

C6649096

MODEL 700<sup>TM</sup> M24

Model 545<sup>TM</sup>

Action

Barrel Length

Capacity

Order No. 5716

\*Includes 1 in chamber.

*Remington*

CHAMBER

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

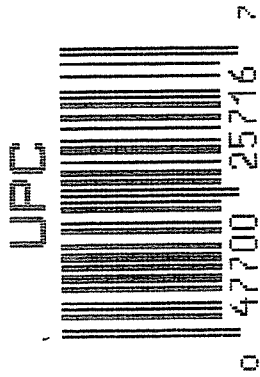
**MODEL 700™ N24**

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

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

|                               |                                 |
|-------------------------------|---------------------------------|
| <b>SERIAL NO.</b><br>C6649096 | <b>ORDER NO.</b><br><b>5716</b> |
|-------------------------------|---------------------------------|

20



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

**C 6649096**

| OP. #        | OP. NAME                                                       | READINGS | DATE         | INIT |
|--------------|----------------------------------------------------------------|----------|--------------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   |          | 6/24/91      | KL   |
| 600          | Proof                                                          |          | 6/26/91      | KL   |
| 607          | Check Headspace                                                |          | 6/26/91      | KL   |
| 610          | Dis-assemble Gun                                               |          | 6/26/91      | KL   |
| 612          | Magnaflux Barrel<br>Action                                     |          | JUL 1 8 1991 | CS   |
|              | Magnaflux Bolt                                                 |          | JUL 1 8 1991 | CS   |
| 615          | Rollmark Caliber                                               |          | JUL 1 8 1991 | CS   |
| 617          | Drill and Tap Sight Holes                                      |          | JUL 1 8 1991 | FB   |
| 618          | Polish Barrel                                                  |          | JUL 2 0 1991 | WB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 8-7-91       | KL   |
|              | Apply Coating (Bolt)                                           |          |              | KL   |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 8/22/91      | KL   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 8/22/91      | KL   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 8/22/91      | KL   |
|              | D) Oil Firing Pin Ass'y                                        |          | 8/22/91      | KL   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 8/24/91      | JU   |

| op. #        | OP. NAME                                                    | READINGS |       |      |      |      | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|-------|------|------|------|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 5        | 5 1/2 | 5    |      |      | 8-26-91 | DH   |
|              | G) Safety Off Force                                         | 3        | 3     | 3    |      |      | 8-26-91 | DH   |
|              | H) Trigger Pull Test & Retainability                        |          |       |      |      |      | 8/24/91 | JH   |
|              | I) Firing Pin Indent                                        | .020     | .020  | .021 |      |      | 8-26-91 | DH   |
|              | J) Assemble Stock                                           |          |       |      |      |      | 8/24/91 | JH   |
|              | K) Assemble Swivel Studs                                    |          |       |      |      |      | 8-31-91 | DH   |
|              | L) Attach Front and Rear Sight Assemblies                   |          |       |      |      |      | 8/24/91 | JH   |
|              | M) Iron Sight Alignment                                     |          |       |      |      |      | 8/24/91 | JH   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |       |      |      |      | 8/24/91 | JH   |
|              | O) Attach Scope to Rifle                                    |          |       |      |      |      | 8/24/91 | JH   |
|              | P) Detach & Attach Scope 20 Times                           |          |       |      |      |      | 8/24/91 | JH   |
| 640          | Gallery Target & Test                                       |          |       |      |      |      | 8-27-91 | AC   |
|              | A) Time                                                     |          |       |      |      |      | 8-27-91 | AC   |
|              | B) Malfunctions                                             |          |       |      |      |      | 8-27-91 | AC   |
|              | C) Pierced Primers                                          |          |       |      |      |      | 8-27-91 | AC   |
|              | D) Optical Clarity of Scope                                 |          |       |      |      |      | 8-27-91 | AC   |
| 645          | Inspect for Live Ammo                                       |          |       |      |      |      | 8-27-91 | AC   |
| 655          | Final Inspection                                            |          |       |      |      |      | 8-31-91 | DH   |
|              | A) Headspace                                                |          |       |      |      |      | 8/29/91 | JH   |
|              | B) Trigger Pull                                             | 2.69     | 2.28  | 2.58 | 2.61 | 2.50 | 8/29/91 | JH   |
|              | C) Function                                                 |          |       |      |      |      | 8-31-91 | DH   |
| 660          | Pack                                                        |          |       |      |      |      | 9-18-91 | VF   |

SWS TRIGGER PULL TEST

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

SERIAL NO. 66649096  
DATE 8/24/91  
TESTER JH

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.50             | 2.43                     | 2.50                           | 2.69 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.34             | 2.49                     | 2.54                           | 2.28 |                                                                        |
| PULL #3 | 2.58             | 2.53                     | 2.56                           | 2.58 |                                                                        |
| PULL #4 | 2.53             | 2.54                     | 2.44                           | 2.51 |                                                                        |
| PULL #5 | 2.45             | 2.45                     | 2.48                           | 2.50 |                                                                        |
| TOTAL   |                  |                          |                                |      |                                                                        |
| AVG.    |                  |                          |                                |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.66             | 3.31                     |  |          |
| PULL #2 | 3.36             | 3.31                     |  |          |
| PULL #3 | 3.36             | 3.34                     |  |          |
| PULL #4 | 3.29             | 3.35                     |  |          |
| PULL #5 | 3.27             | 3.35                     |  |          |
| TOTAL   |                  |                          |  |          |
| AVG.    |                  |                          |  |          |

|         | 4.00#<br>INITIAL | 4.00# AFTER<br>20 CYCLES | MAX SETTING<br>GREATER THAN 4# | RESET TO 4# FOR<br>TARGET & ACCURACY |
|---------|------------------|--------------------------|--------------------------------|--------------------------------------|
| PULL #1 | 4.63             | 4.51                     |                                | 4.56                                 |
| PULL #2 | 4.53             | 4.37                     |                                | 4.52                                 |
| PULL #3 | 4.67             | 4.53                     |                                | 4.51                                 |
| PULL #4 | 4.66             | 4.44                     |                                | 4.59                                 |
| PULL #5 | 4.60             | 4.42                     |                                | 4.57                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6649096  
28 Aug 1991

CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| 0 TO | 1 | .202277 |
| 1 TO | 2 | .290016 |
| 1 TO | 3 | .368676 |
| 1 TO | 4 | .135624 |
| 1 TO | 5 | .399362 |

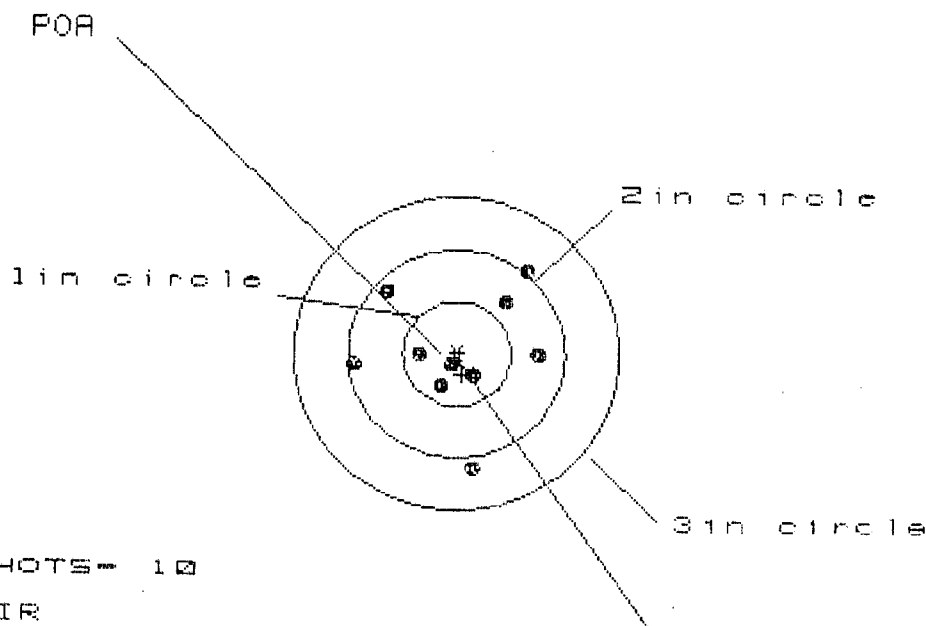
54 <----POR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.263  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1348  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .295533  
THE AMR FOR THIS RIFLE IS: .8408

27 Aug 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6649056

# CENTERFIRE PATTERNS # 1



# OF SHOTS - 10

# IN CIR

1in = 4

2in = 7

3in = 10

HS= 1.740

VS= 1.932

GS= 2.013

CENTROID #

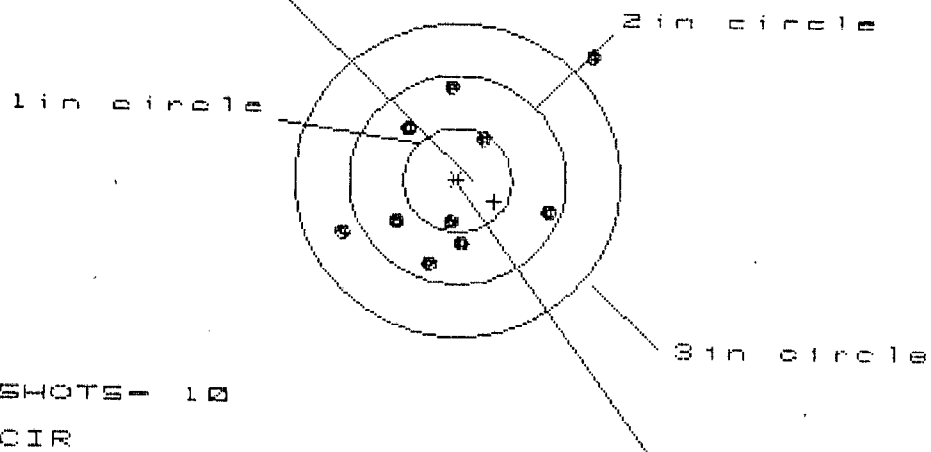
| PATTERN #                     | 10     | 9     | 8     |
|-------------------------------|--------|-------|-------|
| SHOTS (BEST OF)               | 10     | 9     | 8     |
| MAXIMUM X                     | .742   | .756  | .843  |
| MINIMUM X                     | -.997  | -.984 | -.897 |
| MAXIMUM Y                     | .821   | .697  | .535  |
| MINIMUM Y                     | -1.111 | -.450 | -.363 |
| CENTROID X                    | -.050  | -.063 | -.150 |
| CENTROID Y                    | .196   | .320  | .233  |
| POA TO CENTROID in.           | .202   | .326  | .277  |
| MIN RADIUS                    | .082   | .197  | .123  |
| MEAN RADIUS                   | .652   | .616  | .544  |
| MAX RADIUS                    | 1.118  | 1.016 | .912  |
| HORIZONTAL SPREAD             | 1.740  | 1.740 | 1.740 |
| VERTICAL SPREAD               | 1.932  | 1.147 | .898  |
| EXTREME SPREAD                | 2.013  | 1.930 | 1.742 |
| NUMBER IN ONE INCH CIRCLE =   | 4      |       |       |
| NUMBER IN TWO INCH CIRCLE =   | 7      |       |       |
| NUMBER IN THREE INCH CIRCLE = | 10     |       |       |

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FILE:/PATTERNING/CENTERFIRE\_PATT/C6649096

# CENTERFIRE PATTERNS # 2

POA



# OF SHOTS- 10

# IN CIR

1in = 2

2in = 8

3in = 0

HS= 2.217

VS= 2.053

GS= 2.836

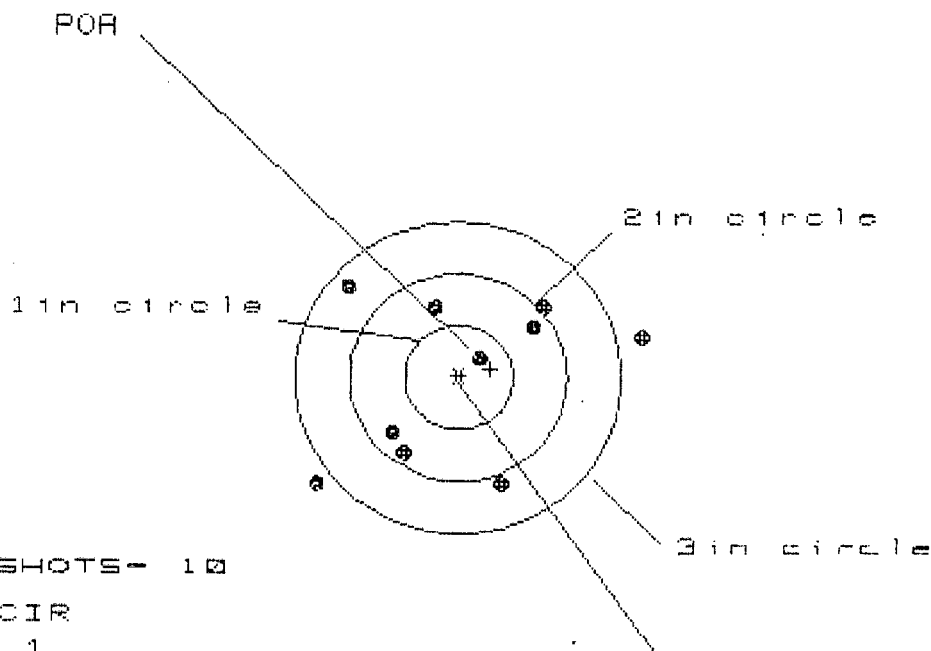
CENTROID \*

| PATTERN #                     | 1      | 2     | 3     |
|-------------------------------|--------|-------|-------|
| SHOTS (BEST OF)               | 10     | 9     | 8     |
| MAXIMUM X                     | 1.190  | .964  | .852  |
| MINIMUM X                     | -1.027 | -.895 | -.535 |
| MAXIMUM Y                     | 1.238  | 1.061 | 1.012 |
| MINIMUM Y                     | -.815  | -.677 | -.727 |
| CENTROID X                    | -.340  | -.472 | -.360 |
| CENTROID Y                    | .199   | .061  | .111  |
| POA TO CENTROID in.           | .394   | .476  | .377  |
| MIN RADIUS                    | .418   | .287  | .327  |
| MEAN RADIUS                   | .836   | .706  | .673  |
| MAX RADIUS                    | 1.717  | 1.064 | 1.012 |
| HORIZONTAL SPREAD             | 2.217  | 1.859 | 1.387 |
| VERTICAL SPREAD               | 2.053  | 1.738 | 1.738 |
| EXTREME SPREAD                | 2.836  | 1.871 | 1.750 |
| NUMBER IN ONE INCH CIRCLE =   |        | 2     |       |
| NUMBER IN TWO INCH CIRCLE =   |        | 8     |       |
| NUMBER IN THREE INCH CIRCLE = |        | 9     |       |

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# CENTERFIRE PATTERNS # 3



# OF SHOTS- 10

# IN CIR

1in = 1

2in = 5

3in = 8

HS= 2.939

VS= 1.946

GS= 3.250

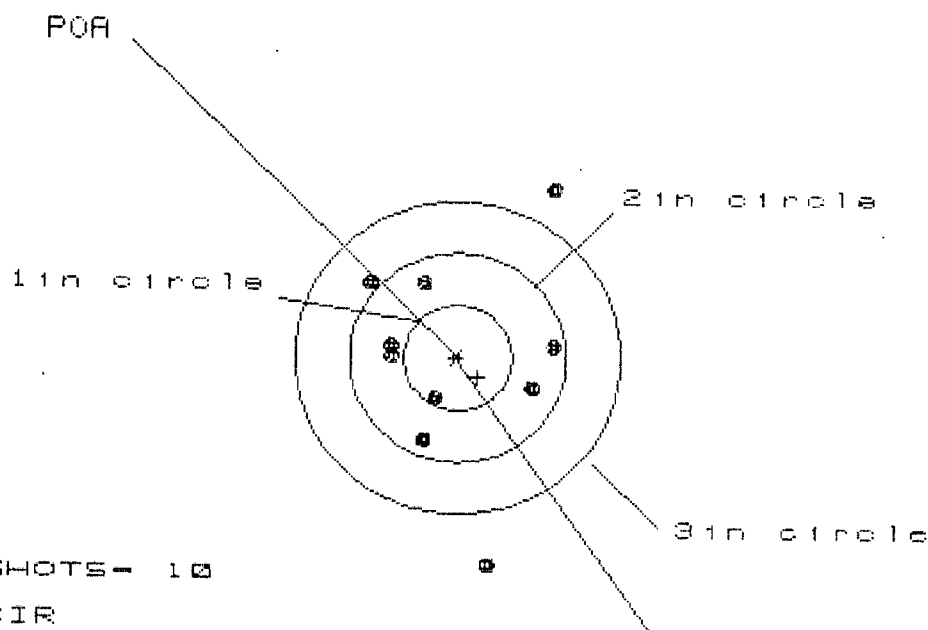
CENTROID \*

| PATTERN #                     | 13     | 14     | 15     |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.653  | .974   | .836   |
| MINIMUM X                     | -1.286 | -1.102 | -.948  |
| MAXIMUM Y                     | .909   | .948   | .823   |
| MINIMUM Y                     | -1.037 | -.998  | -1.122 |
| CENTROID X                    | -.291  | -.475  | -.337  |
| CENTROID Y                    | -.083  | -.122  | .003   |
| POA TO CENTROID in.           | .302   | .490   | .337   |
| MIN RADIUS                    | .251   | .413   | .230   |
| MEAN RADIUS                   | 1.032  | .957   | .863   |
| MAX RADIUS                    | 1.690  | 1.487  | 1.256  |
| HORIZONTAL SPREAD             | 2.939  | 2.076  | 1.784  |
| VERTICAL SPREAD               | 1.946  | 1.946  | 1.945  |
| EXTREME SPREAD                | 3.250  | 2.701  | 2.402  |
| NUMBER IN ONE INCH CIRCLE =   | 1      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 5      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 8      |        |        |

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# CENTERFIRE PATTERNS # 4



# OF SHOTS- 10

# IN CIR

1in = 1

2in = 7

3in = 8

HS= 1.752

VS= 3.606

GS= 3.664

PATTERN #

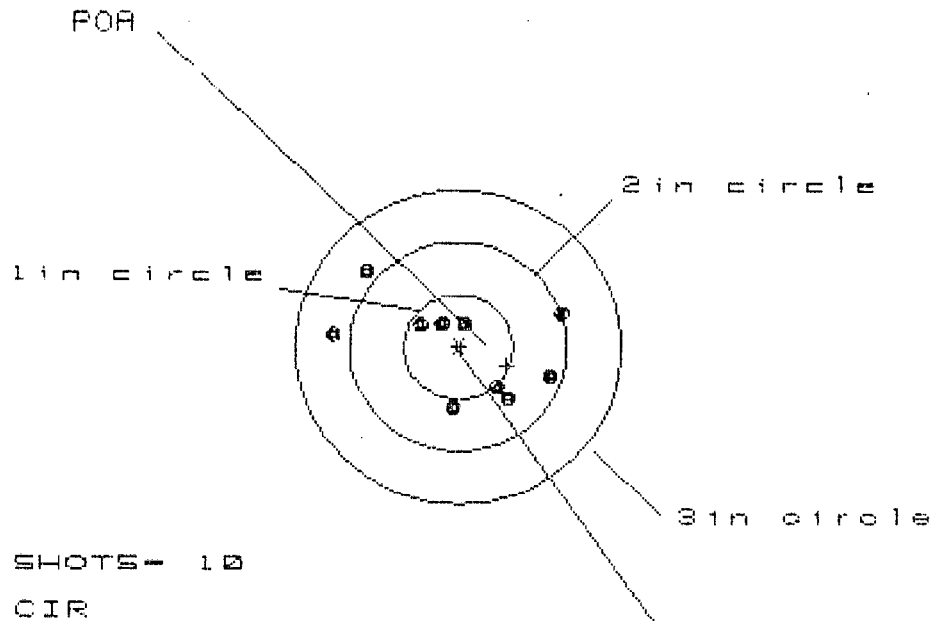
4

| SHOTS (BEST OF)               | 10     | 9      | 8     |
|-------------------------------|--------|--------|-------|
| MAXIMUM X                     | .931   | .963   | 1.038 |
| MINIMUM X                     | -.821  | -.789  | -.669 |
| MAXIMUM Y                     | 1.653  | 1.437  | .722  |
| MINIMUM Y                     | -1.952 | -1.016 | -.837 |
| CENTROID X                    | -.185  | -.217  | -.337 |
| CENTROID Y                    | .183   | .400   | .221  |
| POA TO CENTROID in.           | .261   | .455   | .403  |
| MIN RADIUS                    | .410   | .570   | .408  |
| MEAN RADIUS                   | .994   | .881   | .729  |
| MAX RADIUS                    | 1.973  | 1.729  | 1.045 |
| HORIZONTAL SPREAD             | 1.752  | 1.752  | 1.787 |
| VERTICAL SPREAD               | 3.606  | 2.453  | 1.559 |
| EXTREME SPREAD                | 3.664  | 2.751  | 1.823 |
| NUMBER IN ONE INCH CIRCLE =   |        | 1      |       |
| NUMBER IN TWO INCH CIRCLE =   |        | 7      |       |
| NUMBER IN THREE INCH CIRCLE = |        | 8      |       |

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# CENTERFIRE PATTERNS # 5



# OF SHOTS- 10  
 # IN CIR  
 1 in = 4  
 2 in = 8  
 3 in = 10  
 HS = 2.100  
 VS = 1.304  
 GS = 2.114

| PATTERN #                     | 5      | 5      | 5     |
|-------------------------------|--------|--------|-------|
| SHOTS (BEST OF)               | 10     | 9      | 8     |
| MAXIMUM X                     | .916   | .784   | .655  |
| MINIMUM X                     | -1.184 | -1.031 | -.625 |
| MAXIMUM Y                     | .684   | .696   | .440  |
| MINIMUM Y                     | -.620  | -.608  | -.521 |
| CENTROID X                    | -.449  | -.317  | -.188 |
| CENTROID Y                    | .179   | .167   | .080  |
| POA TO CENTROID in.           | .483   | .359   | .205  |
| MIN RADIUS                    | .244   | .275   | .272  |
| MEAN RADIUS                   | .690   | .626   | .538  |
| MAX RADIUS                    | 1.189  | 1.244  | .789  |
| HORIZONTAL SPREAD             | 2.100  | 1.815  | 1.280 |
| VERTICAL SPREAD               | 1.304  | 1.304  | .961  |
| EXTREME SPREAD                | 2.114  | 2.014  | 1.362 |
| NUMBER IN ONE INCH CIRCLE =   | 4      |        |       |
| NUMBER IN TWO INCH CIRCLE =   | 8      |        |       |
| NUMBER IN THREE INCH CIRCLE = | 10     |        |       |