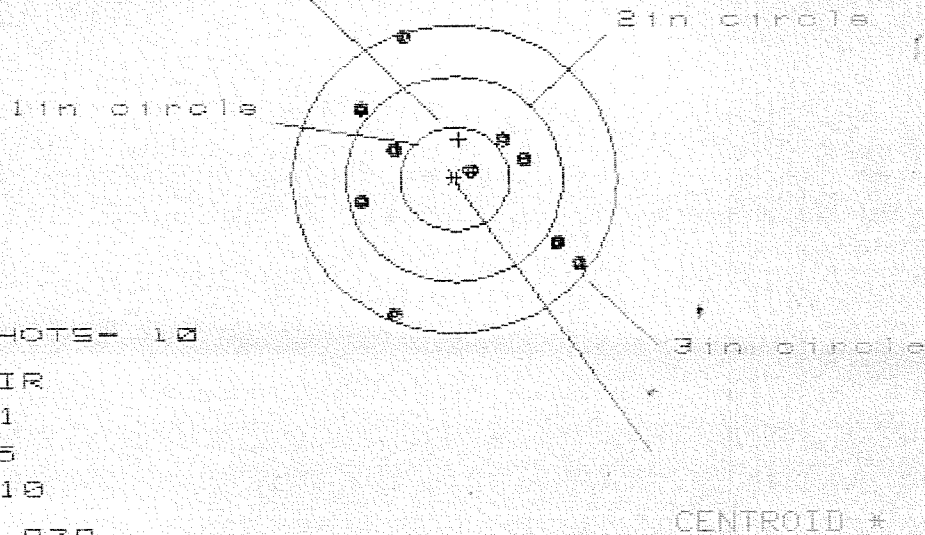
4 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08649184

CENTERFIRE PATTERNS

3

POA



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 1.979

VS= 2.745

CS= 2.747

CENTROID #

PATTERN #

3

SHOTS (BEST OF)

5

10

9

8

MAXIMUM X

5

1.123

1.071

.993

MINIMUM X

5

-.856

-.908

-.986

MAXIMUM Y

5

1.410

.835

.688

MINIMUM Y

5

-1.335

-1.179

-.759

CENTROID X

5

-.040

.012

.090

CENTROID Y

5

-.387

-.543

-.396

POA TO CENTROID in.

5

.389

.543

.406

MIN RADIUS

5

.139

.232

.074

MEAN RADIUS

5

.946

.897

.798

MAX RADIUS

5

1.486

1.334

1.250

HORIZONTAL SPREAD

5

1.979

1.979

1.979

VERTICAL SPREAD

5

2.745

2.014

1.447

EXTREME SPREAD

5

2.747

2.421

2.421

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

5

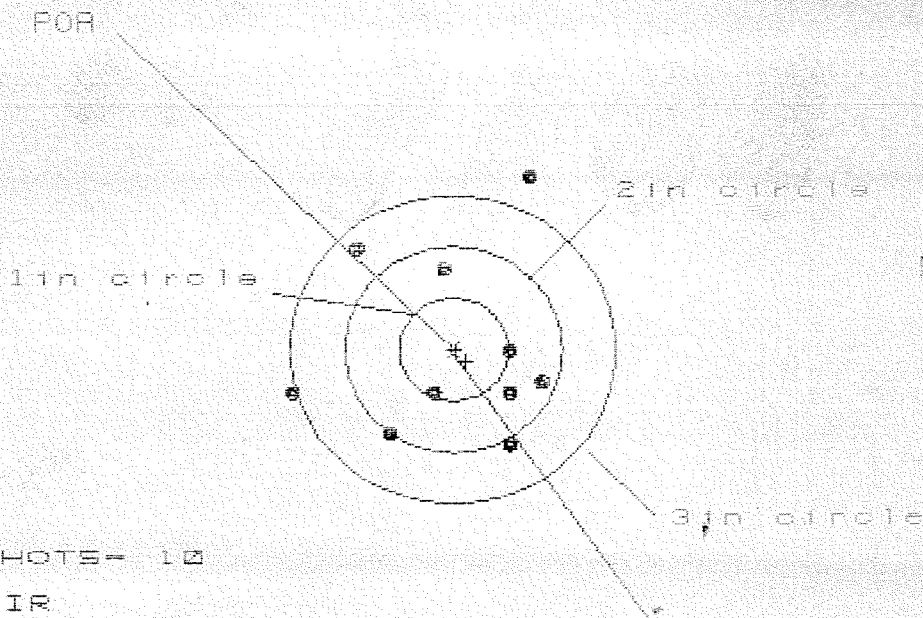
NUMBER IN THREE INCH CIRCLE =

10

4 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649164

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 2.367

VS= 2.546

CS= 3.095

CENTROID *

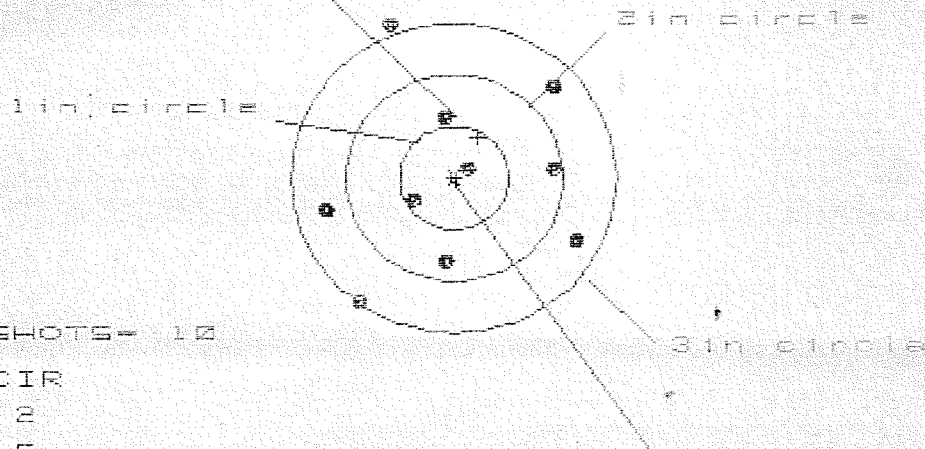
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.841	.925	.745
MINIMUM X	-1.526	-1.442	-.908
MAXIMUM Y	1.640	1.149	1.116
MINIMUM Y	-.906	-.724	-.757
CENTROID X	-.114	-.198	-.018
CENTROID Y	.116	-.066	-.033
POA TO CENTROID in.	.163	.209	.037
MIN RADIUS	.412	.211	.354
MEAN RADIUS	1.012	.896	.797
MAX RADIUS	1.807	1.466	1.490
HORIZONTAL SPREAD	2.367	2.367	1.733
VERTICAL SPREAD	2.546	1.873	1.873
EXTREME SPREAD	3.095	2.370	2.355
NUMBER IN ONE INCH CIRCLE =	1	5	8
NUMBER IN TWO INCH CIRCLE =	5	8	8
NUMBER IN THREE INCH CIRCLE =	8	8	8

4 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PAT/08649164

CENTERFIRE PATTERNS # 5

POB



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS= 2.255

VS= 2.680

GS= 2.764

CENTROID *

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.108

1.041

.925

MINIMUM X

-1.147

-1.214

-1.330

MAXIMUM Y

1.523

1.032

.909

MINIMUM Y

-1.157

-.988

-.755

CENTROID X

-.220

-.153

-.037

CENTROID Y

-.396

-.565

-.442

POB TO CENTROID in.

.453

.586

.443

MIN RADIUS

.146

.235

.112

MEAN RADIUS

.993

.908

.834

MAX RADIUS

1.638

1.366

1.363

HORIZONTAL SPREAD

2.255

2.255

2.255

VERTICAL SPREAD

2.680

2.020

1.664

EXTREME SPREAD

2.764

2.720

2.430

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

5

NUMBER IN THREE INCH CIRCLE =

9