

06523481

MODEL 700™ M24

Model 545™

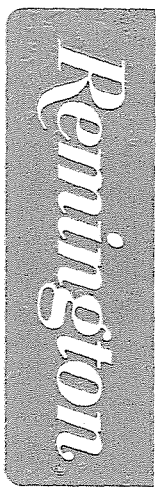
Action

Barrel Length

Capacity

Order No. 5715

* Includes 1 in chamber.



Remington®



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

MODEL 700™ H24

SERIAL NO.
C6523481

ORDER NO.

5716

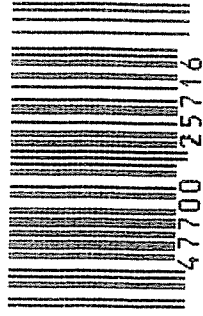
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.



5716 C6523481

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523481

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 25	90	RW
600	Proof	9 25	90	RW
607	Check Headspace	9 25	90	RW
610	Dis-assemble Gun	9 25	90	RW
612	Magnaflux Barrel Action		9-26-90	KR
	Magnaflux Bolt		9-26-90	KR
615	Rollmark Caliber		9-26-90	GL
617	Drill and Tap Sight Holes		9/28/90	LB
618	Polish Barrel RB		10/1/90	WB
620	Apply Coatings (Barrel Action)		10-5-90	JA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		10/8/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/8/90	RW
	C) Inspect Ejector Hole for Chamfer		10/8/90	RW
	D) Oil Firing Pin Ass'y		10/8/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/9/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			10/9/90	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			10/9/90	WB
	H) Trigger Pull Test & Retainability						10/9/90	WB
	I) Firing Pin Indent	.072	.0715	.0715			10/9/90	WB
	J) Assemble Stock						10/9/90	RW
	K) Assemble Swivel Studs						11/19/90	RS
	L) Attach Front and Rear Sight Assemblies						10/9/90	RW
	M) Iron Sight Alignment						10/9/90	RW
	N) Detach Front & Rear Sights & place in numbered container						10/9/90	RW
	O) Attach Scope to Rifle						10/9/90	RW
	P) Detach & Attach Scope 20 Times						10/9/90	RW
640	Gallery Target & Test						10-11-90	AC
	A) Time						10-11-90	AC
	B) Malfunctions						10-11-90	AC
	C) Pierced Primers						10-11-90	AC
	D) Optical Clarity of Scope						10-11-90	AC
645	Inspect for Live Ammo						10-11-90	AC
655	Final Inspection							
	A) Headspace						11/19/90	RS
	B) Trigger Pull	202	202	200	205	202	11/19/90	RS
	C) Function	2.50	2.48	2.52	2.48	2.42	11/19/90	RS
660	Pack						12-17-90	DH

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF	Ream Ejector H/e a Polish Ejector	RW 10/ 30/ 90
TEST ✓		
TGT		
PROOF 10-31-90	shot OK 100 R/L DH	RW
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

MOD. _____		GA. CAL. _____	GUN # _____
#	C6523481		ASSEM. #
TEST	DATE	MALFUNCTION/DEFECT	
	1st 10/1/90	shave Brass	RW
	2nd		
	3rd		
	4th		
		FUNCTION	RD 6654 Rev 1

SWS TRIGGER PULL TEST

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

SERIAL NO. C6523481

DATE 10-9-90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.39	2.27	2.02	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.51	2.39	2.31	2.02	
PULL #3	2.43	2.41	2.40	2.00	
PULL #4	2.52	2.34	2.33	2.05	
PULL #5	2.43	2.16	2.35	2.02	
TOTAL	12.30	11.69	11.66		
AVG.	2.46	2.338	2.33		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.53	3.48		
PULL #2	3.45	3.46		
PULL #3	3.41	3.48		
PULL #4	3.50	3.51		
PULL #5	3.49	3.50		
TOTAL	17.38	17.43		
AVG.	3.476	3.48		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.10	4.20		4.19
PULL #2	4.12	4.17		4.18
PULL #3	4.11	4.18		4.18
PULL #4	4.09	4.17		4.16
PULL #5	4.07	4.20		4.19
TOTAL	20.49	20.92		20.90
AVG.	4.10	4.18		4.18

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523481
12 Oct 1990

CENTROIDAL DISTANCES

0 TO	1	.101912
1 TO	2	.400065
1 TO	3	.347973
1 TO	4	.215539
1 TO	5	.331694

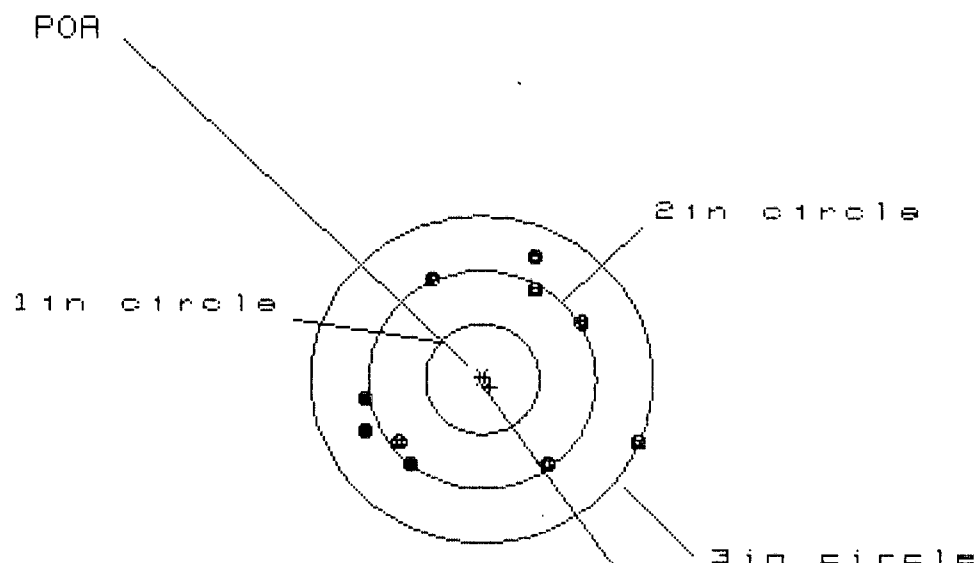
25 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0276
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1458
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .148389
THE AMR FOR THIS RIFLE IS: 1.024

12 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06523481

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 0

2in = 3

3in = 9

HS= 2.437

VS= 1.876

GS= 2.439

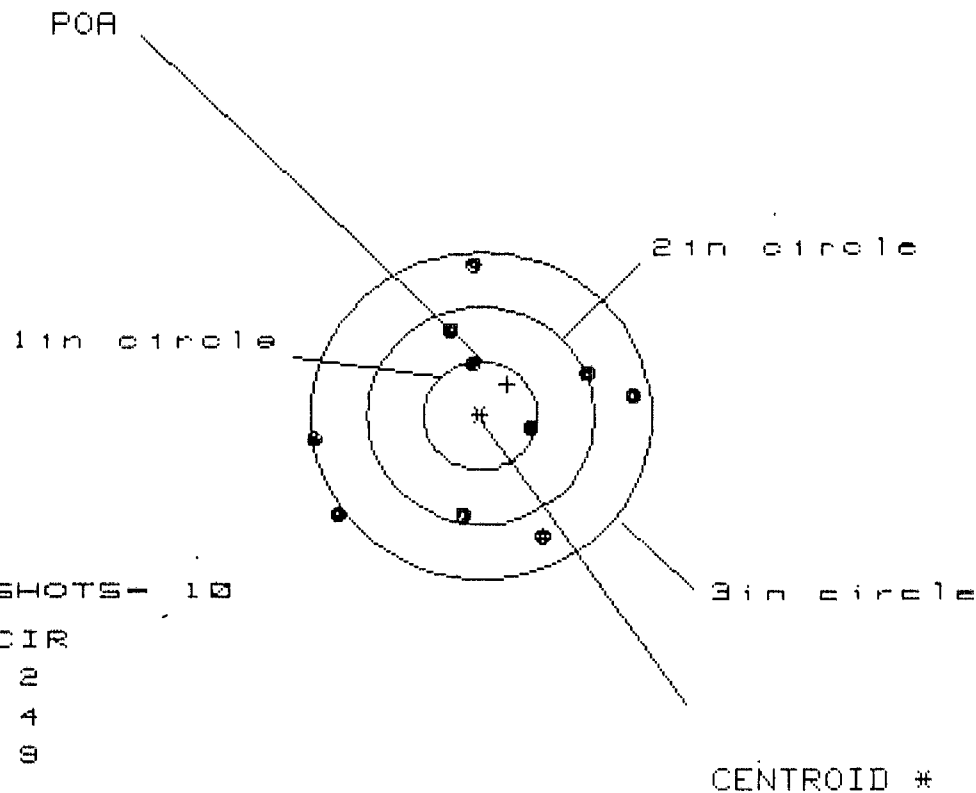
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.392	.992	1.069
MINIMUM X	-1.045	-.890	-.814
MAXIMUM Y	1.088	1.024	1.017
MINIMUM Y	-.788	-.852	-.724
CENTROID X	-.069	-.224	-.301
CENTROID Y	.075	.139	.011
POA TO CENTROID in.	.102	.264	.301
MIN RADIUS	.927	.872	.741
MEAN RADIUS	1.070	1.006	.960
MAX RADIUS	1.507	1.193	1.238
HORIZONTAL SPREAD	2.437	1.882	1.882
VERTICAL SPREAD	1.876	1.876	1.741
EXTREME SPREAD	2.439	2.166	2.146
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 9

HS= 2.787

VS= 2.428

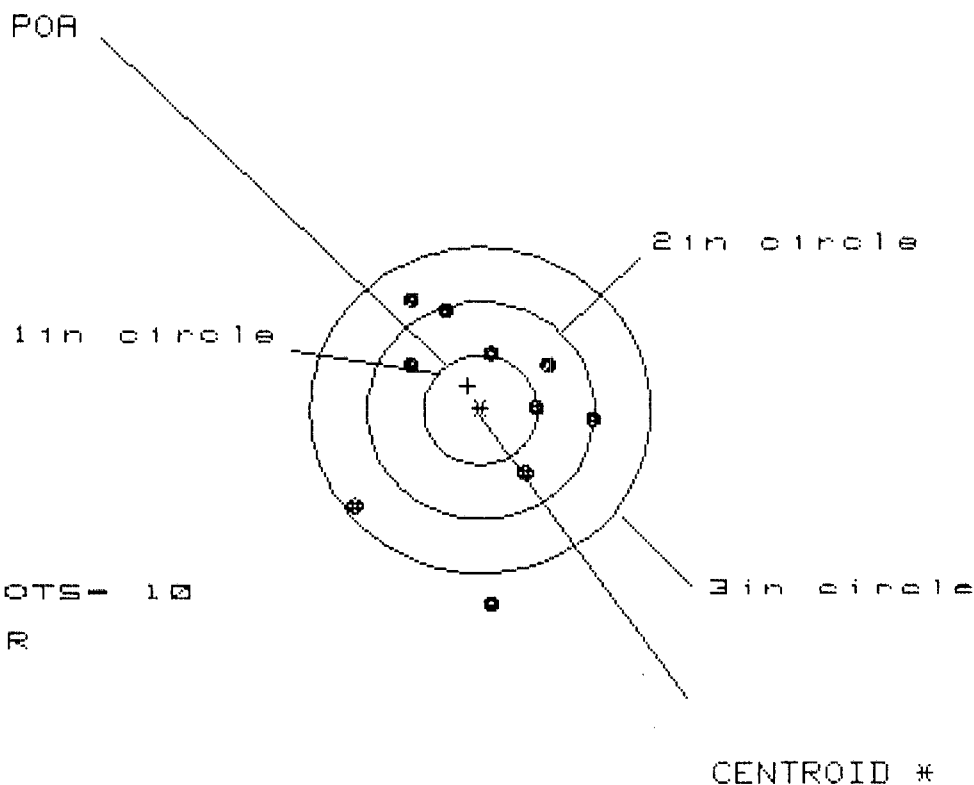
GS= 2.842

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.352	1.211	1.014
MINIMUM X	:	-1.435	-1.576	-.576
MAXIMUM Y	:	1.349	1.251	1.210
MINIMUM Y	:	-1.079	-1.177	-1.218
CENTROID X	:	-.235	-.094	.103
CENTROID Y	:	-.289	-.191	-.150
POA TO CENTROID in.	:	.373	.213	.182
MIN RADIUS	:	.418	.316	.216
MEAN RADIUS	:	1.053	.969	.862
MAX RADIUS	:	1.548	1.611	1.263
HORIZONTAL SPREAD	:	2.787	2.787	1.590
VERTICAL SPREAD	:	2.428	2.428	2.428
EXTREME SPREAD	:	2.842	2.822	2.483
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



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 2.133

VS= 2.762

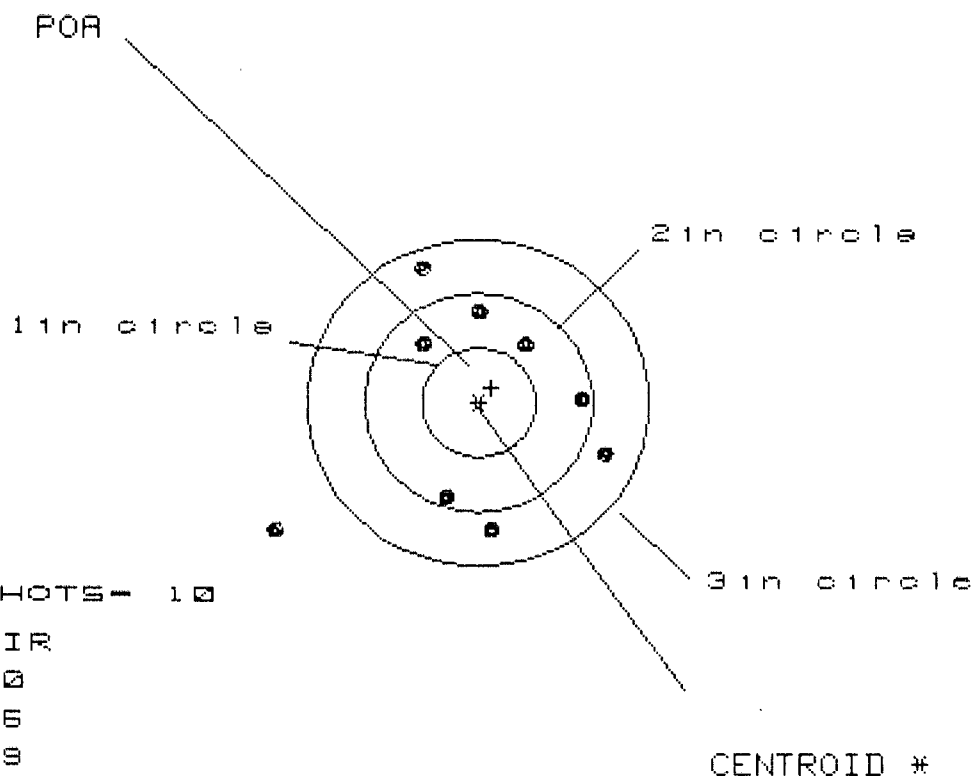
ES= 2.837

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.019	1.026	.888
MINIMUM X	:	-1.114	-1.107	-.744
MAXIMUM Y	:	.975	.777	.647
MINIMUM Y	:	-1.787	-1.033	-.916
CENTROID X	:	.109	.102	.240
CENTROID Y	:	-.224	-.026	.103
POA TO CENTROID in.	:	.249	.105	.262
MIN RADIUS	:	.493	.300	.170
MEAN RADIUS	:	.952	.818	.690
MAX RADIUS	:	1.788	1.514	.962
HORIZONTAL SPREAD	:	2.133	2.133	1.632
VERTICAL SPREAD	:	2.762	1.810	1.564
EXTREME SPREAD	:	2.837	2.277	1.893
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 0

2in = 6

3in = 9

HS= 2.864

VS= 2.414

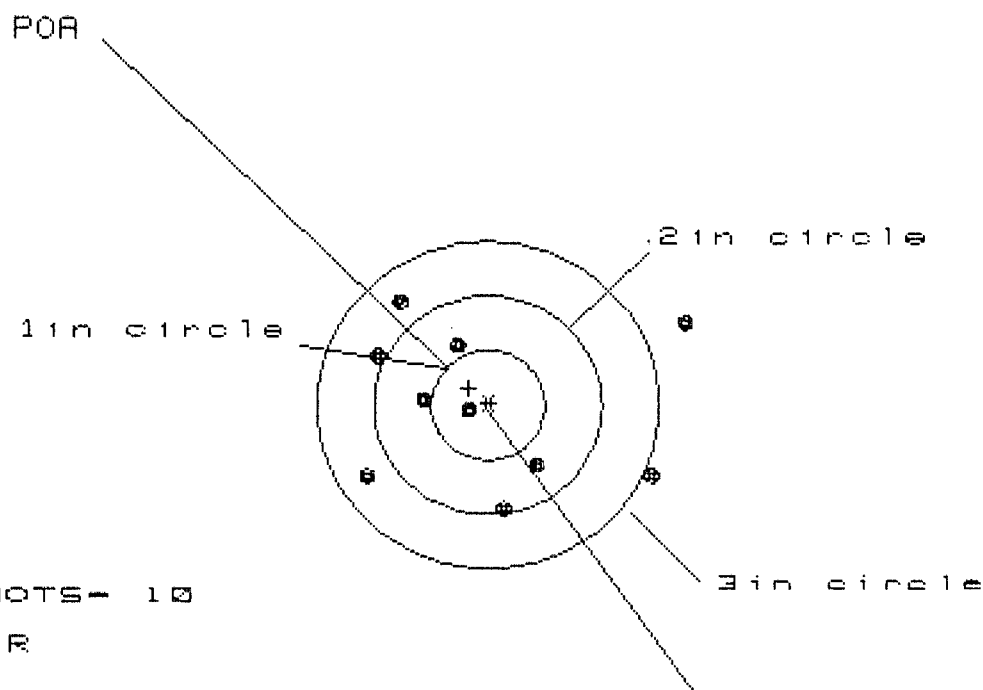
GS= 2.954

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.110	.915	.827
MINIMUM X	:	-1.754	-.708	-.776
MAXIMUM Y	:	1.209	1.082	.851
MINIMUM Y	:	-1.205	-1.332	-1.197
CENTROID X	:	-.113	.082	.171
CENTROID Y	:	-.136	-.009	-.144
POA TO CENTROID in.	:	.177	.083	.223
MIN RADIUS	:	.649	.430	.518
MEAN RADIUS	:	1.053	.883	.836
MAX RADIUS	:	2.093	1.335	1.211
HORIZONTAL SPREAD	:	2.864	1.623	1.603
VERTICAL SPREAD	:	2.414	2.414	2.048
EXTREME SPREAD	:	2.954	2.491	2.049
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in - 1

2 in - 5

3 in - 8

HS= 2.869

VS= 1.858

GS= 3.177

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.774	1.610	.842
MINIMUM X	:	-1.095	-.898	-.696
MAXIMUM Y	:	.923	1.008	.944
MINIMUM Y	:	-.935	-.850	-.914
CENTROID X	:	.170	-.027	-.229
CENTROID Y	:	-.155	-.240	-.176
POA TO CENTROID in.	:	.230	.241	.288
MIN RADIUS	:	.144	.074	.156
MEAN RADIUS	:	.992	.844	.715
MAX RADIUS	:	1.932	1.690	1.042
HORIZONTAL SPREAD	:	2.869	2.508	1.538
VERTICAL SPREAD	:	1.858	1.858	1.858
EXTREME SPREAD	:	3.177	2.628	2.036
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	