

06649271

MODEL 700™ M24

Model **545**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington®
REG. U.S. PAT. & TM. OFF.

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

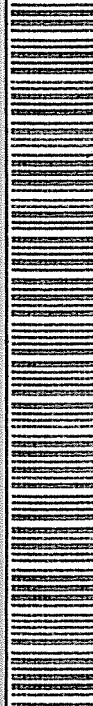
MODEL 700™ M24

SERIAL NO.
C6649271

ORDER NO.
5716

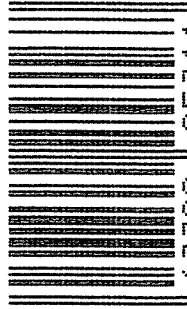
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

20



5716 C6649271

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649271

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 27	9 1	RW
600	Proof	6 27	9 1	RW
607	Check Headspace	6 27	9 1	RW
610	Dis-assemble Gun	6 27	9 1	RW
612	Magnaflux Barrel Action		JUL 2 1991	KR
	Magnaflux Bolt		JUL 2 1991	KR
615	Rollmark Caliber		JUL 2 1991	LS
617	Drill and Tap Sight Holes		JUL 2 1991	LB
618	Polish Barrel		JUL 17 1991	WB
620	Apply Coatings (Barrel Action)		7-22-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/5/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/5/91	RW
	C) Inspect Ejector Hole for Chamfer		8/5/91	RW
	D) Oil Firing Pin Ass'y		8/5/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8-7-91	JH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			8-7-91	DH
	G) Safety Off Force	3 1/2	3 1/4	3			8-7-91	DH
	H) Trigger Pull Test & Retainability						8-7-91	JH
	I) Firing Pin Indent	.020	.021	.022			8-7-91	DH
	J) Assemble Stock						8/15/91	RW
	K) Assemble Swivel Studs						8-17-91	DH
	L) Attach Front and Rear Sight Assemblies						8/15/91	RW
	M) Iron Sight Alignment						8/15/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/15/91	RW
	O) Attach Scope to Rifle						8/15/91	RW
	P) Detach & Attach Scope 20 Times						8/15/91	RW
640	Gallery Target & Test						8-15-91	DH
	A) Time						8-15-91	DH
	B) Malfunctions						8-15-91	DH
	C) Pierced Primers						8-15-91	DH
	D) Optical Clarity of Scope						8-15-91	DH
645	Inspect for Live Ammo						8-15-91	DH
655	Final Inspection						8-17-91	DH
	A) Headspace						8-17-91	DH
	B) Trigger Pull	229	226	230	230	232	8-17-91	DH
	C) Function						8-17-91	DH
660	Pack						9-16-91	AF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. 06649271

DATE 8-7-91

TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.49	2.52	2.29	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.37	2.39	2.24	
PULL #3	2.29	2.42	2.50	2.30	
PULL #4	2.39	2.39	2.51	2.30	
PULL #5	2.55	2.50	2.38	2.32	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.47	3.28		
PULL #2	3.30	3.21		
PULL #3	3.18	3.19		
PULL #4	3.28	3.21		
PULL #5	3.25	3.18		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.54	4.44		4.27
PULL #2	4.40	4.45		4.15
PULL #3	4.36	4.50		4.41
PULL #4	4.41	4.48		4.33
PULL #5	4.32	4.32		4.27
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS

FOR RIFLE # C6649271

23 Aug 1991

CENTROIDAL DISTANCES

0 TO 1	.323883
1 TO 2	.118619
1 TO 3	.157487
1 TO 4	.292015
1 TO 5	.510569

13

-----POA

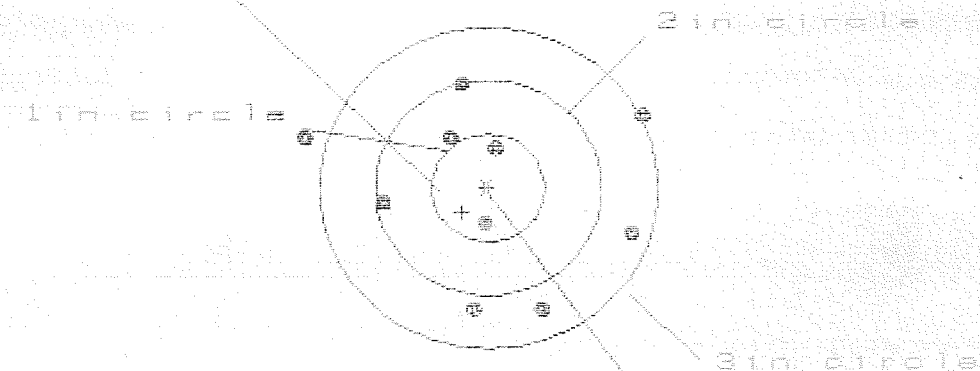
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1754
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .083
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .194047
 THE AMR FOR THIS RIFLE IS: .921

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649271

CENTERFIRE PATTERNS # 1

POB



OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 8

HS = 2.987

VS = 2.086

GS = 3.053

CENTROID #

PATTERN #			
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.340	1.157	1.234
MINIMUM X	-1.647	-1.074	-.929
MAXIMUM Y	.963	1.018	1.109
MINIMUM Y	-1.123	-1.068	-.977
CENTROID X	.232	.415	.270
CENTROID Y	.228	.171	.000
POB TO CENTROID in.	.324	.449	.281
MIN RADIUS	.278	.284	.135
MEAN RADIUS	1.006	.930	.848
MAX RADIUS	1.718	1.371	1.261
HORIZONTAL SPREAD	2.987	2.231	2.163
VERTICAL SPREAD	2.086	2.086	2.086
EXTREME SPREAD	3.053	2.380	2.178
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		8	

23 Aug 1981

FILE:/PATTERNING/CENTERFIRE_PATT/C8E49271

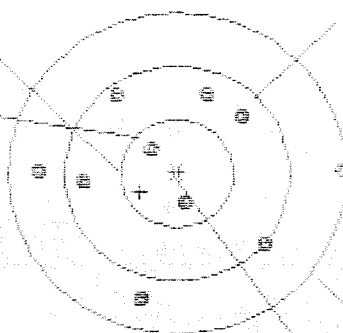
CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 2.726

VS= 1.978

GS= 2.726

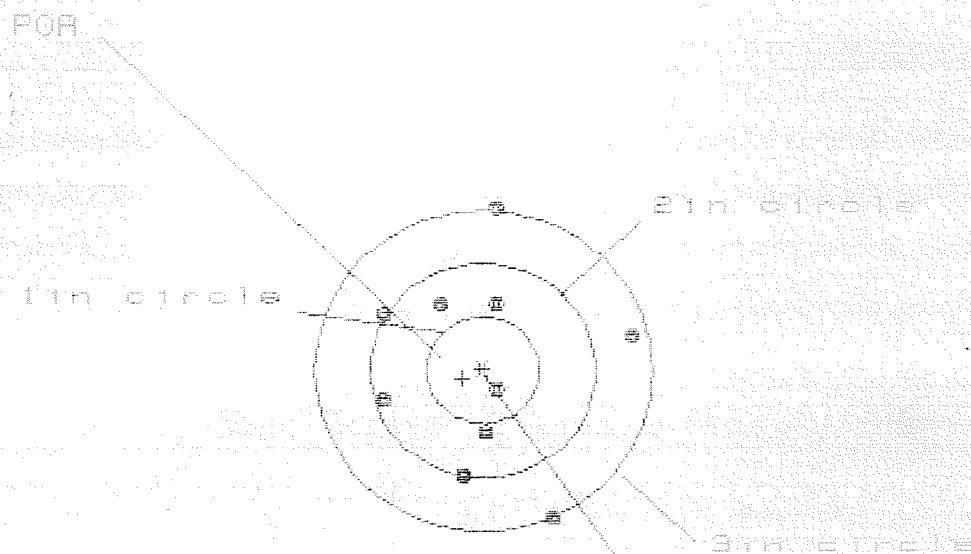
CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.480	.938	.917
MINIMUM X	-1.246	-1.082	-1.103
MAXIMUM Y	.775	.780	.631
MINIMUM Y	-1.203	-1.198	-.837
CENTROID X	.332	.168	.189
CENTROID Y	.166	.161	.310
POA TO CENTROID in.	.371	.232	.363
MIN RADIUS	.269	.216	.099
MEAN RADIUS	.890	.812	.737
MAX RADIUS	1.481	1.209	1.241
HORIZONTAL SPREAD	2.726	2.020	2.020
VERTICAL SPREAD	1.978	1.978	1.467
EXTREME SPREAD	2.726	2.135	2.135
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

29 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08649371

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 2.265

VS= 2.892

GS= 2.923

CENTROID *

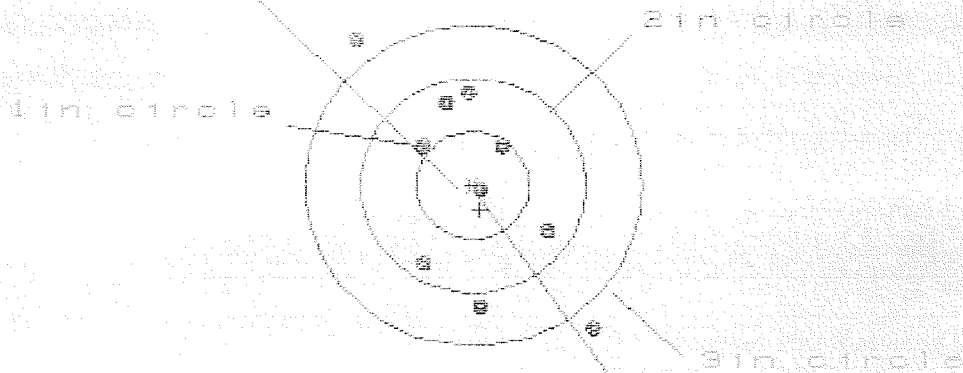
PATTERN #	3
SHOTS (BEST OF)	10 9 8
MAXIMUM X	1.359 1.377 1.453
MINIMUM X	-.906 -.888 -.812
MAXIMUM Y	1.512 .888 .657
MINIMUM Y	-1.380 -1.212 -1.005
CENTROID X	.181 .163 .087
CENTROID Y	.077 -.091 .060
POA TO CENTROID in.	.196 .186 .106
MIN RADIUS	.248 .145 .292
MEAN RADIUS	.960 .875 .815
MAX RADIUS	1.521 1.449 1.483
HORIZONTAL SPREAD	2.265 2.265 2.265
VERTICAL SPREAD	2.892 2.820 1.662
EXTREME SPREAD	2.923 2.383 2.312
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	9

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649871

CENTERFIRE PATTERNS # 4

POA



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 8

HS= 2.000

VS= 2.603

GS= 3.332

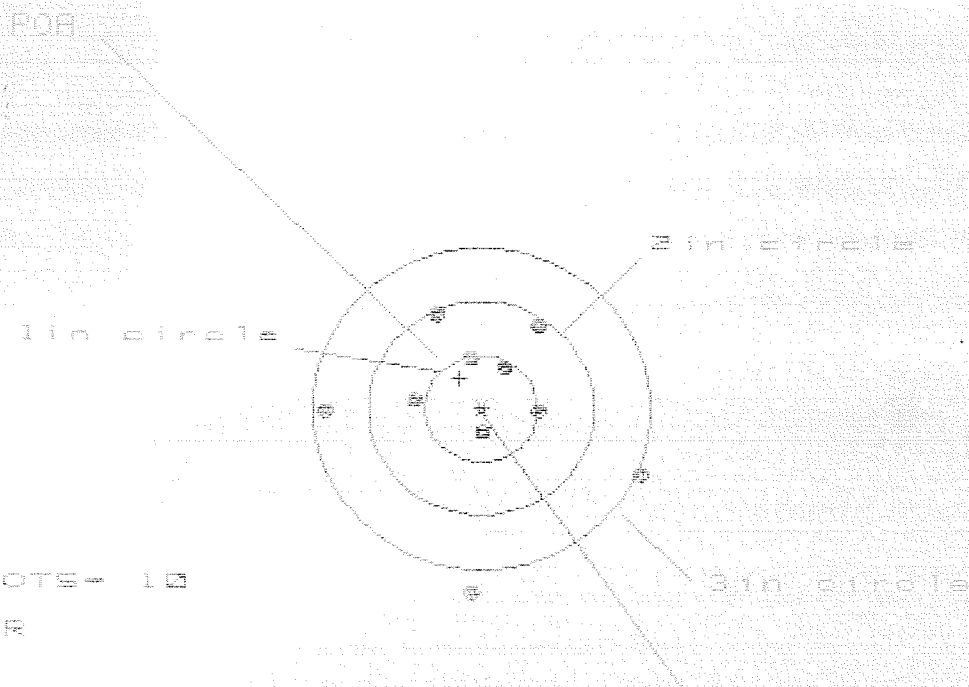
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.068	.747	.635
MINIMUM X	-1.012	-.893	-.425
MAXIMUM Y	1.323	1.180	.886
MINIMUM Y	-1.280	-1.295	-1.147
CENTROID X	-.060	-.179	-.068
CENTROID Y	.229	.372	.224
POA TO CENTROID in.	.237	.413	.234
MIN RADIUS	.076	.261	.077
MEAN RADIUS	.877	.783	.681
MAX RADIUS	1.668	1.480	1.153
HORIZONTAL SPREAD	2.080	1.640	1.061
VERTICAL SPREAD	2.603	2.475	2.093
EXTREME SPREAD	3.332	2.715	2.037
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	

20 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649271

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 7

3 in = 8

HS= 2.732

VS= 2.657

GS= 2.797

PATTERN # 5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.363	1.350	.677
MINIMUM X	-1.369	-1.382	-1.213
MAXIMUM Y	.909	.714	.611
MINIMUM Y	-1.748	-.825	-.484
CENTROID X	.192	.205	.036
CENTROID Y	-.283	-.088	.015
POA TO CENTROID in.	.341	.223	.039
MIN RADIUS	.187	.258	.164
MEAN RADIUS	.872	.738	.621
MAX RADIUS	1.752	1.582	1.256
HORIZONTAL SPREAD	2.732	2.732	1.890
VERTICAL SPREAD	2.657	1.539	1.895
EXTREME SPREAD	2.797	2.797	2.057
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	