

C6636318

MODEL 700™ M24

Model 545™

Action

Barrel Length

Capacity

Order No. 5715

\*Includes 1 in chamber.



**Remington**<sup>®</sup> **DUPONT**  
REG. U.S. PAT. & TM. OFF.

**MODEL 700<sup>™</sup> M24**

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.

**SERIAL NO.**  
 C6636318

**ORDER NO.**  
 5716

20

**UPC**

0 47700 25716 7

5716 C6636318

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636318

| OP. #        | OP. NAME                                                       | READINGS | DATE       | INIT |
|--------------|----------------------------------------------------------------|----------|------------|------|
| 575 &<br>580 | Assemble Action<br>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<br>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<br>(Barrel Action)                              |          | 5-6-91     | TH   |
|              | Apply Coating (Bolt)                                           |          |            |      |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 8/15/91    | KR   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 8/15/91    | KH   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 8/15/91    | KL   |
|              | D) Oil Firing Pin Ass'y                                        |          | 8/15/91    | KL   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 8/16/91    | WB   |

| op. #        | OP. NAME                                                    | READINGS |       |       |     |     | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|-------|-------|-----|-----|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 5        | 5     | 5     |     |     | 8/16/91 | WB   |
|              | G) Safety Off Force                                         | 2 1/4    | 2 1/4 | 2 1/4 |     |     | 8/16/91 | WB   |
|              | H) Trigger Pull Test & Retainability                        |          |       |       |     |     | 8/16/91 | WB   |
|              | I) Firing Pin Indent                                        | .0225    | .0215 | .022  |     |     | 8/16/91 | WB   |
|              | J) Assemble Stock                                           |          |       |       |     |     | 8/19/91 | K    |
|              | K) Assemble Swivel Studs                                    |          |       |       |     |     | 8/22/91 | JH   |
|              | L) Attach Front and Rear Sight Assemblies                   |          |       |       |     |     | 8/19/91 | K    |
|              | M) Iron Sight Alignment                                     |          |       |       |     |     | 8/19/91 | K    |
|              | N) Detach Front & Rear Sights & place in numbered container |          |       |       |     |     | 8/19/91 | K    |
|              | O) Attach Scope to Rifle                                    |          |       |       |     |     | 8/19/91 | K    |
|              | P) Detach & Attach Scope 20 Times                           |          |       |       |     |     | 8/19/91 | K    |
| 640          | Gallery Target & Test                                       |          |       |       |     |     | 8/20/91 | KT   |
|              | A) Time                                                     |          |       |       |     |     |         | KT   |
|              | B) Malfunctions                                             |          |       |       |     |     |         | KT   |
|              | C) Pierced Primers                                          |          |       |       |     |     |         | KT   |
|              | D) Optical Clarity of Scope                                 |          |       |       |     |     |         | KT   |
| 645          | Inspect for Live Ammo                                       |          |       |       |     |     | 8/20/91 | KT   |
| 655          | Final Inspection                                            |          |       |       |     |     |         |      |
|              | A) Headspace                                                |          |       |       |     |     | 8/22/91 | JH   |
|              | B) Trigger Pull                                             | 260      | 265   | 265   | 264 | 264 | 8-21-91 | DU   |
|              | C) Function                                                 |          |       |       |     |     | 8/22/91 | JH   |
| 660          | Pack                                                        |          |       |       |     |     | 9-19-91 | VF   |

SWS TRIGGER PULL TEST

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

SERIAL NO. C6636318  
DATE 8/16/91  
TESTER WAB

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.35             | 2.44                     | 2.48                           | 2.60 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.50             | 2.54                     | 2.43                           | 2.65 |                                                                        |
| PULL #3 | 2.36             | 2.37                     | 2.47                           | 2.65 |                                                                        |
| PULL #4 | 2.35             | 2.36                     | 2.21                           | 2.64 |                                                                        |
| PULL #5 | 2.30             | 2.33                     | 2.45                           | 2.64 |                                                                        |
| TOTAL   | 11.86            | 12.04                    | 12.04                          |      |                                                                        |
| AVG.    | 2.31             | 2.41                     | 2.41                           |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.10             | 3.15                     |  |          |
| PULL #2 | 3.16             | 2.95                     |  |          |
| PULL #3 | 2.90             | 3.07                     |  |          |
| PULL #4 | 3.16             | 3.00                     |  |          |
| PULL #5 | 3.07             | 3.15                     |  |          |
| TOTAL   | 15.39            | 15.32                    |  |          |
| AVG.    | 3.08             | 3.06                     |  |          |

|         | 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 | 4.08             | 4.26                     |                                | 4.29                                 |
| PULL #2 | 4.30             | 4.00                     |                                | 4.20                                 |
| PULL #3 | 4.02             | 4.19                     |                                | 4.37                                 |
| PULL #4 | 4.25             | 4.00                     |                                | 4.11                                 |
| PULL #5 | 4.12             | 3.90                     |                                | 4.39                                 |
| TOTAL   | 20.77            | 20.35                    |                                | 21.36                                |
| AVG.    | 4.15             | 4.07                     |                                | 4.27                                 |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # 06696318  
23 Aug 1991

CENTROIDAL DISTANCES

|        |         |
|--------|---------|
| 0 TO 1 | .234269 |
| 1 TO 2 | .271737 |
| 1 TO 3 | .24226  |
| 1 TO 4 | .199111 |
| 1 TO 5 | .462044 |

POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1058  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.018  
THE RESULTING AVERAGE POT RADIUS FOR THIS RIFLE IS: .10732  
THE AMR FOR THIS RIFLE IS: 1.051

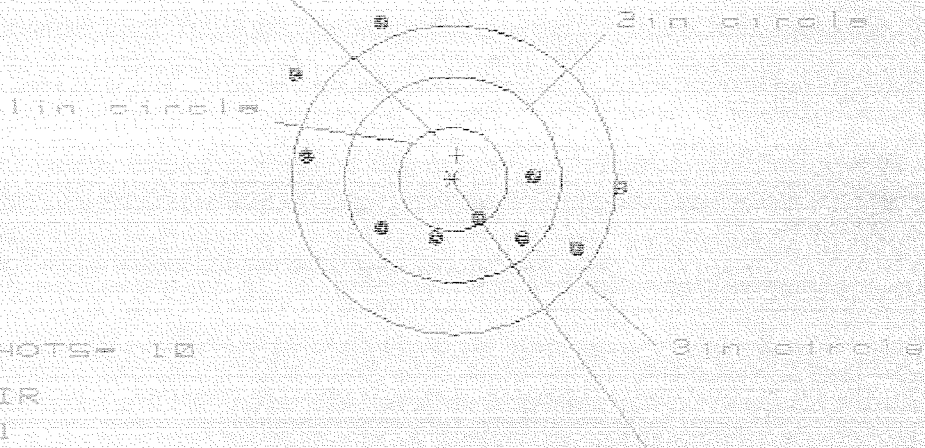


23 Aug 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C663B318

# CENTERFIRE PATTERNS # 1

POB



# OF SHOTS= 10

# IN CIR

1 in = 1

2 in = 5

3 in = 7

HS= 3.053

VS= 2.210

GS= 3.231

CENTROID +

| PATTERN #                     | : |        |        |        |
|-------------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)               | : | 10     | 9      | 8      |
| MAXIMUM X                     | : | 1.580  | 1.417  | 1.211  |
| MINIMUM X                     | : | -1.473 | -1.506 | -1.612 |
| MAXIMUM Y                     | : | 1.536  | 1.647  | .548   |
| MINIMUM Y                     | : | -.675  | -.563  | -.357  |
| CENTROID X                    | : | -.039  | .124   | .230   |
| CENTROID Y                    | : | -.231  | -.343  | -.549  |
| POB TO CENTROID in.           | : | .295   | .365   | .595   |
| MIN RADIUS                    | : | .476   | .306   | .039   |
| MEAN RADIUS                   | : | 1.132  | 1.008  | .832   |
| MAX RADIUS                    | : | 1.782  | 1.850  | 1.702  |
| HORIZONTAL SPREAD             | : | 3.053  | 2.923  | 2.923  |
| VERTICAL SPREAD               | : | 2.210  | 2.210  | .985   |
| EXTREME SPREAD                | : | 3.231  | 2.937  | 2.937  |
| NUMBER IN ONE INCH CIRCLE =   |   |        | 1      |        |
| NUMBER IN TWO INCH CIRCLE =   |   |        | 5      |        |
| NUMBER IN THREE INCH CIRCLE = |   |        | 7      |        |

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FILE:/PATTERNING/CENTERFIRE\_PATT/06636318

# CENTERFIRE PATTERNS

# 2

POA

1in circle

2in circle

3in circle

# OF SHOTS= 10

# IN CIR

1in = 1

2in = 3

3in = 8

HS= 2.449

VS= 3.038

GS= 3.133

CENTROID #

|                               |   |        |        |        |
|-------------------------------|---|--------|--------|--------|
| PATTERN #                     | : | 2      |        |        |
| SHOTS (BEST OF)               | : | 10     | 9      | 8      |
| MAXIMUM X                     | : | 1.286  | 1.231  | 1.145  |
| MINIMUM X                     | : | -1.244 | -1.218 | -1.384 |
| MAXIMUM Y                     | : | 1.638  | 1.389  | 1.243  |
| MINIMUM Y                     | : | -1.392 | -1.210 | -1.358 |
| CENTROID X                    | : | -1.118 | -1.143 | -1.057 |
| CENTROID Y                    | : | .029   | -1.153 | -1.007 |
| POA TO CENTROID IN.           | : | .121   | .218   | .058   |
| MIN RADIUS                    | : | .382   | .520   | .378   |
| MEAN RADIUS                   | : | 1.126  | 1.062  | 1.005  |
| MAX RADIUS                    | : | 1.654  | 1.390  | 1.390  |
| HORIZONTAL SPREAD             | : | 2.449  | 2.449  | 2.449  |
| VERTICAL SPREAD               | : | 3.038  | 2.599  | 2.599  |
| EXTREME SPREAD                | : | 3.133  | 2.638  | 2.634  |
| NUMBER IN ONE INCH CIRCLE =   |   |        | 1      |        |
| NUMBER IN TWO INCH CIRCLE =   |   |        | 3      |        |
| NUMBER IN THREE INCH CIRCLE = |   |        | 8      |        |



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FILE:/PATTERNING/CENTERFIRE\_PATT/C6636318

# CENTERFIRE PATTERNS # 3

FOR

1 in circle

2 in circle

3 in circle

# OF SHOTS= 10

# IN CIR

1 in = 3

2 in = 10

3 in = 10

HS= 1.460

VS= 1.561

GS= 1.775

CENTROID \*

PATTERN #

:

3

SHOTS (BEST OF)

:

10

3

8

MAXIMUM X

:

.714

.665

.428

MINIMUM X

:

-.746

-.795

-.712

MAXIMUM Y

:

.873

.662

.653

MINIMUM Y

:

-.688

-.591

-.509

CENTROID X

:

.034

.083

.000

CENTROID Y

:

.000

-.097

-.179

FOR TO CENTROID in.

:

.034

.128

.179

MIN RADIUS

:

.250

.145

.190

MEAN RADIUS

:

.650

.595

.553

MAX RADIUS

:

.980

.938

.751

HORIZONTAL SPREAD

:

1.460

1.460

1.140

VERTICAL SPREAD

:

1.561

1.253

1.162

EXTREME SPREAD

:

1.775

1.775

1.434

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

10

NUMBER IN THREE INCH CIRCLE =

10

23 Aug 1981

FILE: \PATTERNING\CENTERFIRE\_PATT\06636318

# CENTERFIRE PATTERNS # 4

FOR

1 in circle

2 in circle

3 in circle

CENTROID \*

# OF SHOTS= 10

# IN CIR

1 in = 0

2 in = 2

3 in = 9

HS= 2.485

VS= 2.267

GS= 3.207

PATTERN #

1

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.285

1.304

1.393

MINIMUM X

-1.200

-1.058

-0.894

MAXIMUM Y

1.143

1.249

1.143

MINIMUM Y

-1.124

-0.998

-1.099

CENTROID X

-0.141

-0.289

-0.447

CENTROID Y

-0.060

-0.186

-0.085

FOR TO CENTROID IN.

.153

.339

.455

MIN RADIUS

.919

.754

.638

MEAN RADIUS

1.233

1.162

1.092

MAX RADIUS

1.719

1.536

1.399

HORIZONTAL SPREAD

2.485

2.362

2.297

VERTICAL SPREAD

2.267

2.247

2.247

EXTREME SPREAD

3.207

2.770

2.496

NUMBER IN ONE INCH CIRCLE =

0

NUMBER IN TWO INCH CIRCLE =

2

NUMBER IN THREE INCH CIRCLE =

9

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C8&3E318

# CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

# OF SHOTS= 10

# IN CIR

1in = 2

2in = 4

3in = 7

HS= 4.221

VS= 1.814

GS= 4.332

CENTROID \*

PATTERN #

SHOTS (BEST OF)

MAXIMUM X

MINIMUM X

MAXIMUM Y

MINIMUM Y

CENTROID X

CENTROID Y

POA TO CENTROID in.

MIN RADIUS

MEAN RADIUS

MAX RADIUS

HORIZONTAL SPREAD

VERTICAL SPREAD

EXTREME SPREAD

NUMBER IN ONE INCH CIRCLE =

NUMBER IN TWO INCH CIRCLE =

NUMBER IN THREE INCH CIRCLE =

10

9

8

1.780

1.509

1.008

-2.441

-1.601

-1.418

.733

.767

.688

-1.081

-1.047

-1.126

-.265

.006

-.182

.172

.138

.217

.316

.138

.283

.192

.110

.114

1.114

.919

.821

2.461

1.636

1.511

4.221

3.110

2.421

1.814

1.814

1.814

4.332

3.215

2.715

2

4

7