

C6636235

MODEL 700™ M24

Model S45™

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 700TH H24

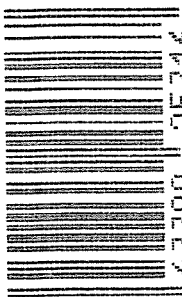
SERIAL NO.
06836235

ORDER NO.
5716

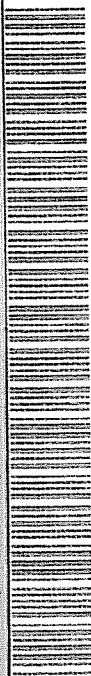
20

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

UPC



0 47700 25716 7



5716 06836235

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636235

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/27/91	KA
600	Proof		6/27/91	KA
607	Check Headspace		6/27/91	KA
610	Dis-assemble Gun		6/27/91	KA
612	Magnaflux Barrel Action		JUL 2 1991	KR
	Magnaflux Bolt		JUL 2 1991	KR
615	Rollmark Caliber		JUL 2 1991	KR
617	Drill and Tap Sight Holes		JUL 2 1991	FB
618	Polish Barrel		JUL 7 1991	WB
620	Apply Coatings (Barrel Action)		8-6-91	KA
	Apply Coating (Bolt)		8-6-91	KA
625	Final Assembly A) Clean inside of Bolt Assembly		9/18/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/18/91	KA
	C) Inspect Ejector Hole for Chamfer		9/18/91	KA
	D) Oil Firing Pin Ass'y		9/18/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		8-20-91	KA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8/20/91	JK
	G) Safety Off Force	3	3	3			8/20/91	JK
	H) Trigger Pull Test & Retainability						8-20-91	JK
	I) Firing Pin Indent	.0215	.0205	.0205			8/20/91	JK
	J) Assemble Stock						8/20/91	JK
	K) Assemble Swivel Studs						8/22/91	JK
	L) Attach Front and Rear Sight Assemblies						8/20/91	JK
	M) Iron Sight Alignment						8/20/91	JK
	N) Detach Front & Rear Sights & place in numbered container						8/20/91	JK
	O) Attach Scope to Rifle						8/20/91	JK
	P) Detach & Attach Scope 20 Times						8/20/91	JK
640	Gallery Target & Test						8/21/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						8/21/91	KT
655	Final Inspection							
	A) Headspace						8/22/91	JK
	B) Trigger Pull	2.46	2.54	2.58	2.56	2.44	8/22-91	JK
	C) Function						8/22/91	JK
660	Pack						9-19-91	JK

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636235
23 Aug 1991

CENTROIDAL DISTANCES

0 TO 1	.169189
1 TO 2	.0764199
1 TO 3	.29218
1 TO 4	.0471275
1 TO 5	.110018

-----POA

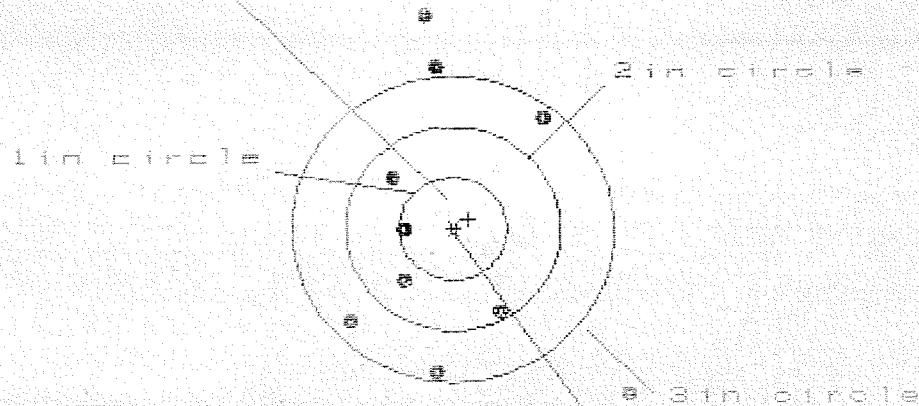
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0894
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0784
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .118907
THE AMR FOR THIS RIFLE IS: 1.067

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B96235

CENTERFIRE PATTERNS # 1

POA



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 7

HS= 2.587

VS= 3.635

GS= 4.107

CENTROID *

PATTERN #

1

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.659

1.066

1.058

MINIMUM X

-1.928

-1.744

-1.752

MAXIMUM Y

2.069

1.895

1.619

MINIMUM Y

-1.566

-1.584

-1.347

CENTROID X

-1.140

-1.324

-1.316

CENTROID Y

-1.095

1.079

-1.158

POA TO CENTROID in.

1.169

1.334

1.353

MIN RADIUS

1.436

1.330

1.259

MEAN RADIUS

1.286

1.146

1.015

MAX RADIUS

2.262

1.896

1.620

HORIZONTAL SPREAD

2.587

1.810

1.810

VERTICAL SPREAD

3.635

3.479

2.967

EXTREME SPREAD

4.107

3.480

2.967

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

4

NUMBER IN THREE INCH CIRCLE =

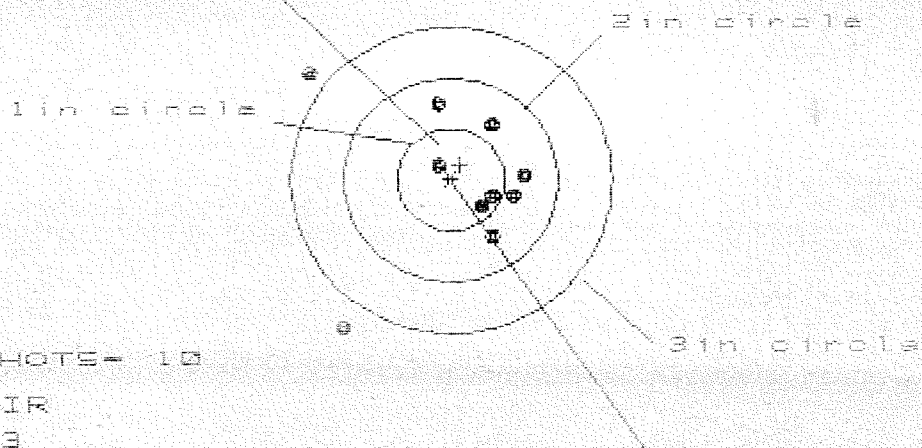
7

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636235

CENTERFIRE PATTERNS # 2

POB



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 8

3 in = 8

HS= 2.068

VS= 2.451

GS= 2.470

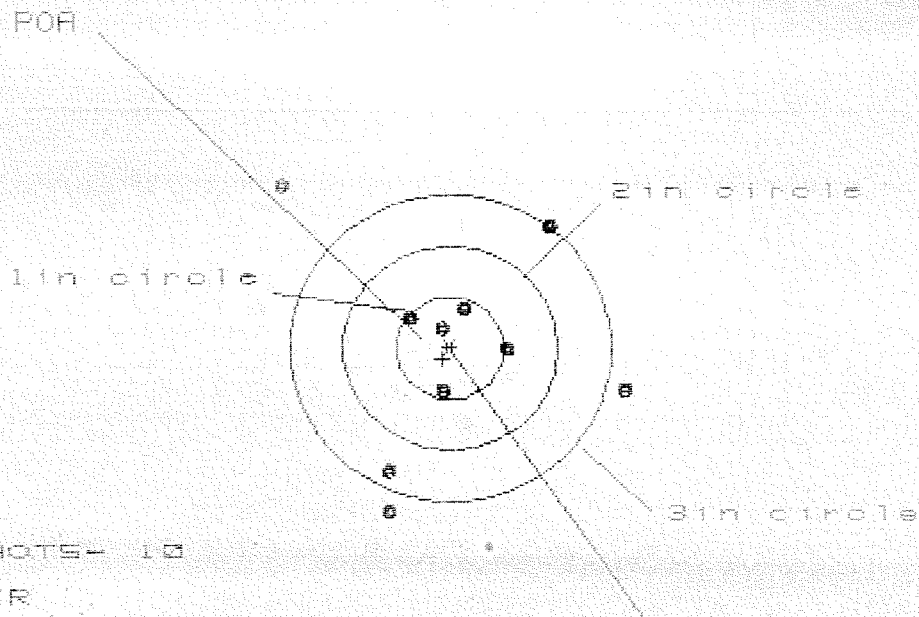
CENTROID +

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.724	.609	.426
MINIMUM X	-1.344	-1.459	-1.452
MAXIMUM Y	1.014	.854	.686
MINIMUM Y	-1.438	-1.700	-1.594
CENTROID X	-.084	.031	.214
CENTROID Y	-.147	.013	-.094
POB TO CENTROID in.	.169	.034	.233
MIN RADIUS	.230	.254	.241
MEAN RADIUS	.791	.655	.473
MAX RADIUS	1.774	1.691	.822
HORIZONTAL SPREAD	2.068	2.069	.878
VERTICAL SPREAD	2.451	1.554	1.280
EXTREME SPREAD	2.470	2.300	1.376
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		8	

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8B35235

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 4

2in = 5

3in = 6

HS= 3.156

VS= 3.207

GS= 3.748

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.618	1.447	1.352
MINIMUM X	-1.538	-1.766	-1.861
MAXIMUM Y	1.607	1.363	1.185
MINIMUM Y	-1.600	-1.421	-1.191
CENTROID X	.073	.244	.339
CENTROID Y	.105	-.074	.104
POA TO CENTROID in.	.128	.255	.354
MIN RADIUS	.170	.320	.296
MEAN RADIUS	1.036	.922	.812
MAX RADIUS	2.224	1.612	1.469
HORIZONTAL SPREAD	3.156	2.213	2.213
VERTICAL SPREAD	3.207	2.784	2.376
EXTREME SPREAD	3.748	3.183	2.835
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	6		

23 Aug 1991

FILE: PATTERNING/CENTERFIRE_PATT/C8636235

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 1

2in = 6

3in = 10

HS = 2.688

VS = 2.067

GS = 2.691

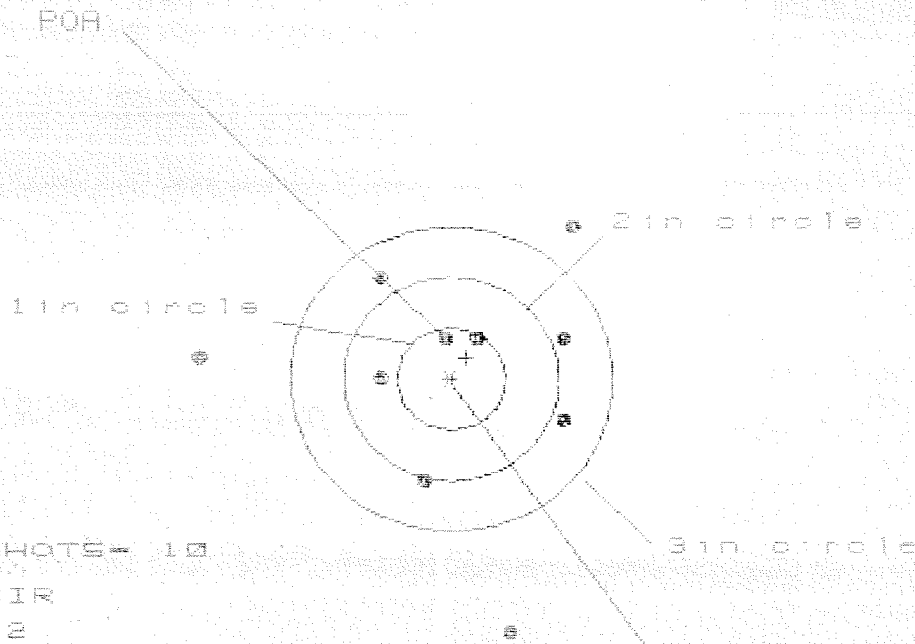
CENTROID *

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.277	1.120	1.157
MINIMUM X	-1.411	-1.066	-1.029
MAXIMUM Y	1.294	1.346	1.725
MINIMUM Y	-1.773	-1.721	-1.553
CENTROID X	-1.154	.003	-.034
CENTROID Y	-.050	-.102	-.270
POA TO CENTROID in.	.162	.102	.272
MIN RADIUS	.327	.371	.248
MEAN RADIUS	.949	.879	.787
MAX RADIUS	1.487	1.378	1.281
HORIZONTAL SPREAD	2.688	2.186	2.186
VERTICAL SPREAD	2.067	2.067	1.278
EXTREME SPREAD	2.691	2.320	2.320
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636235

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1in = 2

2in = 3

3in = 7

HS = 3.499

VS = 3.990

GS = 4.025

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.106	1.170	.879
MINIMUM X	:	-2.393	-2.329	-1.068
MAXIMUM Y	:	1.485	1.207	1.197
MINIMUM Y	:	-2.535	-1.313	-1.323
CENTROID X	:	-.142	-.206	.085
CENTROID Y	:	-.205	.073	.083
POA TO CENTROID in.	:	.249	.219	.119
MIN RADIUS	:	.374	.090	.092
MEAN RADIUS	:	1.274	1.072	.697
MAX RADIUS	:	2.571	2.330	1.485
HORIZONTAL SPREAD	:	3.499	3.499	1.739
VERTICAL SPREAD	:	3.990	2.520	2.520
EXTREME SPREAD	:	4.025	3.728	2.858
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			3	
NUMBER IN THREE INCH CIRCLE =			7	

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C 6636235

DATE 8/20/90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.39	2.24	2.38	2.46	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.36	2.26	2.40	2.54	
PULL #3	2.36	2.26	2.44	2.58	
PULL #4	2.38	2.27	2.23	2.56	
PULL #5	2.33	2.29	2.20	2.44	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.51	3.12		
PULL #2	3.38	3.29		
PULL #3	3.43	3.12		
PULL #4	3.53	3.44		
PULL #5	3.52	3.44		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.24	4.39		4.40
PULL #2	4.49	4.36		4.48
PULL #3	4.45	4.27		4.49
PULL #4	4.47	4.45		4.25
PULL #5	4.44	4.45		4.38
TOTAL				
AVG.				