

RECEIVED
JAN 1 1977
FEDERAL BUREAU OF INVESTIGATION
U.S. DEPARTMENT OF JUSTICE
WASHINGTON, D.C. 20535
TO: DIRECTOR, FBI
FROM: SAC, NEW YORK
SUBJECT: [REDACTED]
RE: [REDACTED]

C6522305

MODEL 700™ M24

Model **545**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6522306

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/27/90	KQ
600	Proof		6/27/90	KQ
607	Check Headspace		6/27/90	KQ
610	Dis-assemble Gun		6/27/90	KQ
612	Magnaflux Barrel Action		7/10/90	KR
	Magnaflux Bolt		7/10/90	KR
615	Rollmark Caliber		7/10/90	LL
617	Drill and Tap Sight Holes		7/11/90	EB
618	Polish Barrel <i>RB</i>		7/13/90	WB
620	Apply Coatings (Barrel Action)		7-23-90	TH
	Apply Coating (Bolt)			TH
625	Final Assembly A) Clean inside of Bolt Assembly		8/3/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/3/90	KS
	C) Inspect Ejector Hole for Chamfer		8/3/90	KS
	D) Oil Firing Pin Ass'y		8/7/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		9-5-90	986

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			8/6/90	QY
	G) Safety Off Force	2	2	2			8/6/90	QY
	H) Trigger Pull Test & Retainability						9-5-90	QY
	I) Firing Pin Indent	.023	.023	.023			8/6/90	QY
	J) Assemble Stock						8/6/90	KS
	K) Assemble Swivel Studs						9/5/90	QY
	L) Attach Front and Rear Sight Assemblies						8/6/90	KS
	M) Iron Sight Alignment						8/6/90	KS
	N) Detach Front & Rear Sights & place in numbered container						8/6/90	KS
	O) Attach Scope to Rifle						8/6/90	KS
	P) Detach & Attach Scope 20 Times						8/6/90	KS
640	Gallery Target & Test						8-9-90	DH
	A) Time						8-9-90	DH
	B) Malfunctions						8-9-90	DH
	C) Pierced Primers						8-9-90	DH
	D) Optical Clarity of Scope						8-9-90	DH
645	Inspect for Live Ammo						8-9-90	DH
655	Final Inspection							
	A) Headspace						9/5/90	QY
	B) Trigger Pull	2.24	2.32	2.36	2.19	2.38	9-5-90	QY
	C) Function						9/5/90	QY
660	Pack						9/20/90	QY

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO C6522306

DATE 9-5-90

TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.38	2.48	2.24	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.35	2.39	2.46	2.32	
PULL #3	2.34	2.31	2.39	2.36	
PULL #4	2.41	2.46	2.41	2.19	
PULL #5	2.43	2.25	2.35	2.38	
TOTAL	11.94	11.79	12.09	11.49	
AVG.	2.388	2.358	2.418	2.298	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.17	3.31		
PULL #2	3.48	3.27		
PULL #3	3.50	3.47		
PULL #4	3.36	3.40		
PULL #5	3.35	3.46		
TOTAL	16.86	16.91		
AVG.	3.372	3.382		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.28	4.40		4.37
PULL #2	4.32	4.41		4.40
PULL #3	4.41	4.25		4.41
PULL #4	4.39	4.40		4.40
PULL #5	4.44	4.39		4.37
TOTAL	21.84	21.85		21.95
AVG.	4.368	4.37		4.39

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522306
9 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.96294
1 TO	2	1.20804
1 TO	3	1.6649
1 TO	4	1.18731
1 TO	5	1.60717

$\bar{x} = \frac{1}{n} \sum_{i=1}^n x_i$
 $\bar{y} = \frac{1}{n} \sum_{i=1}^n y_i$
 $r = \sqrt{\bar{x}^2 + \bar{y}^2}$

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.141
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0452
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .148068
 THE AMR FOR THIS RIFLE IS: .7406

9 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522306

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 4

2in = 8

3in = 9

HS= 1.715

VS= 3.281

GS= 3.483

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.870	.744	.719
MINIMUM X	:	-.845	-.748	-.773
MAXIMUM Y	:	1.444	1.239	.369
MINIMUM Y	:	-1.837	-.527	-.372
CENTROID X	:	.953	.856	.881
CENTROID Y	:	-.138	.067	-.088
POA TO CENTROID in	:	.963	.859	.886
MIN RADIUS	:	.114	.255	.129
MEAN RADIUS	:	.716	.580	.454
MAX RADIUS	:	2.033	1.256	.791
HORIZONTAL SPREAD	:	1.715	1.492	1.492
VERTICAL SPREAD	:	3.281	1.766	.741
EXTREME SPREAD	:	3.483	1.779	1.532
NUMBER IN ONE INCH CIRCLE =	:	4		
NUMBER IN TWO INCH CIRCLE =	:	8		
NUMBER IN THREE INCH CIRCLE =	:	9		

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CENTERFIRE PATTERNS

2

POA

1 in circle

2 in circle

3 in circle

* OF SHOTS - 10

IN CIR

1 in = 7

2 in = 9

3 in = 9

HS = 2.083

VS = 1.285

GS = 2.385

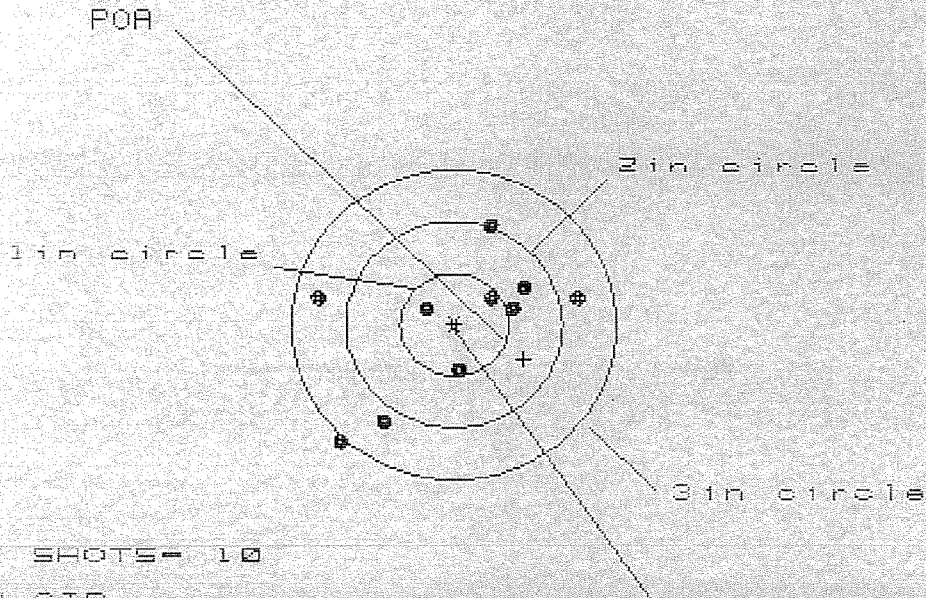
CENTROID *

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.493	.628	.618
MINIMUM X	-.590	-.424	-.434
MAXIMUM Y	.472	.382	.283
MINIMUM Y	-.813	-.794	-.353
CENTROID X	-.237	-.483	-.393
CENTROID Y	.070	.160	.259
POA TO CENTROID in.	.247	.433	.471
MIN RADIUS	.312	.224	.129
MEAN RADIUS	.599	.419	.353
MAX RADIUS	1.700	.798	.644
HORIZONTAL SPREAD	2.083	1.052	1.052
VERTICAL SPREAD	1.285	1.176	.636
EXTREME SPREAD	2.385	1.242	1.105
NUMBER IN ONE INCH CIRCLE =		7	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 5

3 in = 9

HS= 2.349

VS= 2.165

GS= 2.583

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.126	1.014	.847
MINIMUM X	-1.223	-1.335	-.900
MAXIMUM Y	1.012	.884	.905
MINIMUM Y	-1.153	-1.036	-1.015
CENTROID X	-.643	-.531	-.364
CENTROID Y	.336	.464	.443
POA TO CENTROID in.	.726	.705	.573
MIN RADIUS	.246	.306	.206
MEAN RADIUS	.866	.763	.655
MAX RADIUS	1.532	1.346	1.356
HORIZONTAL SPREAD	2.349	2.349	1.747
VERTICAL SPREAD	2.165	1.920	1.920
EXTREME SPREAD	2.583	2.349	2.137
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.466

VS= 1.973

GS= 2.307

CENTROID #

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.659

.729

.637

MINIMUM X

-.806

-.737

-.511

MAXIMUM Y

1.208

.687

.629

MINIMUM Y

-.765

-.631

-.689

CENTROID X

-.142

-.211

-.119

CENTROID Y

-.597

-.731

-.673

POA TO CENTROID in

.613

.761

.683

MIN RADIUS

.022

.026

.101

MEAN RADIUS

.679

.590

.555

MAX RADIUS

1.360

.931

.823

HORIZONTAL SPREAD

1.466

1.466

1.148

VERTICAL SPREAD

1.973

1.318

1.318

EXTREME SPREAD

2.307

1.801

1.512

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

8

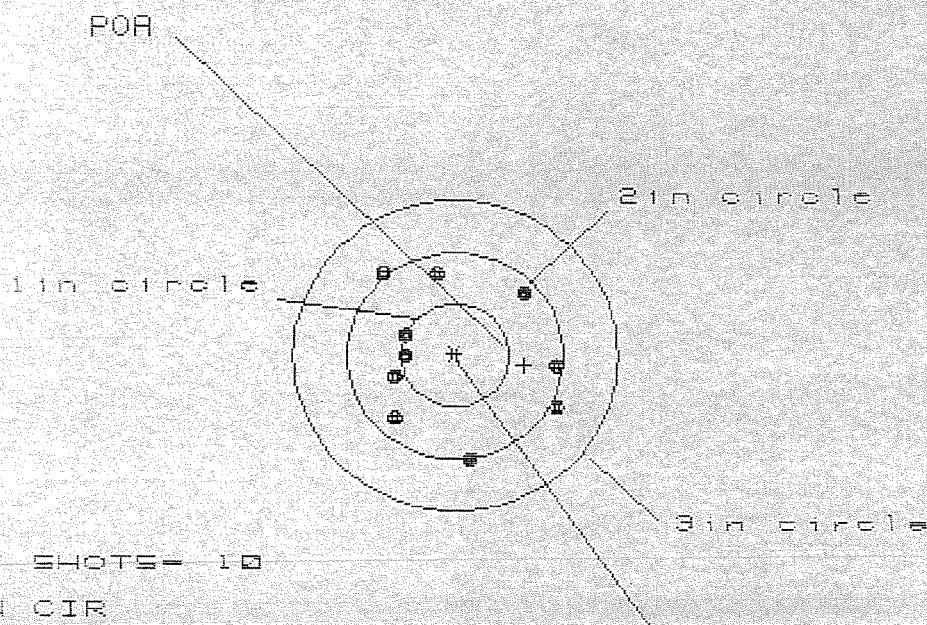
NUMBER IN THREE INCH CIRCLE =

10

9 Aug 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6522386

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 9

3 in = 10

HS = 1.577

VS = 1.758

GS = 1.971

CENTROID +

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.957
MINIMUM X	-.620
MAXIMUM Y	.798
MINIMUM Y	-.960
CENTROID X	-.636
CENTROID Y	.103
POA TO CENTROID in.	.644
MIN RADIUS	.416
MEAN RADIUS	.798
MAX RADIUS	1.022
HORIZONTAL SPREAD	1.577
VERTICAL SPREAD	1.758
EXTREME SPREAD	1.971
NUMBER IN ONE INCH CIRCLE	2
NUMBER IN TWO INCH CIRCLE	9
NUMBER IN THREE INCH CIRCLE	10

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

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

MODEL 700TM M24

SERIAL NO. C6522306

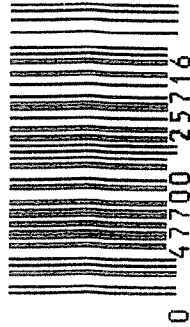
ORDER NO. 5716

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



5716 C6522306

UPC



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