

C6636276

MODEL 700™ 124

Model 545™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

Remington[®]

MODEL 700[™] M24

DUPONT
REG. U.S. PAT. & TM. OFF.

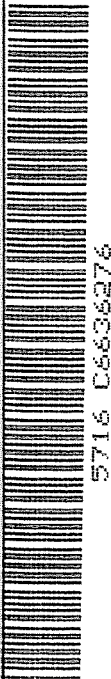
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

SERIAL NO.
C6636276

ORDER NO.
5716

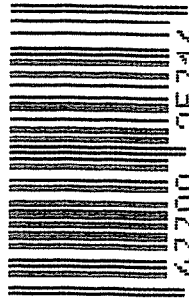
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off. Marca Registrada Marque Deposee.

06



5716 C6636276

UPC

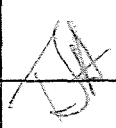


0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636276

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		5/3/91	KS
600	Proof		5/3/91	KS
607	Check Headspace		5/3/91	KS
610	Dis-assemble Gun		5/3/91	KS
612	Magnaflux Barrel Action	5 8 9 1		Kcd
	Magnaflux Bolt	5 8 9 1		Kcd
615	Rollmark Caliber	5 8 9 1		GB
617	Drill and Tap Sight Holes	5 15 9 1		FB
618	Polish Barrel	5 15 9 1		WB
620	Apply Coatings (Barrel Action)		5-29-91	
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		6/4/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6/4/91	KS
	C) Inspect Ejector Hole for Chamfer		6/4/91	KS
	D) Oil Firing Pin Ass'y		6/4/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		6-11-91	

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7	7	7			6-11-91	JK
	G) Safety Off Force	5	5	5			6-11-91	JK
	H) Trigger Pull Test & Retainability						6-11-91	JK
	I) Firing Pin Indent	.0225	.0225	.0225			6-11-91	JK
	J) Assemble Stock						4/12/91	KS
	K) Assemble Swivel Studs						6-14-91	JK
	L) Attach Front and Rear Sight Assemblies						4/12/91	KS
	M) Iron Sight Alignment						4/12/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/12/91	KS
	O) Attach Scope to Rifle						4/12/91	KS
	P) Detach & Attach Scope 20 Times						4/12/91	KS
640	Gallery Target & Test						6/13/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						6/13/91	KT
655	Final Inspection							
	A) Headspace						6-14-91	JK
	B) Trigger Pull	2.25	2.31	2.28	2.21	2.26	6-14-91	JK
	C) Function						6-14-91	JK
660	Pack						6-20-91	JK

SWS TRIGGER PULL TEST

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

SERIAL NO C6636276
DATE 6-11-91
TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.34	2.32	2.36	2.25	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.21	2.35	2.38	2.31	
PULL #3	2.30	2.28	2.35	2.28	
PULL #4	2.34	2.36	2.28	2.21	
PULL #5	2.30	2.30	2.37	2.26	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.32		
PULL #2	3.32	3.30		
PULL #3	3.29	3.38		
PULL #4	3.26	3.20		
PULL #5	3.35	3.17		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.20	4.36		4.40
PULL #2	4.35	4.39		4.38
PULL #3	4.33	4.42		4.38
PULL #4	4.36	4.42		4.36
PULL #5	4.35	4.41		4.36
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6638
13 Jun 1991

C 6636276

~~6269 6276~~

CENTROIDAL DISTANCES

0 TO	1	.42371
1 TO	2	.648235
1 TO	3	.328381
1 TO	4	.409079
1 TO	5	.524389

#1 <----POA

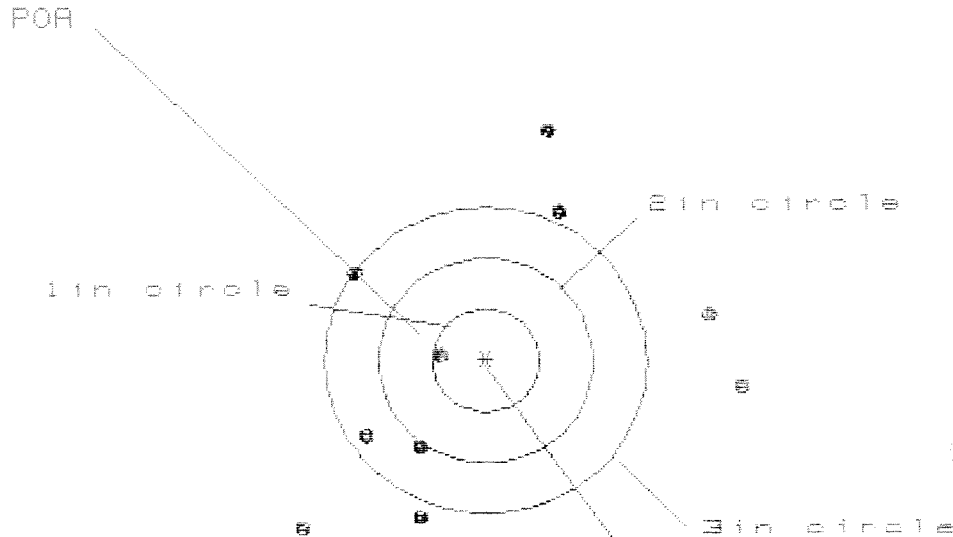
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .083
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0616
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .103361
THE AMR FOR THIS RIFLE IS: 1.176

13 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636276

06636276

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 1

3in = 4

HS= 4.083

VS= 3.806

GS= 4.469

CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.356	2.322	2.139
MINIMUM X	:	-1.728	-1.466	-1.152
MAXIMUM Y	:	2.218	2.191	1.989
MINIMUM Y	:	-1.588	-1.615	-1.807
CENTROID X	:	.419	.158	.341
CENTROID Y	:	-.063	-.036	.166
POA TO CENTROID in.	:	.424	.162	.379
MIN RADIUS	:	.398	.138	.347
MEAN RADIUS	:	1.666	1.523	1.477
MAX RADIUS	:	2.368	2.360	2.149
HORIZONTAL SPREAD	:	4.083	3.788	3.291
VERTICAL SPREAD	:	3.806	3.806	3.796
EXTREME SPREAD	:	4.469	4.469	4.901
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		1	
NUMBER IN THREE INCH CIRCLE	=		4	

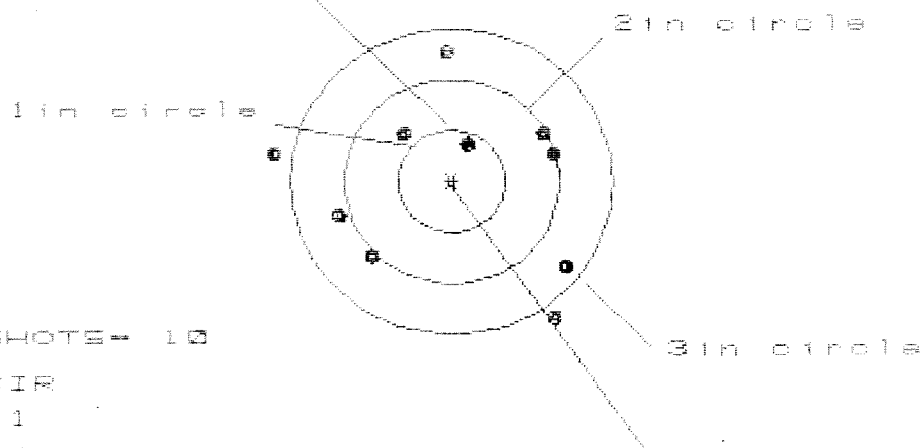
13 Jun 1991

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Q 6636276

CENTERFIRE PATTERNS # 2

POA



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 5

HS = 2.738

VS = 2.540

GS = 3.023

CENTROID *

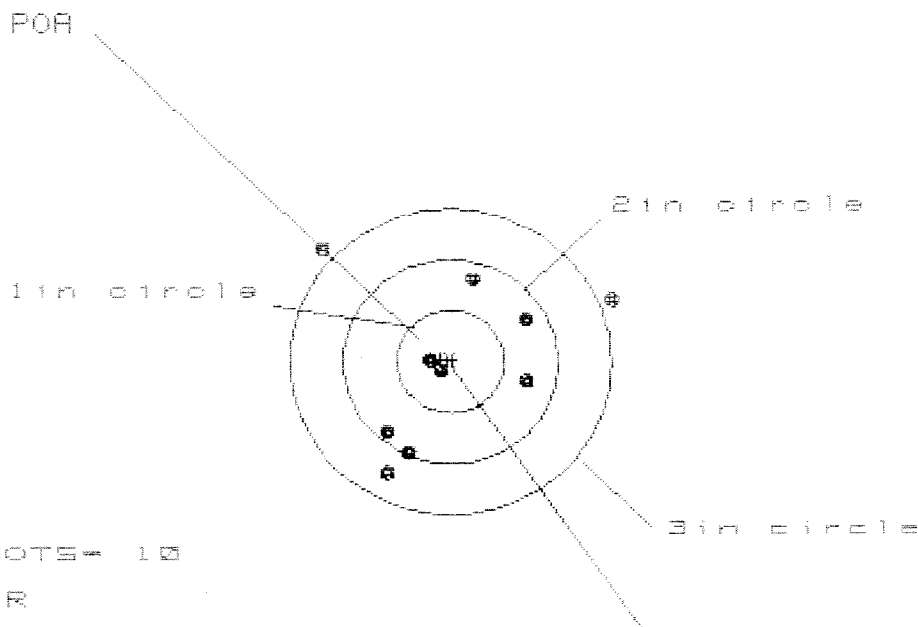
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.101	.919	1.010
MINIMUM X	:	-1.637	-1.188	-1.097
MAXIMUM Y	:	1.229	1.263	1.103
MINIMUM Y	:	-1.311	-1.277	-.914
CENTROID X	:	-.153	.029	-.063
CENTROID Y	:	-.368	-.402	-.243
POA TO CENTROID in.	:	.398	.403	.250
MIN RADIUS	:	.425	.435	.279
MEAN RADIUS	:	1.090	1.018	.925
MAX RADIUS	:	1.666	1.473	1.363
HORIZONTAL SPREAD	:	2.738	2.107	2.107
VERTICAL SPREAD	:	2.540	2.540	2.018
EXTREME SPREAD	:	3.023	2.722	2.329
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		5	

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06636276

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 8

HS = 2.621

VS = 2.164

GS = 2.666

CENTROID #

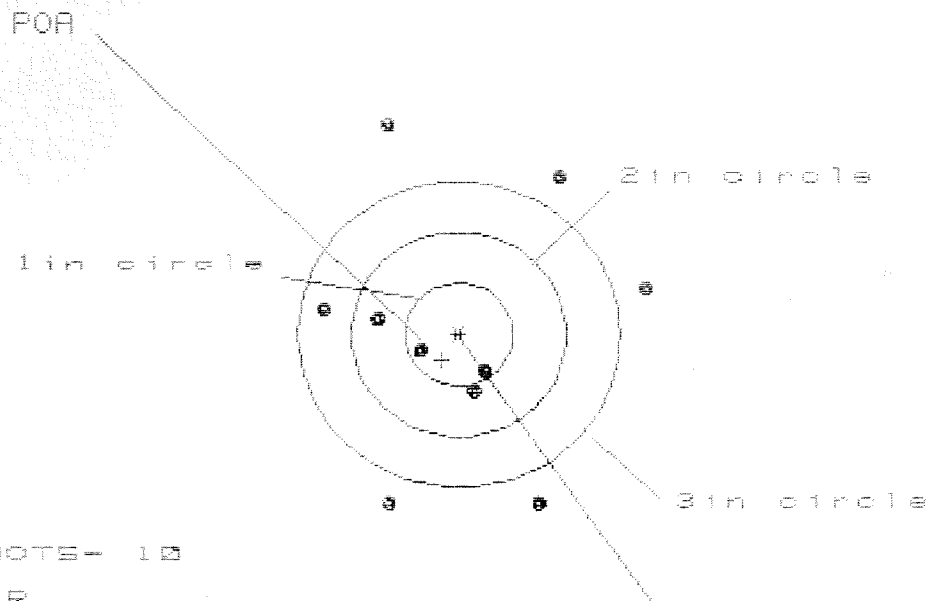
PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.459	1.330	.790
MINIMUM X	-1.162	-.748	-.582
MAXIMUM Y	1.087	.908	1.000
MINIMUM Y	-1.077	-.956	-.864
CENTROID X	.094	.223	.057
CENTROID Y	-.016	-.137	-.229
POA TO CENTROID in.	.095	.261	.236
MIN RADIUS	.103	.231	.173
MEAN RADIUS	.902	.834	.726
MAX RADIUS	1.591	1.522	1.030
HORIZONTAL SPREAD	2.621	2.078	1.372
VERTICAL SPREAD	2.164	1.864	1.064
EXTREME SPREAD	2.666	2.666	2.011
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	

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C6636276

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 5

HS= 3.024

VS= 3.637

GS= 3.883

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.735	1.661	1.076
MINIMUM X	:	-1.289	-1.363	-1.156
MAXIMUM Y	:	2.017	1.732	1.817
MINIMUM Y	:	-1.620	-1.396	-1.311
CENTROID X	:	.158	.232	.025
CENTROID Y	:	.252	.028	-.057
POA TO CENTROID in.	:	.297	.234	.062
MIN RADIUS	:	.414	.265	.265
MEAN RADIUS	:	1.282	1.144	1.028
MAX RADIUS	:	2.125	1.938	2.112
HORIZONTAL SPREAD	:	3.024	3.024	2.232
VERTICAL SPREAD	:	3.637	3.128	3.128
EXTREME SPREAD	:	3.883	3.498	3.498
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		5	

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C6636276

CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 3

2in = 5

3in = 9

HS = 2.757

VS = 2.905

GS = 3.553

CENTROID #

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.019	.826	.732
MINIMUM X	-1.738	-.756	-.804
MAXIMUM Y	1.246	1.062	1.188
MINIMUM Y	-1.659	-.975	-.849
CENTROID X	-.103	.090	.184
CENTROID Y	-.113	.071	-.055
POA TO CENTROID in.	.153	.115	.192
MIN RADIUS	.044	.051	.207
MEAN RADIUS	.942	.750	.666
MAX RADIUS	2.403	1.263	1.312
HORIZONTAL SPREAD	2.757	1.582	1.536
VERTICAL SPREAD	2.905	2.037	2.037
EXTREME SPREAD	3.553	2.510	2.384
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	