

C6611449

MODEL 700™ M24

Model **545**™

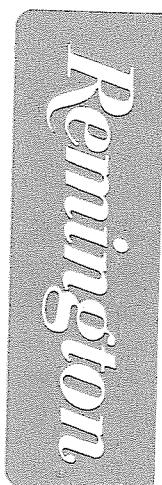
Action

Barrel Length

Capacity

Order No. **5716**

* Includes 1 in chamber.



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

MODEL 700™ H24

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

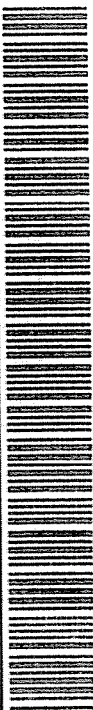
DUPONT

SERIAL NO.
C6611449

ORDER NO.
5716

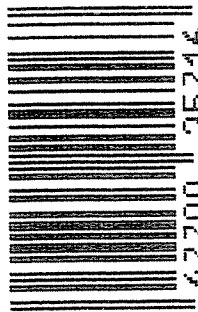
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



5716 C6611449

UPC



0 47700 25716 2

INTERCHANGEABILITY

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611449

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	3/13/91	K.S.
600	Proof		3/13/91	K.S.
607	Check Headspace		3/13/91	K.S.
610	Dis-assemble Gun		3/13/91	K.S.
612	Magnaflux Barrel Action		3/27/91	KR
	Magnaflux Bolt		11	KR
615	Rollmark Caliber		3/27/91	JS
617	Drill and Tap Sight Holes		APR 3 1991	FB
618	Polish Barrel		APR 3 1991	WB
620	Apply Coatings (Barrel Action)		4-12-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/24/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/26/91	KS
	C) Inspect Ejector Hole for Chamfer		4/26/91	KS
	D) Oil Firing Pin Ass'y		4/26/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		4/29/91	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			4/20/91	921
	G) Safety Off Force	3	3	3			4/20/91	94.
	H) Trigger Pull Test & Retainability						4/24/91	921
	I) Firing Pin Indent	1022	1022	1022			4/29/91	921
	J) Assemble Stock						5/1/91	155
	K) Assemble Swivel Studs						5-1-91	D/H
	L) Attach Front and Rear Sight Assemblies						5/1/91	155
	M) Iron Sight Alignment						5/1/91	155
	N) Detach Front & Rear Sights & place in numbered container						5/1/91	155
	O) Attach Scope to Rifle						5/1/91	155
	P) Detach & Attach Scope 20 Times						5/1/91	155
640	Gallery Target & Test						5/1/91	KT
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	KT
645	Inspect for Live Ammo						5/1/91	KT
655	Final Inspection							
	A) Headspace						5-1-91	D/H
	B) Trigger Pull	2.54	2.53	2.54	2.53	2.50	5/1/91	921
	C) Function						5-1-91	D/H
660	Pack						6-19-91	155

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6611449

DATE 4/29/91

TESTER [Signature] (H)

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.42	2.43	2.54	MIN. SETTING,
PULL #2	2.37	2.35	2.40	2.53	NO AVG. OF 5
PULL #3	2.29	2.43	2.39	2.54	READINGS ACCEPT-
PULL #4	2.34	2.39	2.36	2.55	ABLE LESS THAN 2#
PULL #5	2.36	2.39	2.40	2.50	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES			COMMENTS
PULL #1	3.30	3.28			
PULL #2	3.23	3.32			
PULL #3	3.20	3.36			
PULL #4	3.27	3.27			
PULL #5	3.29	3.34			
TOTAL					
AVG.					

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.26	4.45		4.30
PULL #2	4.37	4.45		4.50
PULL #3	4.34	4.46		4.51
PULL #4	4.37	4.41		4.50
PULL #5	4.37	4.40		4.47
TOTAL				
AVG.				

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611449
24 May 1991

CENTROIDAL DISTANCES

0 TO	1	.230931
1 TO	2	.351677
1 TO	3	.688585
1 TO	4	.523004
1 TO	5	.183984

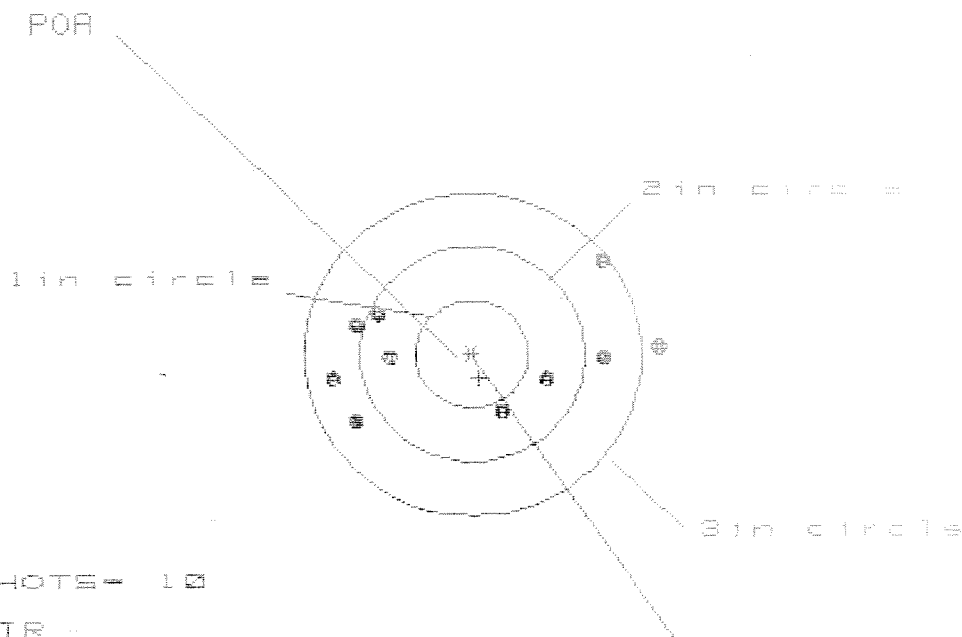
49 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1306
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0122
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .131162
THE AMR FOR THIS RIFLE IS: .9572

24 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/28611442

CENTERFIRE PATTERNS



OF SHOTS= 10

IN CIR =

1 in = 0

2 in = 4

3 in = 9

HS= 2.849

VS= 1.488

GS= 2.866

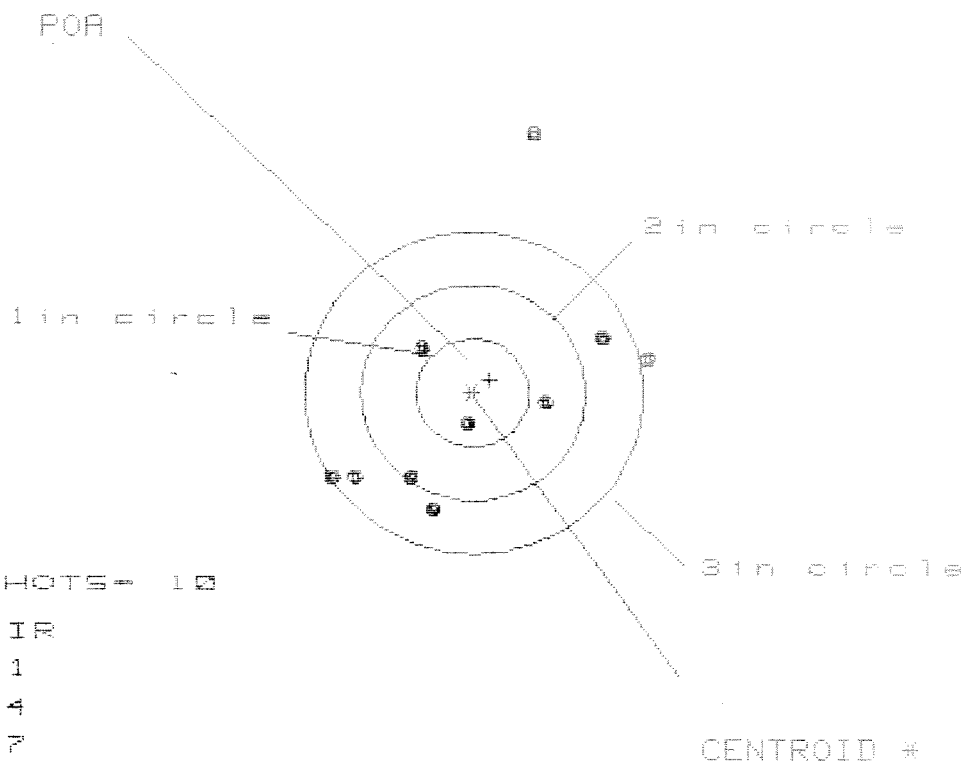
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.655	1.353	1.517
MINIMUM X	-1.194	-1.011	-.847
MAXIMUM Y	.912	.924	.461
MINIMUM Y	-.576	-.564	-.448
CENTROID X	-.060	-.243	-.407
CENTROID Y	.223	.211	.095
POR TO CENTROID in.	.231	.322	.418
MIN RADIUS	.551	.593	.446
MEAN RADIUS	1.068	.973	.852
MAX RADIUS	1.658	1.600	1.518
HORIZONTAL SPREAD	2.849	2.364	2.364
VERTICAL SPREAD	1.488	1.488	.909
EXTREME SPREAD	2.866	2.664	2.368
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	9		

24 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06611449.1

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 5

HS= 2.790

VS= 3.474

GS= 3.651

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.499	1.555	1.413
MINIMUM X	-1.291	-1.235	-1.040
MAXIMUM Y	2.413	.784	.855
MINIMUM Y	-1.062	-.793	-.722
CENTROID X	-.146	-.202	-.397
CENTROID Y	-.118	-.386	-.457
POA TO CENTROID in.	.187	.435	.605
MIN RADIUS	.271	.031	.236
MEAN RADIUS	1.172	.967	.866
MAX RADIUS	2.466	1.657	1.651
HORIZONTAL SPREAD	2.790	2.790	2.453
VERTICAL SPREAD	3.474	1.577	1.577
EXTREME SPREAD	3.651	2.987	2.767
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	5		

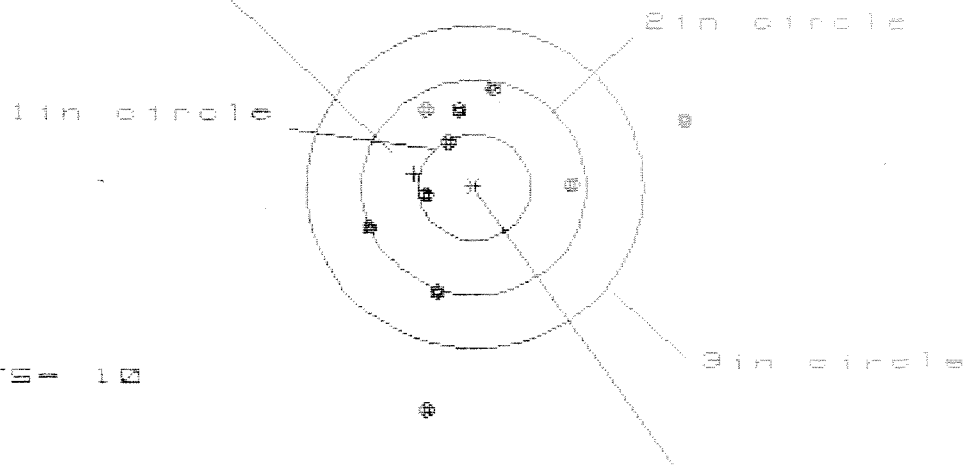
24 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08611449.1

CENTERFIRE PATTERNS

3

POA



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 8

HS= 2.773

VS= 3.064

GS= 3.593

CENTROID *

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.855	1.809	1.046
MINIMUM X	-.918	-.964	-.738
MAXIMUM Y	.946	.711	.765
MINIMUM Y	-2.118	-1.104	-1.129
CENTROID X	.533	.579	.353
CENTROID Y	-.127	.109	.054
POA TO CENTROID in.	.548	.589	.357
MIN RADIUS	.437	.330	.233
MEAN RADIUS	1.040	.873	.706
MAX RADIUS	2.157	1.860	1.143
HORIZONTAL SPREAD	2.773	2.773	1.784
VERTICAL SPREAD	3.064	1.895	1.895
EXTREME SPREAD	3.593	2.958	1.964
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	

24 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611449.1

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 3

2in = 9

3in = 10

HS= 1.720

VS= 1.439

GS= 1.867

PATTERN #

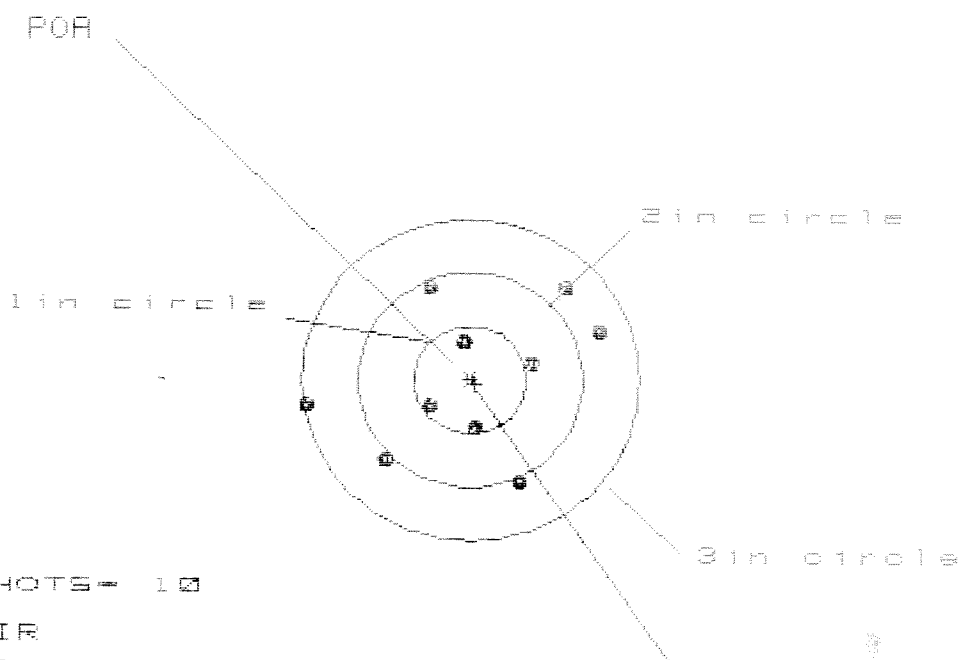
4

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.952	.581	.598
MINIMUM X	:	-.768	-.662	-.645
MAXIMUM Y	:	.776	.704	.708
MINIMUM Y	:	-.663	-.735	-.647
CENTROID X	:	.367	.261	.244
CENTROID Y	:	-.079	-.007	-.095
POA TO CENTROID in.	:	.375	.261	.262
MIN RADIUS	:	.202	.283	.194
MEAN RADIUS	:	.630	.567	.532
MAX RADIUS	:	1.149	.741	.825
HORIZONTAL SPREAD	:	1.720	1.243	1.243
VERTICAL SPREAD	:	1.439	1.439	1.355
EXTREME SPREAD	:	1.867	1.452	1.431
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

24 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06611449.1

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 5

3 in = 9

HS = 2.605

VS = 1.782

GS = 2.693

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.112	.946	.764
MINIMUM X	:	-1.493	-.898	-.780
MAXIMUM Y	:	.848	.818	.867
MINIMUM Y	:	-.934	-.964	-.915
CENTROID X	:	-.041	.125	.007
CENTROID Y	:	.040	.070	.021
POA TO CENTROID in.	:	.057	.143	.022
MIN RADIUS	:	.399	.431	.431
MEAN RADIUS	:	.876	.798	.757
MAX RADIUS	:	1.516	1.194	1.156
HORIZONTAL SPREAD	:	2.605	1.844	1.544
VERTICAL SPREAD	:	1.782	1.782	1.782
EXTREME SPREAD	:	2.693	2.227	2.227
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611449
1 May 1991

CENTROIDAL DISTANCES

0 TO	1	.580662
1 TO	2	.612459
1 TO	3	.138885
1 TO	4	.499673
1 TO	5	.576771

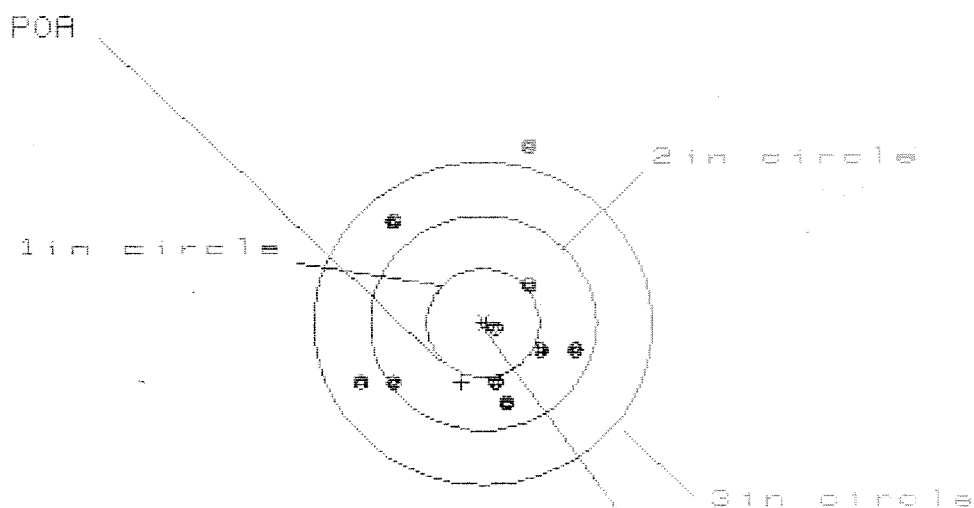
$\bar{x}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .01
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2414
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .241607
THE AMR FOR THIS RIFLE IS: .7888

1 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B11449

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 1

2in = 7

3in = 9

HS = 1.893

VS = 2.419

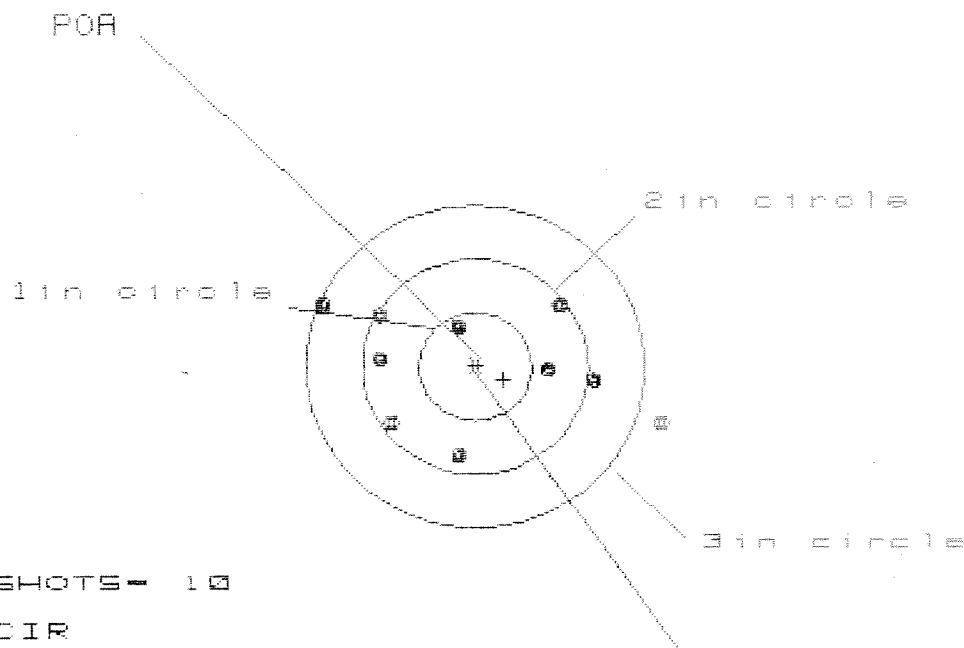
GS = 2.627

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.846	.891	.801
MINIMUM X	:	-1.047	-1.002	-1.092
MAXIMUM Y	:	1.639	1.119	.698
MINIMUM Y	:	-.780	-.598	-.458
CENTROID X	:	.192	.147	.237
CENTROID Y	:	.548	.366	.226
POA TO CENTROID in.	:	.581	.394	.327
MIN RADIUS	:	.131	.225	.274
MEAN RADIUS	:	.852	.740	.633
MAX RADIUS	:	1.689	1.332	1.115
HORIZONTAL SPREAD	:	1.893	1.893	1.893
VERTICAL SPREAD	:	2.419	1.717	1.156
EXTREME SPREAD	:	2.627	1.986	1.921
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	9		

1 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611449

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 1

2in = 7

3in = 9

HS = 2.922

VS = 1.485

GS = 3.146

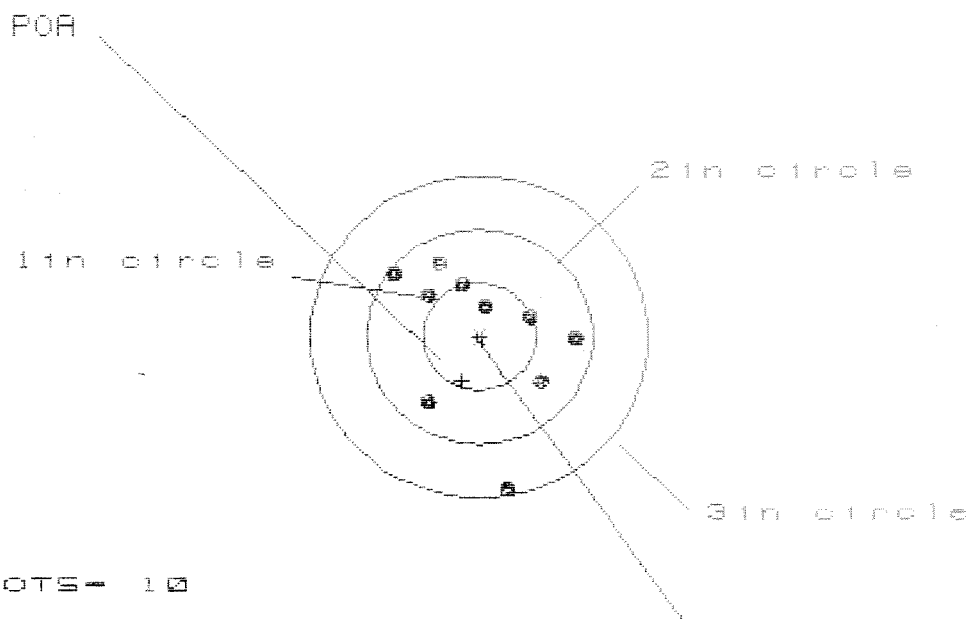
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.603	1.227	1.084
MINIMUM X	:	-1.320	-1.141	-.826
MAXIMUM Y	:	.618	.558	.562
MINIMUM Y	:	-.867	-.927	-.858
CENTROID X	:	-.249	-.427	-.284
CENTROID Y	:	.123	.183	.114
POA TO CENTROID in.	:	.277	.464	.306
MIN RADIUS	:	.446	.350	.442
MEAN RADIUS	:	.987	.885	.838
MAX RADIUS	:	1.693	1.270	1.093
HORIZONTAL SPREAD	:	2.922	2.368	1.910
VERTICAL SPREAD	:	1.485	1.485	1.420
EXTREME SPREAD	:	3.146	2.489	2.005
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

1 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611449

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 3

2in = 9

3in = 10

HS = 1.513

VS = 2.099

GS = 2.190

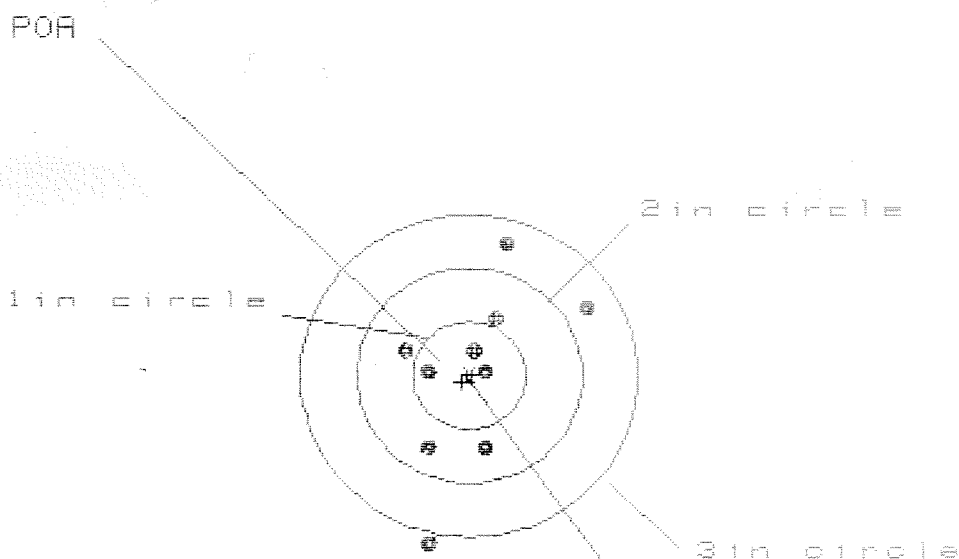
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.805	.836	.752
MINIMUM X	:	-.708	-.677	-.555
MAXIMUM Y	:	.719	.566	.614
MINIMUM Y	:	-1.380	-.795	-.747
CENTROID X	:	.152	.122	.206
CENTROID Y	:	.415	.568	.520
POA TO CENTROID in.	:	.442	.581	.559
MIN RADIUS	:	.293	.170	.178
MEAN RADIUS	:	.732	.619	.680
MAX RADIUS	:	1.407	.912	.917
HORIZONTAL SPREAD	:	1.513	1.513	1.307
VERTICAL SPREAD	:	2.099	1.361	1.361
EXTREME SPREAD	:	2.190	1.617	1.479
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			9	
NUMBER IN THREE INCH CIRCLE =			10	

1 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08611449

CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1in = 3

2in = 7

3in = 9

HS = 1.598

VS = 2.850

GS = 2.923

CENTROID #

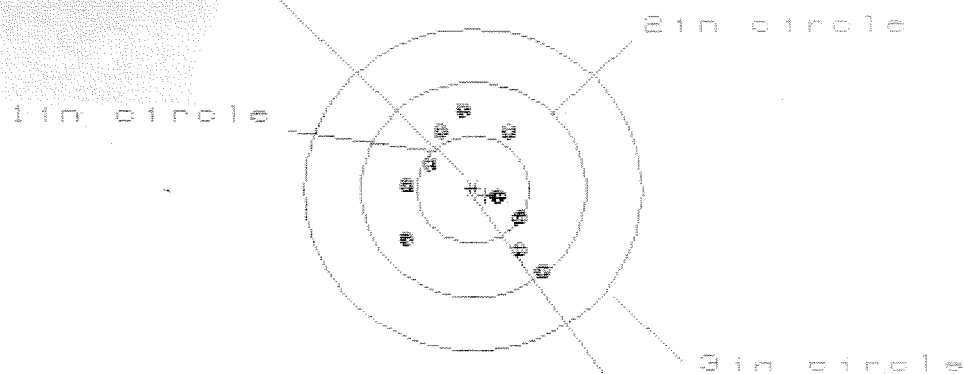
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.997	.957	.989
MINIMUM X	:	-.601	-.641	-.609
MAXIMUM Y	:	1.263	1.087	.631
MINIMUM Y	:	-1.587	-.869	-.733
CENTROID X	:	.064	.104	.072
CENTROID Y	:	.065	.241	.105
POA TO CENTROID in.	:	.091	.263	.128
MIN RADIUS	:	.108	.075	.095
MEAN RADIUS	:	.757	.640	.575
MAX RADIUS	:	1.626	1.116	1.173
HORIZONTAL SPREAD	:	1.598	1.598	1.598
VERTICAL SPREAD	:	2.850	1.956	1.384
EXTREME SPREAD	:	2.923	2.072	1.945
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

1 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8B11449

CENTERFIRE PATTERNS # 5

POA



OF SHOTS= 10

IN CIR

1in = 3

2in = 9

3in = 10

HS= 1.210

VS= 1.569

GS= 1.738

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.635	.477	.472
MINIMUM X	:	-.575	-.504	-.509
MAXIMUM Y	:	.765	.676	.574
MINIMUM Y	:	-.804	-.686	-.602
CENTROID X	:	-.109	-.180	-.175
CENTROID Y	:	.056	.145	.061
POA TO CENTROID in.	:	.123	.231	.185
MIN RADIUS	:	.176	.282	.239
MEAN RADIUS	:	.616	.561	.544
MAX RADIUS	:	1.025	.826	.754
HORIZONTAL SPREAD	:	1.210	.981	.981
VERTICAL SPREAD	:	1.569	1.362	1.176
EXTREME SPREAD	:	1.738	1.451	1.352
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	