

C6648942

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<sup>TM</sup> H24

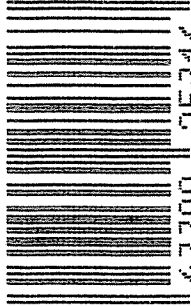
20

SERIAL NO.  
C6648942

ORDER NO.  
5716

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

UPC



0 47700 25716 7



5716 C6648942

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6648942

| OP. #        | OP. NAME                                                       | READINGS | DATE        | INIT |
|--------------|----------------------------------------------------------------|----------|-------------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   | 7 2 9 1  |             | RW   |
| 600          | Proof                                                          | 7 2 9 1  |             | RW   |
| 607          | Check Headspace                                                | 7 2 9 1  |             | RW   |
| 610          | Dis-assemble Gun                                               | 7 2 9 1  |             | RW   |
| 612          | Magnaflux Barrel<br>Action                                     |          | JUL 22 1991 | LS   |
|              | Magnaflux Bolt                                                 |          | JUL 22 1991 | LS   |
| 615          | Rollmark Caliber                                               |          | JUL 22 1991 | LS   |
| 617          | Drill and Tap Sight Holes                                      |          | JUL 22 1991 | LB   |
| 618          | Polish Barrel                                                  |          | 7/22/91     | LB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 8/2/91      | LB   |
|              | Apply Coating (Bolt)                                           |          |             | LB   |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 8/9/91      | RW   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 8/9/91      | RW   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 8/9/91      | RW   |
|              | D) Oil Firing Pin Ass'y                                        |          | 8/9/91      | RW   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 8/9/91      | JS   |

| op. #        | OP. NAME                                                    | READINGS |      |      |      |      | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|------|------|------|------|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 7        | 7    | 7    |      |      | 8-19-91 | DH   |
|              | G) Safety Off Force                                         | 5        | 5    | 5    |      |      | 8-19-91 | DH   |
|              | H) Trigger Pull Test & Retainability                        |          |      |      |      |      | 8/19/91 | DH   |
|              | I) Firing Pin Indent                                        | .022     | .023 | .022 |      |      | 8-19-91 | DH   |
|              | J) Assemble Stock                                           |          |      |      |      |      | 8/20/91 | RW   |
|              | K) Assemble Swivel Studs                                    |          |      |      |      |      | 8-21-91 | AC   |
|              | L) Attach Front and Rear Sight Assemblies                   |          |      |      |      |      | 8/20/91 | RW   |
|              | M) Iron Sight Alignment                                     |          |      |      |      |      | 8/20/91 | RW   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |      |      |      |      | 8/20/91 | RW   |
|              | O) Attach Scope to Rifle                                    |          |      |      |      |      | 8/20/91 | RW   |
|              | P) Detach & Attach Scope 20 Times                           |          |      |      |      |      | 8/20/91 | RW   |
| 640          | Gallery Target & Test                                       |          |      |      |      |      | 8-20-91 | DH   |
|              | A) Time                                                     |          |      |      |      |      | 8-20-91 | DH   |
|              | B) Malfunctions                                             |          |      |      |      |      | 8-20-91 | DH   |
|              | C) Pierced Primers                                          |          |      |      |      |      | 8-20-91 | DH   |
|              | D) Optical Clarity of Scope                                 |          |      |      |      |      | 8-20-91 | DH   |
| 645          | Inspect for Live Ammo                                       |          |      |      |      |      | 8-20-91 | DH   |
| 655          | Final Inspection                                            |          |      |      |      |      |         |      |
|              | A) Headspace                                                |          |      |      |      |      | 8-21-91 | AC   |
|              | B) Trigger Pull                                             | 2.21     | 2.27 | 2.21 | 2.16 | 2.19 | 8-20-91 | DH   |
|              | C) Function                                                 |          |      |      |      |      | 8-21-91 | AC   |
| 660          | Pack                                                        |          |      |      |      |      | 9-18-91 | NF   |

SWS TRIGGER PULL TEST

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

SERIAL NO. C6648942  
DATE 8-19-91  
TESTER JH

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.39             | 2.44                     | 2.40                           | 2.21 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.52             | 2.54                     | 2.38                           | 2.27 |                                                                        |
| PULL #3 | 2.56             | 2.48                     | 2.35                           | 2.21 |                                                                        |
| PULL #4 | 2.61             | 2.24                     | 2.29                           | 2.16 |                                                                        |
| PULL #5 | 2.67             | 2.42                     | 2.43                           | 2.19 |                                                                        |
| TOTAL   |                  |                          |                                |      |                                                                        |
| AVG.    |                  |                          |                                |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.37             | 3.77                     |  |          |
| PULL #2 | 3.65             | 3.58                     |  |          |
| PULL #3 | 3.46             | 3.69                     |  |          |
| PULL #4 | 3.68             | 3.50                     |  |          |
| PULL #5 | 3.48             | 3.45                     |  |          |
| 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 | 4.34             | 4.20                     |                                | 4.44                                 |
| PULL #2 | 4.49             | 4.38                     |                                | 4.26                                 |
| PULL #3 | 4.49             | 4.38                     |                                | 4.42                                 |
| PULL #4 | 4.57             | 4.28                     |                                | 4.50                                 |
| PULL #5 | 4.60             | 4.40                     |                                | 4.40                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6648942  
22 Aug 1991

CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| 0 TO | 1 | .317241 |
| 1 TO | 2 | .574252 |
| 1 TO | 3 | 1.3736  |
| 1 TO | 4 | .402906 |
| 1 TO | 5 | .330442 |

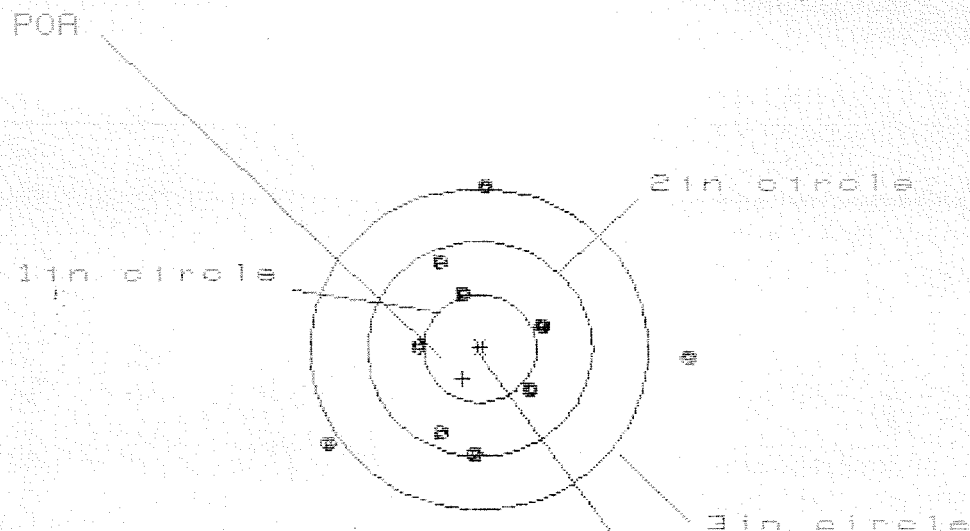
$\frac{1}{4}$  <----POB  
B

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0876  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1788  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .199106  
THE AMR FOR THIS RIFLE IS: .9824

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6548942

# CENTERFIRE PATTERNS # 1



# OF SHOTS= 10

# IN CIR

1in = 0

2in = 6

3in = 7

HS= 3.120

VS= 2.533

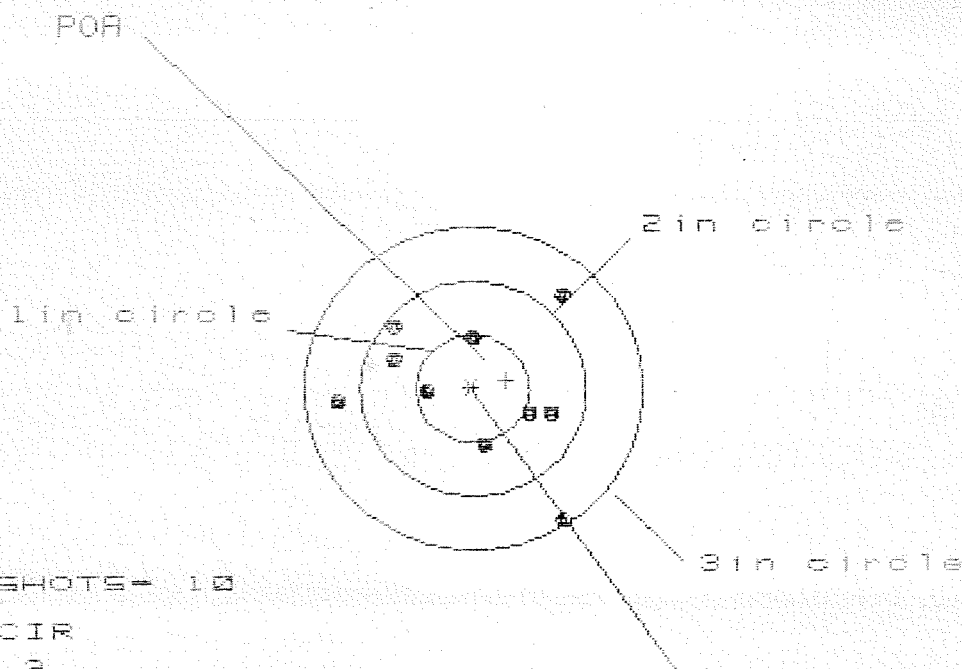
GS= 3.215

| PATTERN #                   | : | 10     | 9      | 8      |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.800  | .776   | .636   |
| MINIMUM X                   | : | -1.320 | -1.119 | -.503  |
| MAXIMUM Y                   | : | 1.514  | 1.502  | 1.388  |
| MINIMUM Y                   | : | -1.018 | -1.031 | -1.145 |
| CENTROID X                  | : | .151   | -.050  | .090   |
| CENTROID Y                  | : | .279   | .292   | .406   |
| POA TO CENTROID in.         | : | .317   | .297   | .416   |
| MIN RADIUS                  | : | .564   | .364   | .452   |
| MEAN RADIUS                 | : | 1.004  | .900   | .822   |
| MAX RADIUS                  | : | 1.804  | 1.521  | 1.392  |
| HORIZONTAL SPREAD           | : | 3.120  | 1.895  | 1.139  |
| VERTICAL SPREAD             | : | 2.533  | 2.533  | 2.533  |
| EXTREME SPREAD              | : | 3.215  | 2.765  | 2.535  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 0      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 6      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 7      |        |

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FILE:/PATTERNING/CENTERFIRE\_PATT/C6648942

# CENTERFIRE PATTERNS # 2



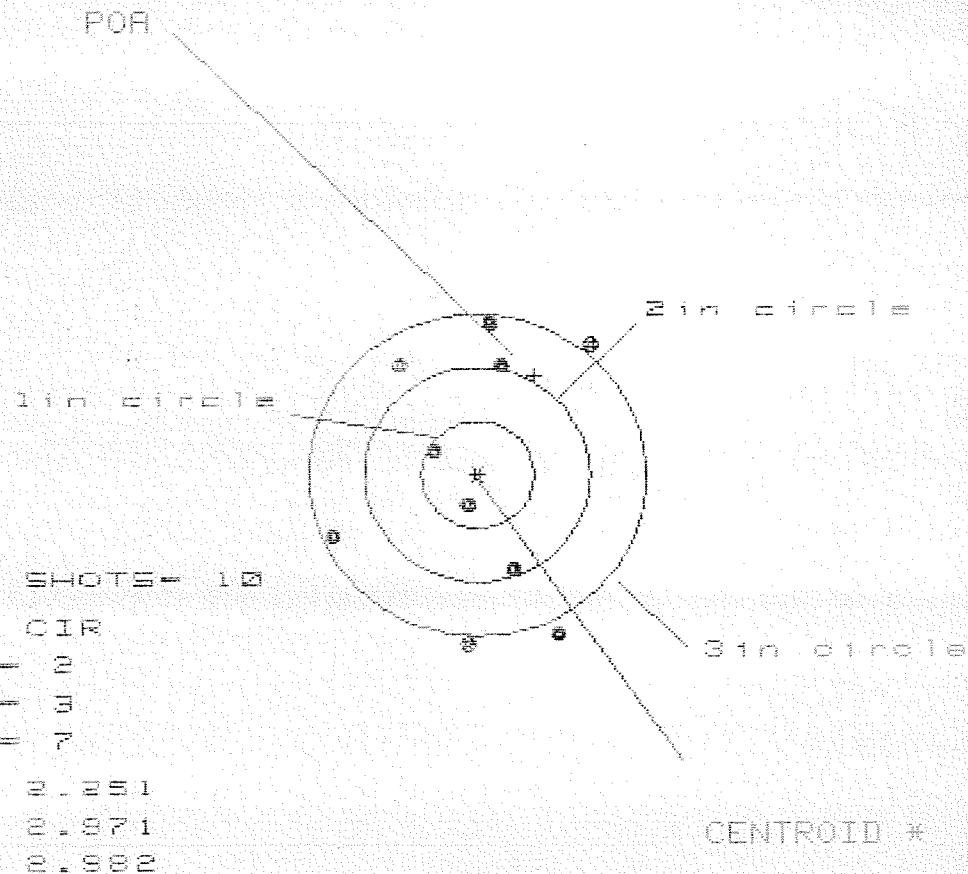
HS= 2.015  
VS= 2.025  
GS= 2.315

|                             |   |        |        |       |
|-----------------------------|---|--------|--------|-------|
| PATTERN #                   | : | 2      |        |       |
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | .832   | .871   | .735  |
| MINIMUM X                   | : | -1.183 | -1.091 | -.750 |
| MAXIMUM Y                   | : | .846   | .715   | .686  |
| MINIMUM Y                   | : | -1.179 | -.664  | -.693 |
| CENTROID X                  | : | -.298  | -.390  | -.254 |
| CENTROID Y                  | : | -.079  | .052   | .001  |
| POA TO CENTROID in.         | : | .308   | .394   | .266  |
| MIN RADIUS                  | : | .361   | .286   | .279  |
| MEAN RADIUS                 | : | .805   | .716   | .666  |
| MAX RADIUS                  | : | 1.443  | 1.127  | 1.006 |
| HORIZONTAL SPREAD           | : | 2.015  | 1.962  | 1.485 |
| VERTICAL SPREAD             | : | 2.025  | 1.379  | 1.379 |
| EXTREME SPREAD              | : | 2.315  | 2.178  | 1.594 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 7      |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 10     |       |

22 Aug 1981

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# CENTERFIRE PATTERNS # 3

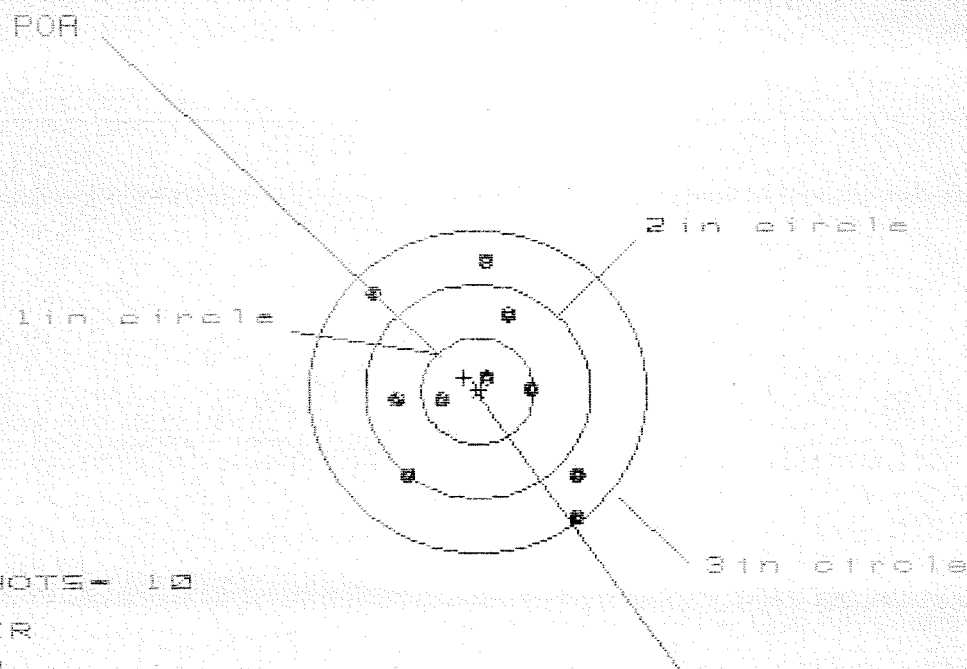


| PATTERN #                     | 3      | 9      | 8      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.997  | 1.080  | 1.083  |
| MINIMUM X                     | -1.254 | -1.171 | -1.168 |
| MAXIMUM Y                     | 1.386  | 1.218  | .999   |
| MINIMUM Y                     | -1.585 | -1.753 | -1.297 |
| CENTROID X                    | -.512  | -.595  | -.598  |
| CENTROID Y                    | -.924  | -.756  | -.537  |
| POA TO CENTROID in.           | 1.057  | .963   | .804   |
| MIN RADIUS                    | .273   | .259   | .327   |
| MEAN RADIUS                   | 1.154  | 1.078  | .980   |
| MAX RADIUS                    | 1.685  | 1.753  | 1.526  |
| HORIZONTAL SPREAD             | 2.251  | 2.251  | 2.251  |
| VERTICAL SPREAD               | 2.971  | 2.971  | 2.296  |
| EXTREME SPREAD                | 2.982  | 2.982  | 2.881  |
| NUMBER IN ONE INCH CIRCLE =   | 2      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 3      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 7      |        |        |

22 Aug 1991

FILE://PATTERNING/CENTERFIRE\_PATT/C8640342

# CENTERFIRE PATTERNS # 4



# OF SHOTS = 10

# IN CIR

1 in = 3

2 in = 6

3 in = 10

HS = 1.803

VS = 2.439

GS = 2.738

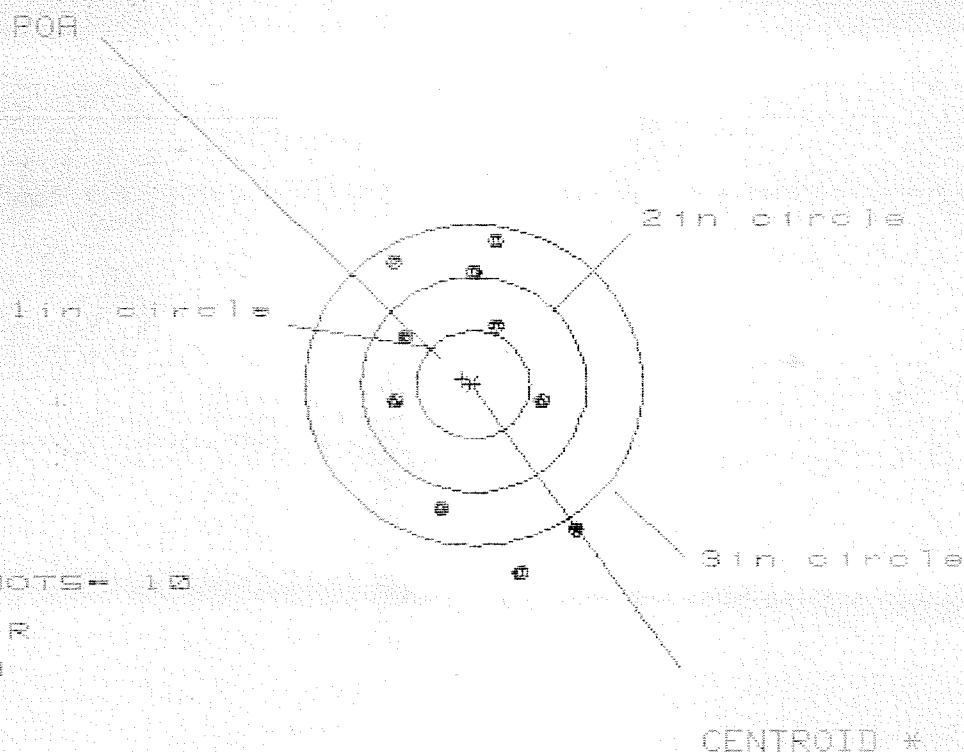
CENTROID \*

|                               |   |        |       |       |
|-------------------------------|---|--------|-------|-------|
| PATTERN #                     | : | 4      |       |       |
| SHOTS (BEST OF)               | : | 10     | 9     | 8     |
| MAXIMUM X                     | : | .876   | .965  | .861  |
| MINIMUM X                     | : | -.927  | -.830 | -.730 |
| MAXIMUM Y                     | : | 1.257  | 1.125 | 1.219 |
| MINIMUM Y                     | : | -1.182 | -.931 | -.837 |
| CENTROID X                    | : | .124   | .027  | .131  |
| CENTROID Y                    | : | -.123  | .009  | -.085 |
| POA TO CENTROID in.           | : | .175   | .028  | .156  |
| MIN RADIUS                    | : | .085   | .148  | .050  |
| MEAN RADIUS                   | : | .849   | .775  | .715  |
| MAX RADIUS                    | : | 1.471  | 1.341 | 1.219 |
| HORIZONTAL SPREAD             | : | 1.803  | 1.795 | 1.591 |
| VERTICAL SPREAD               | : | 2.439  | 2.056 | 2.056 |
| EXTREME SPREAD                | : | 2.738  | 2.456 | 2.221 |
| NUMBER IN ONE INCH CIRCLE =   |   |        | 3     |       |
| NUMBER IN TWO INCH CIRCLE =   |   |        | 6     |       |
| NUMBER IN THREE INCH CIRCLE = |   |        | 10    |       |

22 Aug 1991

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# CENTERFIRE PATTERNS # 5



# OF SHOTS= 10

# IN CIR

1in = 0

2in = 4

3in = 8

HS= 1.578

VS= 3.115

GS= 3.155

| PATTERN #                     | 5      | 9      | 8      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | .882   | .930   | .778   |
| MINIMUM X                     | -.696  | -.648  | -.532  |
| MAXIMUM Y                     | 1.344  | 1.147  | .958   |
| MINIMUM Y                     | -1.771 | -1.519 | -1.513 |
| CENTROID X                    | .097   | .050   | -.066  |
| CENTROID Y                    | -.047  | .150   | .339   |
| POA TO CENTROID in.           | .108   | .158   | .346   |
| MIN RADIUS                    | .543   | .394   | .380   |
| MEAN RADIUS                   | 1.100  | .980   | .838   |
| MAX RADIUS                    | 1.822  | 1.781  | 1.521  |
| HORIZONTAL SPREAD             | 1.578  | 1.578  | 1.310  |
| VERTICAL SPREAD               | 3.115  | 2.666  | 2.471  |
| EXTREME SPREAD                | 3.155  | 2.956  | 2.528  |
| NUMBER IN ONE INCH CIRCLE =   | 0      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 4      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 8      |        |        |