

06587633

MODEL 760™ M24

Model **545**™

Action

Barrel Length

Capacity

Order No. **5716**

*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

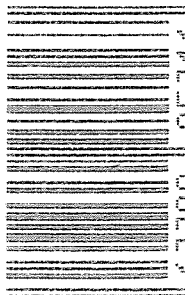
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

SERIAL NO. C6587633	ORDER NO. 5716
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5716 C6587633

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6587633

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	10/31/90	Kd
600	Proof		10/31/90	Kd
607	Check Headspace		10/31/90	Kd
610	Dis-assemble Gun		10/31/90	Kd
612	Magnaflux Barrel Action		11/1/90	KCR
	Magnaflux Bolt		11/1/90	KCR
615	Rollmark Caliber		11/1/90	KCR
617	Drill and Tap Sight Holes		11/5/90	LB
618	Polish Barrel <i>LB</i>		11/6/90	LB
620	Apply Coatings (Barrel Action)		11/26/90	JA
	Apply Coating (Bolt)		11/26/90	JA
625	Final Assembly			
	A) Clean inside of Bolt Assembly		12/28/90	K.S.
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/28/90	K.S.
	C) Inspect Ejector Hole for Chamfer		12/28/90	K.S.
	D) Oil Firing Pin Ass'y		12/28/90	K.S.
	E) Adjust Trigger Pull to Min Setting and Stake		1-3-91	JH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	1.25	2.25	4.50			1/2/91	KJ
	G) Safety Off Force	3.0	3.0	3.0			1/2/91	KJ
	H) Trigger Pull Test & Retainability						1-3-91	JH
	I) Firing Pin Indent	.020	.020	.020			1/2/91	KJ
	J) Assemble Stock						1/3/91	KS
	K) Assemble Swivel Studs						1-15-91	JH
	L) Attach Front and Rear Sight Assemblies						1/3/91	KS
	M) Iron Sight Alignment						1/3/91	KS
	N) Detach Front & Rear Sights & place in numbered container						1/3/91	KS
	O) Attach Scope to Rifle						1/3/91	KS
	P) Detach & Attach Scope 20 Times						1/3/91	KS
640	Gallery Target & Test						1/14/91	KJ
	A) Time						"	KJ
	B) Malfunctions						"	KJ
	C) Pierced Primers						"	KJ
	D) Optical Clarity of Scope						"	KJ
645	Inspect for Live Ammo						1/14/91	KJ
655	Final Inspection							
	A) Headspace						1-15-91	JH
	B) Trigger Pull	2.11	2.27	2.48	2.50	2.33	1-15-91	JH
	C) Function						1-15-91	JH
660	Pack						3-15-91	N

SWS TRIGGER PULL TEST

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

SERIAL NO. C6587633
DATE 1-3-91
TESTER JEL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.23	2.33	2.11	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.37	2.28	2.30	2.27	
PULL #3	2.33	2.30	2.38	2.48	
PULL #4	2.36	2.29	2.27	2.50	
PULL #5	2.30	2.20	2.30	2.33	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.42	3.28		
PULL #2	3.41	3.40		
PULL #3	3.20	3.32		
PULL #4	3.32	3.25		
PULL #5	3.25	3.33		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.27	4.46		4.26
PULL #2	4.26	4.19		4.26
PULL #3	4.28	4.29		4.44
PULL #4	4.18	4.39		4.25
PULL #5	4.44	4.24		4.43
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587633
15 Jan 1991

CENTROIDAL DISTANCES

0 TO	1	.0490918
1 TO	2	.282299
1 TO	3	.251563
1 TO	4	.299095
1 TO	5	.138004

92 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0852
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1032
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .133826

THE AMR FOR THIS RIFLE IS: .9218

15 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CG527633

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 1.633

VS= 2.707

GS= 2.763

CENTROID *

PATTERN #

:

1

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

.693

.681

.539

MINIMUM X

:

-.940

-.952

-.867

MAXIMUM Y

:

1.453

1.073

.949

MINIMUM Y

:

-1.254

-1.092

-1.216

CENTROID X

:

.041

.053

-.032

CENTROID Y

:

.027

-.135

-.011

POA TO CENTROID in.:

:

.049

.145

.034

MIN RADIUS

:

.070

.165

.021

MEAN RADIUS

:

.813

.755

.664

MAX RADIUS

:

1.458

1.202

1.320

HORIZONTAL SPREAD

:

1.633

1.633

1.406

VERTICAL SPREAD

:

2.707

2.165

2.165

EXTREME SPREAD

:

2.763

2.216

2.216

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

7

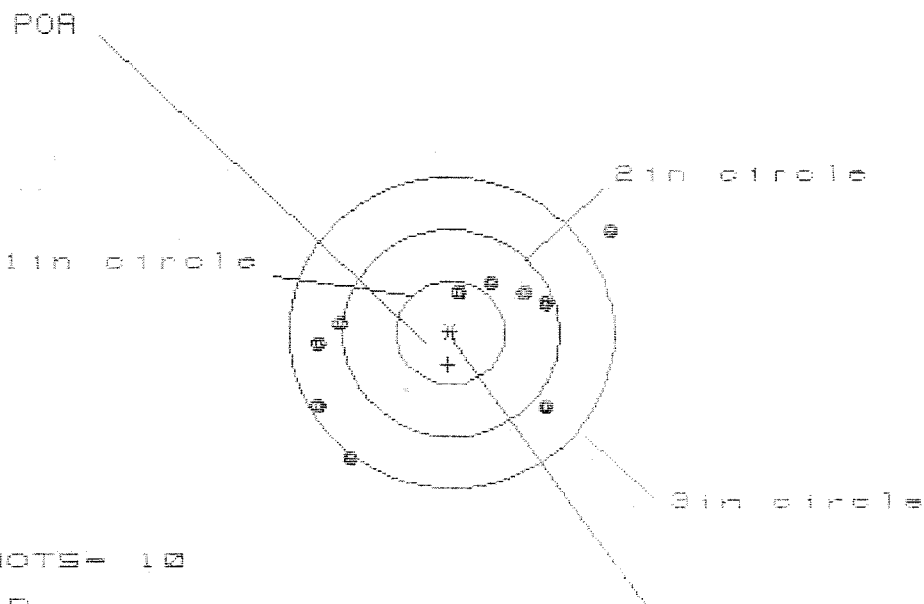
NUMBER IN THREE INCH CIRCLE =

10

15 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8527633

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 8

HS= 2.653

VS= 2.246

GS= 3.266

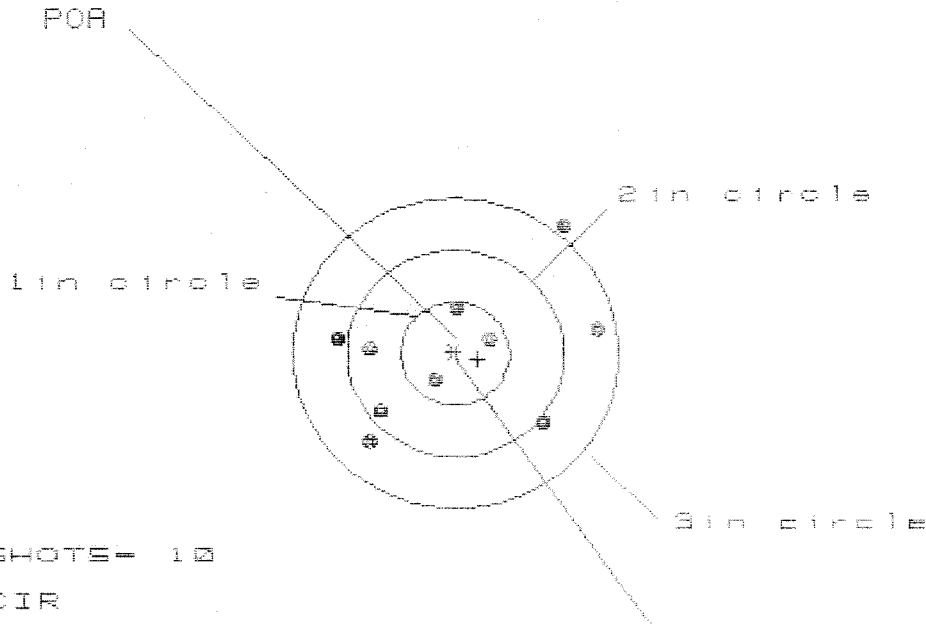
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.468	1.036	.943
MINIMUM X	:	-1.185	-1.022	-1.115
MAXIMUM Y	:	1.001	.618	.476
MINIMUM Y	:	-1.245	-1.134	-.714
CENTROID X	:	.028	-.135	-.042
CENTROID Y	:	.309	.198	.340
POA TO CENTROID in.	:	.310	.239	.342
MIN RADIUS	:	.434	.580	.416
MEAN RADIUS	:	1.072	1.005	.925
MAX RADIUS	:	1.776	1.354	1.323
HORIZONTAL SPREAD	:	2.653	2.058	2.058
VERTICAL SPREAD	:	2.246	1.752	1.190
EXTREME SPREAD	:	3.266	2.317	2.254
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

15 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6527633

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 2

HS= 2.397

VS= 2.029

GS= 2.681

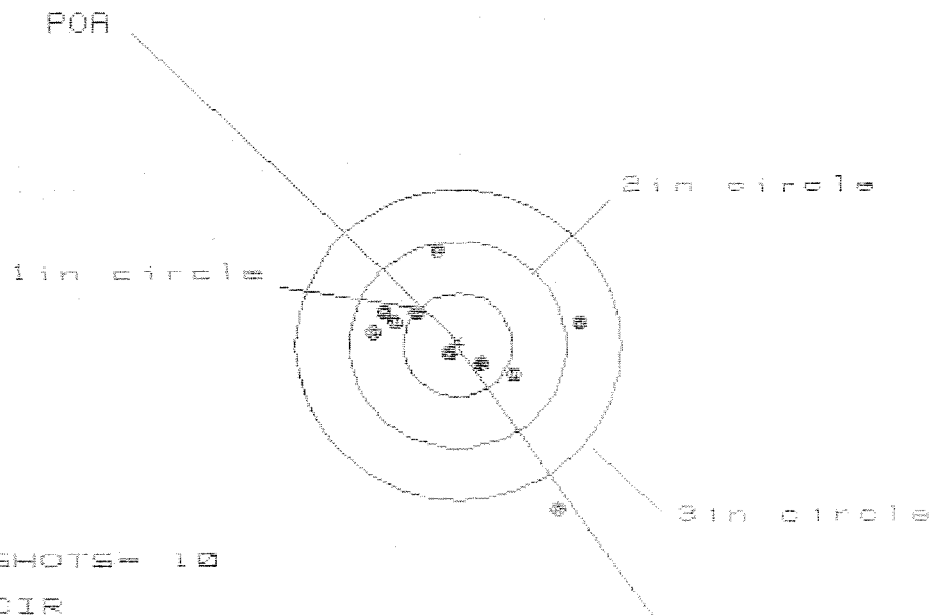
PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.327	1.439	1.899
MINIMUM X	-1.070	-.958	-.778
MAXIMUM Y	1.206	.552	.599
MINIMUM Y	-.823	-.689	-.642
CENTROID X	-.209	-.321	-.501
CENTROID Y	.055	-.079	-.126
POA TO CENTROID in.	.216	.331	.517
MIN RADIUS	.362	.189	.148
MEAN RADIUS	.889	.789	.671
MAX RADIUS	1.573	1.487	1.185
HORIZONTAL SPREAD	2.397	2.397	1.877
VERTICAL SPREAD	2.029	1.241	1.241
EXTREME SPREAD	2.681	2.398	2.039
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

15 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8527633

CENTERFIRE PATTERNS

4



OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 1.927

VS= 2.523

GS= 2.735

CENTROID #

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.104	1.203	.792
MINIMUM X	-.823	-.724	-.573
MAXIMUM Y	.937	.760	.764
MINIMUM Y	-1.586	-.463	-.459
CENTROID X	-.216	-.315	-.466
CENTROID Y	.180	.357	.353
POA TO CENTROID in.	.281	.476	.585
MIN RADIUS	.140	.291	.207
MEAN RADIUS	.762	.626	.519
MAX RADIUS	1.822	1.204	.916
HORIZONTAL SPREAD	1.927	1.927	1.365
VERTICAL SPREAD	2.523	1.223	1.223
EXTREME SPREAD	2.735	1.929	1.420
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	8	
NUMBER IN THREE INCH CIRCLE	=	9	

15 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8527833

CENTERFIRE PATTERNS

5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS= 3.743

VS= 2.575

CS= 3.783

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	2.211
MINIMUM X	-1.532
MAXIMUM Y	1.467
MINIMUM Y	-1.108
CENTROID X	-.070
CENTROID Y	-.055
POA TO CENTROID in.	.089
MIN RADIUS	.240
MEAN RADIUS	1.073
MAX RADIUS	2.297
HORIZONTAL SPREAD	3.743
VERTICAL SPREAD	2.575
EXTREME SPREAD	3.783
NUMBER IN ONE INCH CIRCLE	2
NUMBER IN TWO INCH CIRCLE	6
NUMBER IN THREE INCH CIRCLE	8

SWS TRIGGER PULL TEST

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

SERIAL NO. C6587633
DATE 11-9-95
TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.61	2.61	2.60	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.52	2.56	2.59	
PULL #3	2.66	2.60	2.62	
PULL #4	2.64	2.60	2.59	
PULL #5	2.63	2.65	2.59	
TOTAL	13.06	13.02	12.99	
AVG.	2.61	2.60	2.59	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.02	3.09	
PULL #2	3.02	3.09	
PULL #3	3.04	3.02	
PULL #4	3.05	3.04	
PULL #5	3.11	3.09	
TOTAL	15.24	15.33	
AVG.	3.04	3.06	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.01	4.10		4.25
PULL #2	4.00	4.06		4.26
PULL #3	4.00	4.14		4.26
PULL #4	4.14	4.13		4.30
PULL #5	4.13	4.18		4.35
TOTAL	20.28	20.61		21.42
AVG.	4.05	4.12		4.28

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C-6587633

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock			
600	Proof			
607.	Check Headspace			
610	Dis-assemble Gun			
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4.25	4.5	4.5			12-13-95	DA
	G) Safety Off Force	3.5	3.5	3.5			12-13-95	DA
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent							
	J) Assemble Stock							
	K) Assemble Swivel Studs							
	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							
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection							
	A) Headspace							
	B) Trigger Pull	2.69	2.66	2.73	2.74	2.79	12-13-95	DA
	C) Function							
660	Pack							