

06649265

MODEL 760™ M24

Model 545™

Action

Barrel Length

Capacity

Order No. 5715

*Includes 1 in chamber.

Remington



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

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

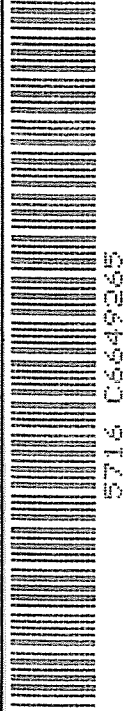
MODEL 700™ M24

SERIAL NO.
C6649265

ORDER NO.
5716

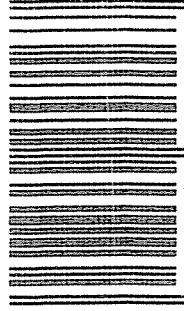
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Trm. Off. Marca Registrada Marque Deposee.



5716 C6649265

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649265

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 25	9 1	RW
600	Proof	6 25	9 1	RW
607	Check Headspace	6 25		RW
610	Dis-assemble Gun			RW
612	Magnaflux Barrel Action	JUL	1 1991	KR
	Magnaflux Bolt	JUL	1 1991	KR
615	Rollmark Caliber	JUL	1 1991	GS.
617	Drill and Tap Sight Holes	JUL	1 1991	EB
618	Polish Barrel	JUL	2 1991	WB
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/25/91	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/25/91	WB
	C) Inspect Ejector Hole for Chamfer		8/25/91	WB
	D) Oil Firing Pin Ass'y		8/25/91	WB
	E) Adjust Trigger Pull to Min Setting and Stake		8/26/91	JU.

Op.	PARADE - M24 M240067104	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/4	5 1/2	5 1/4			8/26/91	OH
	G) Safety Off Force	2	2 1/4	2 1/2			8/26/91	OH
	H) Trigger Pull Test & Retainability						8/26/91	JU
	I) Firing Pin Indent	.021	.020	.021			8/26/91	OH
	J) Assemble Stock							
	K) Assemble Swivel Studs						8-31-91	OH
	L) Attach Front and Rear Sight Assemblies							
	M) Iron Sight Alignment							
	N) Detach Front & Rear Sights & place in numbered container							
	O) Attach Scope to Rifle							
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test						8-31-91	OH
	A) Time						8-31-91	OH
	B) Malfunctions						8-31-91	OH
	C) Pierced Primers						8-31-91	OH
	D) Optical Clarity of Scope						8-31-91	OH
645	Inspect for Live Ammo						8-31-91	OH
655	Final Inspection						8-31-91	OH
	A) Headspace						8-31-91	OH
	B) Trigger Pull	2.45	2.47	2.51	2.53	2.56	8/29/91	OH
	C) Function						8-31-91	OH
660	Pack						9-18-91	N

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6649205DATE 8-26-91TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.42	2.38	2.36	2.45	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.34	2.36	2.30	2.47	
PULL #3	2.32	2.39	2.38	2.51	
PULL #4	2.34	2.29	2.28	2.53	
PULL #5	2.31	2.33	2.36	2.56	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.42	3.24		
PULL #2	3.29	3.35		
PULL #3	3.26	3.33		
PULL #4	3.28	3.31		
PULL #5	3.32	3.22		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.36	4.43		4.29
PULL #2	4.40	4.42		4.44
PULL #3	4.42	4.36		4.40
PULL #4	4.45	4.39		4.37
PULL #5	4.38	4.21		4.38
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
 FOR RIFLE # 06649265
 28 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.394726
1 TO	2	.286007
1 TO	3	.859964
1 TO	4	.453207
1 TO	5	.344494

21
 24+ <----POA

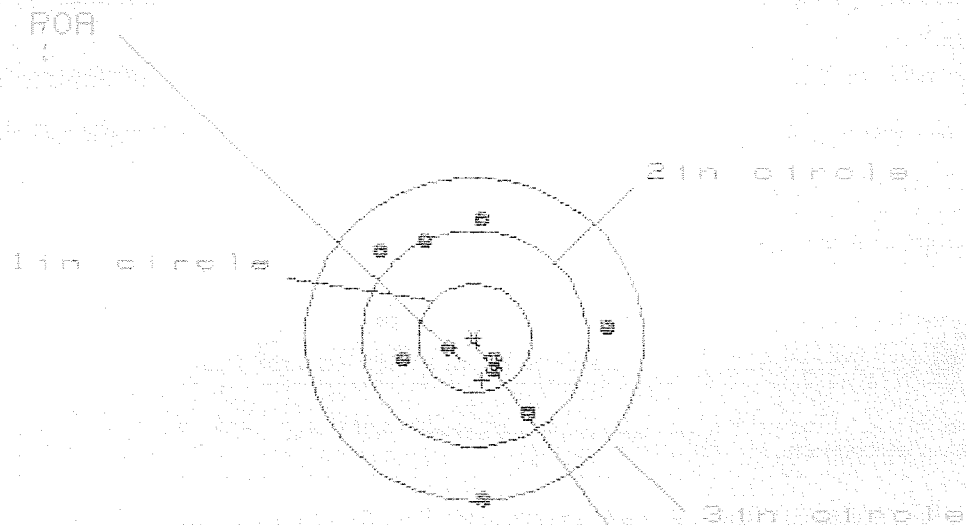
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.397
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .202
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .445436

THE AVE FOR THIS RIFLE IS: .8438

27 Aug 1991

FILE: PATTERNING/CENTERFIRE_PATT/C6649265

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 10

HS= 2.004

VS= 2.647

GS= 2.648

PATTERN #

1

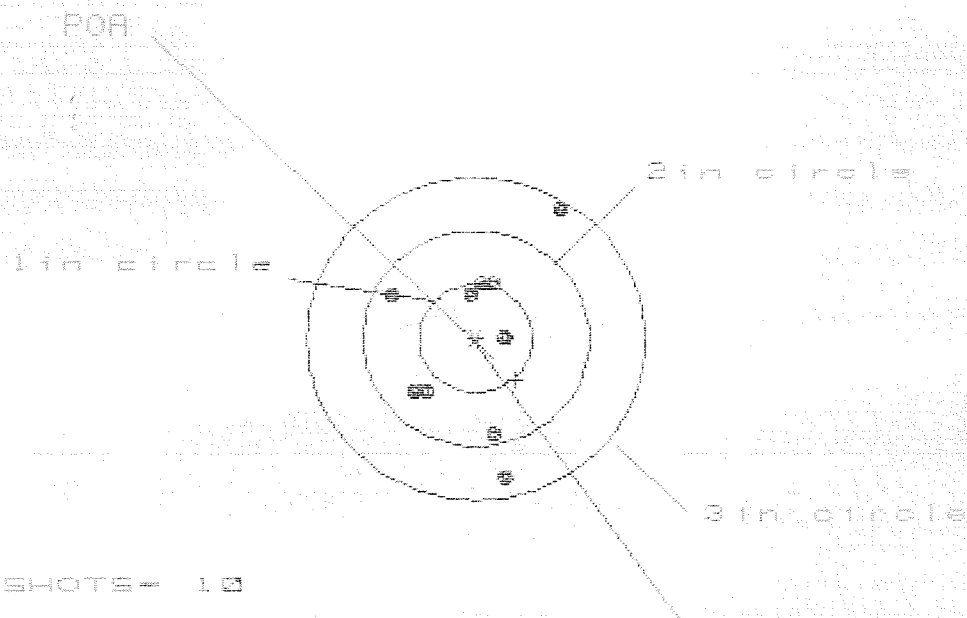
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.122	1.125	1.015
MINIMUM X	-.882	-.879	-.738
MAXIMUM Y	1.153	.987	1.063
MINIMUM Y	-1.494	-.856	-.780
CENTROID X	-.067	-.070	.040
CENTROID Y	.389	.555	.479
FOR TO CENTROID in.	.395	.559	.481
MIN RADIUS	.228	.346	.295
MEAN RADIUS	.828	.774	.716
MAX RADIUS	1.494	1.127	1.063
HORIZONTAL SPREAD	2.004	2.004	1.753
VERTICAL SPREAD	2.647	1.843	1.843
EXTREME SPREAD	2.648	2.112	1.887
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		10	

27 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649265

CENTERFIRE PATTERNS

2



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 8

3 in = 10

HS = 1.493

VS = 2.464

GS = 2.508

PATTERN

2

SHOTS (BEST OF)

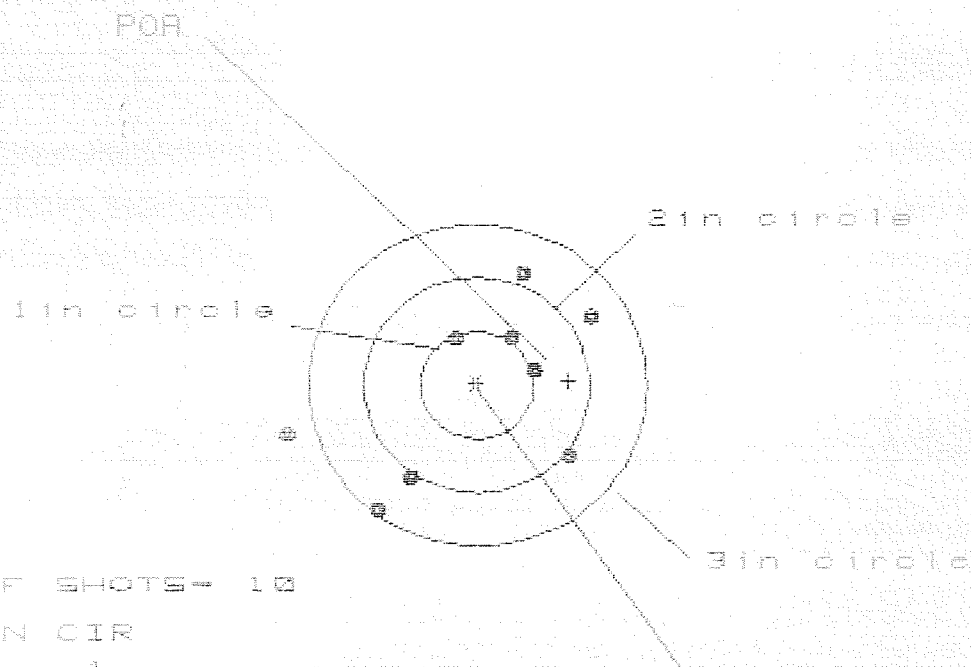
	10	9	8
MAXIMUM X	.728	.372	.415
MINIMUM X	-.765	-.684	-.641
MAXIMUM Y	1.182	.656	.512
MINIMUM Y	-1.282	-1.151	-.870
CENTROID X	-.353	-.434	-.477
CENTROID Y	.387	.256	.400
POA TO CENTROID in.	.524	.504	.622
MIN RADIUS	.292	.391	.404
MEAN RADIUS	.750	.682	.596
MAX RADIUS	1.388	1.200	.926
HORIZONTAL SPREAD	1.493	1.056	1.056
VERTICAL SPREAD	2.464	1.807	1.382
EXTREME SPREAD	2.508	2.001	1.610
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

27 Aug 1997

FILE:/PATTERNING/CENTERFIRE_PATT/C8649265

CENTERFIRE PATTERNS

3



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS = 2.659

VS = 2.252

GS = 2.861

PATTERN #

3

SHOTS (BEST OF)

10

9

8

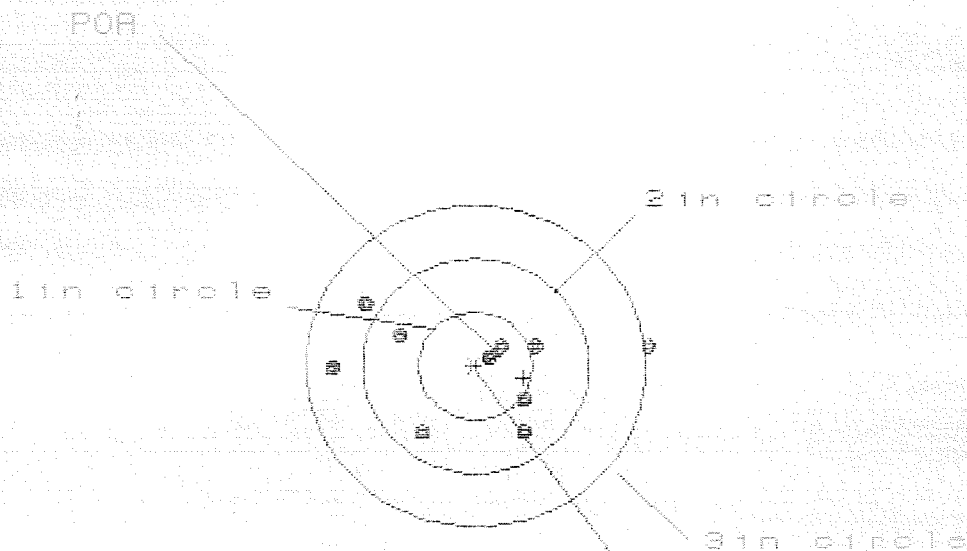
MAXIMUM X	: .982	-.795	-.663
MINIMUM X	: -1.677	-1.062	-.869
MAXIMUM Y	: 1.068	1.018	.864
MINIMUM Y	: -1.184	-1.234	-1.030
CENTROID X	: -.810	-.623	-.491
CENTROID Y	: -.044	.006	.160
POA TO CENTROID in.	: .811	.623	.516
MIN RADIUS	: .455	.335	.190
MEAN RADIUS	: .955	.816	.641
MAX RADIUS	: 1.736	1.628	1.347
HORIZONTAL SPREAD	: 2.659	1.857	1.532
VERTICAL SPREAD	: 2.252	2.252	1.893
EXTREME SPREAD	: 2.861	2.582	2.103
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

27 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649265

CENTERFIRE PATTERNS

4



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS = 2.743

VS = 1.165

GS = 2.743

CENTROID *

PATTERN #

4

SHOTS (BEST OF)

10

9

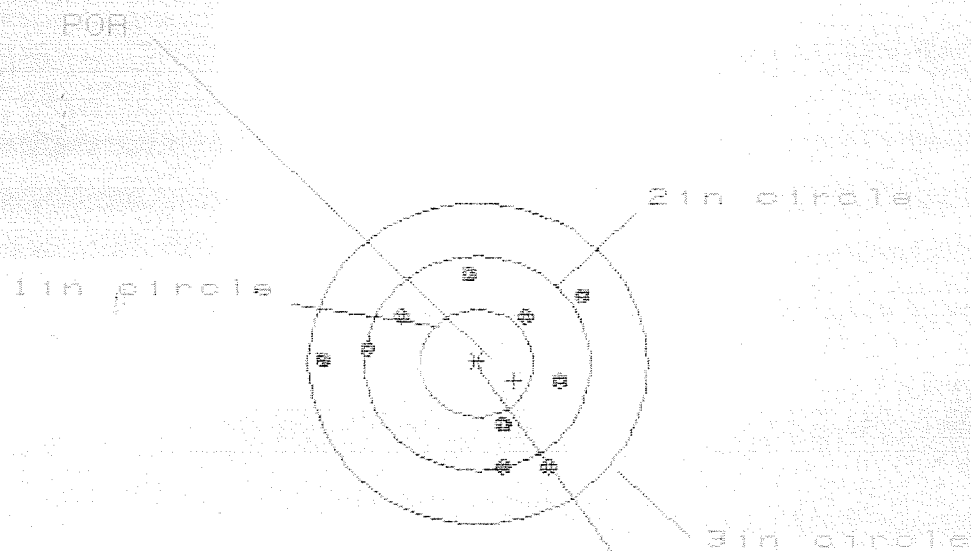
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MAXIMUM X	1.499	.703	.569
MINIMUM X	-1.244	-1.078	-.903
MAXIMUM Y	.558	.582	.589
MINIMUM Y	-.607	-.583	-.576
CENTROID X	-.428	-.594	-.459
CENTROID Y	.115	.091	.084
POA TO CENTROID in.	.443	.601	.457
MIN RADIUS	.205	.366	.248
MEAN RADIUS	.769	.705	.625
MAX RADIUS	1.514	1.079	1.078
HORIZONTAL SPREAD	2.743	1.781	1.471
VERTICAL SPREAD	1.165	1.165	1.165
EXTREME SPREAD	2.749	1.820	1.817
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649265

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1in = 0

2in = 7

3in = 10

HS = 2.358

VS = 1.827

GS = 2.425

CENTROID *

PATTERN # : 5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.958	.802	.636
MINIMUM X	-1.400	-1.114	-1.014
MAXIMUM Y	.870	.876	.954
MINIMUM Y	-.957	-.951	-.873
CENTROID X	-.327	-.171	-.271
CENTROID Y	.163	.157	.079
POA TO CENTROID in.	.365	.232	.283
MIN RADIUS	.578	.496	.504
MEAN RADIUS	.917	.841	.820
MAX RADIUS	1.401	1.126	1.042
HORIZONTAL SPREAD	2.358	1.916	1.650
VERTICAL SPREAD	1.827	1.827	1.827
EXTREME SPREAD	2.425	1.970	1.911
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	