

CG522305

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 RB		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

SWS TRIGGER PULL TEST

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 JL

	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

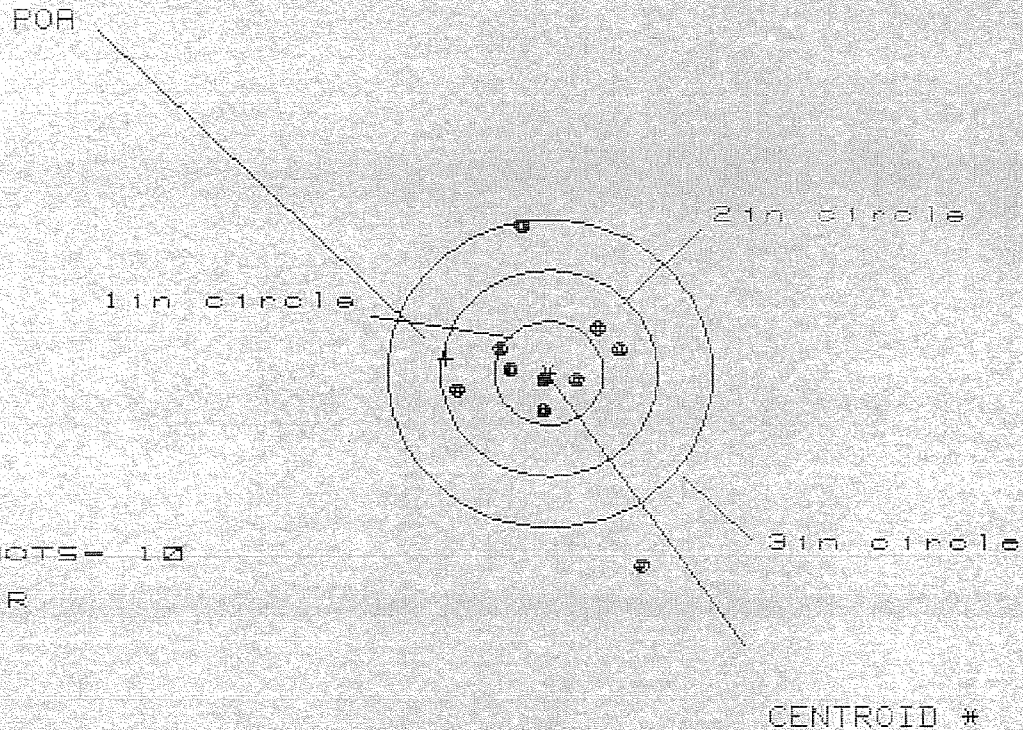
$\bar{x} = \frac{1}{4} \sum_{i=1}^4 x_i$ POA

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



OF SHOTS- 10

IN CIR

1in = 4

2in = 8

3in = 9

HS= 1.715

VS= 3.281

GS= 3.483

CENTROID #

PATTERN #	:	1		
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

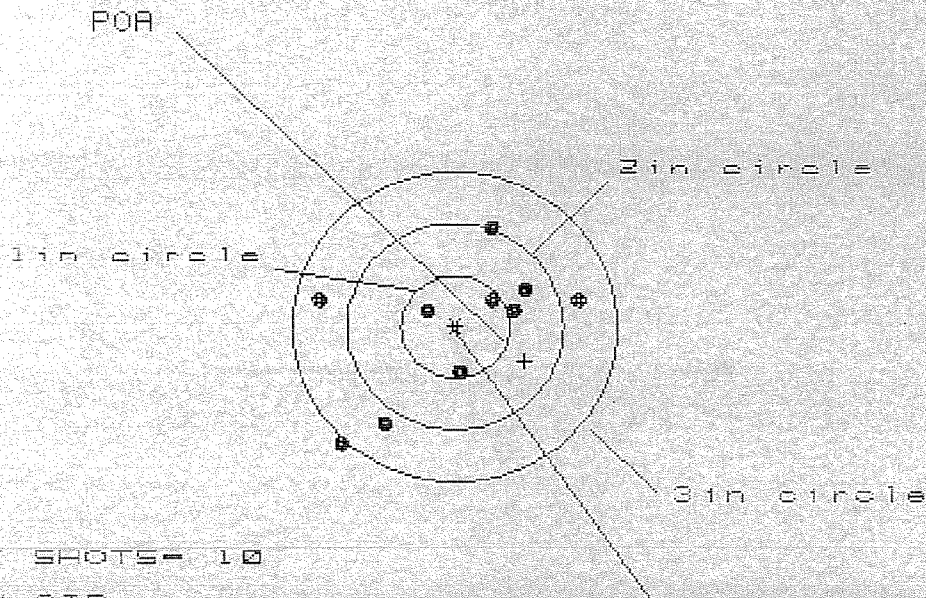
CENTROID *

PATTERN #	1	2	3
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

HE= 2.349

VS= 2.165

GS= 2.583

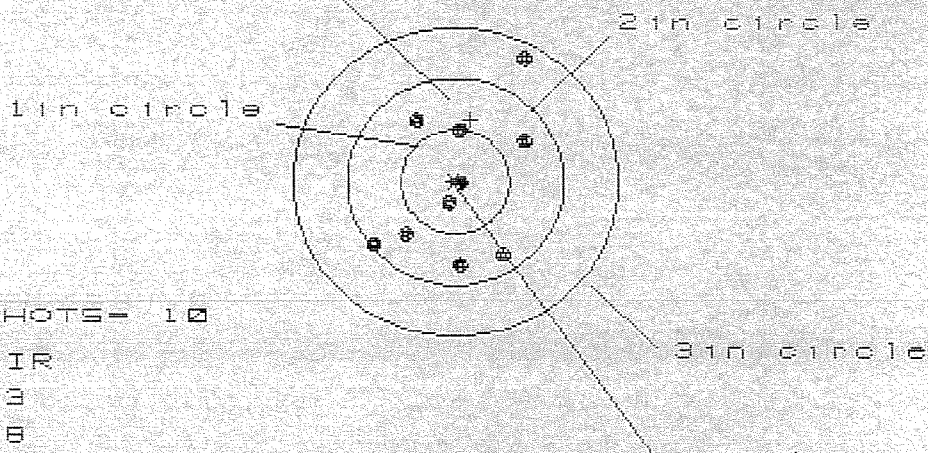
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.126	1.014	.847
MINIMUM X	:	-1.223	-1.335	-.900
MAXIMUM Y	:	1.012	.884	.905
MINIMUM Y	:	-1.153	-1.036	-1.015
CENTROID X	:	-.643	-.531	-.364
CENTROID Y	:	.336	.464	.443
POA TO CENTROID in.	:	.726	.705	.573
MIN RADIUS	:	.246	.306	.206
MEAN RADIUS	:	.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



OF SHOTS= 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.466

VS= 1.973

GS= 2.307

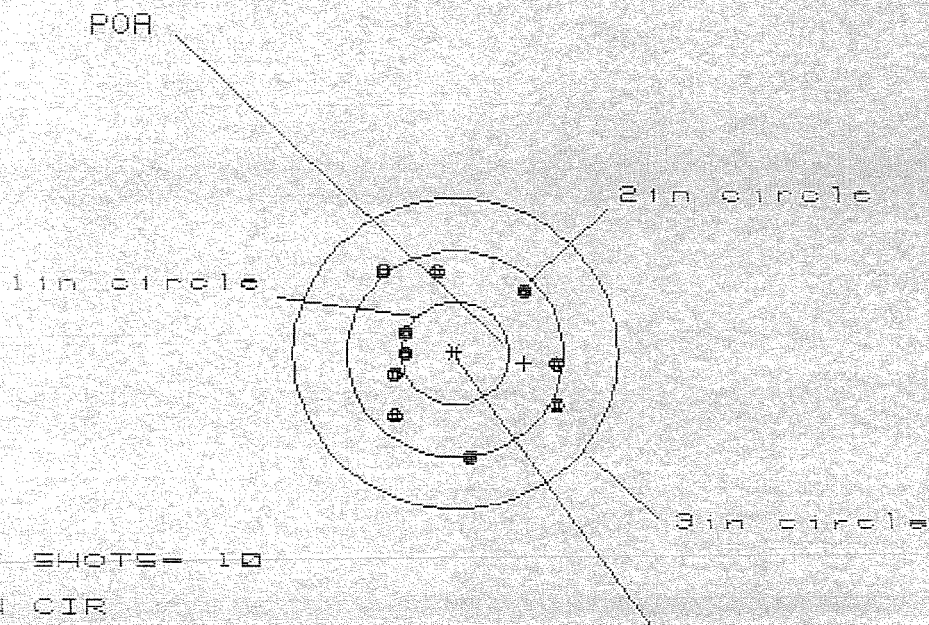
CENTROID #

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	

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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

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.957	1.057	.992
MINIMUM X	:	-.620	-.520	-.535
MAXIMUM Y	:	.798	.746	.836
MINIMUM Y	:	-.960	-1.012	-.922
CENTROID X	:	-.636	-.736	-.671
CENTROID Y	:	.103	.155	.065
POA TO CENTROID in.	:	.644	.753	.675
MIN RADIUS	:	.416	.320	.382
MEAN RADIUS	:	.798	.747	.739
MAX RADIUS	:	1.022	1.065	.993
HORIZONTAL SPREAD	:	1.577	1.577	1.527
VERTICAL SPREAD	:	1.758	1.758	1.758
EXTREME SPREAD	:	1.971	1.906	1.789
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.

MODEL 700[™] W24

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

VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.	SERIAL NO. C6522306	ORDER NO. 5716
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