

C6522245

MODEL 700TM M24

Model **5M5** TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6522245

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/24/90	KA
600	Proof		6/24/90	KA
607	Check Headspace		6/24/90	KA
610	Dis-assemble Gun		6/24/90	KA
612	Magnaflux Barrel Action		7/10/90	KR
	Magnaflux Bolt		7/11/90	KR
615	Rollmark Caliber		7/10/90	LS
617	Drill and Tap Sight Holes		7/11/90	KB
618	Polish Barrel AB		7/13/90	WB
620	Apply Coatings (Barrel Action)		7-23-90	TJA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		8/17/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/17/90	KS
	C) Inspect Ejector Hole for Chamfer		8/17/90	KS
	D) Oil Firing Pin Ass'y		8/17/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		9-15-90	SL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/4	4 1/4			8/30/90	WLB
	G) Safety Off Force	7 1/4	7 1/4	7 1/4			8/30/90	WLB
	H) Trigger Pull Test & Retainability						9-15-90	84
	I) Firing Pin Indent	.0225	.023	.0225			8/31/90	WLB
	J) Assemble Stock						8/20/90	KS
	K) Assemble Swivel Studs						9/16/90	928
	L) Attach Front and Rear Sight Assemblies						8/20/90	KS
	M) Iron Sight Alignment						8/20/90	KS
	N) Detach Front & Rear Sights & place in numbered container						8/20/90	KS
	O) Attach Scope to Rifle						8/20/90	KS
	P) Detach & Attach Scope 20 Times						8/20/90	KS
640	Gallery Target & Test						8/21/90	KJ
	A) Time						8/21/90	KJ
	B) Malfunctions						8/21/90	KJ
	C) Pierced Primers						8/21/90	KJ
	D) Optical Clarity of Scope						8/21/90	KJ
645	Inspect for Live Ammo						8/21/90	KJ
655	Final Inspection							
	A) Headspace						9/16/90	928
	B) Trigger Pull	2.20	2.17	2.21	2.19	2.18	9-15-90	84
	C) Function						9/16/90	928
660	Pack						9/19/90	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6522245

DATE 9-15-90

TESTER J21

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.43	2.51	2.20	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.42	2.45	2.49	2.17	
PULL #3	2.40	2.56	2.20	2.21	
PULL #4	2.48	2.52	2.29	2.19	
PULL #5	2.44	2.51	2.05	2.18	
TOTAL	12.15	12.47	11.54	10.95	
AVG.	2.43	2.494	2.308	2.19	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.22	3.16		
PULL #2	3.17	3.20		
PULL #3	3.12	3.20		
PULL #4	3.18	3.25		
PULL #5	3.20	3.22		
TOTAL	15.89	16.03		
AVG.	3.178	3.206		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.37	4.25		4.29
PULL #2	4.22	4.28		4.24
PULL #3	4.21	4.19		4.26
PULL #4	4.25	4.23		4.26
PULL #5	4.23	4.26		4.29
TOTAL	21.28	21.21		21.34
AVG.	4.256	4.242		4.268

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522245
22 Aug 1990

CENTROIDAL DISTANCES

0 TO 1	.268961
1 TO 2	.671751
1 TO 3	.611569
1 TO 4	.504406
1 TO 5	.475742

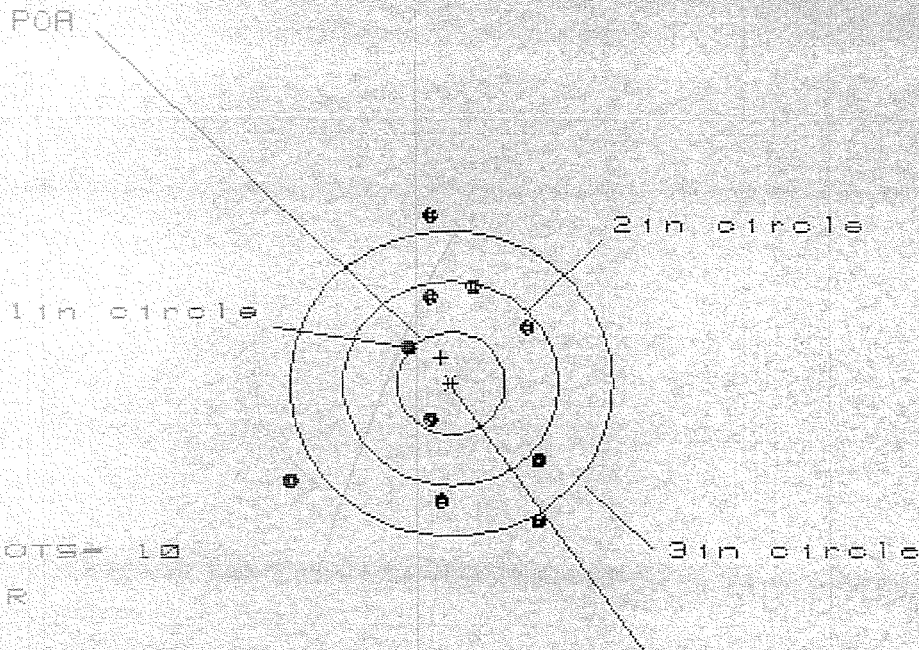
34² <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1058
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .127
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .165296
THE AMR FOR THIS RIFLE IS: .8784

21 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522245

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 1

2in = 4

3in = 7

HS = 2.305

VS = 2.972

GS = 3.142

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.818	.653	.607
MINIMUM X	:	-1.487	-.531	-.577
MAXIMUM Y	:	1.659	1.556	1.078
MINIMUM Y	:	-1.313	-1.416	-1.222
CENTROID X	:	.094	.259	.305
CENTROID Y	:	-.252	-.149	-.343
POA TO CENTROID in.	:	.269	.298	.459
MIN RADIUS	:	.370	.543	.438
MEAN RADIUS	:	1.080	.996	.919
MAX RADIUS	:	1.755	1.598	1.365
HORIZONTAL SPREAD	:	2.305	1.184	1.184
VERTICAL SPREAD	:	2.972	2.972	2.300
EXTREME SPREAD	:	3.142	3.142	2.382
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

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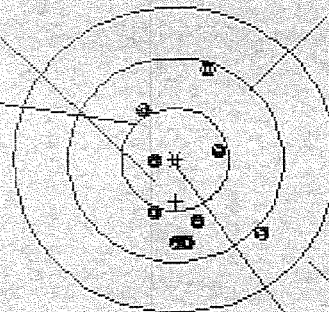
CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle



OF SHOTS- 10

IN CIR

1in = 2

2in = 8

3in = 9

HS= 1.899

VS= 2.960

GS= 3.421

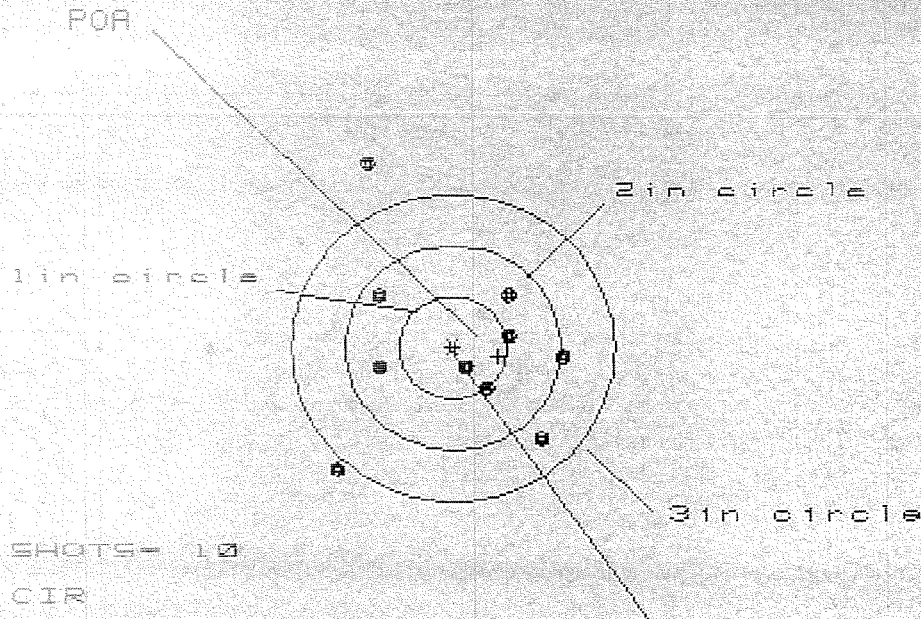
CENTROID #

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.838	.720	.324
MINIMUM X	:	-1.061	-.388	-.298
MAXIMUM Y	:	2.116	1.093	1.031
MINIMUM Y	:	-.844	-.609	-.670
CENTROID X	:	-.001	.117	.027
CENTROID Y	:	.413	.178	.239
POA TO CENTROID in.	:	.413	.213	.241
MIN RADIUS	:	.177	.345	.236
MEAN RADIUS	:	.832	.618	.579
MAX RADIUS	:	2.367	1.109	1.068
HORIZONTAL SPREAD	:	1.899	1.108	.622
VERTICAL SPREAD	:	2.960	1.702	1.702
EXTREME SPREAD	:	3.421	1.731	1.731
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	8		
NUMBER IN THREE INCH CIRCLE	=	9		

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CENTERFIRE PATTERNS # 3



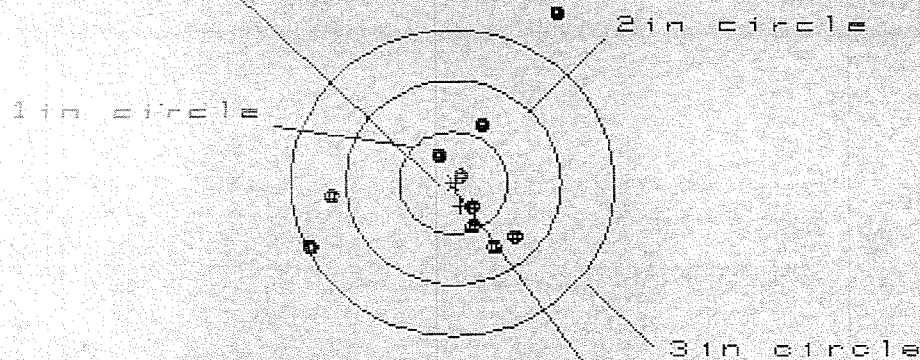
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.039	.947	.805
MINIMUM X	:	-1.049	-1.141	-.933
MAXIMUM Y	:	1.824	.747	.618
MINIMUM Y	:	-1.232	-1.029	-.812
CENTROID X	:	-.417	-.325	-.183
CENTROID Y	:	.084	-.119	.010
POA TO CENTROID in.	:	.425	.346	.183
MIN RADIUS	:	.224	.067	.127
MEAN RADIUS	:	.938	.777	.654
MAX RADIUS	:	2.001	1.536	1.119
HORIZONTAL SPREAD	:	2.088	2.088	1.738
VERTICAL SPREAD	:	3.056	1.776	1.430
EXTREME SPREAD	:	3.153	2.376	2.063
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 4

POA



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 8

HS= 2.297

VS= 2.284

GS= 3.239

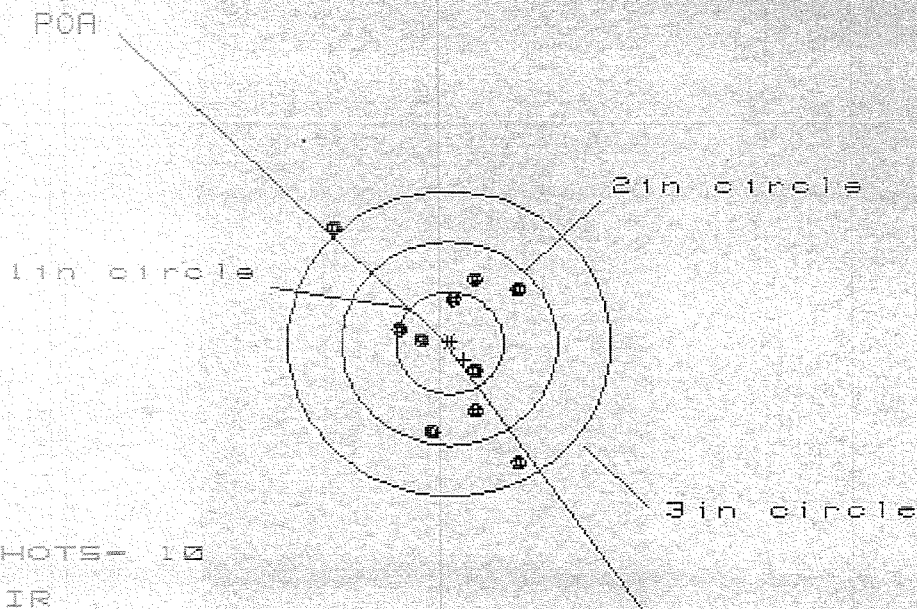
CENTROID *

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.935	.718	.560
MINIMUM X	:	-1.362	-1.258	-1.212
MAXIMUM Y	:	1.626	.716	.657
MINIMUM Y	:	-.658	-.478	-.528
CENTROID X	:	-.070	-.174	-.016
CENTROID Y	:	.225	.045	.104
POA TO CENTROID in.	:	.236	.179	.106
MIN RADIUS	:	.128	.251	.116
MEAN RADIUS	:	.786	.680	.539
MAX RADIUS	:	1.875	1.346	1.212
HORIZONTAL SPREAD	:	2.297	1.976	1.772
VERTICAL SPREAD	:	2.284	1.194	1.185
EXTREME SPREAD	:	3.239	2.036	1.815
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 4

2in = 8

3in = 9

HS= 1.719

VS= 2.243

GS= 2.794

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.641	.522	.580
MINIMUM X	-1.077	-.589	-.531
MAXIMUM Y	1.091	.771	.642
MINIMUM Y	-1.152	-1.031	-.862
CENTROID X	-.135	-.015	-.073
CENTROID Y	.164	.043	.172
POA TO CENTROID in.	.212	.045	.187
MIN RADIUS	.298	.185	.314
MEAN RADIUS	.756	.666	.593
MAX RADIUS	1.533	1.132	.892
HORIZONTAL SPREAD	1.719	1.111	1.111
VERTICAL SPREAD	2.243	1.802	1.504
EXTREME SPREAD	2.794	1.832	1.621
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	9		

Remington®



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

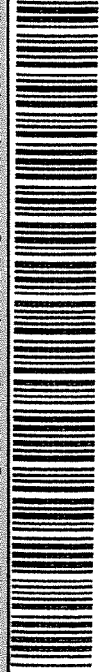
MODEL 700™ H24

SERIAL NO.
06522245

ORDER NO.
5716

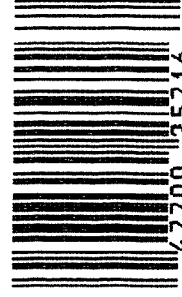
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