

C6611435

MODEL 700™ M24

Model 545™

Action _____

Barrel Length _____

Capacity _____

Order No. 5715

*Includes 1 in chamber.



AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6611435

DATE 6-10-96

TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.56	2.50	2.67	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.56	2.62	2.77	
PULL #3	2.63	2.63	2.75	
PULL #4	2.65	2.63	2.78	
PULL #5	2.65	2.64	2.70	
TOTAL	13.05	13.02	13.67	
AVG.	2.61	2.60	2.73	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.00	3.00	
PULL #2	3.20	3.02	
PULL #3	3.15	3.01	
PULL #4	3.11	3.00	
PULL #5	3.09	3.03	
TOTAL	15.55	15.06	
AVG.	3.11	3.01	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.10	4.02		4.15
PULL #2	4.00	4.05		4.14
PULL #3	4.09	4.03		4.16
PULL #4	4.01	4.02		4.17
PULL #5	4.00	4.11		4.15
TOTAL	20.20	20.23		20.77
AVG.	4.04	4.04		4.15

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06611435
16 Apr 1900

CENTROIDAL DISTANCES

0 TO	1	.573206
1 TO	2	.210723
1 TO	3	.258751
1 TO	4	.439159
1 TO	5	.293234

-----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1528
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .3164
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .370514

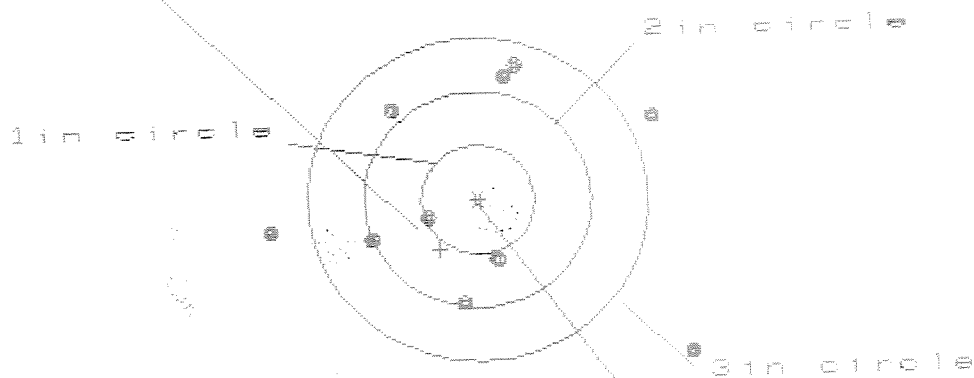
THE AMR FOR THIS RIFLE IS: 1.074

16 Apr 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8611435

CENTERFIRE PATTERNS # 1

POA



OF SHOTS- 12

IN CIR

1in = 1

2in = 3

3in = 7

HS= 3.786

VS= 2.711

GS= 3.972

CENTROID *

PATTERN #

1

SHOTS (BEST OF)

	10	9	8
MAXIMUM X	1.896	1.771	1.561
MINIMUM X	-1.890	-1.679	-.968
MAXIMUM Y	1.219	1.053	.996
MINIMUM Y	-1.492	-1.129	-1.186
CENTROID X	.346	.135	.345
CENTROID Y	.457	.623	.680
POA TO CENTROID in.	.573	.637	.763
MIN RADIUS	.451	.383	.566
MEAN RADIUS	1.262	1.104	1.035
MAX RADIUS	2.413	1.857	1.639
HORIZONTAL SPREAD	3.786	3.450	2.529
VERTICAL SPREAD	2.711	2.182	2.182
EXTREME SPREAD	3.972	3.596	2.758
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		7	

16 Apr 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8611435

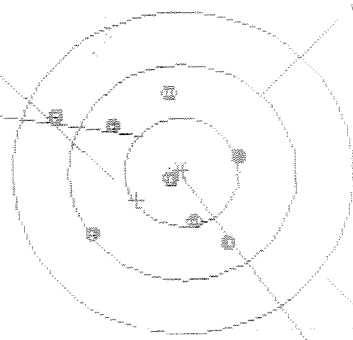
CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 1

HS= 1.930

VS= 3.524

GS= 3.525

CENTROID #

PATTERN #

2

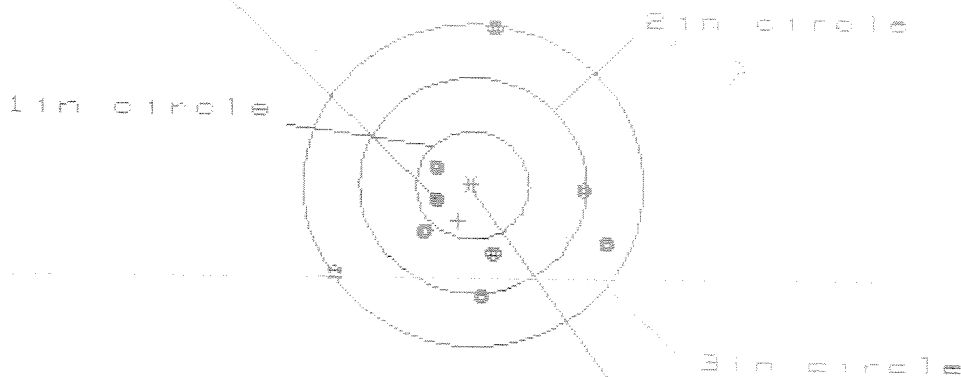
	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.868	.896	.691
MINIMUM X	-1.062	-.965	-.853
MAXIMUM Y	1.699	1.496	.718
MINIMUM Y	-1.825	-.850	-.663
CENTROID X	.406	.309	.197
CENTROID Y	.255	.458	.271
POA TO CENTROID in.	.479	.553	.335
MIN RADIUS	.080	.261	.167
MEAN RADIUS	.941	.827	.687
MAX RADIUS	2.021	1.744	1.000
HORIZONTAL SPREAD	1.930	1.861	1.544
VERTICAL SPREAD	3.524	2.346	1.381
EXTREME SPREAD	3.525	2.762	1.877
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		

16 Apr 1900

FILE:/PATTERNING/CENTERFIRE_PATT/C8611435

CENTERFIRE PATTERNS # 3

POA



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 9

HS= 2.360

VS= 3.153

GS= 3.173

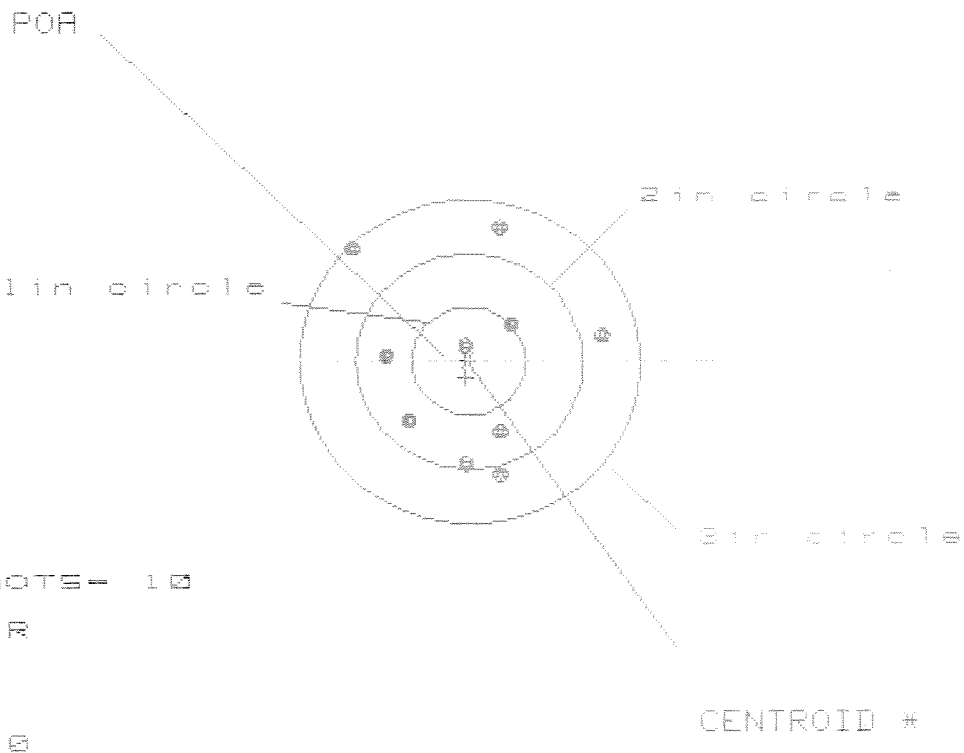
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.135	1.102	.945
MINIMUM X	:	-1.225	-1.258	-.603
MAXIMUM Y	:	2.114	1.664	1.587
MINIMUM Y	:	-1.039	-.804	-.881
CENTROID X	:	.120	.154	.311
CENTROID Y	:	.331	.096	.173
POA TO CENTROID in.	:	.352	.182	.356
MIN RADIUS	:	.345	.380	.449
MEAN RADIUS	:	1.035	.868	.820
MAX RADIUS	:	2.136	1.670	1.587
HORIZONTAL SPREAD	:	2.360	2.360	1.548
VERTICAL SPREAD	:	3.153	2.468	2.468
EXTREME SPREAD	:	3.173	2.678	2.471
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

15 Apr 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6B11435

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 10

HS= 2.251

VS= 2.322

GS= 2.498

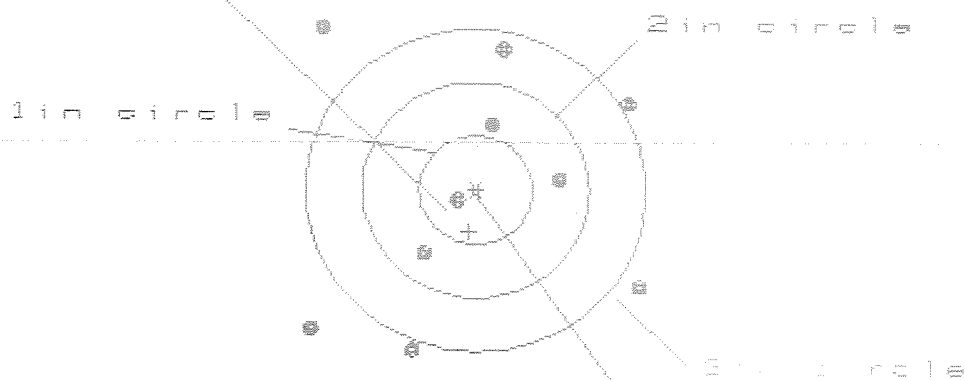
PATTERN #	4	9	5
SHOTS (BEST OF)	10	9	5
MAXIMUM X	1.212	1.897	1.121
MINIMUM X	-1.039	-0.866	-0.664
MAXIMUM Y	1.280	1.460	1.219
MINIMUM Y	-1.042	-0.922	-0.748
CENTROID X	.031	.146	.122
CENTROID Y	.151	.031	-0.143
POA TO CENTROID in.	.154	.150	.189
MIN RADIUS	.193	.347	.388
MEAN RADIUS	.904	.831	.739
MAX RADIUS	1.498	1.413	1.259
HORIZONTAL SPREAD	2.251	1.985	1.985
VERTICAL SPREAD	2.322	2.322	1.367
EXTREME SPREAD	2.498	2.322	1.996
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

16 Apr 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06611435

CENTERFIRE PATTERNS # 5

FOR



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 5

HS= 2.886

VS= 2.942

GS= 3.635

CENTROID #

PATTERN # : 5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.468	1.311	1.413
MINIMUM X	-1.436	-1.585	-1.919
MAXIMUM Y	1.474	1.438	1.296
MINIMUM Y	-1.468	-1.304	-1.446
CENTROID X	.061	.210	.408
CENTROID Y	.388	.224	.366
FOR TO CENTROID in.	.393	.307	.548
MIN RADIUS	.153	.283	.402
MEAN RADIUS	1.226	1.142	1.020
MAX RADIUS	1.993	1.947	1.713
HORIZONTAL SPREAD	2.896	2.896	2.032
VERTICAL SPREAD	2.942	2.742	2.742
EXTREME SPREAD	3.635	3.445	2.940
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	5		

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611435

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock			
600	Proof			
607	Check Headspace			
610	Dis-assemble Gun			
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/2	5 1/2	5 1/2			6/24/96	WB
	G) Safety Off Force	3	3	3			6/24/96	WB
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent							
	J) Assemble Stock							
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies							
	M) Iron Sight Alignment							
	N) Detach Front & Rear Sights & place in numbered container							
	O) Attach Scope to Rifle							
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test							
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection							
	A) Headspace							
	B) Trigger Pull	2.58	2.58	2.62	2.69	2.66	6/20/96	WB
	C) Function							
660	Pack							

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

Remington.

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

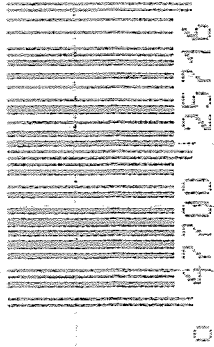
DUPONT

MODEL 700 H24

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

SERIAL NO.
C6611435

ORDER NO.
5716



GFM 1.75

GUN SERIAL # C6611435

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 25 91		RW
600	Proof	1 25 91		RW
607	Check Headspace	1 25 91		RW
610	Dis-assemble Gun	1 25 91		RW
612	Magnaflux Barrel Action	1 25 91		KR
	Magnaflux Bolt	1 25 91		KR
615	Rollmark Caliber	1 25 91		JS
617	Drill and Tap Sight Holes	1 30 91		LB
618	Polish Barrel <i>RBB</i>	1 30 91		WB
620	Apply Coatings (Barrel Action)		2-10-91	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/11/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/11/91	RW
	C) Inspect Ejector Hole for Chamfer		2/11/91	RW
	D) Oil Firing Pin Ass'y		2/11/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2/15/91	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/4	4	4			2/16/91	WB
	G) Safety Off Force	2 1/2	2 1/4	2 1/4			2/16/91	WB
	H) Trigger Pull Test & Retainability						2/16/91	JH
	I) Firing Pin Indent	.021	.021	.021			2/16/91	WB
	J) Assemble Stock						2/16/91	RW
	K) Assemble Swivel Studs						2-28-91	A
	L) Attach Front and Rear Sight Assemblies						2/16/91	RW
	M) Iron Sight Alignment						2/16/91	RW
	N) Detach Front & Rear Sights & place in numbered container						2/16/91	RW
	O) Attach Scope to Rifle						2/16/91	RW
	P) Detach & Attach Scope 20 Times						2/16/91	RW
640	Gallery Target & Test						2-18-91	DH
	A) Time						2-18-91	DH
	B) Malfunctions						2-18-91	DH
	C) Pierced Primers						2-18-91	DH
	D) Optical Clarity of Scope						2-18-91	DH
645	Inspect for Live Ammo						2-18-91	DH
655	Final Inspection							
	A) Headspace						2-22-91	A
	B) Trigger Pull	2.42	2.44	2.34	2.31	2.41	2/22/91	JH
	C) Function						2-22-91	A
660	Pack						3/15/91	WB

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS2.50# + .50#
3.00# + .75#
4.00# + 1.00#SERIAL NO. 06611435DATE 2/15/91TESTER JK

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.55	2.29	2.19	2.42	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.29	2.25	2.28	2.44	
PULL #3	2.35	2.28	2.20	2.34	
PULL #4	2.31	2.20	2.22	2.31	
PULL #5	2.26	2.21	2.27	2.41	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.48	3.39		
PULL #2	3.46	3.32		
PULL #3	3.42	3.34		
PULL #4	3.39	3.34		
PULL #5	3.37	3.38		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.43	4.34		4.42
PULL #2	4.46	4.41		4.34
PULL #3	4.25	4.18		4.34
PULL #4	4.33	4.43		4.29
PULL #5	4.41	4.41		4.41
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611435
18 Feb 1991

CENTROIDAL DISTANCES

0 TO 1	.158597
1 TO 2	.304424
1 TO 3	.244561
1 TO 4	.307278
1 TO 5	.165342

342 <-----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1428
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0506
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .1515
THE AMP FOR THIS RIFLE IS: .9198

18 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611435

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS= 2.084

VS= 2.535

GS= 3.157

CENTROID *

PATTERN #

1

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.986

.879

.981

MINIMUM X

-1.098

-1.205

-1.103

MAXIMUM Y

1.223

1.078

.779

MINIMUM Y

-1.312

-.894

-.760

CENTROID X

.057

.164

.062

CENTROID Y

.148

.293

.159

POA TO CENTROID in.

.158

.336

.170

MIN RADIUS

.151

.321

.163

MEAN RADIUS

.968

.905

.817

MAX RADIUS

1.627

1.350

1.143

HORIZONTAL SPREAD

2.084

2.084

2.084

VERTICAL SPREAD

2.535

1.972

1.539

EXTREME SPREAD

3.157

2.520

2.136

NUMBER IN ONE

INCH CIRCLE

= 2

NUMBER IN TWO

INCH CIRCLE

= 5

NUMBER IN THREE

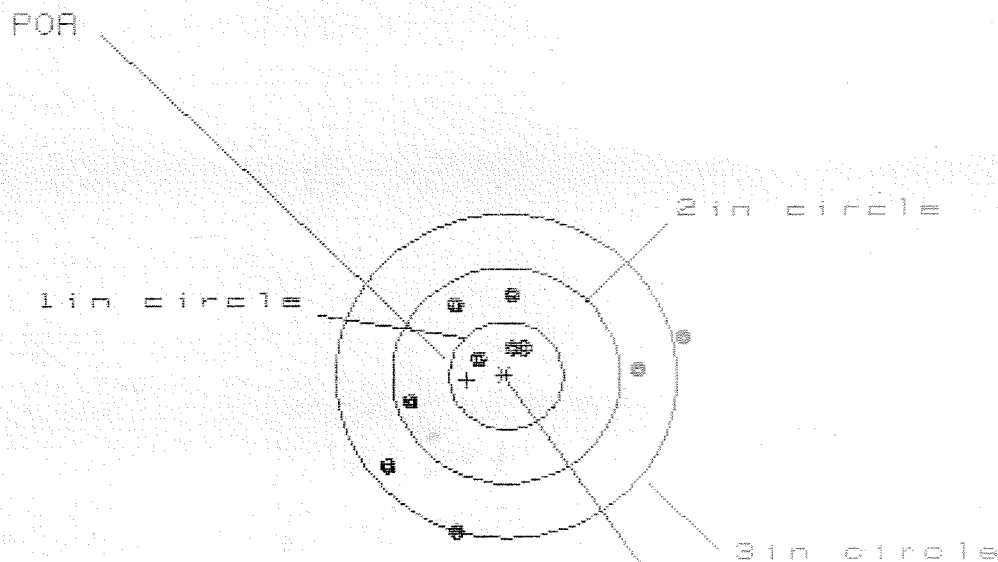
INCH CIRCLE

= 8

18 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611435

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS = 2.645

VS = 2.215

GS = 2.920

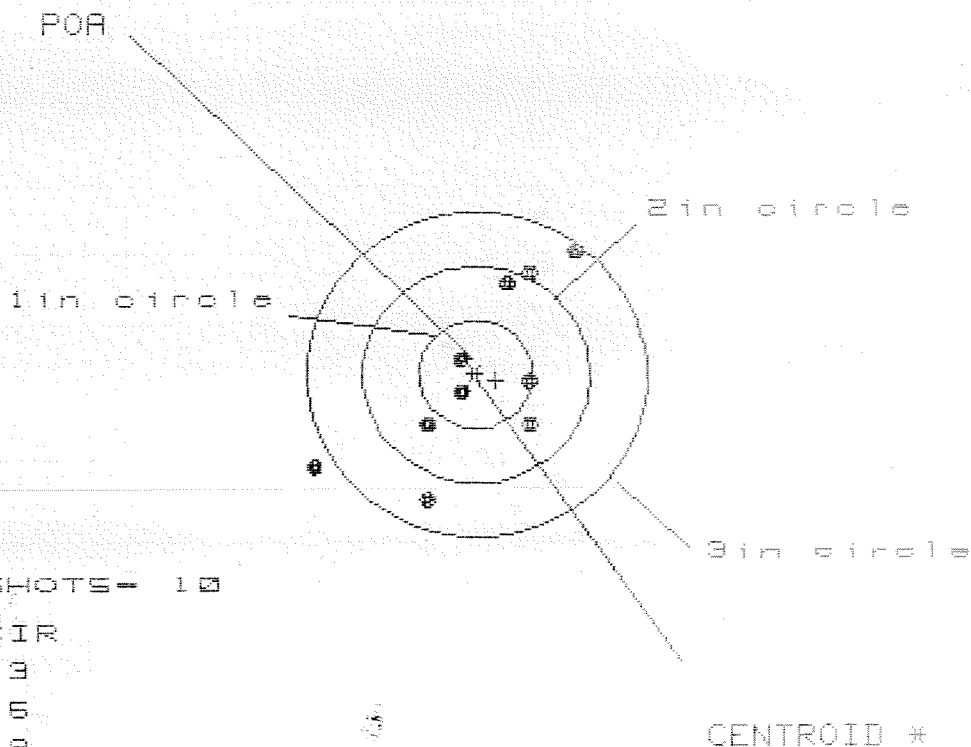
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.556	1.301	1.264
MINIMUM X	:	-1.089	-.917	-.954
MAXIMUM Y	:	.805	.846	.674
MINIMUM Y	:	-1.410	-1.369	-1.006
CENTROID X	:	.342	.170	.207
CENTROID Y	:	.041	.000	.172
POA TO CENTROID in.	:	.345	.170	.269
MIN RADIUS	:	.238	.243	.106
MEAN RADIUS	:	.890	.813	.678
MAX RADIUS	:	1.597	1.402	1.387
HORIZONTAL SPREAD	:	2.645	2.218	2.218
VERTICAL SPREAD	:	2.215	2.215	1.681
EXTREME SPREAD	:	2.920	2.391	2.391
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

18 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611435

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS = 2.283

VS = 2.302

GS = 3.049

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.857	.698	.407
MINIMUM X	:	-1.426	-.614	-.526
MAXIMUM Y	:	1.162	1.066	1.006
MINIMUM Y	:	-1.140	-1.236	-1.102
CENTROID X	:	-.170	-.011	-.099
CENTROID Y	:	.057	.153	.019
POA TO CENTROID in.	:	.179	.153	.100
MIN RADIUS	:	.200	.288	.221
MEAN RADIUS	:	.839	.747	.658
MAX RADIUS	:	1.665	1.380	1.221
HORIZONTAL SPREAD	:	2.283	1.312	.933
VERTICAL SPREAD	:	2.302	2.302	2.108
EXTREME SPREAD	:	3.049	2.650	2.301
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

18 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611435

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 9

HS= 2.091

VS= 2.709

GS= 2.869

CENTROID #

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.971

.944

.804

MINIMUM X

-1.120

-1.147

-1.287

MAXIMUM Y

1.760

1.307

1.213

MINIMUM Y

-.949

-.754

-.820

CENTROID X

.285

.312

.452

CENTROID Y

-.058

-.253

-.159

POA TO CENTROID in.

.290

.402

.479

MIN RADIUS

.354

.172

.196

MEAN RADIUS

1.058

.929

.857

MAX RADIUS

1.777

1.496

1.512

HORIZONTAL SPREAD

2.091

2.091

2.091

VERTICAL SPREAD

2.709

2.061

2.033

EXTREME SPREAD

2.869

2.534

2.534

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

4

NUMBER IN THREE INCH CIRCLE =

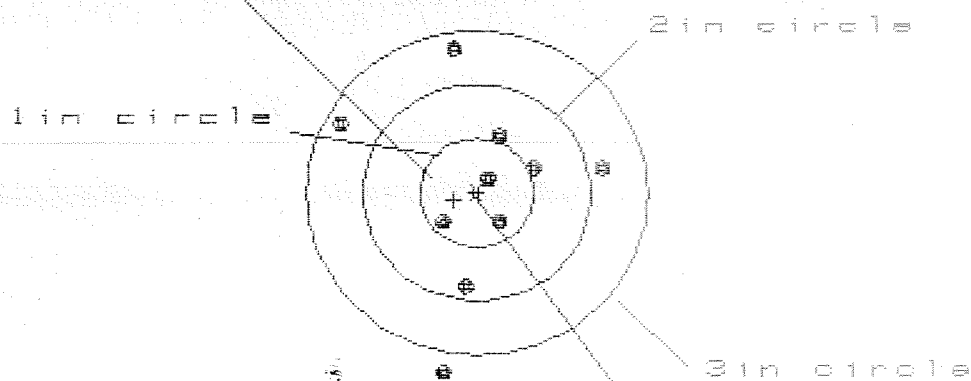
9

18 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611435

CENTERFIRE PATTERNS # 5

POA



OF SHOTS= 10

IN CIR

1in = 3

2in = 6

3in = 9

HS= 2.337

VS= 2.950

GS= 2.951

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.143	1.113	.960
MINIMUM X	:	-1.194	-1.224	-.473
MAXIMUM Y	:	1.319	1.137	1.196
MINIMUM Y	:	-1.631	-1.059	-1.000
CENTROID X	:	.200	.230	.383
CENTROID Y	:	.065	.247	.187
POA TO CENTROID in.	:	.210	.337	.427
MIN RADIUS	:	.187	.110	.055
MEAN RADIUS	:	.844	.741	.638
MAX RADIUS	:	1.654	1.313	1.260
HORIZONTAL SPREAD	:	2.337	2.337	1.433
VERTICAL SPREAD	:	2.950	2.196	2.196
EXTREME SPREAD	:	2.951	2.379	2.198

