

C6611453

MODEL 700TM M24

Model **545**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

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

MODEL 700™ M24

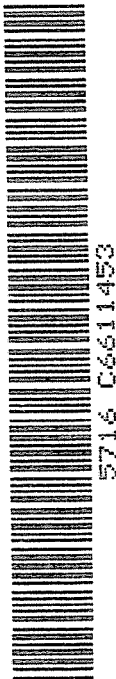
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

SERIAL NO.
C6611453

ORDER NO.
5716

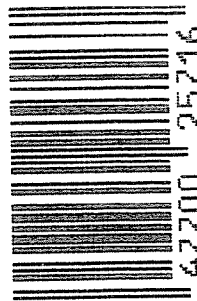
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



5716 C6611453

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611453

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 25	91	RW
600	Proof	3 25	91	RW
607	Check Headspace	3 25	91	RW
610	Dis-assemble Gun	3 25	91	RW
612	Magnaflux Barrel Action	3 28	91	KR
	Magnaflux Bolt	3 28	91	U
615	Rollmark Caliber	3 28	91	LS
617	Drill and Tap Sight Holes	APR	3 1991	LB
618	Polish Barrel	APR	3 1991	LB
620	Apply Coatings (Barrel Action)		4-11-91	JS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/16/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/16/91	RW
	C) Inspect Ejector Hole for Chamfer		4/16/91	RW
	D) Oil Firing Pin Ass'y		4/16/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/6/91	JS

op. #	BARBER - M24 0077117 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5/6/91	JP
	G) Safety Off Force	4	4	4			5/6/91	JP
	H) Trigger Pull Test & Retainability						5/6/91	JP
	I) Firing Pin Indent	.021	.021	.021			5/6/91	JP
	J) Assemble Stock						5/7/91	RW
	K) Assemble Swivel Studs						5-9-91	K
	L) Attach Front and Rear Sight Assemblies						5/7/91	RW
	M) Iron Sight Alignment						5/7/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/7/91	RW
	O) Attach Scope to Rifle						5/7/91	RW
	P) Detach & Attach Scope 20 Times						5/7/91	RW
640	Gallery Target & Test						5/7/91	KJ
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	KT
645	Inspect for Live Ammo						5/7/91	KT
655	Final Inspection							
	A) Headspace						5-9-91	K
	B) Trigger Pull	2.18	2.19	2.22	2.24	2.18	5/9/91	JP
	C) Function						5-9-91	K
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. C-6611453

DATE 5/6/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.26	2.31	2.30	2.18	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.19	2.35	2.29	2.19	
PULL #3	2.28	2.28	2.20	2.22	
PULL #4	2.26	2.29	2.22	2.24	
PULL #5	2.30	2.25	2.19	2.18	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.34	3.30		
PULL #2	3.34	3.41		
PULL #3	3.35	3.42		
PULL #4	3.44	3.44		
PULL #5	3.25	3.32		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.42	4.16		4.23
PULL #2	4.44	4.21		4.23
PULL #3	4.26	4.25		4.16
PULL #4	4.22	4.22		4.29
PULL #5	4.25	4.32		4.25
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06611453
7 May 1991

CENTROIDAL DISTANCES

0 TO	1	.498526
1 TO	2	.920385
1 TO	3	.600616
1 TO	4	.759458
1 TO	5	.304237

$\frac{2}{5} \frac{2}{4}$ <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .3272
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0712
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .334857

THE AMR FOR THIS RIFLE IS: 1.252

7 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611453

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 5

3 in = 7

HS = 2.968

VS = 3.894

GS = 3.493

PATTERN #

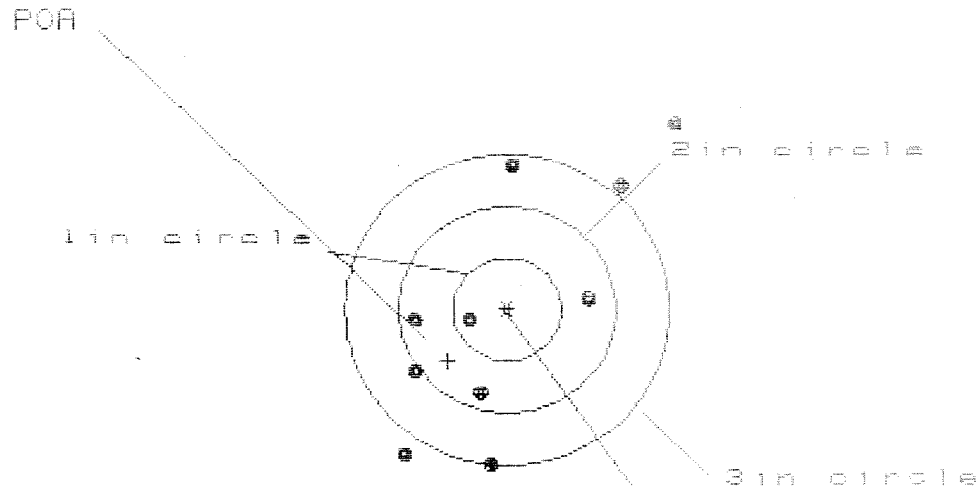
1

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.789	1.761	1.798
MINIMUM X	:	-1.179	-1.207	-.986
MAXIMUM Y	:	1.019	.789	.855
MINIMUM Y	:	-2.075	-1.239	-1.173
CENTROID X	:	.308	.336	.115
CENTROID Y	:	-.392	-.162	-.228
POA TO CENTROID in.	:	.499	.372	.256
MIN RADIUS	:	.241	.294	.271
MEAN RADIUS	:	1.159	1.034	.879
MAX RADIUS	:	2.089	2.006	2.146
HORIZONTAL SPREAD	:	2.968	2.968	2.784
VERTICAL SPREAD	:	3.894	2.028	2.028
EXTREME SPREAD	:	3.493	3.370	3.370
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

7 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06611453

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 6

HE = 2.549

VE = 3.330

GS = 4.137

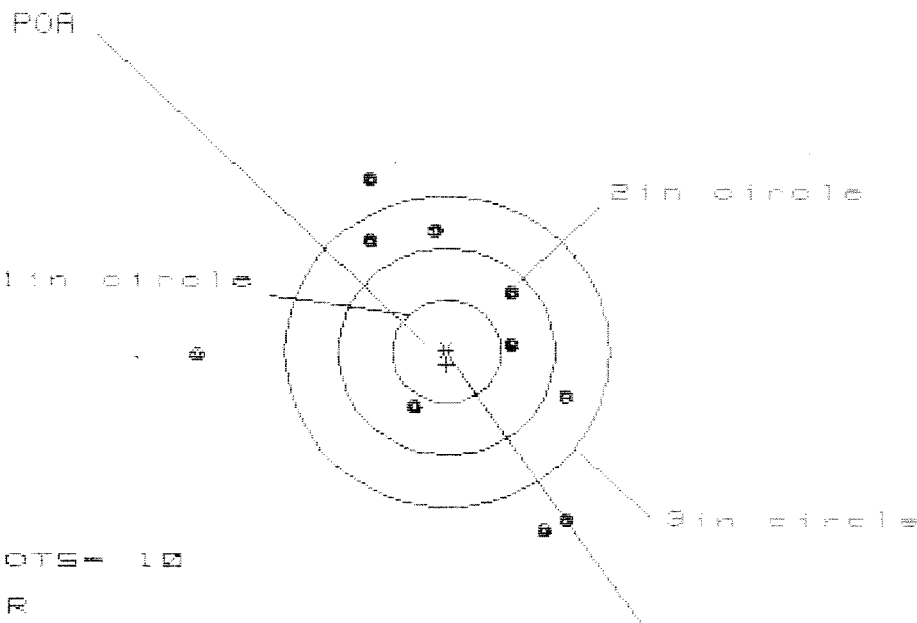
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.559	1.269	1.167
MINIMUM X	-0.990	-0.816	-0.801
MAXIMUM Y	1.822	1.614	1.459
MINIMUM Y	-1.588	-1.305	-1.460
CENTROID X	.550	.376	.478
CENTROID Y	.496	.293	.448
POA TO CENTROID in.	.740	.477	.655
MIN RADIUS	.354	.220	.277
MEAN RADIUS	1.252	1.061	1.029
MAX RADIUS	2.398	1.859	1.677
HORIZONTAL SPREAD	2.549	2.085	1.968
VERTICAL SPREAD	3.330	2.919	2.919
EXTREME SPREAD	4.137	3.327	2.955
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		6	

7 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611453

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 0

2in = 3

3in = 6

HS = 3.401

VS = 3.413

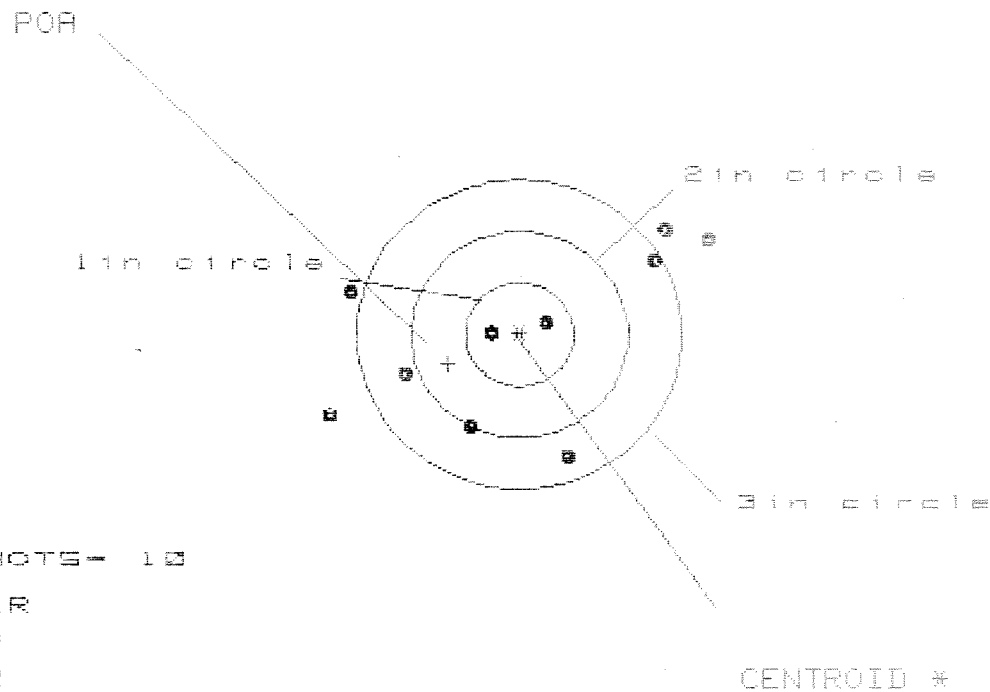
GS = 3.740

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.066
MINIMUM X	-2.335
MAXIMUM Y	1.643
MINIMUM Y	-1.770
CENTROID X	.004
CENTROID Y	.126
POA TO CENTROID in.	.127
MIN RADIUS	.640
MEAN RADIUS	1.363
MAX RADIUS	2.336
HORIZONTAL SPREAD	3.401
VERTICAL SPREAD	3.413
EXTREME SPREAD	3.740
NUMBER IN ONE INCH CIRCLE	0
NUMBER IN TWO INCH CIRCLE	3
NUMBER IN THREE INCH CIRCLE	6

7 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611453

CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1in = 2

2in = 2

3in = 6

HS = 3.519

VS = 2.254

GS = 3.962

PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	1.788
MINIMUM X	-1.731
MAXIMUM Y	1.044
MINIMUM Y	-1.210
CENTROID X	.658
CENTROID Y	.282
POA TO CENTROID in.	.716
MIN RADIUS	.218
MEAN RADIUS	1.251
MAX RADIUS	2.008
HORIZONTAL SPREAD	3.519
VERTICAL SPREAD	2.254
EXTREME SPREAD	3.962
NUMBER IN ONE INCH CIRCLE	2
NUMBER IN TWO INCH CIRCLE	2
NUMBER IN THREE INCH CIRCLE	6

7 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611453

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS - 10

IN CIR

1in = 0

2in = 3

3in = 8

HS = 2.619

VS = 2.451

GS = 3.511

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.424	1.342	1.255
MINIMUM X	-1.195	-1.036	-1.123
MAXIMUM Y	.871	.695	.588
MINIMUM Y	-1.588	-1.561	-1.826
CENTROID X	.116	-.043	.044
CENTROID Y	-.156	.020	.215
POA TO CENTROID in.	.194	.047	.228
MIN RADIUS	.540	.584	.541
MEAN RADIUS	1.237	1.107	1.014
MAX RADIUS	2.128	1.707	1.349
HORIZONTAL SPREAD	2.619	2.378	2.378
VERTICAL SPREAD	2.451	2.256	1.326
EXTREME SPREAD	3.511	3.035	2.529
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	3	
NUMBER IN THREE INCH CIRCLE	=	8	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611453
8 May 1991

CENTROIDAL DISTANCES

0 TO	1	.279158
1 TO	2	.0455412
1 TO	3	.380296
1 TO	4	.255096
1 TO	5	.426517

54 (----) POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .131
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0092
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .131323
THE AMR FOR THIS RIFLE IS: 1.158

8 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06611453.1

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 0

2in = 1

3in = 6

HS = 2.794

VS = 3.914

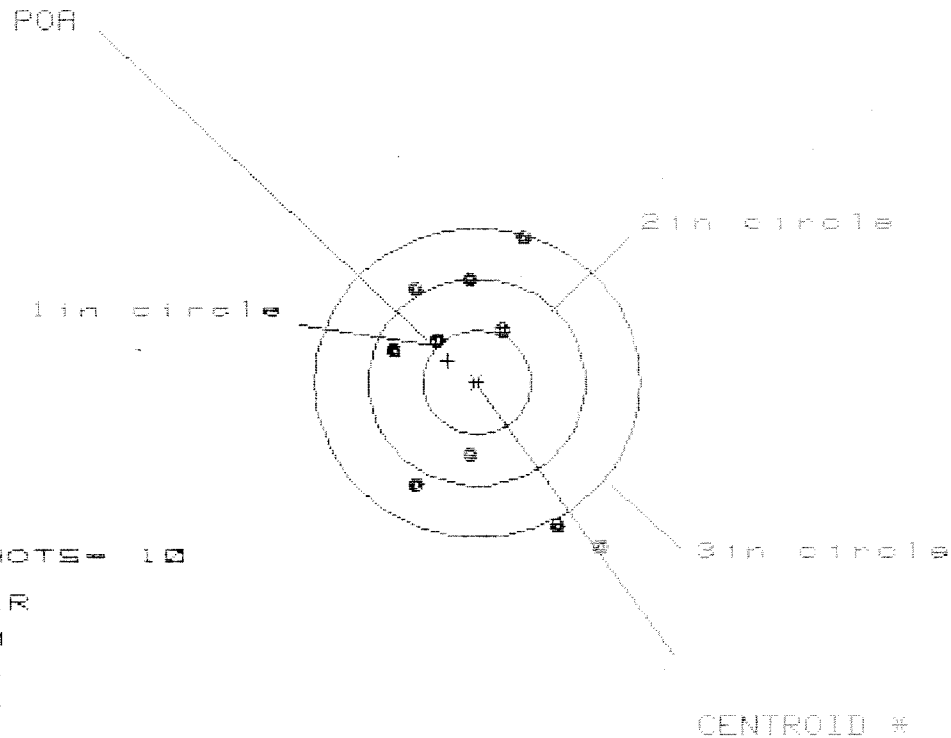
GS = 4.011

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.268	1.355	1.342
MINIMUM X	-1.526	-1.274	-1.287
MAXIMUM Y	2.046	1.982	1.086
MINIMUM Y	-1.868	-1.932	-1.684
CENTROID X	-.070	-.322	-.309
CENTROID Y	-.112	-.047	-.295
POA TO CENTROID in.	.131	.325	.427
MIN RADIUS	.636	.865	.925
MEAN RADIUS	1.479	1.362	1.280
MAX RADIUS	2.340	2.082	1.849
HORIZONTAL SPREAD	3.794	2.629	2.629
VERTICAL SPREAD	3.914	3.914	2.770
EXTREME SPREAD	4.011	4.011	2.901
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		1	
NUMBER IN THREE INCH CIRCLE =		6	

8 May 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 0

2in = 4

3in = 7

HS = 1.948

VS = 3.070

GS = 3.150

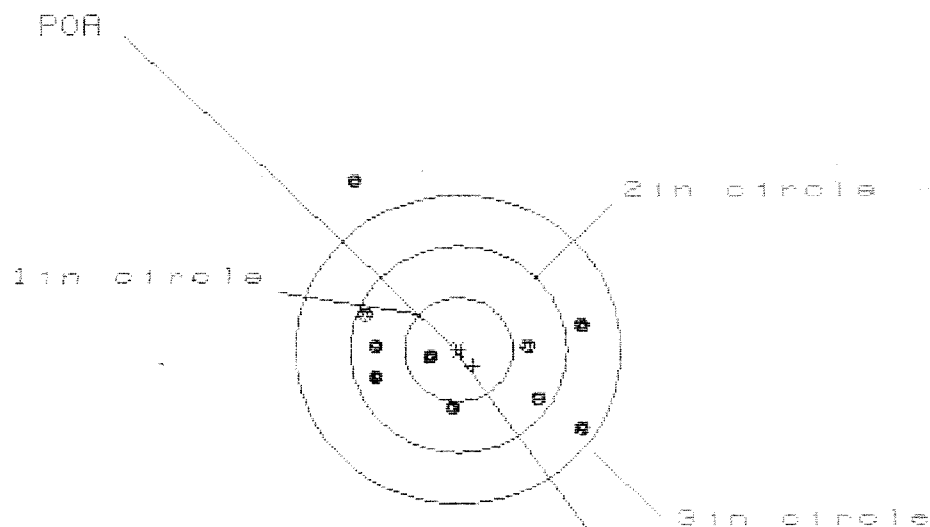
CENTROID #

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.138	.815	.659
MINIMUM X	-.810	-.683	-.582
MAXIMUM Y	1.443	1.263	1.072
MINIMUM Y	-1.627	-1.528	-1.344
CENTROID X	.268	.141	.039
CENTROID Y	-.207	-.027	.164
POA TO CENTROID in.	.339	.144	.169
MIN RADIUS	.554	.359	.176
MEAN RADIUS	1.093	.941	.786
MAX RADIUS	1.985	1.732	1.392
HORIZONTAL SPREAD	1.948	1.498	1.241
VERTICAL SPREAD	3.070	2.791	2.416
EXTREME SPREAD	3.150	2.803	2.622
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		7	

8 May 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 1

2in = 7

3in = 9

HS = 2.083

VS = 2.345

GS = 3.124

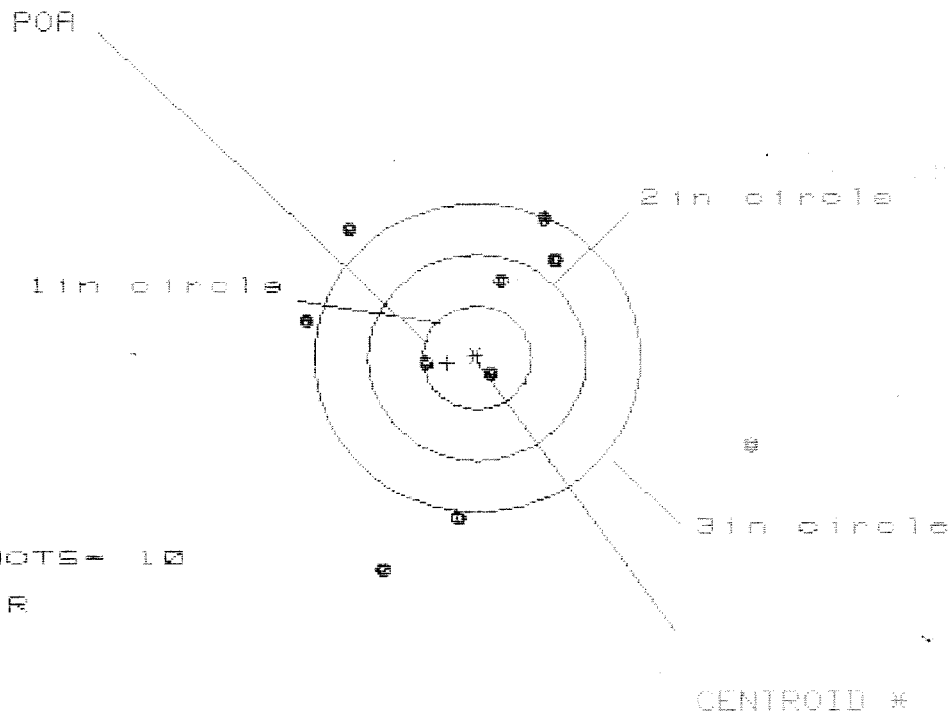
CENTROID *

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.164
MINIMUM X	-.919
MAXIMUM Y	1.597
MINIMUM Y	-.748
CENTROID X	-.136
CENTROID Y	.162
POA TO CENTROID in.	.211
MIN RADIUS	.233
MEAN RADIUS	.935
MAX RADIUS	1.843
HORIZONTAL SPREAD	2.083
VERTICAL SPREAD	2.345
EXTREME SPREAD	3.124
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	7
NUMBER IN THREE INCH CIRCLE =	9

8 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611453.1

CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1in = 2

2in = 3

3in = 4

HS = 4.039

VS = 3.467

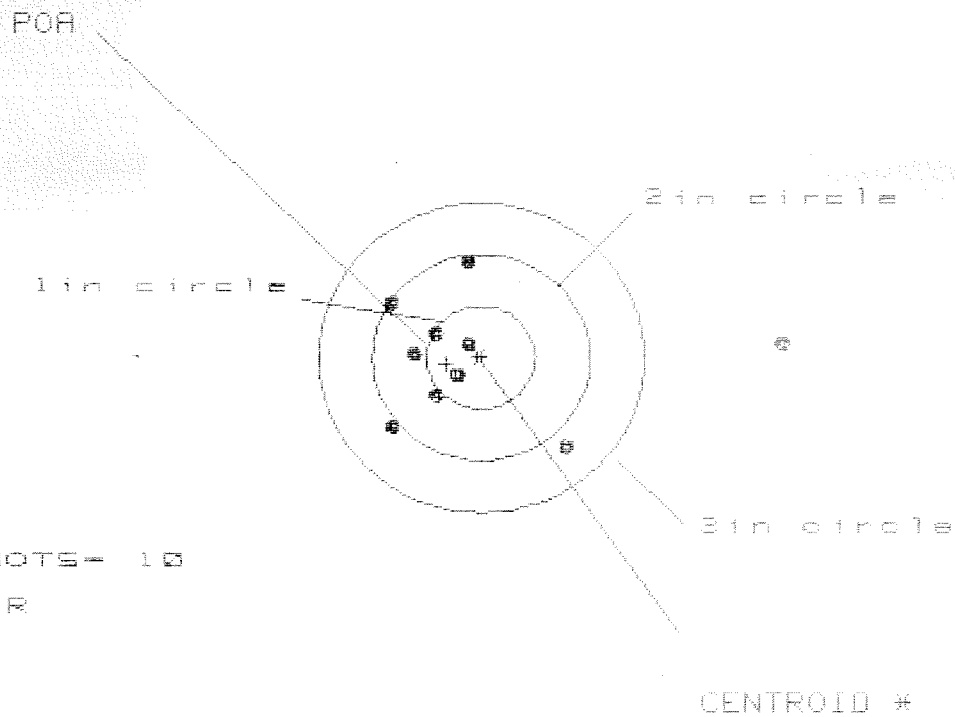
GS = 4.227

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.484	.961	.891
MINIMUM X	:	-1.555	-1.279	-1.349
MAXIMUM Y	:	1.373	1.275	1.001
MINIMUM Y	:	-2.094	-2.192	-1.911
CENTROID X	:	.275	-.001	.069
CENTROID Y	:	.048	.146	.420
POA TO CENTROID in.	:	.279	.146	.425
MIN RADIUS	:	.221	.229	.475
MEAN RADIUS	:	1.390	1.228	1.077
MAX RADIUS	:	2.635	2.262	1.911
HORIZONTAL SPREAD	:	4.039	2.240	2.240
VERTICAL SPREAD	:	3.467	3.467	2.912
EXTREME SPREAD	:	4.227	3.770	3.024
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		4	

8 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C3811453.1

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 3.562

VS= 1.770

GS= 3.643

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	2.771
MINIMUM X	-.791
MAXIMUM Y	.908
MINIMUM Y	-.862
CENTROID X	.318
CENTROID Y	.063
POA TO CENTROID in.	.324
MIN RADIUS	.203
MEAN RADIUS	.894
MAX RADIUS	2.773
HORIZONTAL SPREAD	3.562
VERTICAL SPREAD	1.770
EXTREME SPREAD	3.643
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	7
NUMBER IN THREE INCH CIRCLE =	9