

C6611705

MODEL 700™ M24

Model **545**™

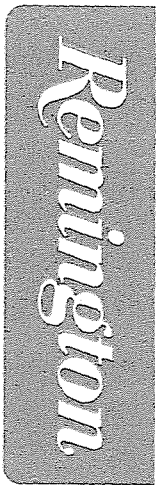
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



M2400034603

Remington[®]



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

MODEL 700TM M24

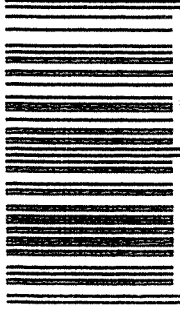
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off. Marca Registrada Marque Deposee.



5716 C6611705

UPC



0 47700 25716 7

SERIAL NO.

C6611705

ORDER NO.

5716

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611705

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 28	9 1	RW
600	Proof	3 28	9 1	RW
607	Check Headspace	3 28	9 1	RW
610	Dis-assemble Gun	3 28	9 1	RW
612	Magnaflux Barrel Action	APR	2 1991	KR
	Magnaflux Bolt	APR	2 1991	U
615	Rollmark Caliber	APR	2 1991	GS
617	Drill and Tap Sight Holes	APR	5 1991	EB
618	Polish Barrel	APR	5 1991	WB
620	Apply Coatings (Barrel Action)		4-9-91	TA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		4/10/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/10/91	RW
	C) Inspect Ejector Hole for Chamfer		4/10/91	RW
	D) Oil Firing Pin Ass'y		4/10/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake.		5/1/91	GM

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5/1/91	JH
	G) Safety Off Force	4	4	4			5/1/91	JH
	H) Trigger Pull Test & Retainability						5/1/91	JH
	I) Firing Pin Indent	.0215	.0215	.0215			5/1/91	JH
	J) Assemble Stock						5/1/91	Rw
	K) Assemble Swivel Studs						5-13-91	D/H
	L) Attach Front and Rear Sight Assemblies						5/1/91	Rw
	M) Iron Sight Alignment						5/1/91	Rw
	N) Detach Front & Rear Sights & place in numbered container						5/1/91	Rw
	O) Attach Scope to Rifle						5/1/91	Rw
	P) Detach & Attach Scope 20 Times						5/1/91	Rw
640	Gallery Target & Test						5-1-91	D/H
	A) Time						5-1-91	D/H
	B) Malfunctions						5-1-91	D/H
	C) Pierced Primers						5-1-91	D/H
	D) Optical Clarity of Scope						5-1-91	D/H
645	Inspect for Live Ammo						5-1-90	D/H
655	Final Inspection							
	A) Headspace						5-13-91	D/H
	B) Trigger Pull	2.57	2.42	2.50	2.60	2.55	5/10/91	JH
	C) Function						5-13-91	D/H
660	Pack						6-19-91	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6611705

DATE 5/1/91

TESTER JEL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.20	2.33	2.57	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.47	2.29	2.35	2.42	
PULL #3	2.45	2.23	2.40	2.50	
PULL #4	2.40	2.30	2.28	2.60	
PULL #5	2.56	2.44	2.36	2.55	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.57	3.30		
PULL #2	3.30	3.36		
PULL #3	3.50	3.38		
PULL #4	3.48	3.40		
PULL #5	3.40	3.49		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.36	4.42		4.63
PULL #2	4.35	4.43		4.30
PULL #3	4.33	4.41		4.63
PULL #4	4.29	4.40		4.46
PULL #5	4.23	4.41		4.46
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611705
1 May 1991

CENTROIDAL DISTANCES

0 TO 1	.280045
1 TO 2	.419981
1 TO 3	.39685
1 TO 4	.616536
1 TO 5	.28048

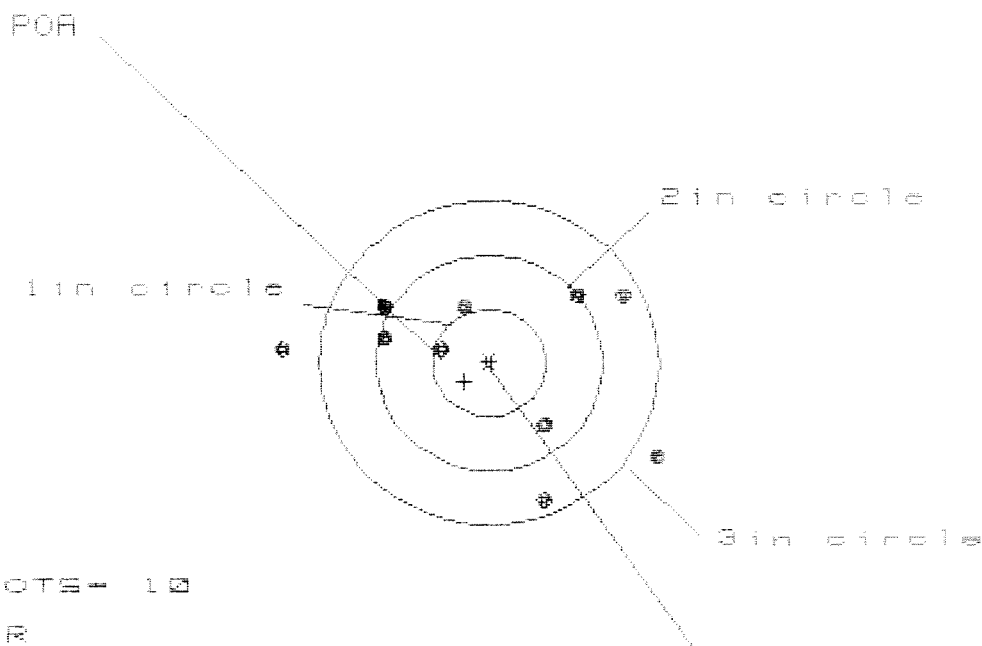
49¹₂ <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0496
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0178
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0526972
THE AMR FOR THIS RIFLE IS: .976

1 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08611785

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 3.347

VS= 1.975

GS= 3.503

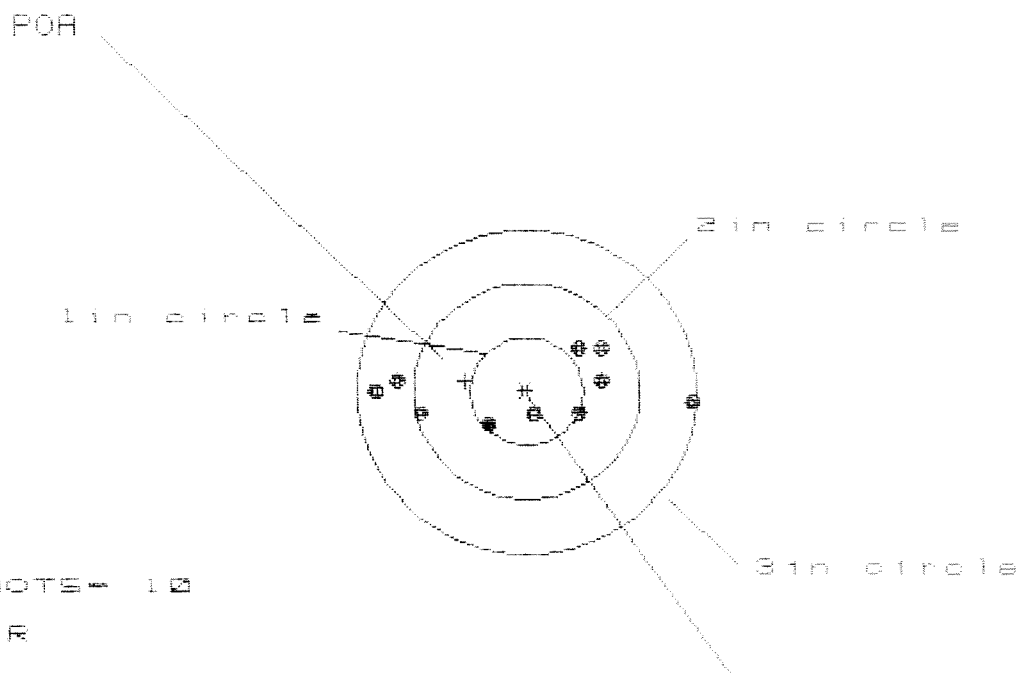
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.480	1.273	1.105
MINIMUM X	:	-1.867	-1.104	-1.945
MAXIMUM Y	:	.666	.681	.569
MINIMUM Y	:	-1.309	-1.294	-1.405
CENTROID X	:	.221	.428	.269
CENTROID Y	:	.172	.157	.269
POA TO CENTROID in.	:	.280	.456	.380
MIN RADIUS	:	.433	.613	.462
MEAN RADIUS	:	1.098	1.017	.915
MAX RADIUS	:	1.871	1.552	1.458
HORIZONTAL SPREAD	:	3.347	2.377	2.050
VERTICAL SPREAD	:	1.975	1.975	1.975
EXTREME SPREAD	:	3.503	2.750	2.230
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

1 May 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS = 0.749

VS = .723

GS = 0.749

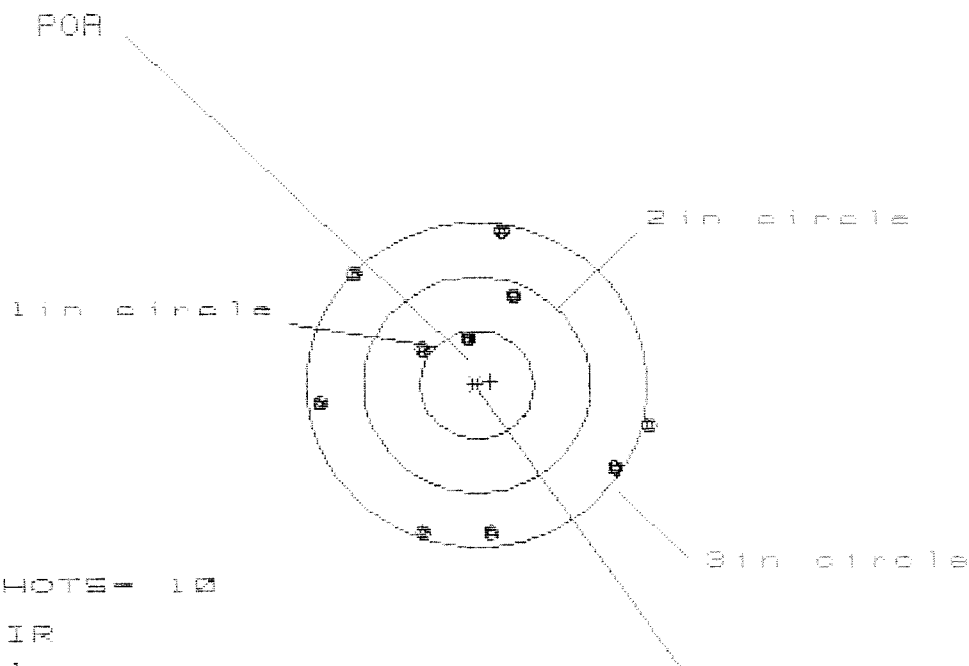
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.430	.794	.649
MINIMUM X	:	-1.319	-1.160	-1.130
MAXIMUM Y	:	.425	.417	.413
MINIMUM Y	:	-.298	-.306	-.310
CENTROID X	:	.541	.382	.527
CENTROID Y	:	-.100	-.092	-.088
POA TO CENTROID in.	:	.550	.393	.535
MIN RADIUS	:	.210	.322	.227
MEAN RADIUS	:	.806	.748	.666
MAX RADIUS	:	1.431	1.161	1.135
HORIZONTAL SPREAD	:	2.749	1.954	1.779
VERTICAL SPREAD	:	.723	.723	.723
EXTREME SPREAD	:	2.749	1.998	1.800
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

1 May 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 8

HS= 2.866

VS= 2.821

GS= 2.938

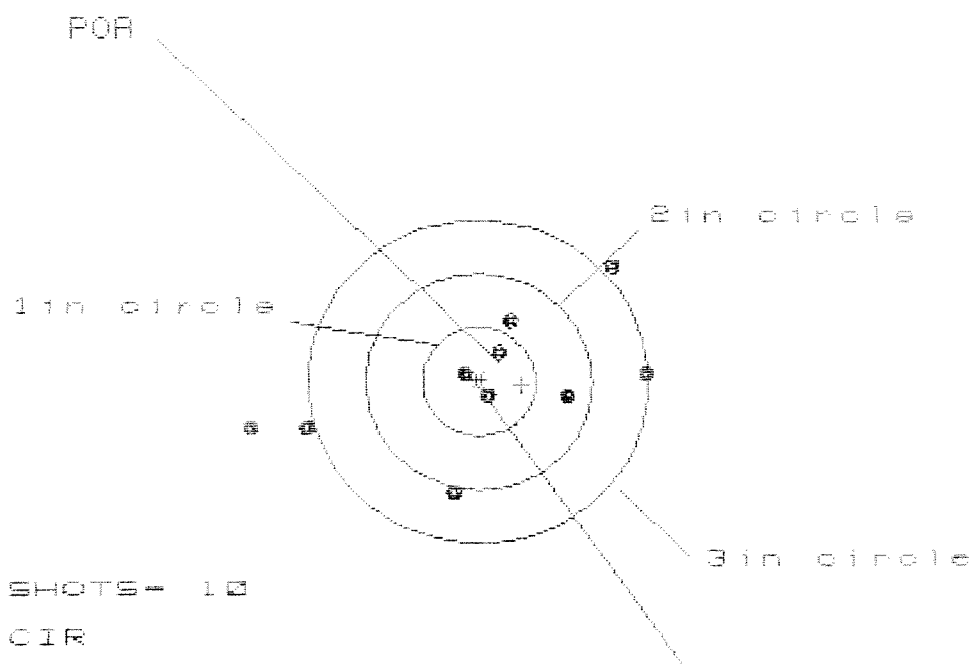
CENTROID *

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.505	1.396	1.286
MINIMUM X	-1.361	-1.194	-1.304
MAXIMUM Y	1.419	1.377	1.507
MINIMUM Y	-1.402	-1.444	-1.314
CENTROID X	-.120	-.287	-.177
CENTROID Y	-.031	.011	-.119
POA TO CENTROID in.	.124	.287	.213
MIN RADIUS	.413	.383	.497
MEAN RADIUS	1.202	1.139	1.129
MAX RADIUS	1.551	1.596	1.526
HORIZONTAL SPREAD	2.866	2.590	2.590
VERTICAL SPREAD	2.821	2.821	2.821
EXTREME SPREAD	2.938	2.908	2.890
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	8		

1 May 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 6

HS= 3.500

VS= 2.070

GS= 3.534

CENTROID #

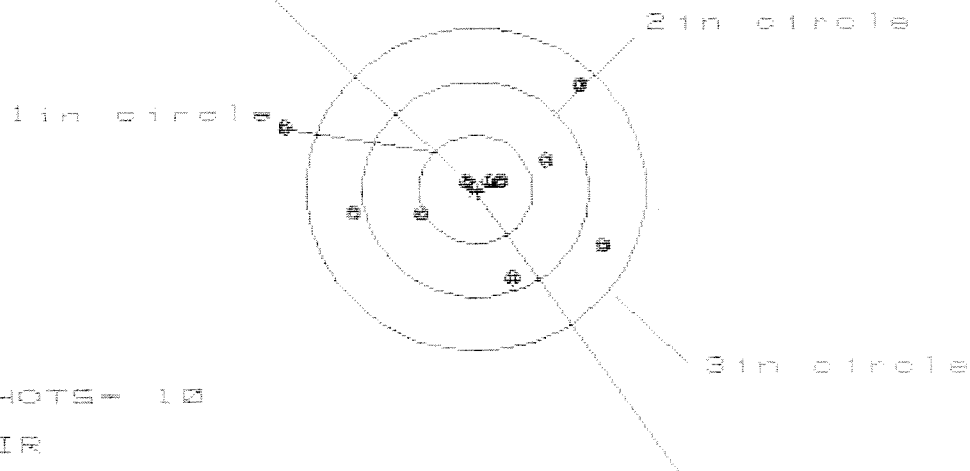
PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.507	1.286	1.070
MINIMUM X	:	-1.993	-1.725	-.702
MAXIMUM Y	:	1.050	1.008	.952
MINIMUM Y	:	-1.020	-1.062	-1.117
CENTROID X	:	-.378	-.157	.059
CENTROID Y	:	.026	.069	.124
POA TO CENTROID in.	:	.379	.171	.138
MIN RADIUS	:	.170	.208	.336
MEAN RADIUS	:	.976	.836	.724
MAX RADIUS	:	2.030	1.781	1.320
HORIZONTAL SPREAD	:	3.500	3.011	1.772
VERTICAL SPREAD	:	2.070	2.070	2.070
EXTREME SPREAD	:	3.534	3.052	2.505
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	6		

1 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8B11785

CENTERFIRE PATTERNS # 5

POA



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 9

HS= 2.801

VS= 1.828

GS= 3.024

CENTROID #

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.135	.950	1.045
MINIMUM X	-1.666	-1.232	-1.137
MAXIMUM Y	.985	1.048	.431
MINIMUM Y	-.843	-.780	-.648
CENTROID X	-.016	.169	.074
CENTROID Y	.022	-.041	-.173
POA TO CENTROID in.	.027	.174	.188
MIN RADIUS	.103	.103	.236
MEAN RADIUS	.798	.684	.623
MAX RADIUS	1.762	1.296	1.139
HORIZONTAL SPREAD	2.801	2.182	2.182
VERTICAL SPREAD	1.828	1.828	1.080
EXTREME SPREAD	3.024	2.351	2.203
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	