

06649101

MODEL 700TH M24

Model 545TH

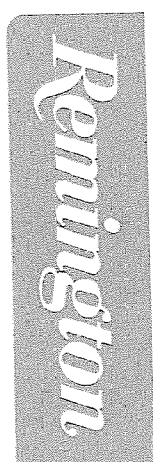
Action _____

Barrel Length _____

Capacity _____

Order No. 5715

*Includes 1 in chamber.



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

MODEL 700™ H24

MADE IN LION, 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.
C6649101

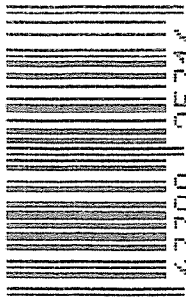
ORDER NO.
5716

20



5716 C6649101

UPC



0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649101

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action 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 Action		JUL 22 1991	GS
	Magnaflux Bolt		JUL 22 1991	GS
615	Rollmark Caliber		JUL 22 1991	GS
617	Drill and Tap Sight Holes		JUL 22 1991	LB
618	Polish Barrel		7/22/91	WB
620	Apply Coatings (Barrel Action)		7-2-91	LB
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/9/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/9/91	RW
	C) Inspect Ejector Hole for Chamfer		8/9/91	RW
	D) Oil Firing Pin Ass'y		8/9/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8-12-91	JH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			8-12-91	SH
	G) Safety Off Force	3	3	3			8-12-91	SH
	H) Trigger Pull Test & Retainability						8-12-91	SH
	I) Firing Pin Indent	.0205	.0205	.0205			8-12-91	SH
	J) Assemble Stock						8-14-91	RW
	K) Assemble Swivel Studs						8-15-91	D/H
	L) Attach Front and Rear Sight Assemblies						8-14-91	RW
	M) Iron Sight Alignment						8-14-91	RW
	N) Detach Front & Rear Sights & place in numbered container						8-14-91	RW
	O) Attach Scope to Rifle						8-14-91	RW
	P) Detach & Attach Scope 20 Times						8-14-91	RW
640	Gallery Target & Test						8-14-91	D/H
	A) Time						8-14-91	D/H
	B) Malfunctions						8-14-91	D/H
	C) Pierced Primers						8-14-91	D/H
	D) Optical Clarity of Scope						8-14-91	D/H
645	Inspect for Live Ammo						8-14-91	D/H
655	Final Inspection							
	A) Headspace						8-15-91	D/H
	B) Trigger Pull	2.48	2.52	2.65	2.23	2.32	8-14-91	SH
	C) Function						8-15-91	D/H
660	Pack						7-17-91	D/H

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C6649101

DATE 8-12-91

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.48	2.46	2.48	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.42	2.45	2.50	2.52	
PULL #3	2.39	2.40	2.47	2.65	
PULL #4	2.38	2.47	2.44	2.23	
PULL #5	2.40	2.46	2.47	2.32	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.66	3.47		
PULL #2	3.54	3.24		
PULL #3	3.49	3.55		
PULL #4	3.50	3.57		
PULL #5	3.51	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	4.42	4.44		4.61
PULL #2	4.44	4.58		4.61
PULL #3	4.47	4.47		4.48
PULL #4	4.47	4.57		4.65
PULL #5	4.51	4.57		4.54
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649101
23 Aug 1991

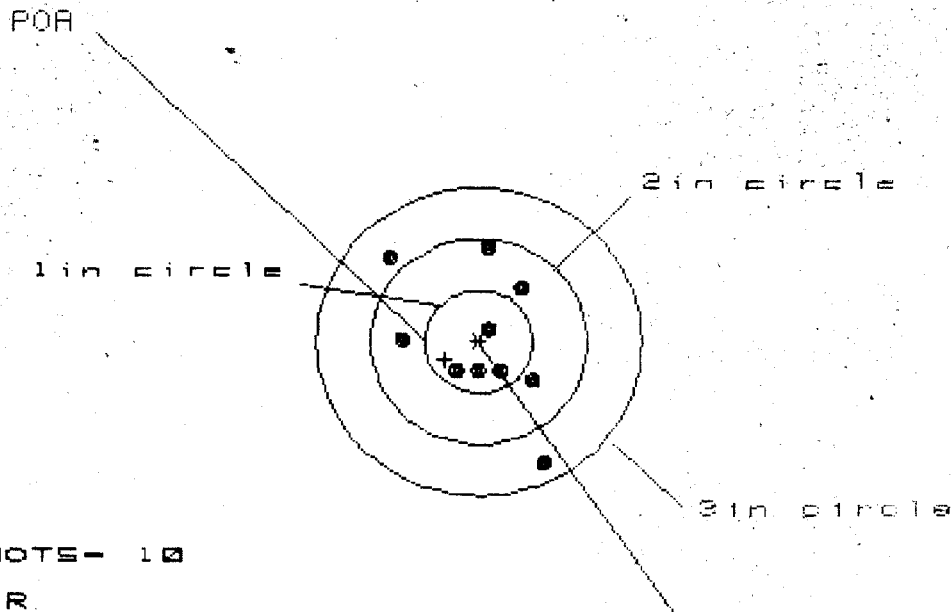
CENTROIDAL DISTANCES

0 TO	1	.359205
1 TO	2	.44801
1 TO	3	.153444
1 TO	4	.310757
1 TO	5	.196229

201 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1144
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1048
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .155140
THE AMR FOR THIS RIFLE IS: .7984

CENTERFIRE PATTERNS # 1

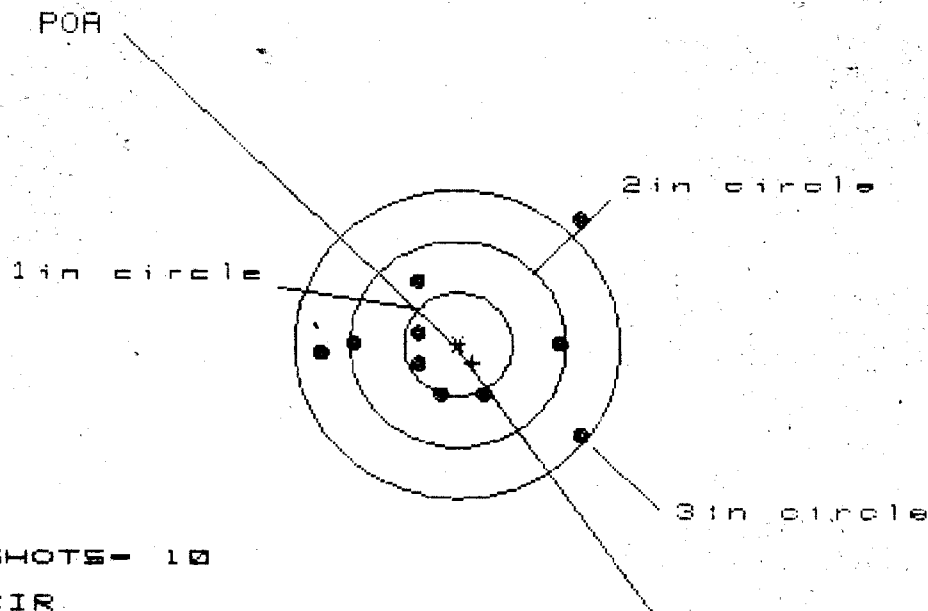


OF SHOTS- 10
 # IN CIR
 1in = 4
 2in = 8
 3in = 10
 HS = 1.419
 VS = 2.108
 GS = 2.460

CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.573	.510	.412
MINIMUM X	-.846	-.782	-.717
MAXIMUM Y	.968	.841	.934
MINIMUM Y	-1.140	-.511	-.418
CENTROID X	.312	.248	.346
CENTROID Y	.178	.305	.212
POA TO CENTROID in.	.359	.393	.406
MIN RADIUS	.116	.161	.069
MEAN RADIUS	.653	.603	.505
MAX RADIUS	1.276	1.078	.935
HORIZONTAL SPREAD	1.419	1.292	1.129
VERTICAL SPREAD	2.108	1.352	1.352
EXTREME SPREAD	2.460	1.800	1.399
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 2.349

VS= 2.120

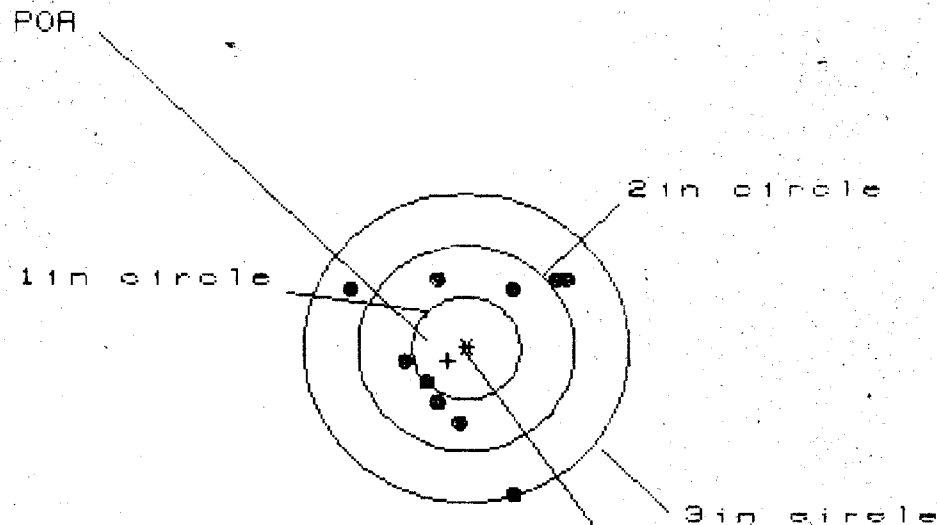
GS= 2.693

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.132	1.217	1.189
MINIMUM X	:	-1.217	-1.091	-.939
MAXIMUM Y	:	1.216	.793	.697
MINIMUM Y	:	-.904	-.769	-.461
CENTROID X	:	-.136	-.262	-.414
CENTROID Y	:	.181	.046	.142
POA TO CENTROID in.	:	.226	.266	.437
MIN RADIUS	:	.365	.284	.173
MEAN RADIUS	:	.876	.752	.634
MAX RADIUS	:	1.661	1.439	1.193
HORIZONTAL SPREAD	:	2.349	2.308	2.128
VERTICAL SPREAD	:	2.120	1.562	1.158
EXTREME SPREAD	:	2.693	2.443	2.134
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649101

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 0

2in = 6

3in = 10

HS= 1.976

VS= 2.133

GS= 2.478

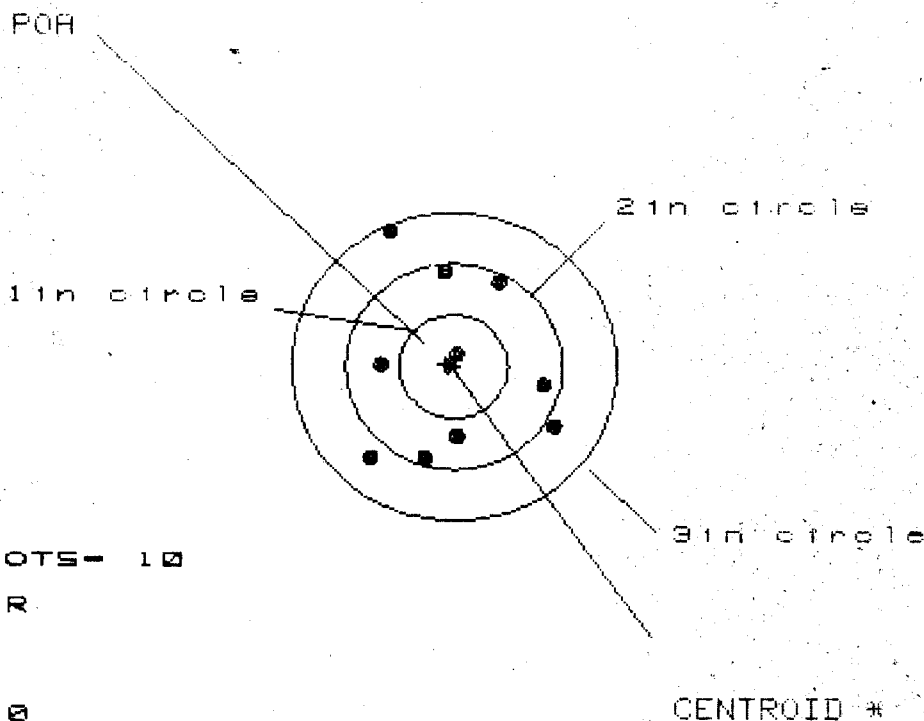
CENTROID *

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.887	.930	.799
MINIMUM X	:	-1.089	-1.046	-.609
MAXIMUM Y	:	.686	.525	.573
MINIMUM Y	:	-1.447	-.904	-.856
CENTROID X	:	.168	.125	.256
CENTROID Y	:	.125	.286	.238
POA TO CENTROID in.	:	.210	.312	.350
MIN RADIUS	:	.510	.556	.633
MEAN RADIUS	:	.879	.804	.765
MAX RADIUS	:	1.498	1.114	.964
HORIZONTAL SPREAD	:	1.976	1.976	1.408
VERTICAL SPREAD	:	2.133	1.429	1.429
EXTREME SPREAD	:	2.478	1.979	1.712
NUMBER IN ONE INCH CIRCLE =			0	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			10	

28 Aug 1981

FILE:/PATTERNING/CENTERFIRE_PATT/06649101

CENTERFIRE PATTERNS # 4



* OF SHOTS- 10

* IN CIR

1in = 1

2in = 7

3in = 10

HS= 1.747

VS= 2.228

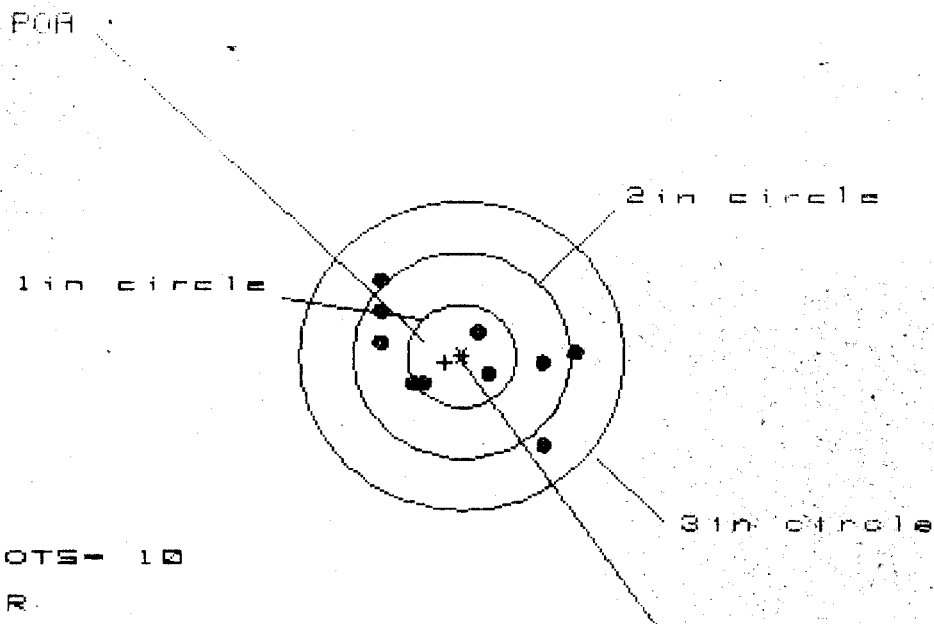
GS= 2.462

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.952	.888	.780
MINIMUM X	:	-.795	-.859	-.802
MAXIMUM Y	:	1.323	1.050	.961
MINIMUM Y	:	-.905	-.758	-.847
CENTROID X	:	.075	.139	.247
CENTROID Y	:	-.023	-.170	-.081
POA TO CENTROID in.	:	.078	.220	.260
MIN RADIUS	:	.152	.282	.218
MEAN RADIUS	:	.877	.807	.759
MAX RADIUS	:	1.444	1.114	.996
HORIZONTAL SPREAD	:	1.747	1.747	1.582
VERTICAL SPREAD	:	2.228	1.808	1.808
EXTREME SPREAD	:	2.462	2.090	1.855
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

12 Aug 1981

FILE: PATTERNING/CENTERFIRE_PATT/06649101

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR.

1in = 4

2in = 7

3in = 10

HS= 1.827

VS= 1.583

GS= 2.150

CENTROID *

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.073	1.152	1.013
MINIMUM X	:	-.754	-.675	-.531
MAXIMUM Y	:	.722	.626	.624
MINIMUM Y	:	-.861	-.362	-.364
CENTROID X	:	.153	.074	-.070
CENTROID Y	:	.063	.159	.161
POA TO CENTROID in.	:	.165	.175	.176
MIN RADIUS	:	.243	.231	.335
MEAN RADIUS	:	.707	.657	.579
MAX RADIUS	:	1.116	1.152	1.024
HORIZONTAL SPEED	:	1.827	1.827	1.544
VERTICAL SPEED	:	1.583	.988	.988
EXTREME SPEED	:	2.150	1.930	1.721
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	