C663625

MODEL 700™ M24

Model 548 ™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636125

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		4/23/91	K.S.
600	Proof		4/23/91	K.S.
607	Check Headspace		4/23/91	K.S.
610	Dis-assemble Gun		4/23/91	K.S.
612	Magnaflux Barrel Action		5 8 91	KCd
	Magnaflux Bolt		5 8 91	KCd
615	Rollmark Caliber		5 8 91	CS
617	Drill and Tap Sight Holes		5 15 91	ES
618	Polish Barrel		5 15 91	ws
620	Apply Coatings (Barrel Action)		5-31-91	
	Apply Coating (Bolt)		5-31-91	
625	Final Assembly A) Clean inside of Bolt Assembly		6/12/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6/12/91	KS
	C) Inspect Ejector Hole for Chamfer		6/12/91	KS
	D) Oil Firing Pin Ass'y		6/12/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		6/13/91	

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			6-13-91	DH
	G) Safety Off Force	4	4	4			6-13-91	DH
	H) Trigger Pull Test & Retainability						6-13-91	DH
	I) Firing Pin Indent	.022	.022	.022			6-13-91	DH
	J) Assemble Stock						6/13/91	KS
	K) Assemble Swivel Studs						6-14-91	DH
	L) Attach Front and Rear Sight Assemblies						6/13/91	KS
	M) Iron Sight Alignment						6/13/91	KS
	N) Detach Front & Rear Sights & place in numbered container						6/13/91	KS
	O) Attach Scope to Rifle						6/13/91	KS
	P) Detach & Attach Scope 20 Times						6/13/91	KS
640	Gallery Target & Test						6/14/91	KS
	A) Time						"	KS
	B) Malfunctions						"	KS
	C) Pierced Primers						"	KS
	D) Optical Clearity of Scope						"	KS
645	Inspect for Live Ammo						6/14/91	KS
655	Final Inspection A) Headspace						6-15-91	DH
	B) Trigger Pull	2.70	2.42	2.31	2.32	2.26	6-15-91	DH
	C) Function						6-15-91	DH
660	Pack						6-19-91	KS

MOD. _____ GA. CAL. _____ GUN # 6125

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st	Ejector Stick	KS
	2nd	Reamed Ejector Hole & Polish Ejector	
	3rd		
	4th		

FUNCTION RD 6654 Rev 1

TEST INIT.	ACTION TO CORRECT	ASSEM. #
PROOF	100 RD test	
TEST	OK	
TGT	6-15-91 DH	
PROOF		
TEST		
TGT		
	ENGINEER	
PROOF		
TEST		
TGT		
	ENGINEER	
PROOF		
TEST		
TGT		

SWS TRIGGER PULL TEST

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

SERIAL NO. CC636175
DATE 6-13-91
TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.59	2.72	2.80	2.70	MIN. SETTING,
PULL #2	2.61	2.73	2.79	2.42	NO AVG. OF 5
PULL #3	2.54	2.42	2.72	2.31	READINGS ACCEPT-
PULL #4	2.62	2.72	2.80	2.32	ABLE LESS THAN 2#
PULL #5	2.61	2.73	2.90	2.26	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.26	3.28		
PULL #2	3.34	3.26		
PULL #3	3.17	3.17		
PULL #4	3.14	3.16		
PULL #5	3.16	3.27		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.29	4.50		4.42
PULL #2	4.30	4.48		4.60
PULL #3	4.37	4.52		3.98
PULL #4	4.54	4.59		4.26
PULL #5	4.36	4.52		4.48
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636125
14 Jun 1991

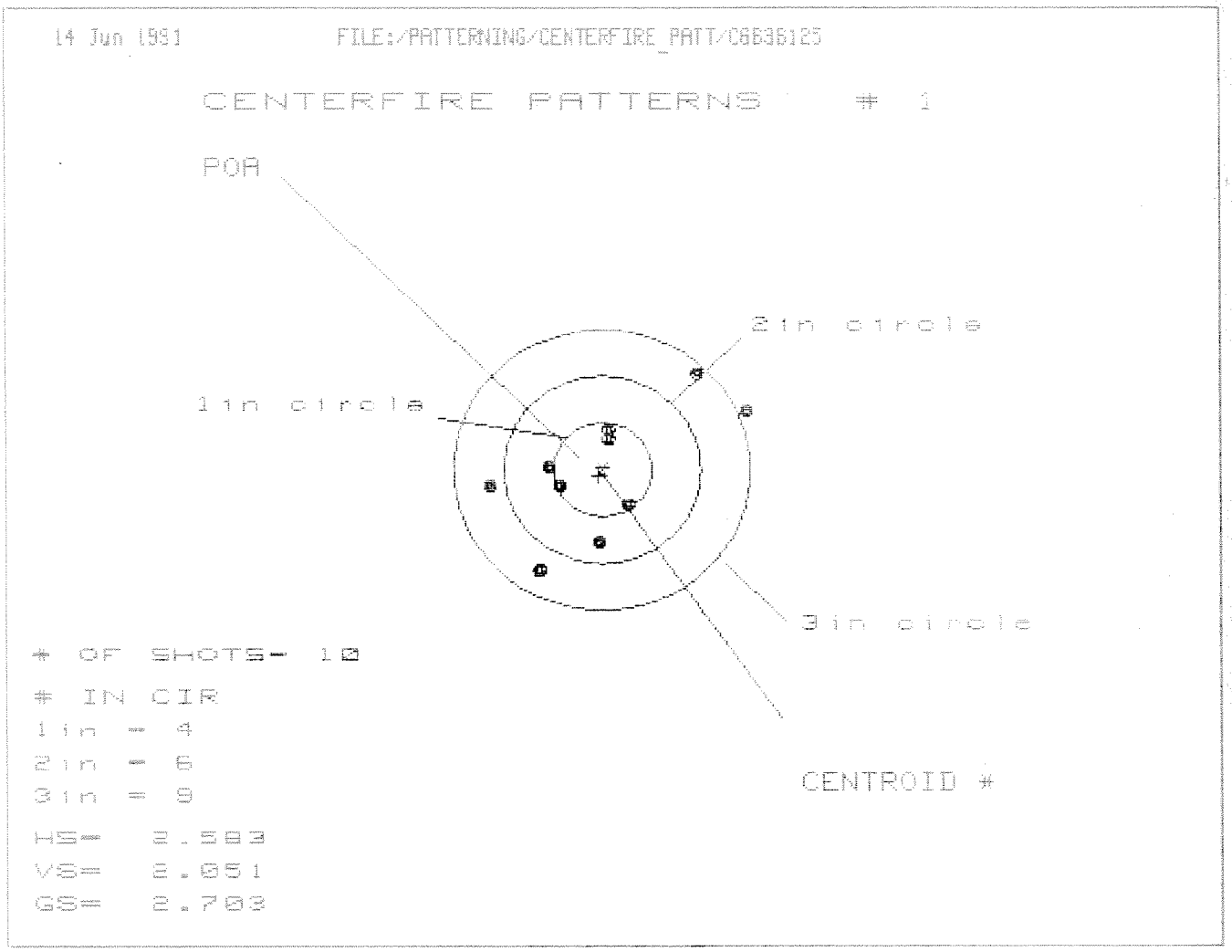
CENTROIDAL DISTANCES

0	TO	1	.0814923
1	TO	2	.0858662
1	TO	3	.202633
1	TO	4	.247891
1	TO	5	.0424853

<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0604
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0446
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0750621

THE AMR FOR THIS RIFLE IS: .8602



PATTERN #	:	[redacted]		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.418	1.072	.573
MINIMUM X	:	-1.165	-1.008	-.873
MAXIMUM Y	:	1.028	1.101	.614
MINIMUM Y	:	-1.023	-.950	-.812
CENTROID X	:	.040	-.117	-.252
CENTROID Y	:	.071	-.002	-.140
POA TO CENTROID in.	:	.081	.117	.288
MIN RADIUS	:	.350	.263	.121
MEAN RADIUS	:	.827	.721	.600
MAX RADIUS	:	1.562	1.537	.876
HORIZONTAL SPREAD	:	2.583	2.080	1.446
VERTICAL SPREAD	:	2.051	2.051	1.426
EXTREME SPREAD	:	2.703	2.549	1.562
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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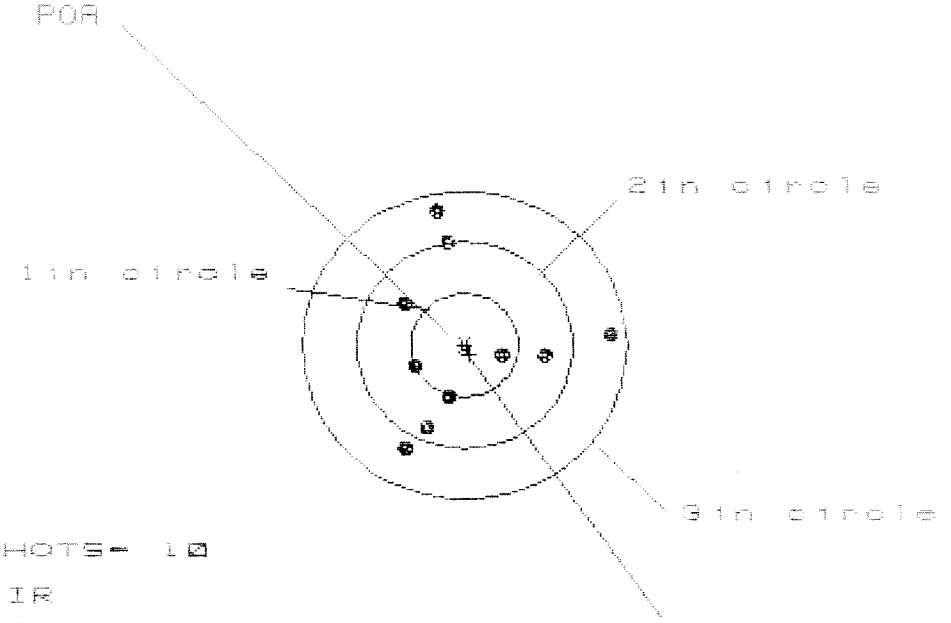
CENTERFIRE PATTERNS # 2

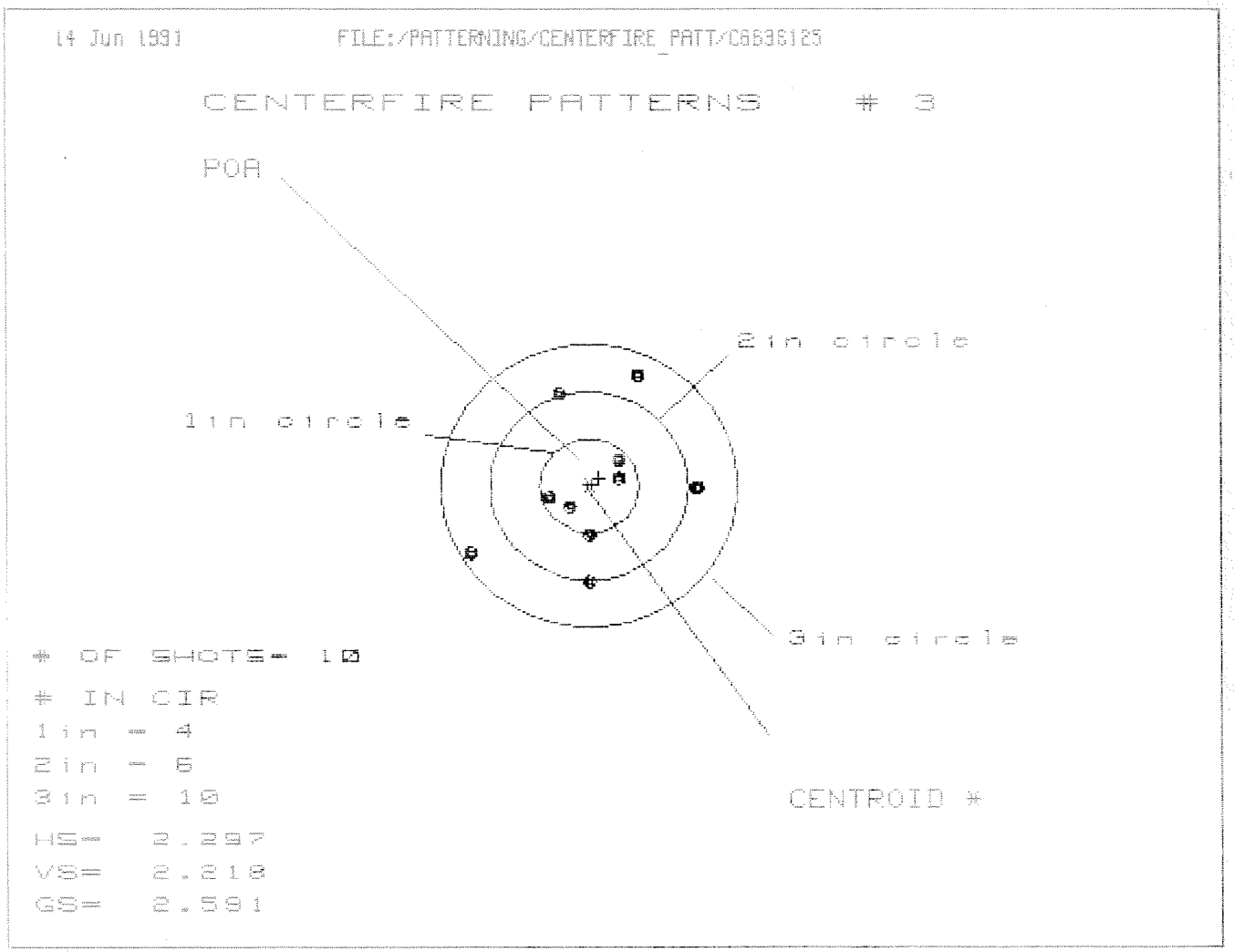


\# OF SHOTS= 10

# IN CIR	
1in	1
2in	7
3in	10

HS= 1.907
VS= 2.346
GS= 2.372

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.351	1.327	.913
MINIMUM X	:	-.556	-.580	-.414
MAXIMUM Y	:	1.346	1.116	1.144
MINIMUM Y	:	-1.000	-.850	-.822
CENTROID X	:	-.043	-.020	-.186
CENTROID Y	:	.093	-.057	-.085
POA TO CENTROID in.	:	.102	.061	.205
MIN RADIUS	:	.345	.314	.353
MEAN RADIUS	:	.863	.787	.696
MAX RADIUS	:	1.362	1.346	1.144
HORIZONTAL SPREAD	:	1.907	1.907	1.327
VERTICAL SPREAD	:	2.346	1.966	1.966
EXTREME SPREAD	:	2.372	2.188	2.012
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	



PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.063	.926	.966
MINIMUM X	:	-1.234	-.507	-.467
MAXIMUM Y	:	1.229	1.147	1.014
MINIMUM Y	:	-.989	-1.071	-.928
CENTROID X	:	-.094	.043	.003
CENTROID Y	:	-.081	.001	-.142
POA TO CENTROID in.	:	.124	.043	.143
MIN RADIUS	:	.300	.144	.252
MEAN RADIUS	:	.783	.701	.627
MAX RADIUS	:	1.436	1.191	1.108
HORIZONTAL SPREAD	:	2.297	1.433	1.433
VERTICAL SPREAD	:	2.218	2.218	1.941
EXTREME SPREAD	:	2.591	2.257	1.979
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

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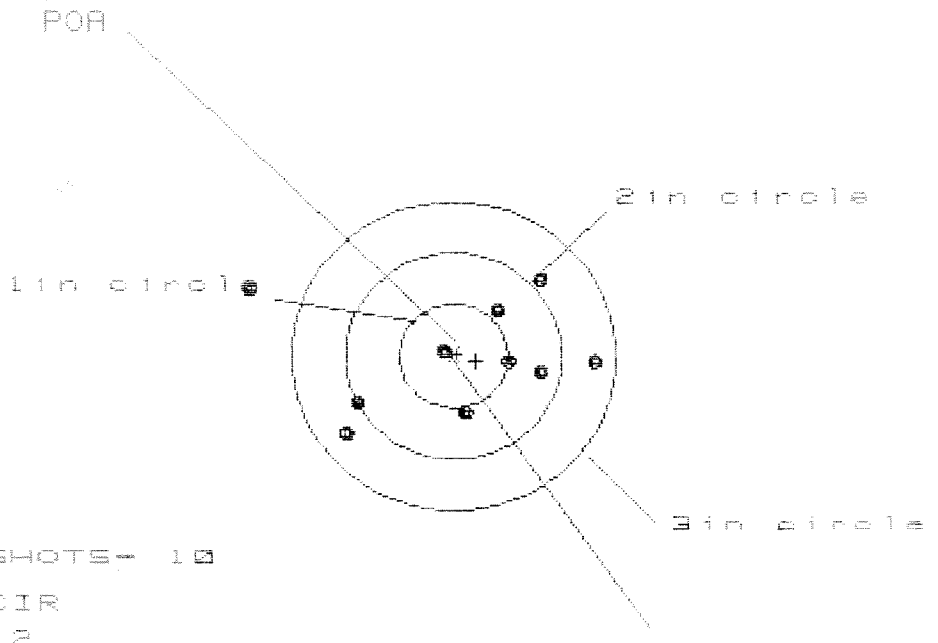
CENTERFIRE PATTERNS # 4



OF SHOTS= 10

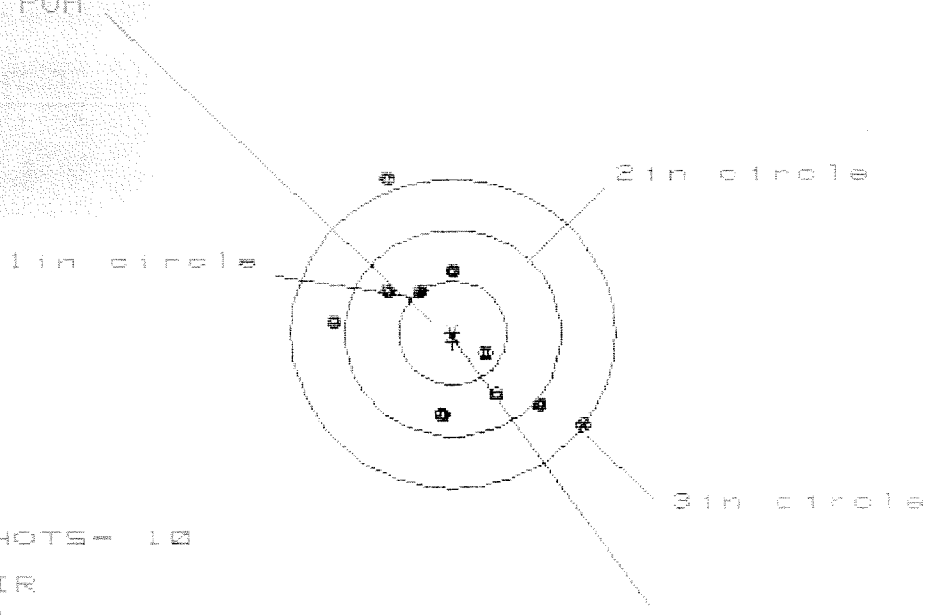
# IN CIR	
1in =	2
2in =	5
3in =	9

HS= 3.225
VS= 1.473
GS= 3.286

PATTERN #	:	[redacted]		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.317	1.105	.736
MINIMUM X	:	-1.908	-1.195	-1.057
MAXIMUM Y	:	.729	.798	.806
MINIMUM Y	:	-.744	-.675	-.667
CENTROID X	:	-.207	.005	-.133
CENTROID Y	:	.050	-.019	-.027
POA TO CENTROID in.	:	.213	.020	.135
MIN RADIUS	:	.109	.267	.213
MEAN RADIUS	:	.921	.764	.727
MAX RADIUS	:	2.008	1.373	1.250
HORIZONTAL SPREAD	:	3.225	2.300	1.793
VERTICAL SPREAD	:	1.473	1.473	1.473
EXTREME SPREAD	:	3.286	2.416	2.320
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

14 Jun 1993 FILE:/PATTERNING/CENTERFIRE_PATT/C8636125

CENTERFIRE PATTERNS # 5



* OF SHOTS= 10

# IN CIR
1in = 1
2in = 6
3in = 9

HS= 2.291
VS= 2.406
GS= 2.980

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.157	1.090	.881
MINIMUM X	:	-1.134	-1.201	-1.065
MAXIMUM Y	:	1.540	.829	.742
MINIMUM Y	:	-.866	-.694	-.684
CENTROID X	:	.002	.069	-.067
CENTROID Y	:	.090	-.081	.006
POA TO CENTROID in.	:	.091	.106	.067
MIN RADIUS	:	.386	.275	.422
MEAN RADIUS	:	.907	.806	.745
MAX RADIUS	:	1.654	1.292	1.078
HORIZONTAL SPREAD	:	2.291	2.291	1.946
VERTICAL SPREAD	:	2.406	1.523	1.426
EXTREME SPREAD	:	2.980	2.479	2.079
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	