

05649244

MODEL 706™ M24

Model **S45**™

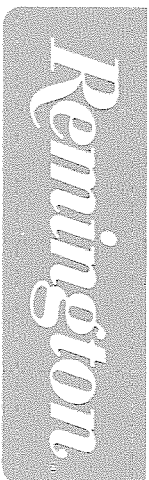
Action

Barrel Length

Capacity

Order No. **5715**™

*Includes 1 in chamber.



Remington® **DUPONT**
REG. U.S. PAT. & TM. OFF.

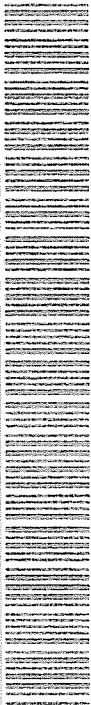
MODEL 700™ H24

SERIAL NO. C6649244

ORDER NO. 5716

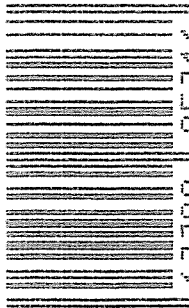
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

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



5716 C6649244

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649244

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	6 27 9 1	AW
600	Proof		6 27 9 1	AW
607	Check Headspace		6 27 9 1	AW
610	Dis-assemble Gun		6 27 9 1	AW
612	Magnaflux Barrel Action		JUL 2 1991	KR
	Magnaflux Bolt		JUL 2 1991	KR
615	Rollmark Caliber		JUL 2 1991	JS
617	Drill and Tap Sight Holes		JUL 2 1991	EB
618	Polish Barrel		JUL 7 1991	WB
620	Apply Coatings (Barrel Action)		7-22-91	DA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/23/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/23/91	RW
	C) Inspect Ejector Hole for Chamfer		7/23/91	RW
	D) Oil Firing Pin Ass'y		7/23/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8-5-91	JH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			Aug 5-91	K
	G) Safety Off Force	4	4	4			Aug 5-91	K
	H) Trigger Pull Test & Retainability						8-5-91	JH
	I) Firing Pin Indent	.020	.021	.021			Aug 5-91	AC
	J) Assemble Stock						8/6/91	RW
	K) Assemble Swivel Studs						8-7-91	JH
	L) Attach Front and Rear Sight Assemblies						8/6/91	RW
	M) Iron Sight Alignment						8/6/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/6/91	RW
	O) Attach Scope to Rifle						8/6/91	RW
	P) Detach & Attach Scope 20 Times						8/6/91	RW
640	Gallery Target & Test						8/6/91	KJ
	A) Time							KJ
	B) Malfunctions							KJ
	C) Pierced Primers							KJ
	D) Optical Clarity of Scope							KJ
645	Inspect for Live Ammo						8/6/91	KJ
655	Final Inspection							
	A) Headspace						8-7-91	JH
	B) Trigger Pull	2.22	2.22	2.20	2.23	2.24	8-7-91	JH
	C) Function						8-7-91	JH
660	Pack						9-17-91	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6649244

DATE 8-5-91

TESTER JH.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.34	2.27	2.44	2.22	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.28	2.27	2.46	2.22	
PULL #3	2.29	2.31	2.38	2.20	
PULL #4	2.29	2.27	2.30	2.23	
PULL #5	2.26	2.30	2.34	2.24	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.54	3.41		
PULL #2	3.31	3.40		
PULL #3	3.27	3.20		
PULL #4	3.40	3.34		
PULL #5	3.31	3.40		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.24	4.48		4.52
PULL #2	4.25	4.45		4.45
PULL #3	4.15	4.35		4.51
PULL #4	4.53	4.50		4.43
PULL #5	4.58	4.35		4.51
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649244
6 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.376197
1 TO	2	.4936
1 TO	3	.661011
1 TO	4	.399606
1 TO	5	.65124

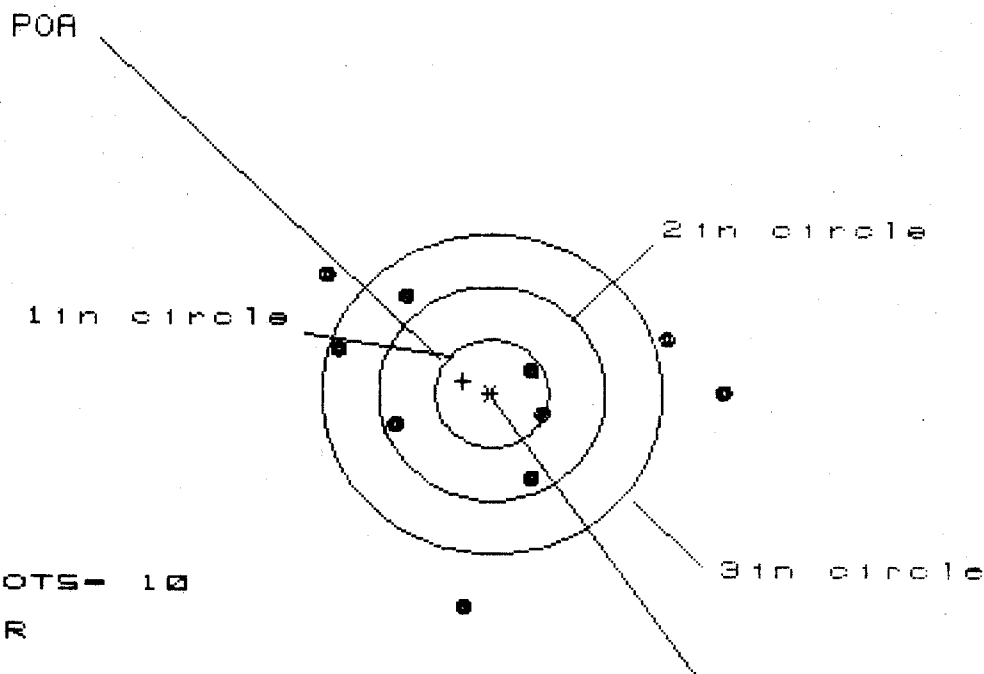
1 4 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0424
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0852
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0951672
THE AMR FOR THIS RIFLE IS: 1.026

6 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649244

CENTERFIRE PATTERNS # 5



* OF SHOTS- 10

* IN CIR

1in = 2

2in = 4

3in = 6

HS= 3.498

VS= 3.055

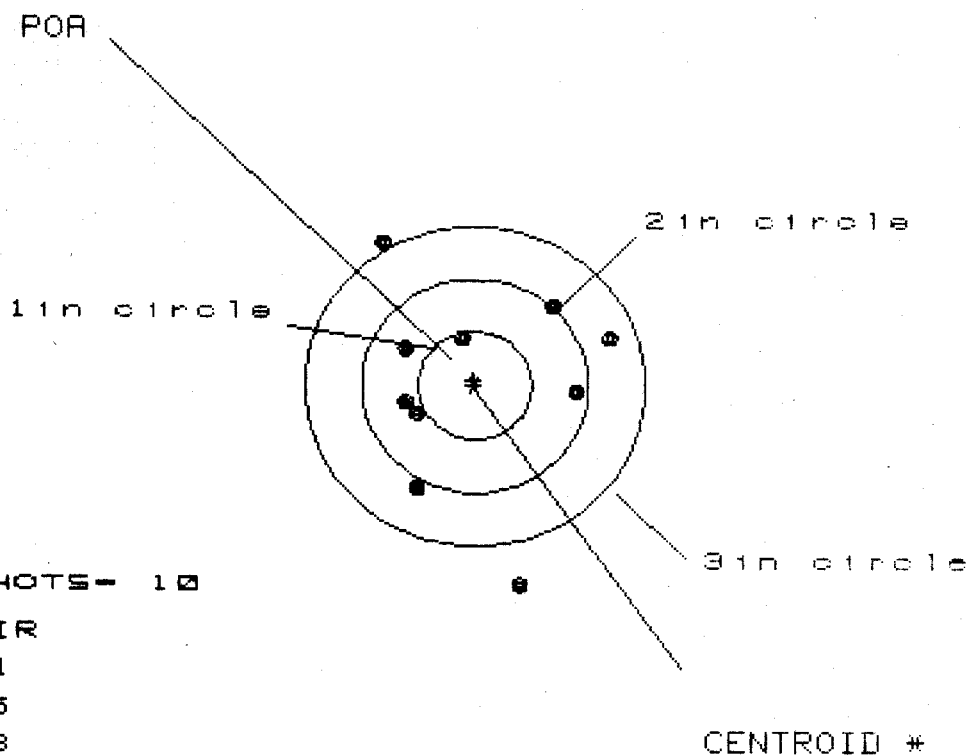
GS= 3.663

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.032	1.786	1.779
MINIMUM X	:	-1.466	-1.240	-1.247
MAXIMUM Y	:	1.111	1.114	.871
MINIMUM Y	:	-1.944	-1.941	-1.018
CENTROID X	:	.255	.029	.036
CENTROID Y	:	-.115	-.118	.125
POA TO CENTROID in.	:	.280	.121	.130
MIN RADIUS	:	.437	.650	.609
MEAN RADIUS	:	1.267	1.182	1.079
MAX RADIUS	:	2.032	1.942	1.803
HORIZONTAL SPREAD	:	3.498	3.026	3.026
VERTICAL SPREAD	:	3.055	3.055	1.889
EXTREME SPREAD	:	3.663	3.276	3.080
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 1.941

VS= 3.154

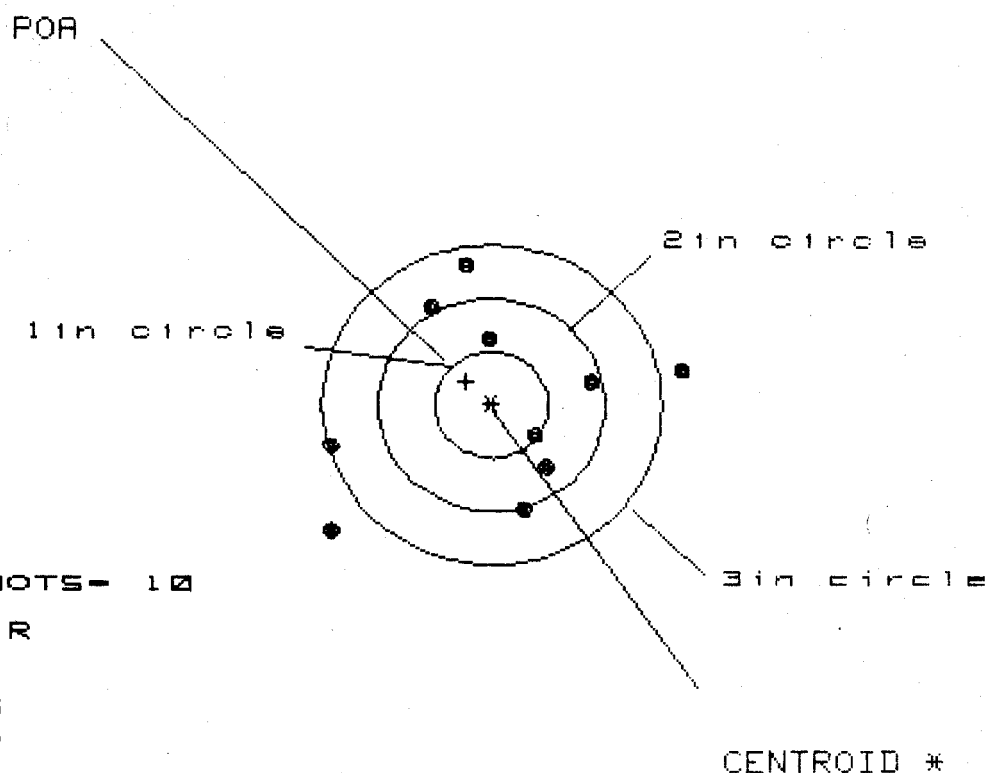
GS= 3.362

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.164	1.207	1.115
MINIMUM X	:	-.777	-.734	-.648
MAXIMUM Y	:	1.328	1.125	.717
MINIMUM Y	:	-1.826	-1.195	-1.054
CENTROID X	:	.013	-.030	.062
CENTROID Y	:	-.046	.157	.016
POA TO CENTROID in.	:	.048	.160	.064
MIN RADIUS	:	.441	.233	.394
MEAN RADIUS	:	1.004	.879	.830
MAX RADIUS	:	1.966	1.343	1.200
HORIZONTAL SPREAD	:	1.941	1.941	1.763
VERTICAL SPREAD	:	3.154	2.320	1.771
EXTREME SPREAD	:	3.362	2.334	2.224
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 3



* OF SHOTS- 10

* IN CIR

1in = 1

2in = 5

3in = 7

HS= 3.106

VS= 2.541

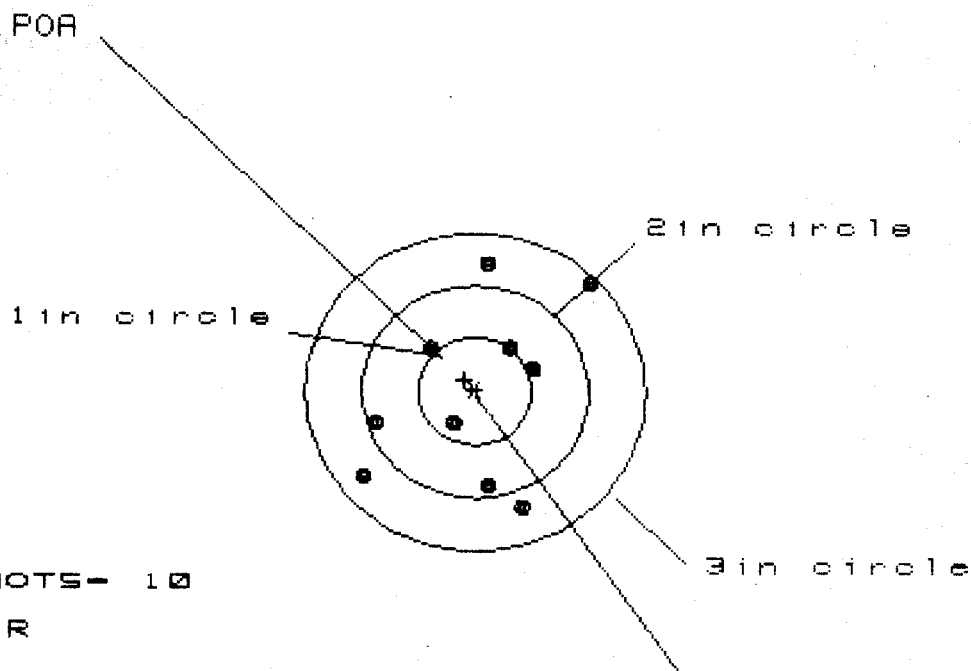
GS= 3.424

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.642	1.482	.924
MINIMUM X	:	-1.464	-1.624	-1.439
MAXIMUM Y	:	1.343	1.210	1.230
MINIMUM Y	:	-1.198	-1.073	-1.053
CENTROID X	:	.224	.384	.199
CENTROID Y	:	-.222	-.089	-.109
POA TO CENTROID in.	:	.315	.394	.227
MIN RADIUS	:	.465	.473	.511
MEAN RADIUS	:	1.126	1.016	.965
MAX RADIUS	:	1.873	1.715	1.534
HORIZONTAL SPREAD	:	3.106	3.106	2.363
VERTICAL SPREAD	:	2.541	2.283	2.283
EXTREME SPREAD	:	3.424	3.187	2.448
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 10

HS= 1.985

VS= 2.332

GS= 2.654

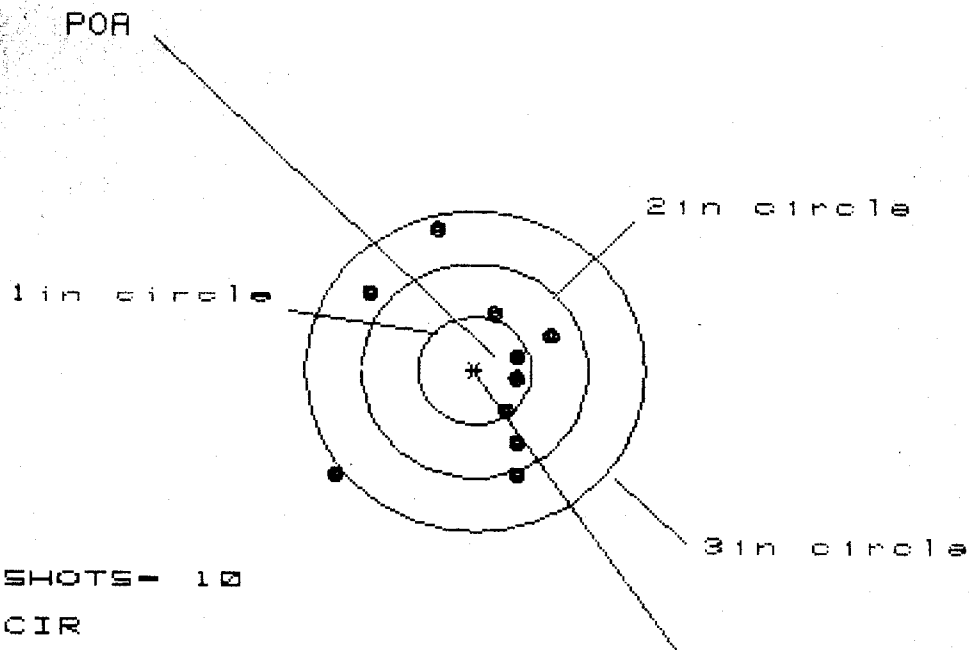
CENTROID *

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.982	.667	.694
MINIMUM X	:	-1.003	-.894	-.867
MAXIMUM Y	:	1.254	1.368	.693
MINIMUM Y	:	-1.078	-.964	-.793
CENTROID X	:	.090	-.019	-.046
CENTROID Y	:	-.111	-.225	-.396
POA TO CENTROID in.:	:	.143	.226	.398
MIN RADIUS	:	.357	.210	.044
MEAN RADIUS	:	.892	.818	.723
MAX RADIUS	:	1.415	1.385	.981
HORIZONTAL SPREAD	:	1.985	1.561	1.561
VERTICAL SPREAD	:	2.332	2.332	1.486
EXTREME SPREAD	:	2.654	2.354	1.851
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 1



* OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 9

HS= 1.866

VS= 2.326

GS= 2.481

CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.629	.492	.428
MINIMUM X	:	-1.237	-1.113	-1.177
MAXIMUM Y	:	1.322	1.211	.800
MINIMUM Y	:	-1.004	-1.086	-.935
CENTROID X	:	-.370	-.233	-.169
CENTROID Y	:	.068	.179	.028
POA TO CENTROID IN.	:	.376	.294	.171
1IN RADIUS	:	.354	.236	.149
2IN RADIUS	:	.842	.712	.602
3IN RADIUS	:	1.593	1.314	1.423
HORIZONTAL SPREAD	:	1.866	1.605	1.605
VERTICAL SPREAD	:	2.326	2.297	1.735
EXTREME SPREAD	:	2.481	2.430	2.226
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	9		