

C5649216

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.

Remington®

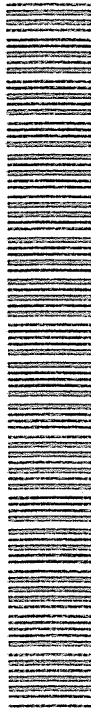
REG. U.S. PAT. & TM. OFF.

MODEL 700™ H24

SERIAL NO.
C6649216

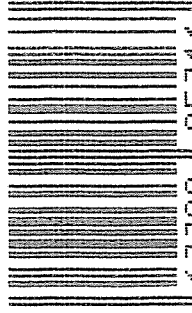
ORDER NO.
5716

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



5716 C6649216

LPC



0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649216

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 27	9 1	RW
600	Proof	6 27	9 1	dw
607	Check Headspace	6 27	9 1	dw
610	Dis-assemble Gun	6 27	9 1	dw
612	Magnaflux Barrel Action		JUL 2 1991	KR
	Magnaflux Bolt		JUL 2 1991	KR
615	Rollmark Caliber		JUL 2 1991	GL
617	Drill and Tap Sight Holes		JUL 2 1991	LB
618	Polish Barrel		JUL 1 7 1991	WB
620	Apply Coatings (Barrel Action)		7-22-91	TS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/23/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/23/91	RW
	C) Inspect Ejector Hole for Chamfer		7/23/91	RW
	D) Oil Firing Pin Ass'y		7/23/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8-8-91	JH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8-8-91	YJ
	G) Safety Off Force	4	4	4			8-8-91	YJ
	H) Trigger Pull Test & Retainability						8-8-91	YJ
	I) Firing Pin Indent	.023	.022	.022			8-8-91	YJ
	J) Assemble Stock						8/9/91	RW
	K) Assemble Swivel Studs						8-13-91	D/H
	L) Attach Front and Rear Sight Assemblies						8/9/91	RW
	M) Iron Sight Alignment						8/9/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/9/91	RW
	O) Attach Scope to Rifle						8/9/91	RW
	P) Detach & Attach Scope 20 Times						8/9/91	RW
640	Gallery Target & Test						8-12-91	AC
	A) Time						8-12-91	AC
	B) Malfunctions						8-12-91	AC
	C) Pierced Primers						8-12-91	AC
	D) Optical Clarity of Scope						8-12-91	AC
645	Inspect for Live Ammo						8-12-91	AC
655	Final Inspection						8-13-91	D/H
	A) Headspace							
	B) Trigger Pull	2.45	2.62	2.65	2.25	2.35	8-13-91	YJ
	C) Function						8-13-91	D/H
660	Pack						9-19-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50#+ .50#
3.00#+ .75#
4.00#+1.00#

SERIAL NO. 06649216

DATE 8-8-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.34	2.60	2.45	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.31	2.35	2.40	2.62	
PULL #3	2.38	2.43	2.53	2.65	
PULL #4	2.31	2.43	2.43	2.25	
PULL #5	2.33	2.42	2.40	2.35	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.54	3.49		
PULL #2	3.47	3.48		
PULL #3	3.48	3.49		
PULL #4	3.48	3.46		
PULL #5	3.47	3.49		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.20	4.44		4.48
PULL #2	4.38	4.44		4.62
PULL #3	4.20	4.49		4.48
PULL #4	4.21	4.49		4.49
PULL #5	4.11	4.60		4.50
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649216
12 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.0696348
1 TO	2	.315824
1 TO	3	.0661891
1 TO	4	.233112
1 TO	5	.677997

5
4
2 <----POA

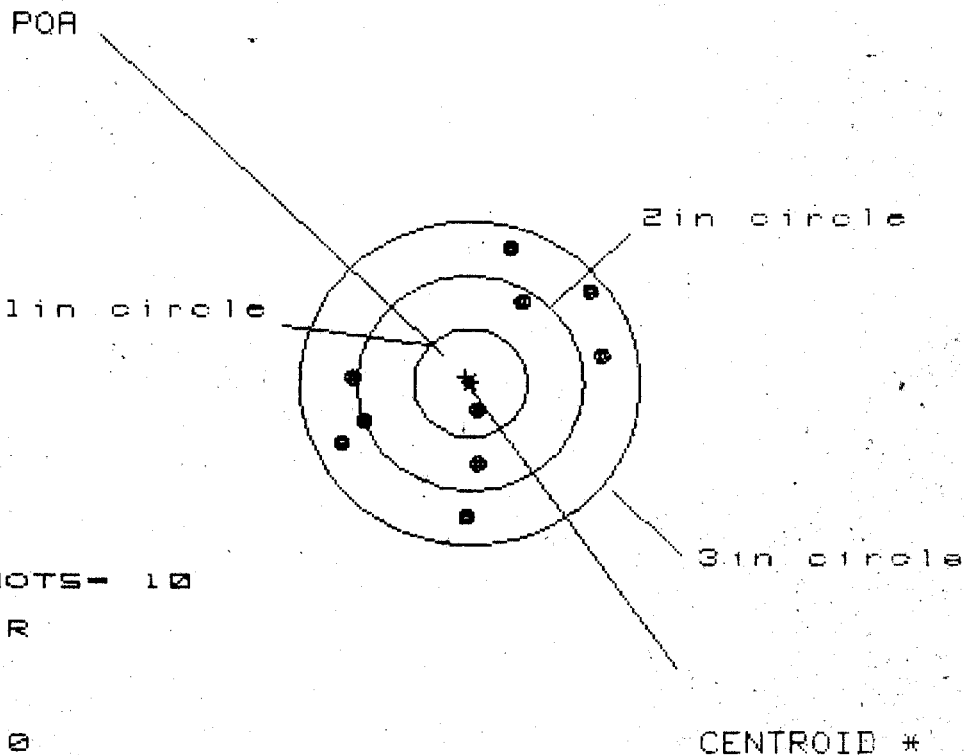
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1028
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.012
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .103499

THE AMR FOR THIS RIFLE IS: .9004

12 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649216

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 10

HS= 2.310

VS= 2.508

GS= 2.617

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.189	1.305	1.315
MINIMUM X	:	-1.121	-1.005	-.995
MAXIMUM Y	:	1.224	1.322	1.174
MINIMUM Y	:	-1.284	-1.186	-.759
CENTROID X	:	.040	-.076	-.086
CENTROID Y	:	-.057	-.154	-.006
POA TO CENTROID in.	:	.069	.172	.086
MIN RADIUS	:	.245	.216	.338
MEAN RADIUS	:	1.026	.968	.950
MAX RADIUS	:	1.368	1.390	1.324
HORIZONTAL SPREAD	:	2.310	2.310	2.310
VERTICAL SPREAD	:	2.508	2.508	1.933
EXTREME SPREAD	:	2.617	2.533	2.442
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

12 Aug 1991

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CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 2.100

VS= 2.740

GS= 2.826

CENTROID *

PATTERN #

	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.777	.779	.869
MINIMUM X	-1.323	-1.321	-1.231
MAXIMUM Y	1.569	1.295	1.171
MINIMUM Y	-1.171	-.997	-1.119
CENTROID X	-.009	-.011	-.101
CENTROID Y	-.369	-.543	-.418
POA TO CENTROID in.	.369	.543	.430
MIN RADIUS	.106	.070	.117
MEAN RADIUS	.934	.842	.803
MAX RADIUS	1.569	1.348	1.239
HORIZONTAL SPREAD	2.100	2.100	2.100
VERTICAL SPREAD	2.740	2.292	2.289
EXTREME SPREAD	2.826	2.516	2.291
NUMBER IN ONE INCH CIRCLE =	1	5	9
NUMBER IN TWO INCH CIRCLE =	5	9	
NUMBER IN THREE INCH CIRCLE =	9		

12 Aug 1991

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CENTERFIRE PATTERNS

3

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.790

VS= 1.716

GS= 2.866

PATTERN #

SHOTS (BEST OF)

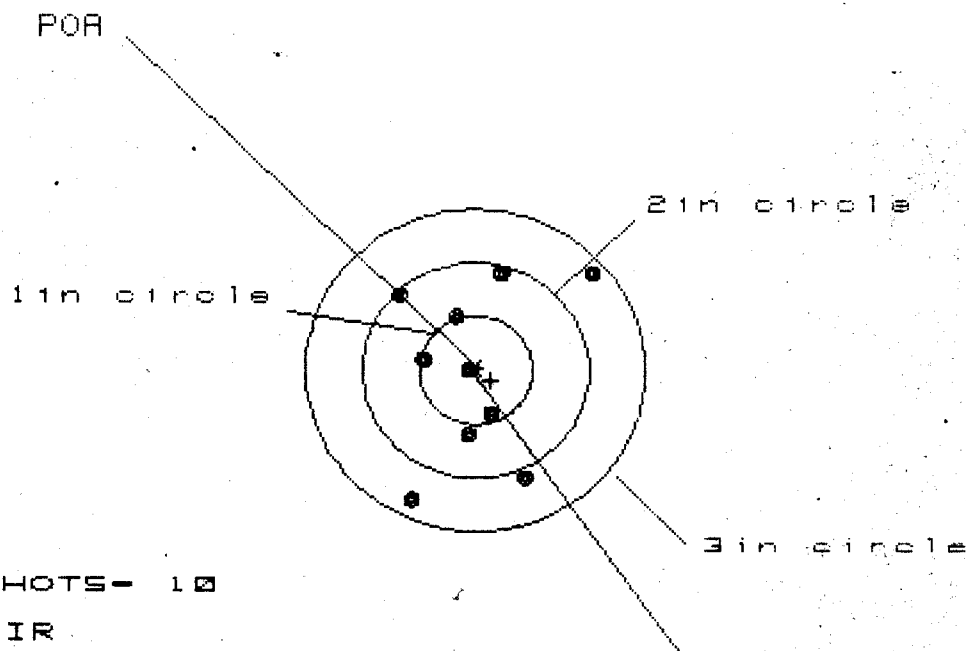
	10	9	8
MAXIMUM X	1.040	.846	.694
MINIMUM X	-1.750	-1.217	-1.177
MAXIMUM Y	.666	.667	.536
MINIMUM Y	-1.050	-1.049	-.529
CENTROID X	.106	.300	.452
CENTROID Y	-.062	-.063	.068
POA TO CENTROID in.	.122	.307	.457
MIN RADIUS	.140	.124	.238
MEAN RADIUS	.885	.755	.639
MAX RADIUS	1.750	1.607	1.184
HORIZONTAL SPREAD	2.790	2.063	1.871
VERTICAL SPREAD	1.716	1.716	1.065
EXTREME SPREAD	2.866	2.683	1.985
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

12 Aug 1991

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CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 1.685

VS= 2.090

GS= 2.610

CENTROID *

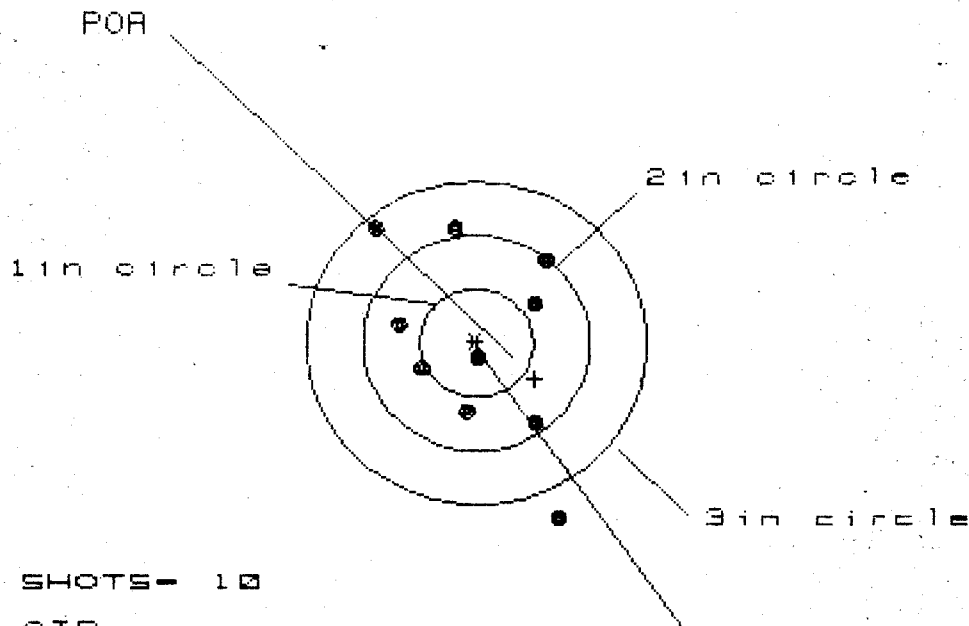
PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.047	.509	.459
MINIMUM X	:	-.638	-.522	-.572
MAXIMUM Y	:	.935	.979	.847
MINIMUM Y	:	-1.155	-1.051	-1.063
CENTROID X	:	-.135	-.251	-.201
CENTROID Y	:	.097	-.007	.125
POR TO CENTROID in.	:	.166	.251	.237
MIN RADIUS	:	.035	.123	.054
MEAN RADIUS	:	.777	.701	.633
MAX RADIUS	:	1.403	1.125	1.158
HORIZONTAL SPREAD	:	1.685	1.031	1.031
VERTICAL SPREAD	:	2.090	2.030	1.910
EXTREME SPREAD	:	2.610	2.180	2.041
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

12 Aug 1991

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CENTERFIRE PATTERNS

5



OF SHOTS- 10

IN CIR

1in - 1

2in - 7

3in = 9

HS- 1.615

VS= 2.732

GS= 3.174

CENTROID #

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.713	.657	.554
MINIMUM X	:	-.902	-.823	-.693
MAXIMUM Y	:	1.103	.922	.953
MINIMUM Y	:	-1.629	-.935	-.820
CENTROID X	:	-.516	-.595	-.492
CENTROID Y	:	.331	.512	.397
POA TO CENTROID in.	:	.613	.785	.632
MIN RADIUS	:	.111	.309	.169
MEAN RADIUS	:	.880	.785	.705
MAX RADIUS	:	1.778	1.236	.978
HORIZONTAL SPREAD	:	1.615	1.480	1.247
VERTICAL SPREAD	:	2.732	1.857	1.773
EXTREME SPREAD	:	3.174	2.357	1.922
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	9		