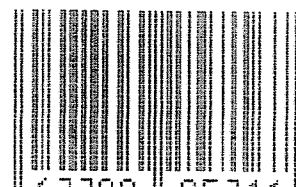


FOCI

UPC



0 47700 25716 7

05649173

MODEL 700 TM M24

5716

ORDER NO.

BARREL LENGTH

CAPACITY\*

\*INCLUDES 1 IN CHAMBER

*Remington*



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

MODEL 700 <sup>TM</sup> M24

SERIAL NO.

C6649173

ORDER NO.

5716

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

20



5716 C6649173

ORDER 5716

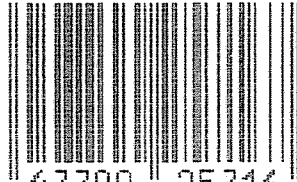
MODEL 700 <sup>TM</sup> M24

UPC

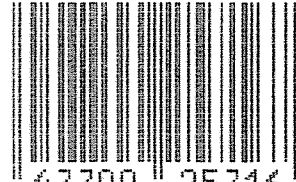
ORDER 5716

MODEL 700 <sup>TM</sup> M24

UPC



0 47700 25716 7



0 47700 25716 7

**GFM**

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649173

| OP. #        | OP. NAME                                                       | READINGS | DATE        | INIT |
|--------------|----------------------------------------------------------------|----------|-------------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   | 10 1     | 91          | Rw   |
| 600          | Proof                                                          | 10 1     | 91          | Rw   |
| 607          | Check Headspace                                                | 10 1     | 91          | Rw   |
| 610          | Dis-assemble Gun                                               | 10 1     | 91          | Rw   |
| 612          | Magnaflux Barrel<br>Action                                     |          | OCT 10 1991 | KR   |
|              | Magnaflux Bolt                                                 |          | OCT 10 1991 | KR   |
| 615          | Rollmark Caliber                                               |          | OCT 10 1991 | Rw   |
| 617          | Drill and Tap Sight Holes                                      |          | OCT 10 1991 | LB   |
| 618          | Polish Barrel                                                  |          | 10/15/91    | WB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 11-8-91     | TH   |
|              | Apply Coating (Bolt)                                           |          |             |      |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 11/11/91    | Rw   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 11/11/91    | Rw   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 11/11/91    | Rw   |
|              | D) Oil Firing Pin Ass'y                                        |          | 11/11/91    | Rw   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 12-9-91     | Rw   |

| op. #        | BARBER M24 0065685                                          | READINGS |      |      |      |      | DATE     | INIT |
|--------------|-------------------------------------------------------------|----------|------|------|------|------|----------|------|
| 625<br>cont. | F) Safety On Force                                          | 3        | 4    | 4    |      |      | 12-9-91  | A    |
|              | G) Safety Off Force                                         | 2        | 3    | 3    |      |      | 12-9-91  | C    |
|              | H) Trigger Pull Test & Retainability                        |          |      |      |      |      | 12-9-91  | W    |
|              | I) Firing Pin Indent                                        | .021     | .020 | .020 |      |      | 12-9-91  | Ac   |
|              | J) Assemble Stock                                           |          |      |      |      |      | 12/9/91  | RW   |
|              | K) Assemble Swivel Studs                                    |          |      |      |      |      | 12/13/91 | W    |
|              | L) Attach Front and Rear Sight Assemblies                   |          |      |      |      |      | 12/9/91  | RW   |
|              | M) Iron Sight Alignment                                     |          |      |      |      |      | 12/9/91  | RW   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |      |      |      |      | 12/9/91  | RW   |
|              | O) Attach Scope to Rifle                                    |          |      |      |      |      | 12/9/91  | RW   |
|              | P) Detach & Attach Scope 20 Times                           |          |      |      |      |      | 12/9/91  | RW   |
| 640          | Gallery Target & Test                                       |          |      |      |      |      | 12-10-91 | A    |
|              | A) Time                                                     |          |      |      |      |      | 12-10-91 | A    |
|              | B) Malfunctions                                             |          |      |      |      |      | 12-10-91 | A    |
|              | C) Pierced Primers                                          |          |      |      |      |      | 12-10-91 | A    |
|              | D) Optical Clarity of Scope                                 |          |      |      |      |      | 12-10-91 | A    |
| 645          | Inspect for Live Ammo                                       |          |      |      |      |      | 12-10-91 | A    |
| 655          | Final Inspection                                            |          |      |      |      |      |          |      |
|              | A) Headspace                                                |          |      |      |      |      | 12-13-91 | W    |
|              | B) Trigger Pull                                             | 2.20     | 2.48 | 2.39 | 2.45 | 2.49 | 12-11-91 | W    |
|              | C) Function                                                 |          |      |      |      |      | 12-13-91 | W    |
| 660          | Pack                                                        |          |      |      |      |      | 12-17-91 | N    |

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6649173DATE 12-9-91TESTER JU

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.27             | 2.41                     | 2.20                           | 2.20 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.35             | 2.18                     | 2.44                           | 2.48 |                                                                        |
| PULL #3 | 2.24             | 2.48                     | 2.60                           | 2.39 |                                                                        |
| PULL #4 | 2.42             | 2.42                     | 2.31                           | 2.45 |                                                                        |
| PULL #5 | 2.37             | 2.46                     | 2.25                           | 2.49 |                                                                        |
| TOTAL   |                  |                          |                                |      |                                                                        |
| AVG.    |                  |                          |                                |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.42             | 3.43                     |  |          |
| PULL #2 | 3.44             | 3.45                     |  |          |
| PULL #3 | 3.38             | 3.37                     |  |          |
| PULL #4 | 3.45             | 3.36                     |  |          |
| PULL #5 | 3.47             | 3.44                     |  |          |
| TOTAL   |                  |                          |  |          |
| AVG.    |                  |                          |  |          |

|         | 4.00#<br>INITIAL | 4.00# AFTER<br>20 CYCLES | MAX SETTING<br>GREATER THAN 4# | RESET TO 4# FOR<br>TARGET & ACCURACY |
|---------|------------------|--------------------------|--------------------------------|--------------------------------------|
| PULL #1 | 4.43             | 4.28                     |                                | 4.28                                 |
| PULL #2 | 4.37             | 4.30                     |                                | 4.21                                 |
| PULL #3 | 4.28             | 4.33                     |                                | 4.39                                 |
| PULL #4 | 4.29             | 4.33                     |                                | 4.39                                 |
| PULL #5 | 4.34             | 4.29                     |                                | 4.40                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6649173  
10 Dec 1991

## CENTROIDAL DISTANCES

|   |    |   |         |
|---|----|---|---------|
| 0 | TO | 1 | .549229 |
| 1 | TO | 2 | .536143 |
| 1 | TO | 3 | 1.08769 |
| 1 | TO | 4 | .955799 |
| 1 | TO | 5 | .654478 |

Figure 1. Schematic representation of the proposed model. The model is based on the assumption that the observed data are generated by a latent variable  $Z$  (e.g.,  $Z = 1$  for "Yes" and  $Z = 0$  for "No"). The latent variable  $Z$  is assumed to be a function of the observed data  $X$  and the observed data  $X$  is assumed to be a function of the latent variable  $Z$ . The observed data  $X$  is assumed to be a function of the latent variable  $Z$  and the observed data  $X$  is assumed to be a function of the latent variable  $Z$ .

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0628  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0148  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0645204

|      |      |      |    |       |  |
|------|------|------|----|-------|--|
| DATE | BOOK | FROM | TO | PRICE |  |
| 1945 |      |      |    | 1.00  |  |

JUL 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/06643173

## CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

CENTROID \*

# OF SHOTS= 10

# IN CIR

1in = 0

2in = 4

3in = 8

HS= 3.344

VS= 3.138

GS= 3.458

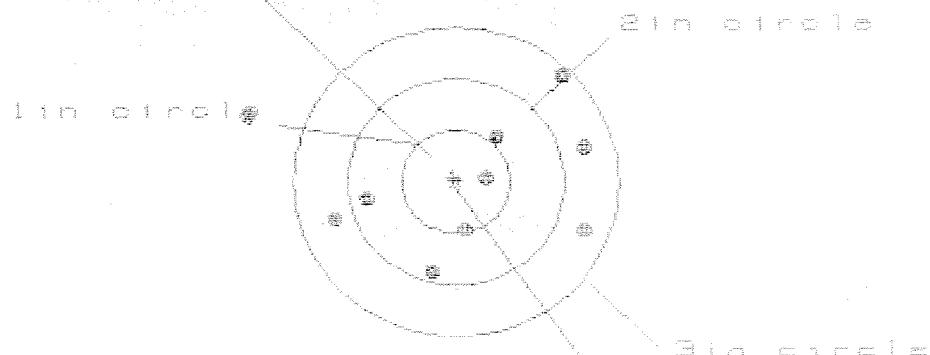
| PATTERN #                     | 1      | 2      | 3      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.078  | .826   | .809   |
| MINIMUM X                     | -2.266 | -1.302 | -1.319 |
| MAXIMUM Y                     | 1.863  | 1.815  | .970   |
| MINIMUM Y                     | -1.275 | -1.323 | -1.097 |
| CENTROID X                    | -.334  | -.062  | -.055  |
| CENTROID Y                    | -.436  | -.388  | -.614  |
| POA TO CENTROID in.           | .549   | .396   | .618   |
| MIN RADIUS                    | .549   | .501   | .275   |
| MEAN RADIUS                   | 1.214  | 1.050  | .917   |
| MAX RADIUS                    | 2.308  | 1.820  | 1.447  |
| HORIZONTAL SPREAD             | 3.344  | 2.128  | 2.128  |
| VERTICAL SPREAD               | 3.138  | 3.138  | 2.067  |
| EXTREME SPREAD                | 3.458  | 3.139  | 2.371  |
| NUMBER IN ONE INCH CIRCLE =   | 0      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 4      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 8      |        |        |

8 Dec 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6849173

## CENTERFIRE PATTERNS # 2

POA



# OF SHOTS= 10

# IN CIR

1in = 2

2in = 5

3in = 9

HS= 3.135

VS= 1.893

GS= 3.301

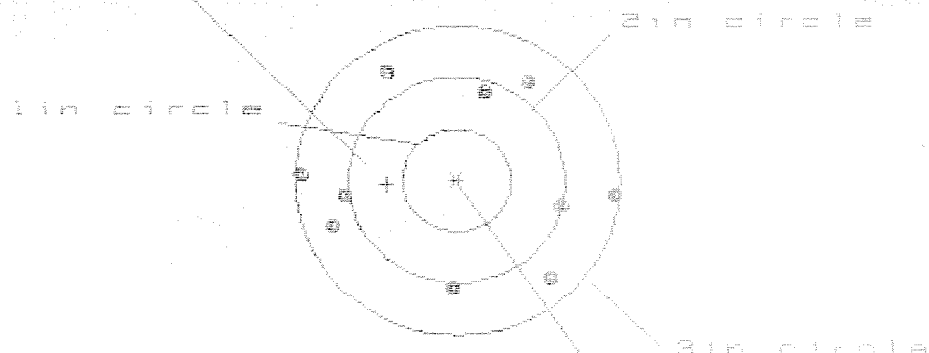
| PATTERN #                     | 2      |
|-------------------------------|--------|
| SHOTS (BEST OF)               | 10     |
| MAXIMUM X                     | 1.213  |
| MINIMUM X                     | -1.922 |
| MAXIMUM Y                     | .992   |
| MINIMUM Y                     | -.901  |
| CENTROID X                    | .023   |
| CENTROID Y                    | -.036  |
| POA TO CENTROID in.           | .043   |
| MIN RADIUS                    | .243   |
| MEAN RADIUS                   | 1.012  |
| MAX RADIUS                    | 2.010  |
| HORIZONTAL SPREAD             | 3.135  |
| VERTICAL SPREAD               | 1.893  |
| EXTREME SPREAD                | 3.301  |
| NUMBER IN ONE INCH CIRCLE =   | 2      |
| NUMBER IN TWO INCH CIRCLE =   | 5      |
| NUMBER IN THREE INCH CIRCLE = | 9      |

18 Dec 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/06645173

## CENTERFIRE PATTERNS # 3

POR



# OF SHOTS- 10

# IN CIR

1in = 0

2in = 1

3in = 10

HS= 2.862

VS= 2.028

GS= 2.869

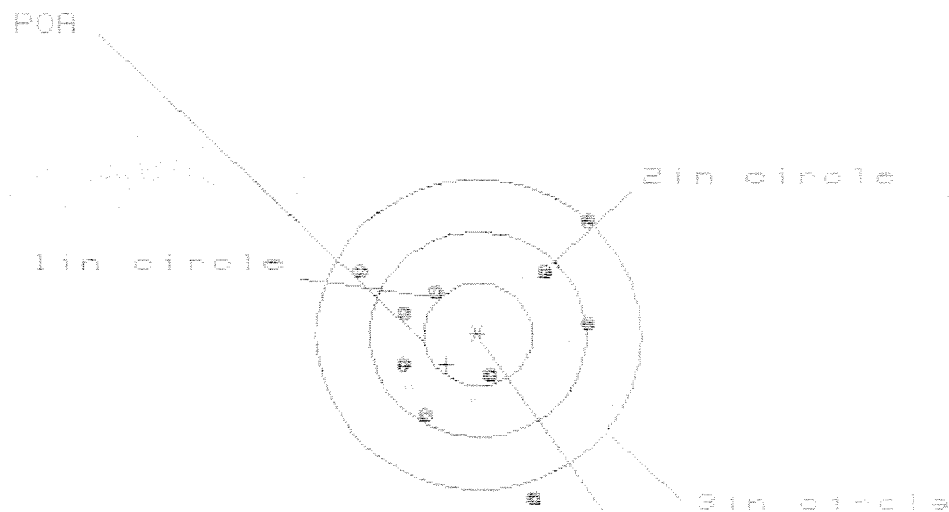
CENTROID \*

| PATTERN #                   | 3      |
|-----------------------------|--------|
| SHOTS (BEST OF)             | 10     |
| MAXIMUM X                   | 1.443  |
| MINIMUM X                   | -1.419 |
| MAXIMUM Y                   | 1.013  |
| MINIMUM Y                   | -1.015 |
| CENTROID X                  | .644   |
| CENTROID Y                  | .040   |
| POR TO CENTROID in.         | .645   |
| MIN RADIUS                  | .905   |
| MEAN RADIUS                 | 1.175  |
| MAX RADIUS                  | 1.447  |
| HORIZONTAL SPREAD           | 2.862  |
| VERTICAL SPREAD             | 2.028  |
| EXTREME SPREAD              | 2.869  |
| NUMBER IN ONE INCH CIRCLE   | 0      |
| NUMBER IN TWO INCH CIRCLE   | 1      |
| NUMBER IN THREE INCH CIRCLE | 10     |

10 Dec 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6849173

## CENTERFIRE PATTERNS # 4



# OF SHOTS= 10

# IN CIR

1in = 1

2in = 5

3in = 9

HS= 2.073

VS= 2.624

GS= 2.723

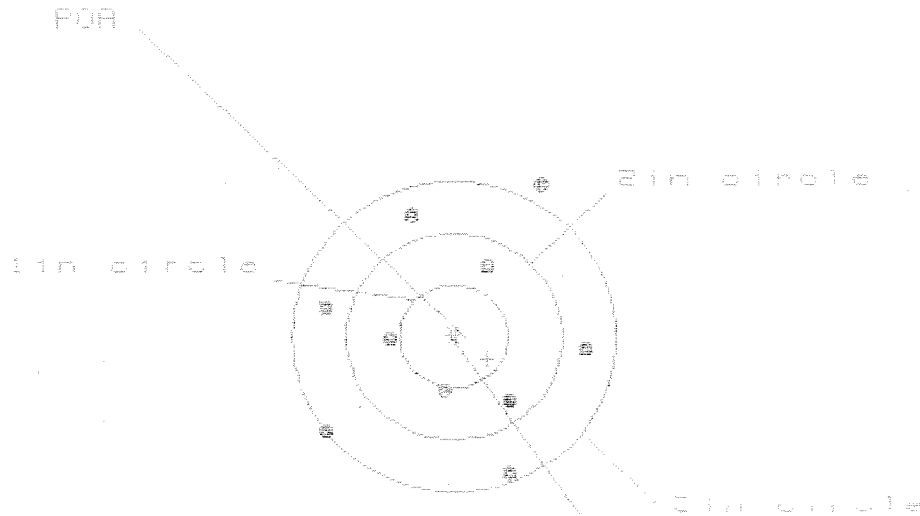
CENTROID \*

| PATTERN #                   | : | 4      |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.032  | 1.094  | 1.224  |
| MINIMUM X                   | : | -1.041 | -0.979 | -0.849 |
| MAXIMUM Y                   | : | 1.062  | .889   | .596   |
| MINIMUM Y                   | : | -1.562 | -0.991 | -0.880 |
| CENTROID X                  | : | .290   | .228   | .098   |
| CENTROID Y                  | : | .288   | .461   | .350   |
| POA TO CENTROID in.         | : | .409   | .515   | .364   |
| MIN RADIUS                  | : | .427   | .367   | .359   |
| MEAN RADIUS                 | : | .966   | .873   | .792   |
| MAX RADIUS                  | : | 1.658  | 1.372  | 1.225  |
| HORIZONTAL SPREAD           | : | 2.073  | 2.073  | 2.073  |
| VERTICAL SPREAD             | : | 2.624  | 1.880  | 1.476  |
| EXTREME SPREAD              | : | 2.723  | 2.395  | 2.141  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 1      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 6      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |        |

8 Dec 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/06549173

## CENTERFIRE PATTERNS # 5



# OF SHOTS= 10

# IN CIR

1in = 2

2in = 4

3in = 8

HS= 2.388

VS= 2.753

GS= 3.097

CENTROID #

| PATTERN #                   | 5      | 9      | 8      |
|-----------------------------|--------|--------|--------|
| SHOTS (BEST OF)             | 10     | 9      | 8      |
| MAXIMUM X                   | 1.232  | 1.326  | 1.192  |
| MINIMUM X                   | -1.164 | -1.078 | -1.187 |
| MAXIMUM Y                   | 1.458  | 1.316  | 1.224  |
| MINIMUM Y                   | -1.295 | -1.134 | -1.226 |
| CENTROID X                  | -.389  | -.403  | -.269  |
| CENTROID Y                  | .218   | .057   | .144   |
| POA TO CENTROID in.         | .379   | .407   | .368   |
| MIN RADIUS                  | .533   | .367   | .472   |
| MEAN RADIUS                 | 1.083  | .993   | .954   |
| MAX RADIUS                  | 1.684  | 1.355  | 1.312  |
| HORIZONTAL SPREAD           | 2.396  | 2.396  | 2.379  |
| VERTICAL SPREAD             | 2.753  | 2.450  | 2.450  |
| EXTREME SPREAD              | 3.097  | 2.617  | 2.617  |
| NUMBER IN ONE INCH CIRCLE   | =      | 0      |        |
| NUMBER IN TWO INCH CIRCLE   | =      | 4      |        |
| NUMBER IN THREE INCH CIRCLE | =      | 9      |        |