C6594528

MODEL 700™ M24

Model 548™

Action

Barrel Length

Capacity

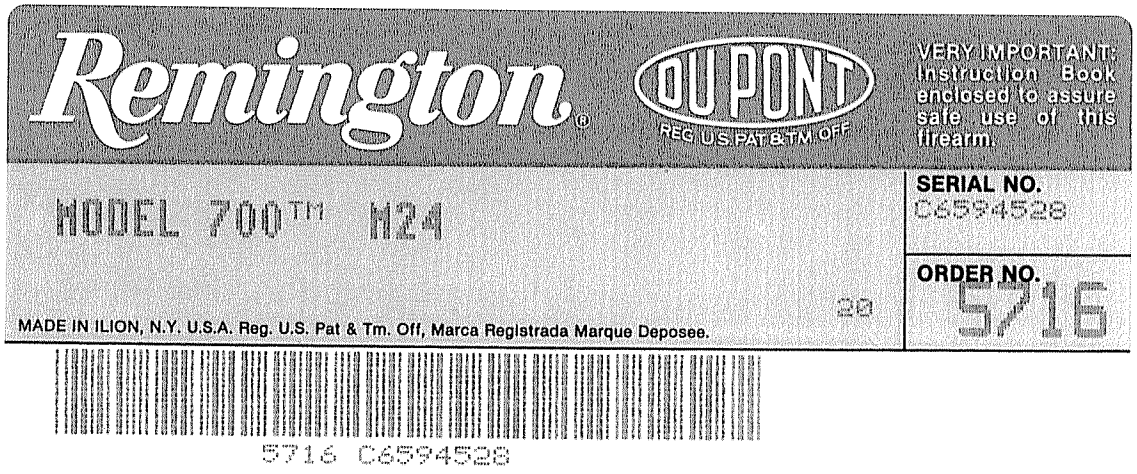
Order No. 5715

*Includes 1 in chamber.

Remington

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

BARBER - M24 00018722



BARBER - M24 00018722

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6594528

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1228 90		RW
600	Proof	1228 90		RW
607	Check Headspace	1228 90		RW
610	Dis-assemble Gun	1228 90		RW
612	Magnaflux Barrel Action		1-7-91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	GB
617	Drill and Tap Sight Holes	1 10 91		FB
618	Polish Barrel	1 10 91		WB
620	Apply Coatings (Barrel Action)		1-18-91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		1/19/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/19/91	RW
	C) Inspect Ejector Hole for Chamfer		1/19/91	RW
	D) Oil Firing Pin Ass'y		1/19/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		1-22-91	RW

Op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/4	4 1/4	4 1/4			1/22/91	WB
	G) Safety Off Force	2 1/4	2 1/4	2 1/4			1/22/91	WB
	H) Trigger Pull Test & Retainability						1-22-91	JL
	I) Firing Pin Indent	.0205	.020	.0205			1/22/91	WB
	J) Assemble Stock						1/24/91	RW
	K) Assemble Swivel Studs						2-4-91	A
	L) Attach Front and Rear Sight Assemblies						1/24/91	RW
	M) Iron Sight Alignment						1/24/91	RW
	N) Detach Front & Rear Sights & place in numbered container						1/24/91	RW
	O) Attach Scope to Rifle						1/24/91	RW
	P) Detach & Attach Scope 20 Times						1/24/91	RW
640	Gallery Target & Test						1-24-91	AC
	A) Time						1-24-91	AC
	B) Malfunctions						1-24-91	AC
	C) Pierced Primers						1-24-91	AC
	D) Optical Clearity of Scope						1-24-91	AC
645	Inspect for Live Ammo						1-24-91	AC
655	Final Inspection A) Headspace						2-4-91	AC
	B) Trigger Pull	2.46	2.21	2.32	2.30	2.29	2-1-91	JL
	C) Function						2-4-91	AC
660	Pack						3-19-91	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO C654528
DATE 1-22-91
TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.21	2.49	2.44	2.46	MIN. SETTING,
PULL #2	2.35	2.56	2.55	2.21	NO AVG. OF 5
PULL #3	2.47	2.38	2.56	2.32	READINGS ACCEPT-
PULL #4	2.51	2.57	2.47	2.30	ABLE LESS THAN 2#
PULL #5	2.32	2.46	2.47	2.29	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.43	3.29		
PULL #2	3.22	3.41		
PULL #3	3.35	3.20		
PULL #4	3.20	3.38		
PULL #5	3.36	3.20		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.28	4.33		4.20
PULL #2	4.20	4.25		4.28
PULL #3	4.37	4.35		4.27
PULL #4	4.08	4.39		4.18
PULL #5	4.37	4.41		4.25
TOTAL				
AVG.				

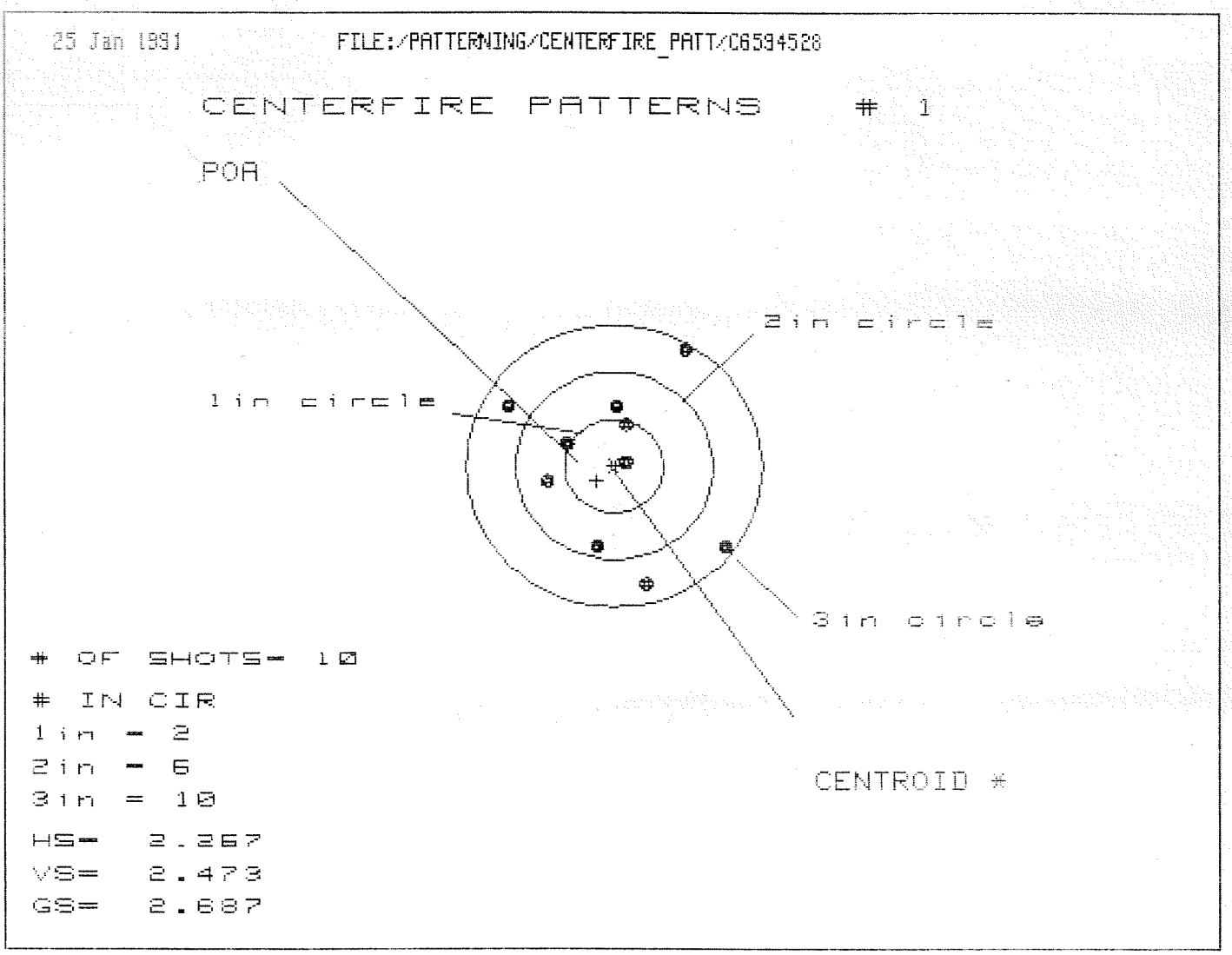
CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594528
25 Jan 1991

CENTROIDAL DISTANCES

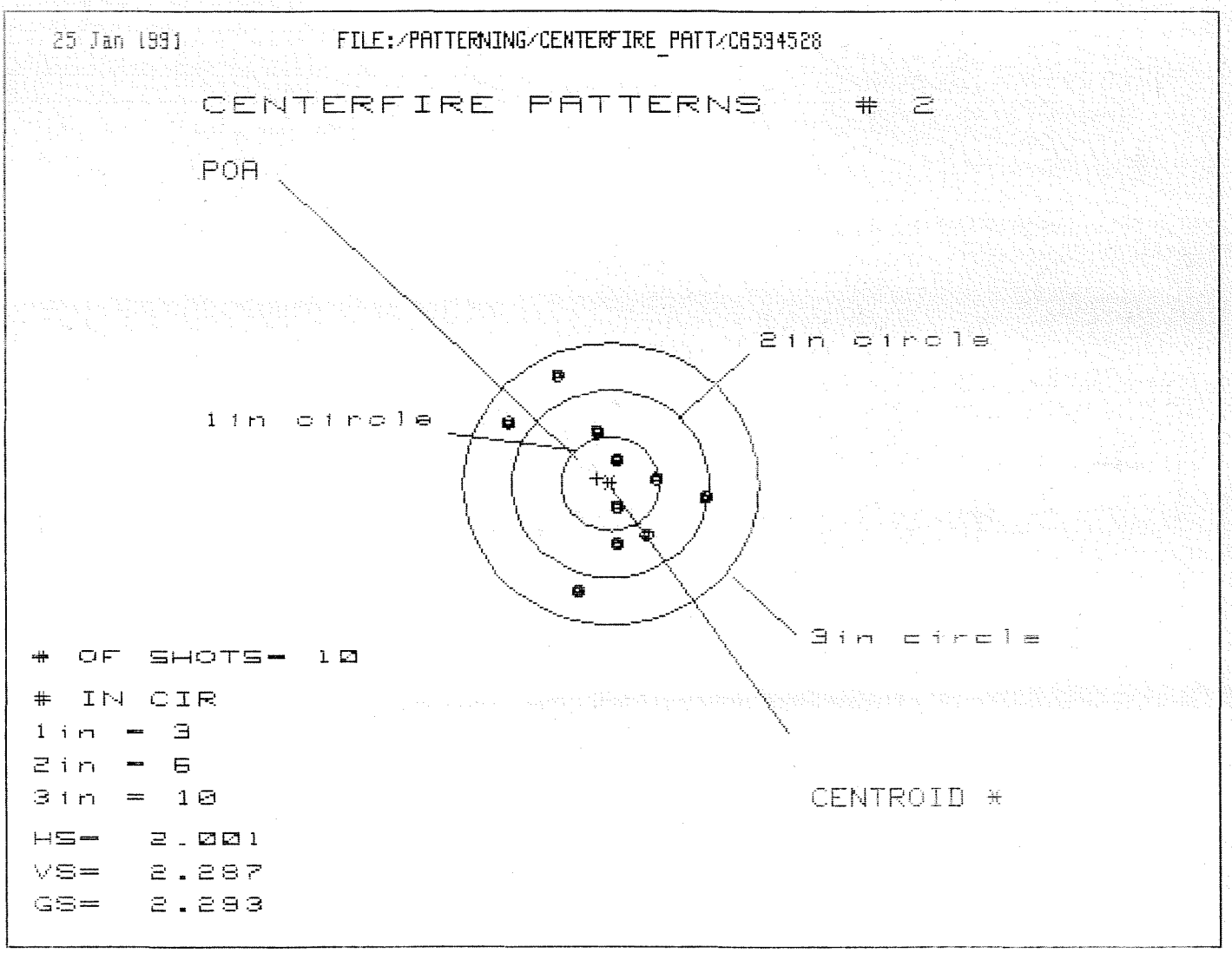
0	TO	1	.234617
1	TO	2	.217892
1	TO	3	.116211
1	TO	4	.227982
1	TO	5	.0329848

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0988
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .113
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .150101

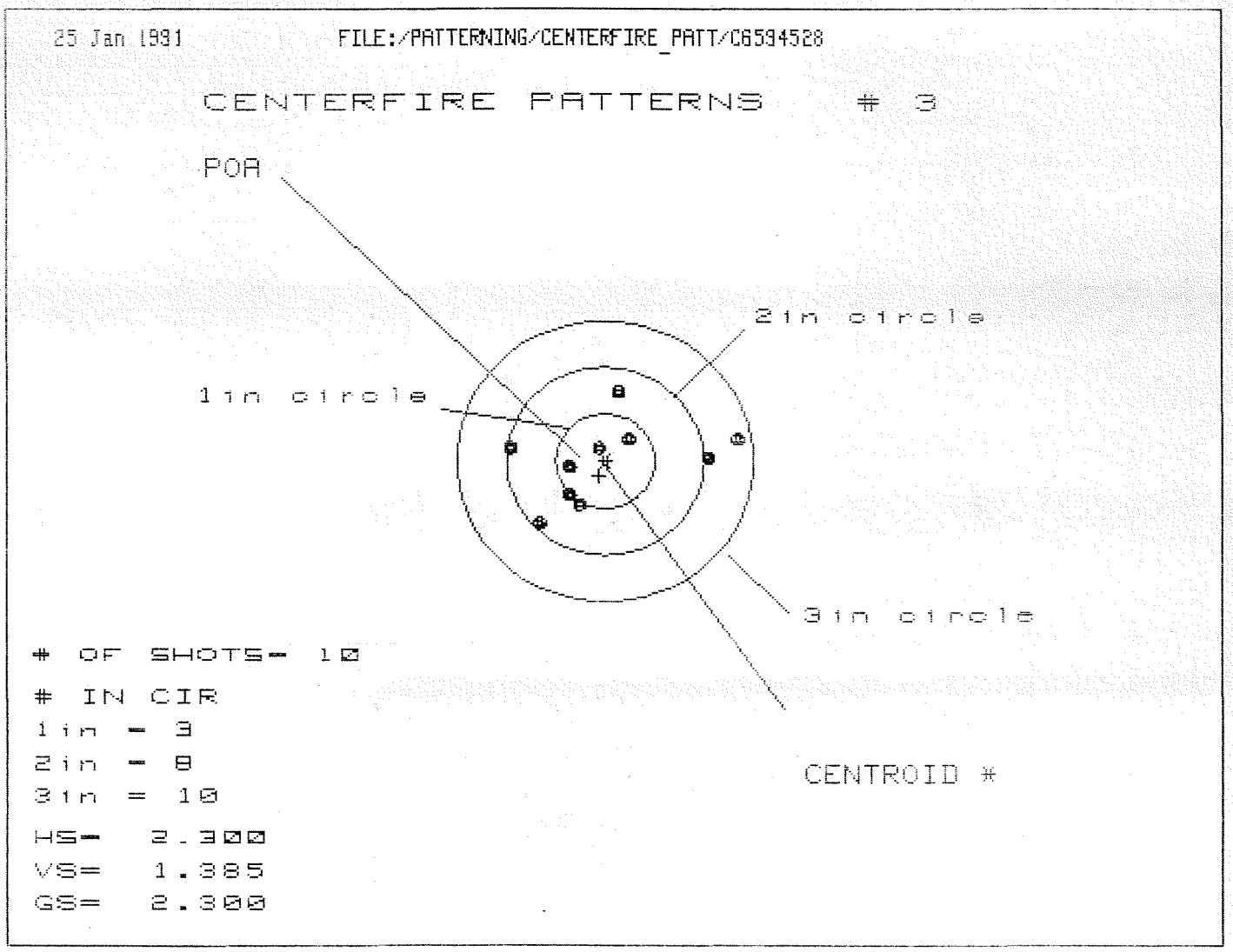
THE AMR FOR THIS RIFLE IS: .8772



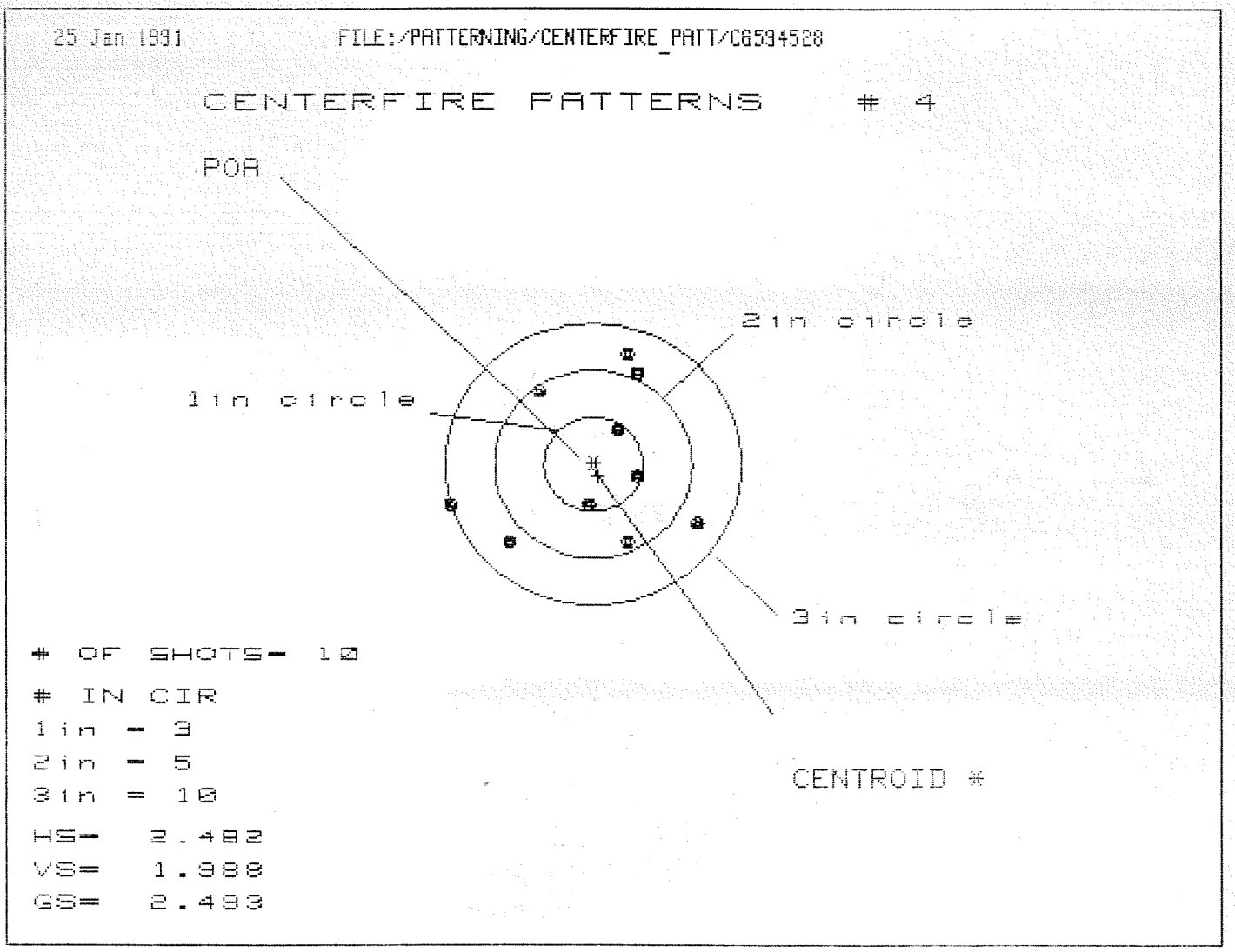
PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.152	.814	.563
MINIMUM X	:	-1.115	-.987	-.885
MAXIMUM Y	:	1.228	1.136	.683
MINIMUM Y	:	-1.245	-1.337	-1.196
CENTROID X	:	.177	.049	-.053
CENTROID Y	:	.154	.246	.105
POA TO CENTROID in.	:	.235	.251	.117
MIN RADIUS	:	.139	.277	.374
MEAN RADIUS	:	.872	.793	.723
MAX RADIUS	:	1.420	1.415	1.321
HORIZONTAL SPREAD	:	2.267	1.801	1.448
VERTICAL SPREAD	:	2.473	2.473	1.879
EXTREME SPREAD	:	2.687	2.498	2.356
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	



PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.007	.946	.891
MINIMUM X	:	-.994	-1.055	-1.110
MAXIMUM Y	:	1.137	.785	.657
MINIMUM Y	:	-1.149	-1.023	-.601
CENTROID X	:	.136	.197	.252
CENTROID Y	:	-.060	-.187	-.059
POA TO CENTROID in.	:	.149	.271	.258
MIN RADIUS	:	.238	.130	.222
MEAN RADIUS	:	.744	.662	.598
MAX RADIUS	:	1.263	1.315	1.290
HORIZONTAL SPREAD	:	2.001	2.001	2.001
VERTICAL SPREAD	:	2.287	1.808	1.258
EXTREME SPREAD	:	2.293	2.162	2.162
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	10		



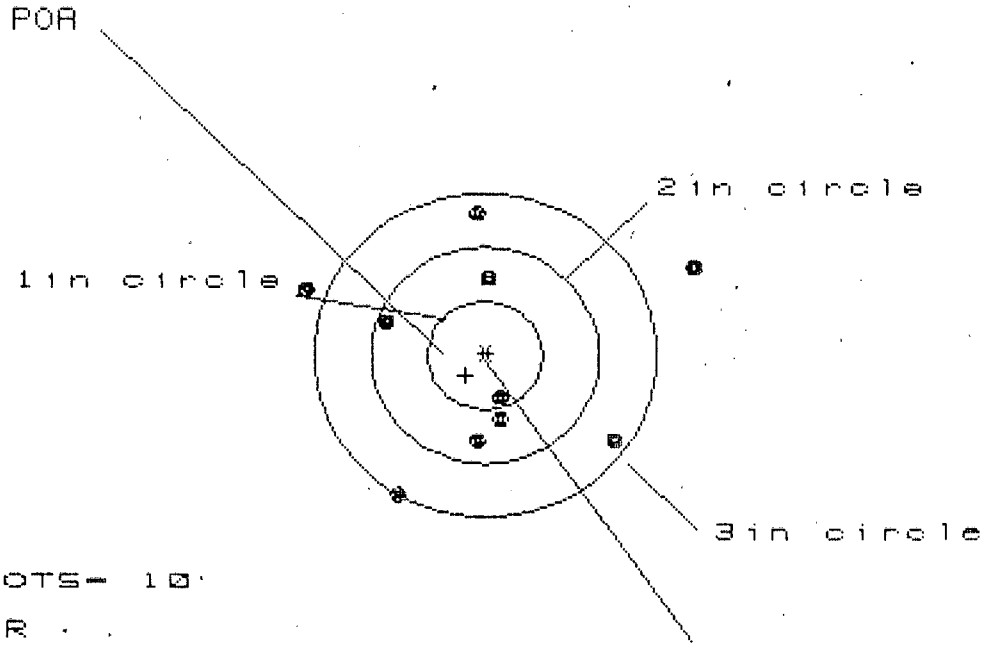
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.333	1.163	.537
MINIMUM X	:	-.967	-.819	-.674
MAXIMUM Y	:	.739	.760	.773
MINIMUM Y	:	-.646	-.625	-.612
CENTROID X	:	.061	-.087	-.232
CENTROID Y	:	.161	.140	.127
POA TO CENTROID in.	:	.173	.164	.264
MIN RADIUS	:	.167	.218	.129
MEAN RADIUS	:	.698	.604	.514
MAX RADIUS	:	1.347	1.167	.868
HORIZONTAL SPREAD	:	2.300	1.982	1.211
VERTICAL SPREAD	:	1.385	1.385	1.385
EXTREME SPREAD	:	2.300	1.984	1.577
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	



PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.064	.907	.409
MINIMUM X	:	-1.418	-1.044	-.931
MAXIMUM Y	:	1.131	1.086	1.001
MINIMUM Y	:	-.857	-.902	-.987
CENTROID X	:	-.049	.108	-.005
CENTROID Y	:	.124	.169	.254
POA TO CENTROID in.	:	.134	.201	.254
MIN RADIUS	:	.450	.328	.351
MEAN RADIUS	:	.951	.867	.837
MAX RADIUS	:	1.474	1.380	1.357
HORIZONTAL SPREAD	:	2.482	1.951	1.340
VERTICAL SPREAD	:	1.988	1.988	1.988
EXTREME SPREAD	:	2.493	2.335	2.335
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

25 Jan 1991 FILE:/PATTERNING/CENTERFIRE_PATT/C6594528

CENTERFIRE PATTERNS # 5



# OF SHOTS= 10
# IN CIR
1in = 1
2in = 5
3in = 8
HS= 3.411
VS= 2.564
GS= 3.419

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.878	1.341	1.175
MINIMUM X	:	-1.533	-1.324	-.836
MAXIMUM Y	:	1.312	1.402	1.484
MINIMUM Y	:	-1.252	-1.162	-1.080
CENTROID X	:	.169	-.040	.126
CENTROID Y	:	.186	.096	.014
POA TO CENTROID in.	:	.251	.104	.126
MIN RADIUS	:	.396	.447	.269
MEAN RADIUS	:	1.121	1.002	.906
MAX RADIUS	:	2.042	1.499	1.484
HORIZONTAL SPREAD	:	3.411	2.665	2.011
VERTICAL SPREAD	:	2.564	2.564	2.564
EXTREME SPREAD	:	3.419	2.978	2.672
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	