

FORM

UPC



0 47700 25716 7

C6665672

*INCLUDES 1 IN CHAMBER

MODEL 700 TM M24

ORDER NO. 5716

BARREL LENGTH

CAPACITY*

RemingtonVERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.**MODEL 700™ M24****SERIAL NO.**

C6665672

ORDER NO.**5716**

20

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



5716 C6665672

ORDER 5716

MODEL 700™ M24

UPC**ORDER 5716**

MODEL 700™ M24

UPC

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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6665672

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	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 Action		OCT 4 1991	KR
	Magnaflux Bolt		OCT 4 1991	KR
615	Rollmark Caliber		OCT 4 1991	LS.
617	Drill and Tap Sight Holes		OCT 4 1991	FB
618	Polish Barrel		10/8/91	CVB
620	Apply Coatings (Barrel Action)		10-22-91	HA
	Apply Coating (Bolt)		10-22-91	HA
625	Final Assembly			
	A) Clean inside of Bolt Assembly		10/22/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/22/91	RW
	C) Inspect Ejector Hole for Chamfer		10/22/91	RW
	D) Oil Firing Pin Ass'y		10/22/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/30/91	JP

op. #	BARBER - M24 0101162	READINGS					DATE	INIT
	OP. NAME							
625 cont.	F) Safety On Force	5	5	5			10/31/91	DH
	G) Safety Off Force	3	3	3			10/31/91	DH
	H) Trigger Pull Test & Retainability						10/30/91	DH
	I) Firing Pin Indent	1021	1021	1021			10/31/91	DH
	J) Assemble Stock						10/31/91	RW
	K) Assemble Swivel Studs						11-12-91	AC
	L) Attach Front and Rear Sight Assemblies						10/31/91	RW
	M) Iron Sight Alignment						10/31/91	RW
	N) Detach Front & Rear Sights & place in numbered container						10/31/91	RW
	O) Attach Scope to Rifle						10/31/91	RW
	P) Detach & Attach Scope 20 Times						10/31/91	RW
640	Gallery Target & Test						11-1-91	DH
	A) Time						11-1-91	DH
	B) Malfunctions						11-1-91	DH
	C) Pierced Primers						11-1-91	DH
	D) Optical Clarity of Scope						11-1-91	DH
645	Inspect for Live Ammo						11-1-91	DH
655	Final Inspection							
	A) Headspace						11-12-91	AC
	B) Trigger Pull	2.45	2.59	2.58	2.44	2.42	11-5-91	DH
	C) Function						11-12-91	AC
660	Pack						12-17-91	N

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6665672

DATE 10/30/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.51	2.51	2.48	245	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.45	2.48	2.50	259	
PULL #3	2.45	2.36	2.35	258	
PULL #4	2.41	2.44	2.31	244	
PULL #5	2.35	2.55	2.36	242	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.58	3.51		
PULL #2	3.55	3.48		
PULL #3	3.52	3.45		
PULL #4	3.39	3.39		
PULL #5	3.42	3.53		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.55	4.58		4.53
PULL #2	4.45	4.60		4.33
PULL #3	4.42	4.51		4.61
PULL #4	4.53	4.48		4.54
PULL #5	4.54	4.58		4.38
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06665672
1 Nov 1991

CENTROIDAL DISTANCES

0 TO	1	.26786
1 TO	2	.678114
1 TO	3	.450004
1 TO	4	.149933
1 TO	5	.303621

$\frac{2}{4}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .004
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .012
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .199352
THE AMR FOR THIS RIFLE IS: 1.043

1 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06065672

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS = 2.635

VS = 3.397

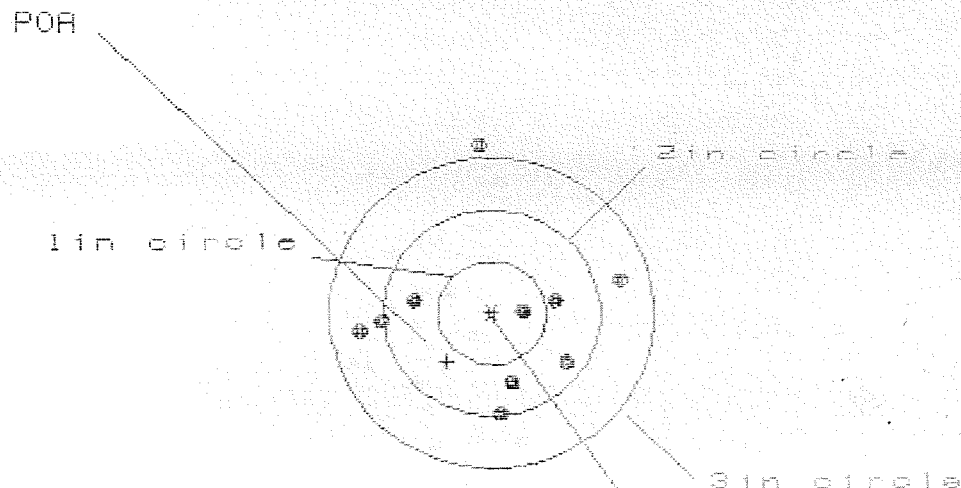
GS = 3.422

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.496	1.579	1.116
MINIMUM X	-1.139	-1.056	-0.858
MAXIMUM Y	1.345	1.117	1.216
MINIMUM Y	-2.052	-1.289	-1.191
CENTROID X	.207	.124	-.074
CENTROID Y	-.170	.058	-.040
POA TO CENTROID in.	.268	.136	.084
MIN RADIUS	.488	.298	.379
MEAN RADIUS	1.160	1.019	.894
MAX RADIUS	2.184	1.764	1.365
HORIZONTAL SPREAD	2.635	2.635	1.974
VERTICAL SPREAD	3.397	2.406	2.406
EXTREME SPREAD	3.422	2.754	2.421
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

1 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8685672

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 1

2in = 6

3in = 9

HS = 2.410

VS = 2.544

GS = 2.552

CENTROID #

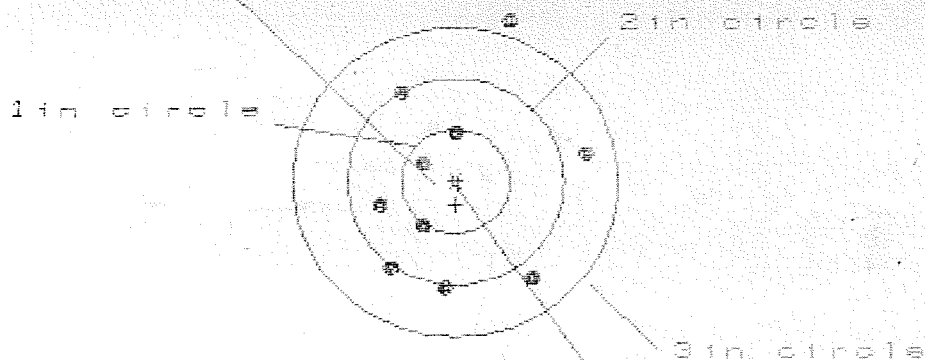
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.198	1.185	.856
MINIMUM X	:	-1.212	-1.225	-1.077
MAXIMUM Y	:	1.606	.474	.407
MINIMUM Y	:	-.938	-.759	-.700
CENTROID X	:	.416	.429	.281
CENTROID Y	:	.473	.294	.235
POR TO CENTROID in.	:	.630	.520	.366
MIN RADIUS	:	.334	.389	.529
MEAN RADIUS	:	.922	.823	.774
MAX RADIUS	:	1.610	1.276	1.078
HORIZONTAL SPREAD	:	2.410	2.410	1.933
VERTICAL SPREAD	:	2.544	1.233	1.107
EXTREME SPREAD	:	2.552	2.459	1.949
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

1 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665672

CENTERFIRE PATTERNS # 3

POA



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 9

HS= 1.858

VS= 2.530

GS= 2.626

CENTROID #

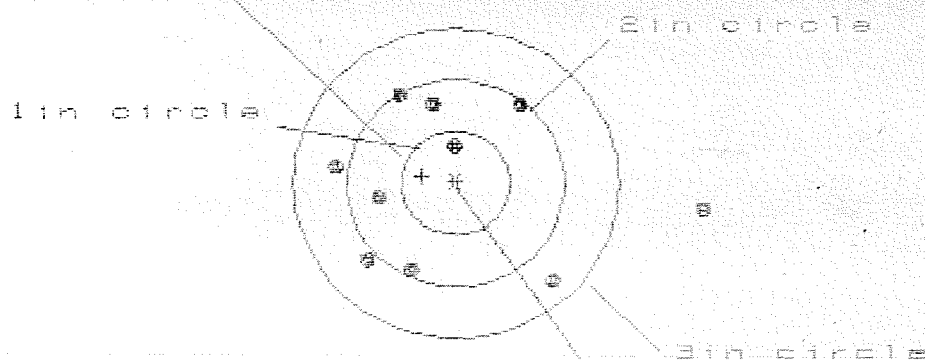
PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.175
MINIMUM X	-.683
MAXIMUM Y	1.537
MINIMUM Y	-.993
CENTROID X	-.003
CENTROID Y	.228
POA TO CENTROID in.	.228
MIN RADIUS	.308
MEAN RADIUS	.899
MAX RADIUS	1.627
HORIZONTAL SPREAD	1.858
VERTICAL SPREAD	2.530
EXTREME SPREAD	2.626
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	9

1 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06665672

CENTERFIRE PATTERNS # 4

POA



OF SHOTS = 10

IN CIR

1in = 1

2in = 4

3in = 9

HS = 3.433

VS = 1.795

GS = 3.464

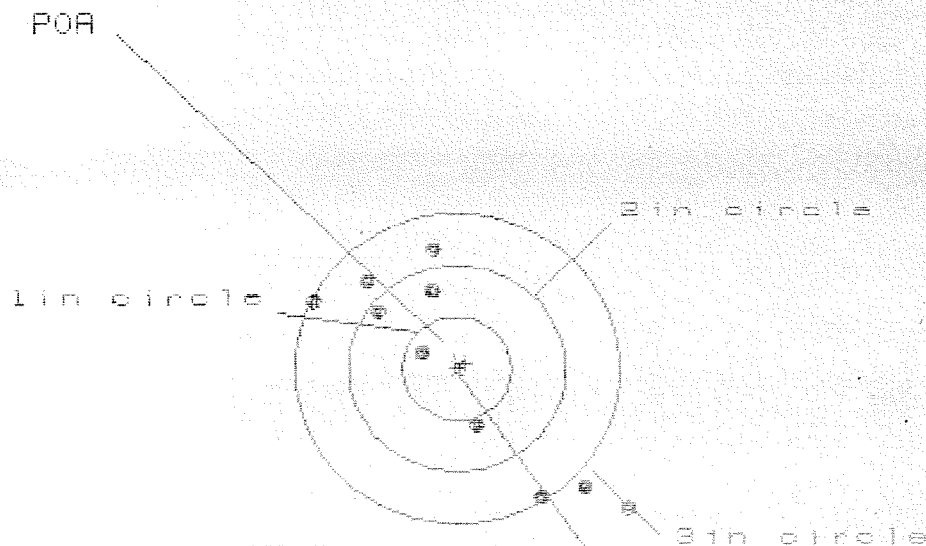
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	9
MAXIMUM X	:	2.330	1.162	1.020
MINIMUM X	:	-1.103	-.844	-.699
MAXIMUM Y	:	.887	.856	.738
MINIMUM Y	:	-.908	-.939	-1.033
CENTROID X	:	.311	.052	-.093
CENTROID Y	:	-.062	-.031	.087
POA TO CENTROID in.	:	.317	.060	.127
MIN RADIUS	:	.361	.407	.439
MEAN RADIUS	:	1.074	.878	.769
MAX RADIUS	:	2.347	1.494	1.216
HORIZONTAL SPREAD	:	3.433	2.006	1.719
VERTICAL SPREAD	:	1.795	1.795	1.771
EXTREME SPREAD	:	3.464	2.309	2.092
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

1 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8683672

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 8

HS= 2.878

VS= 2.474

GS= 3.488

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.546	1.318	1.063
MINIMUM X	:	-1.332	-1.160	-0.995
MAXIMUM Y	:	1.174	1.030	.874
MINIMUM Y	:	-1.388	-1.404	-1.560
CENTROID X	:	-.074	-.246	-.411
CENTROID Y	:	-.055	.089	.245
POA TO CENTROID in.	:	.092	.261	.478
MIN RADIUS	:	.345	.126	.124
MEAN RADIUS	:	1.158	.997	.828
MAX RADIUS	:	2.020	1.815	1.888
HORIZONTAL SPREAD	:	2.878	2.478	2.058
VERTICAL SPREAD	:	2.474	2.434	2.434
EXTREME SPREAD	:	3.488	3.048	2.821
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			4	
NUMBER IN THREE INCH CIRCLE =			8	