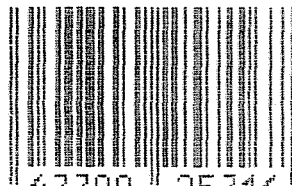


FORM

UPC



0 47700 25716 7

06549009

*INCLUDES 1 IN CHAMBER

CAPACITY*

BARREL LENGTH

MODEL 700 TM M24
ORDER NO 5716

Remington



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

MODEL 700 TM M24

SERIAL NO.

C6649009

ORDER NO.

5716

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

20



5716 C6649009

ORDER 5716

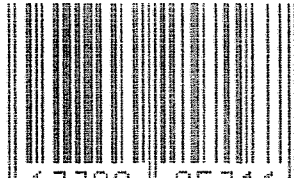
MODEL 700 TM M24

UPC

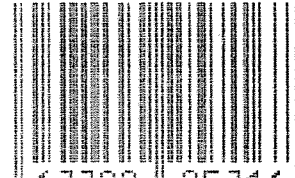
ORDER 5716

MODEL 700 TM M24

UPC



0 47700 25716 7



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GFM

GUN SERIAL # C6649009

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	M7 2	9 1	Rw
600	Proof	M7 2	9 1	Rw
607	Check Headspace	3	9 1	Rw
610	Dis-assemble Gun	2	8 1	Rw
612	Magnaflux Barrel Action		JUL 22 1991	GS
	Magnaflux Bolt		JUL 22 1991	GS
615	Rollmark Caliber		JUL 22 1991	GS
617	Drill and Tap Sight Holes		JUL 22 1991	LB
618	Polish Barrel		7/28/91	WB
620	Apply Coatings (Barrel Action)		8-28-91	TH
	Apply Coating (Bolt)		8-28-91	TH
625	Final Assembly A) Clean inside of Bolt Assembly		8/30/91	Rw
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/30/91	Rw
	C) Inspect Ejector Hole for Chamfer		8/30/91	Rw
	D) Oil Firing Pin Ass'y		8/30/91	Rw
	E) Adjust Trigger Pull to Min Setting and Stake		9/9/91	SLP

op. #	BARBER M24 0030586	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			9/9/91	JH
	G) Safety Off Force	4	4	4			9/9/91	JH
	H) Trigger Pull Test & Retainability						9/9/91	JH
	I) Firing Pin Indent	.021	.021	.021			9/9/91	JH
	J) Assemble Stock						10/8/91	RW
	K) Assemble Swivel Studs						10-17-91	AC
	L) Attach Front and Rear Sight Assemblies						10/8/91	RW
	M) Iron Sight Alignment						10/8/91	RW
	N) Detach Front & Rear Sights & place in numbered container						10/8/91	RW
	O) Attach Scope to Rifle						10/8/91	RW
	P) Detach & Attach Scope 20 Times						10/8/91	RW
640	Gallery Target & Test						10-8-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						10-8-91	NF
655	Final Inspection							
	A) Headspace						10-17-91	AC
	B) Trigger Pull	224	228	228	234	238	10-9-91	D/H
	C) Function						10-17-91	AC
660	Pack						12/7/91	D/H

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. 06649009

DATE 9-9-91

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.58	2.49	2.38	2.24	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.50	2.44	2.44	2.28	
PULL #3	2.34	2.60	2.43	2.28	
PULL #4	2.51	2.33	2.35	2.34	
PULL #5	2.59	2.33	2.50	2.38	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.58	3.49		
PULL #2	3.69	3.65		
PULL #3	3.55	3.57		
PULL #4	3.55	3.57		
PULL #5	3.48	3.59		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.30	4.20		4.42
PULL #2	4.37	4.25		4.31
PULL #3	4.20	4.25		4.32
PULL #4	4.26	4.38		4.45
PULL #5	4.42	4.23		4.34
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649009
8 Oct 1991

CENTROIDAL DISTANCES

0 TO 1	.486385
1 TO 2	.598359
1 TO 3	.466499
1 TO 4	.609007
1 TO 5	.507592

1
4  <----POA

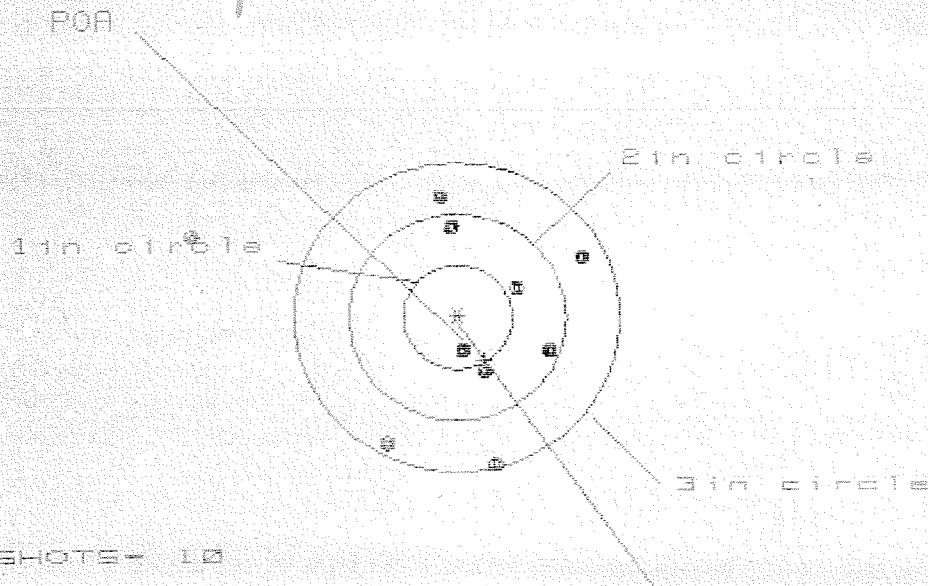
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .033
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1502
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .153782
THE AMR FOR THIS RIFLE IS: 1.046

8 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649089

1649009

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 9

HS = 3.612

VS = 2.529

GS = 3.615

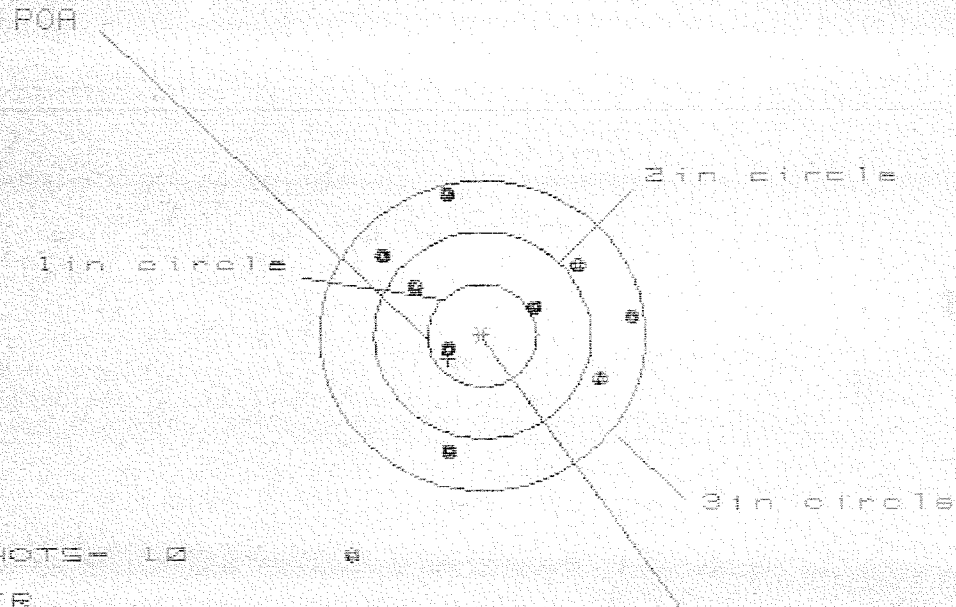
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.187	.917	.927
MINIMUM X	-2.425	-.890	-.880
MAXIMUM Y	1.135	1.217	1.053
MINIMUM Y	-1.394	-1.312	-1.299
CENTROID X	-.247	.023	.013
CENTROID Y	.419	.337	.501
POA TO CENTROID in.	.487	.337	.501
MIN RADIUS	.272	.325	.355
MEAN RADIUS	1.099	.882	.826
MAX RADIUS	2.537	1.442	1.569
HORIZONTAL SPREAD	3.612	1.807	1.807
VERTICAL SPREAD	2.529	2.529	2.352
EXTREME SPREAD	3.615	2.573	2.568
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

8 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649909

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 3

3 in = 9

HS= 2.548

VS= 3.498

GS= 3.593

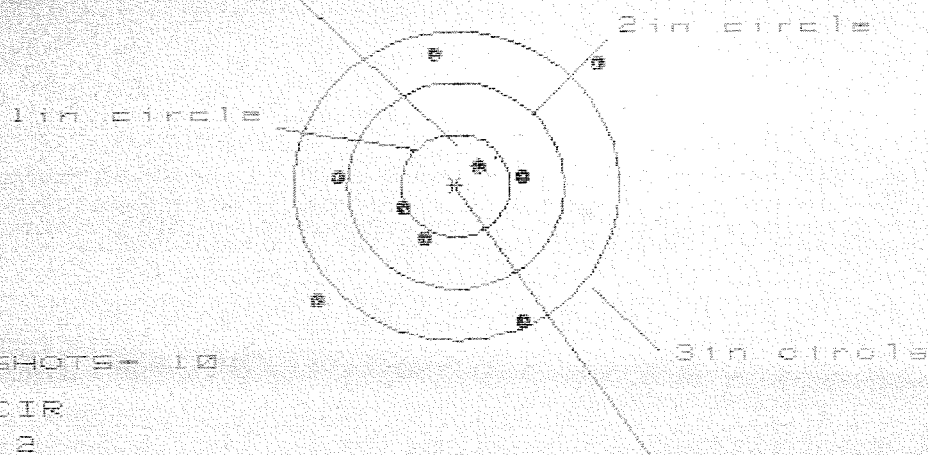
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.373	1.243	1.183
MINIMUM X	-1.175	-1.080	-1.140
MAXIMUM Y	1.421	1.190	.740
MINIMUM Y	-2.077	-1.307	-1.158
CENTROID X	.318	.448	.508
CENTROID Y	.222	.453	.304
POA TO CENTROID in.	.387	.637	.592
MIN RADIUS	.365	.369	.378
MEAN RADIUS	1.158	.992	.947
MAX RADIUS	2.386	1.396	1.359
HORIZONTAL SPREAD	2.548	2.323	2.328
VERTICAL SPREAD	3.498	2.497	1.898
EXTREME SPREAD	3.593	2.497	2.423
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	9		

8 Oct 1991

FILE: PATTERNING/CENTERFIRE_PATT/C8849983

CENTERFIRE PATTERNS # 4

POA



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS= 2.522

VS= 2.618

GS= 3.411

CENTROID *

PATTERN #

4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.277	.880	.662
MINIMUM X	-1.245	-1.103	-1.095
MAXIMUM Y	1.328	1.463	1.345
MINIMUM Y	-1.290	-1.155	-1.273
CENTROID X	-.212	-.354	-.216
CENTROID Y	-.189	-.324	-.206
POA TO CENTROID in.	.284	.480	.299
MIN RADIUS	.309	.307	.325
MEAN RADIUS	.987	.895	.808
MAX RADIUS	1.765	1.464	1.435
HORIZONTAL SPREAD	2.522	1.903	1.757
VERTICAL SPREAD	2.618	2.618	2.618
EXTREME SPREAD	3.411	2.754	2.754
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		8	

8 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08649909

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 3

2 in = 5

3 in = 10

HS= 2.539

VS= 2.278

GS= 2.540

PATTERN #

3

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.306

1.000

.881

MINIMUM X

-1.233

-1.088

-.963

MAXIMUM Y

.996

1.040

.502

MINIMUM Y

-1.282

-1.238

-1.108

CENTROID X

.208

.063

-.062

CENTROID Y

.194

.150

.020

POA TO CENTROID in.

.285

.163

.065

MIN RADIUS

.203

.111

.071

MEAN RADIUS

.841

.772

.693

MAX RADIUS

1.365

1.443

1.108

HORIZONTAL SPREAD

2.539

2.088

1.844

VERTICAL SPREAD

2.278

2.278

1.610

EXTREME SPREAD

2.540

2.538

2.112

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

6

NUMBER IN THREE INCH CIRCLE =

10