

C6498827

MODEL 700™ M24

Model **S45**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6498827

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 12 90		RW
600	Proof	7 12 90		RW
607	Check Headspace	7 12 90		RW
610	Dis-assemble Gun	8 12 90		RW
612	Magnaflux Barrel Action		7-17-90	KR
	Magnaflux Bolt		7-17-90	KR
615	Rollmark Caliber		7-17-90	LL
617	Drill and Tap Sight Holes		7/23/90	FB
618	Polish Barrel PB		7/24/90	WB
620	Apply Coatings (Barrel Action)		8-6-90	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/8/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/8/90	RW
	C) Inspect Ejector Hole for Chamfer		8/8/90	RW
	D) Oil Firing Pin Ass'y		8/8/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9-5-90	TH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			8/24/90	WB
	G) Safety Off Force	7 1/4	7 1/4	7 1/4			8/24/90	WB
	H) Trigger Pull Test & Retainability						9-5-90	RL
	I) Firing Pin Indent	.0225	.023	.0225			8/24/90	WB
	J) Assemble Stock						8/25/90	RW
	K) Assemble Swivel Studs						9/6/90	RL
	L) Attach Front and Rear Sight Assemblies						8/25/90	RW
	M) Iron Sight Alignment						8/25/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/25/90	RW
	O) Attach Scope to Rifle						8/25/90	RW
	P) Detach & Attach Scope 20 Times						8/25/90	RW
640	Gallery Target & Test						8/24/90	DH
	A) Time						8/24/90	DH
	B) Malfunctions						8/24/90	DH
	C) Pierced Primers						8/24/90	DH
	D) Optical Clarity of Scope						8/24/90	DH
645	Inspect for Live Ammo						8/24/90	DH
655	Final Inspection							
	A) Headspace						9/6/90	RL
	B) Trigger Pull	2.25	2.25	2.11	2.11	2.12	9-5-90	RL
	C) Function						9/6/90	RL
660	Pack						9/20/90	RF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO C6498/827

DATE 9-5-90

TESTER JR.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.17	2.52	2.25	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.29	2.18	2.50	2.25	
PULL #3	2.26	2.23	2.18	2.11	
PULL #4	2.24	2.22	2.22	2.11	
PULL #5	2.28	2.23	2.06	2.12	
TOTAL	11.50	11.03	11.48	10.84	
AVG.	2.3	2.206	2.296	2.168	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.23	3.12		
PULL #2	3.30	3.11		
PULL #3	3.14	3.18		
PULL #4	3.19	3.10		
PULL #5	3.21	3.34		
TOTAL	16.09	15.85		
AVG.	3.218	3.17		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.16	4.20		4.10
PULL #2	4.18	4.18		4.12
PULL #3	4.09	4.23		4.26
PULL #4	4.12	4.21		4.17
PULL #5	4.10	4.28		4.27
TOTAL	20.65	21.10		20.92
AVG.	4.13	4.22		4.184

CENTROIDAL DISTANCES

Ø	TO	1	.494037
1	TO	2	.696003
1	TO	3	.484175
1	TO	4	.826395
1	TO	5	.580858

5 +
1
23
4

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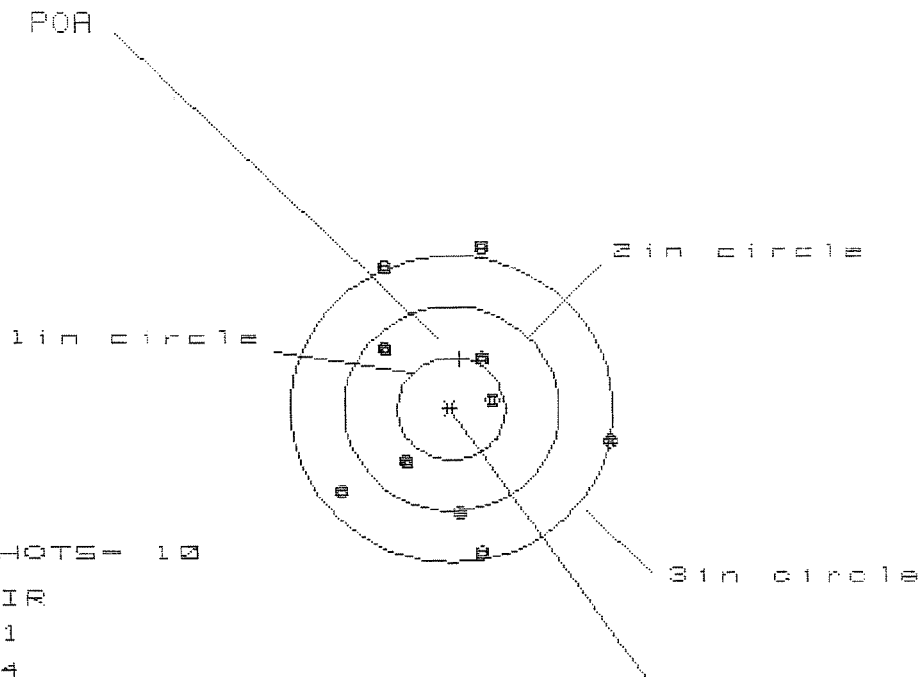
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KINZER V. REMINGTON

M2400008467

28 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06498827

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in - 1

2 in - 4

3 in - 7

HS= 2.529

VS= 3.047

GS= 3.048

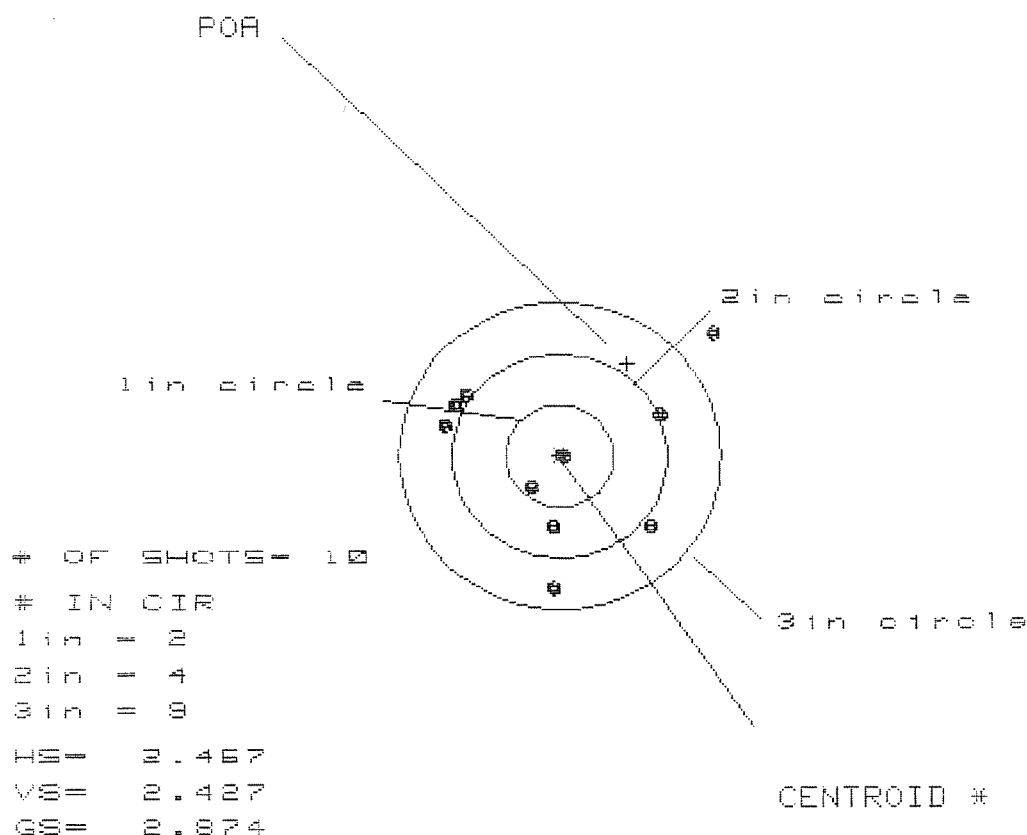
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.514	1.548	.574
MINIMUM X	-1.015	-.981	-.788
MAXIMUM Y	1.627	1.590	1.574
MINIMUM Y	-1.420	-1.239	-1.255
CENTROID X	-.077	-.111	-.304
CENTROID Y	-.488	-.669	-.653
POA TO CENTROID in.	.494	.678	.720
MIN RADIUS	.349	.443	.436
MEAN RADIUS	1.089	1.015	.939
MAX RADIUS	1.656	1.690	1.619
HORIZONTAL SPREAD	2.529	2.529	1.362
VERTICAL SPREAD	3.047	2.829	2.829
EXTREME SPREAD	3.048	2.953	2.953
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

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CENTERFIRE PATTERNS # 2

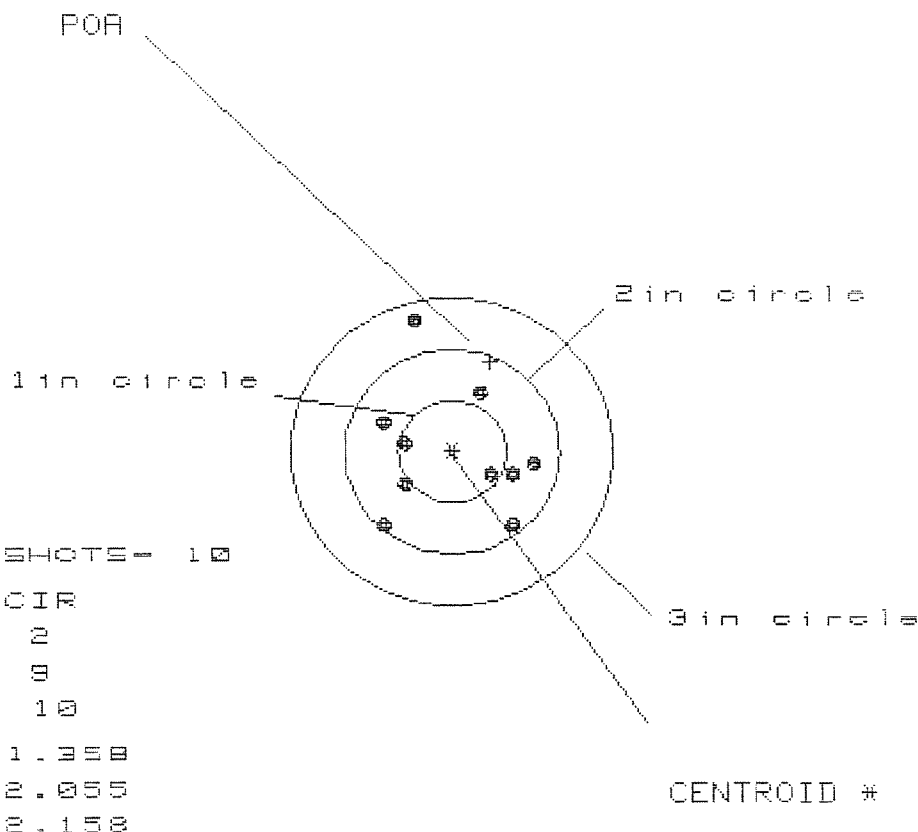


PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.443	1.071	1.079
MINIMUM X	:	-1.024	-.864	-.856
MAXIMUM Y	:	1.173	.754	.614
MINIMUM Y	:	-1.254	-1.124	-.739
CENTROID X	:	-.635	-.795	-.803
CENTROID Y	:	-.904	-1.034	-.894
POA TO CENTROID in.	:	1.105	1.305	1.202
MIN RADIUS	:	.075	.158	.235
MEAN RADIUS	:	.963	.836	.805
MAX RADIUS	:	1.859	1.197	1.280
HORIZONTAL SPREAD	:	2.467	1.935	1.935
VERTICAL SPREAD	:	2.427	1.878	1.353
EXTREME SPREAD	:	2.874	2.215	2.215
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3

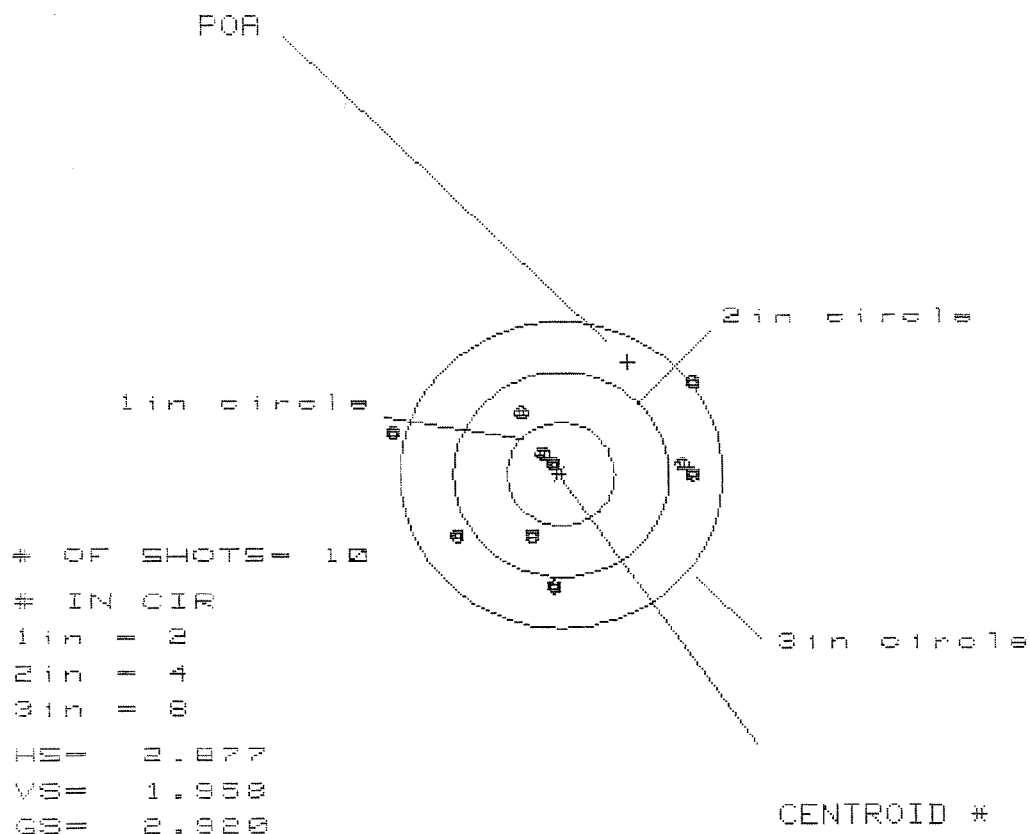


PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.725	.689	.605
MINIMUM X	:	-.633	-.669	-.719
MAXIMUM Y	:	1.292	.706	.628
MINIMUM Y	:	-.763	-.619	-.623
CENTROID X	:	-.357	-.321	-.237
CENTROID Y	:	-.883	-1.027	-.949
POA TO CENTROID in.	:	.952	1.076	.978
MIN RADIUS	:	.430	.350	.294
MEAN RADIUS	:	.735	.654	.608
MAX RADIUS	:	1.332	.912	.810
HORIZONTAL SPREAD	:	1.358	1.358	1.324
VERTICAL SPREAD	:	2.055	1.325	1.251
EXTREME SPREAD	:	2.158	1.603	1.509
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

28 Aug 1990

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CENTERFIRE PATTERNS # 4

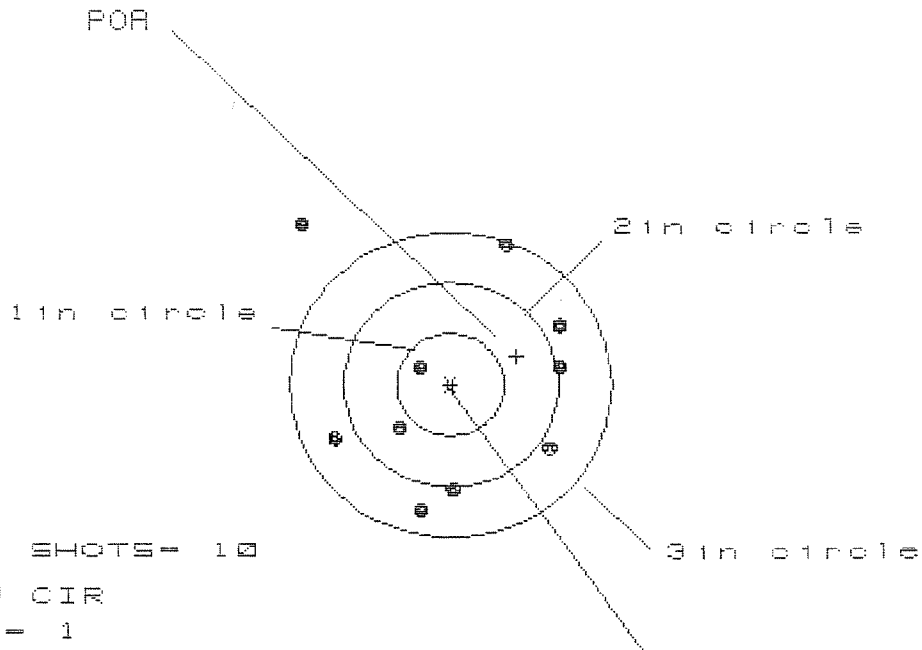


PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.260	1.080	1.192
MINIMUM X	:	-1.617	-1.158	-1.023
MAXIMUM Y	:	.907	.952	.782
MINIMUM Y	:	-1.051	-1.006	-.887
CENTROID X	:	-.629	-.449	-.584
CENTROID Y	:	-1.103	-1.148	-1.267
POA TO CENTROID in.	:	1.270	1.233	1.395
MIN RADIUS	:	.076	.251	.241
MEAN RADIUS	:	.958	.903	.809
MAX RADIUS	:	1.668	1.440	1.207
HORIZONTAL SPREAD	:	2.877	2.238	2.215
VERTICAL SPREAD	:	1.958	1.958	1.669
EXTREME SPREAD	:	2.920	2.706	2.306
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

28 Aug 1998

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 2

3 in = 9

HS= 2.478

VS= 2.858

GS= 3.229

CENTROID *

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.052	.893	.939
MINIMUM X	-1.426	-1.216	-1.170
MAXIMUM Y	1.611	1.508	.930
MINIMUM Y	-1.247	-1.068	-.879
CENTROID X	-.617	-.458	-.504
CENTROID Y	-.274	-.453	-.642
POA TO CENTROID in.	.675	.644	.816
MIN RADIUS	.306	.540	.619
MEAN RADIUS	1.133	1.001	.907
MAX RADIUS	2.152	1.553	1.279
HORIZONTAL SPREAD	2.478	2.109	2.109
VERTICAL SPREAD	2.858	2.576	1.809
EXTREME SPREAD	3.229	2.692	2.321
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	9		

Remington



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

MODEL 700™ M24

SERIAL NO.
C6498827

ORDER NO.
5716

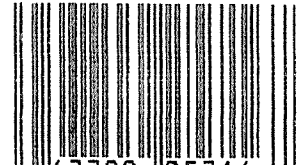
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