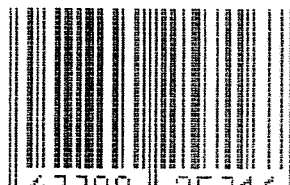


FORM

UPC



0 47700 25716 7

6665696

*INCLUDES 1 IN CHAMBER

CAPACITY

MODEL 700 TM M24

5716

ORDER NO.

BARREL LENGTH

Remington

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

MODEL 700TM M24**SERIAL NO.**

C6665696

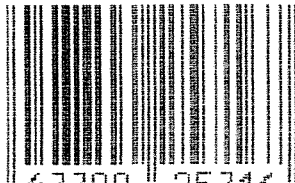
ORDER NO.**5716**

20

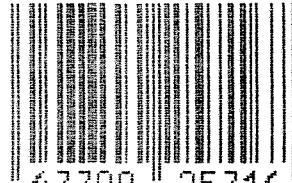
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off. Marca Registrada Marque Deposee.



5716 C6665696

ORDER 5716MODEL 700TM M24**UPC**

0 47700 25716 7

ORDER 5716MODEL 700TM M24**UPC**

0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6665696

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action 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 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	LS
618	Polish Barrel		10/8/91	WLB
620	Apply Coatings (Barrel Action)		10-22-91	SA
	Apply Coating (Bolt)			
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		11-4-91	SA

op. #	BARBER - M24 0101439	READINGS					DATE	INIT
	OP. NAME							
625 cont.	F) Safety On Force	3 1/2	3 1/2	3 1/2			11/5/91	WB
	G) Safety Off Force	3	3	3			11/5/91	WB
	H) Trigger Pull Test & Retainability						11-4-91	JF
	I) Firing Pin Indent	.0205	.021	.0205			11/5/91	WB
	J) Assemble Stock						11/5/91	RW
	K) Assemble Swivel Studs						11-12-91	AC
	L) Attach Front and Rear Sight Assemblies						11/5/91	RW
	M) Iron Sight Alignment						11/5/91	RW
	N) Detach Front & Rear Sights & place in numbered container						11/5/91	RW
	O) Attach Scope to Rifle						11/5/91	RW
		P) Detach & Attach Scope 20 Times						11/5/91
640	Gallery Target & Test						11-6-91	DH
	A) Time						11-6-91	DH
	B) Malfunctions						11-6-91	DH
	C) Pierced Primers						11-6-91	DH
	D) Optical Clarity of Scope						11-6-91	DH
645	Inspect for Live Ammo						11-6-91	DH
655	Final Inspection							
	A) Headspace						11-12-91	AC
	B) Trigger Pull	274	278	278	278	268	11-6-91	DH
	C) Function						11-12-91	AC
660	Pack						12-17-91	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO C-6665696

DATE 11-4-91

TESTER JPL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.49	2.45	2.55	2.74	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.46	2.33	2.48	2.78	
PULL #3	2.55	2.25	2.40	2.78	
PULL #4	2.20	2.23	2.60	2.78	
PULL #5	2.39	2.66	2.62	2.68	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.45	3.56		
PULL #2	3.60	3.54		
PULL #3	3.55	3.56		
PULL #4	3.53	3.60		
PULL #5	3.43	3.50		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.58	4.36		4.56
PULL #2	4.28	4.50		4.48
PULL #3	4.39	4.58		4.63
PULL #4	4.51	4.53		4.52
PULL #5	4.58	4.61		4.42
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665696
6 Nov 1991

CENTROIDAL DISTANCES

0 TO	1	.547614
1 TO	2	.505846
1 TO	3	.478804
1 TO	4	.664248
1 TO	5	.718604

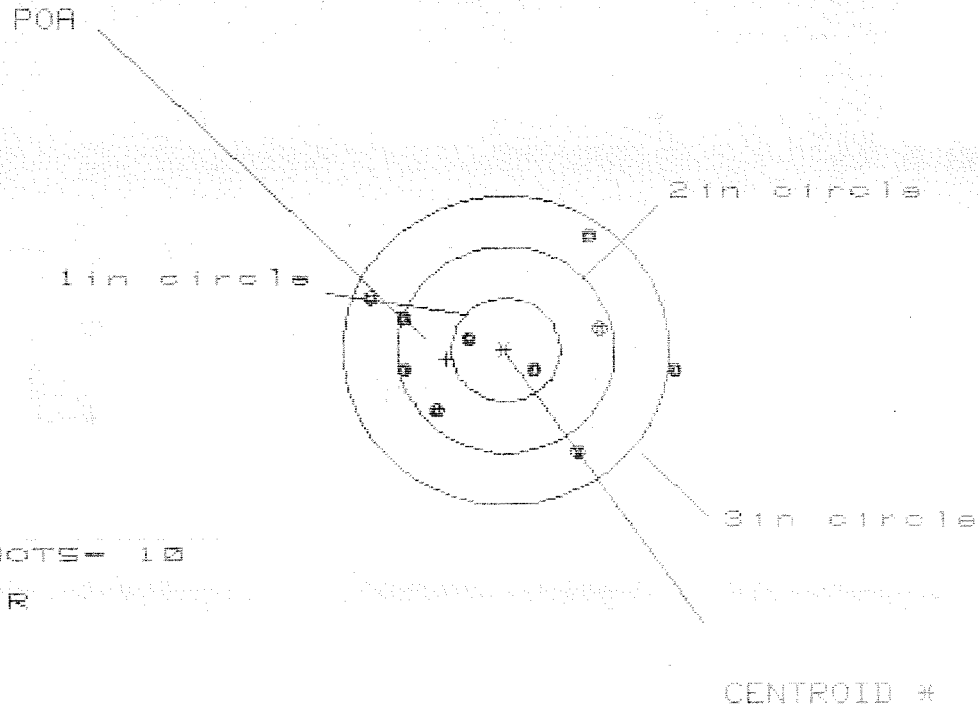
$\frac{2}{50} \frac{1}{4}$ <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1212
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0022
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .12122
THE AMR FOR THIS RIFLE IS: .9246

6 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08685698

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 2.828

VS= 2.137

GS= 2.901

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.595	1.034	1.147
MINIMUM X	-1.233	-1.056	-.943
MAXIMUM Y	1.126	1.110	.622
MINIMUM Y	-1.011	-1.027	-.889
CENTROID X	.540	.363	.250
CENTROID Y	.091	.107	-.032
POA TO CENTROID in.	.547	.378	.252
MIN RADIUS	.318	.185	.210
MEAN RADIUS	.990	.895	.805
MAX RADIUS	1.602	1.429	1.327
HORIZONTAL SPREAD	2.828	2.090	2.090
VERTICAL SPREAD	2.137	2.137	1.511
EXTREME SPREAD	2.901	2.450	2.450
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

6 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8885896

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 6

3 in = 10

HS = 1.858

VS = 2.076

GS = 2.423

CENTROID *

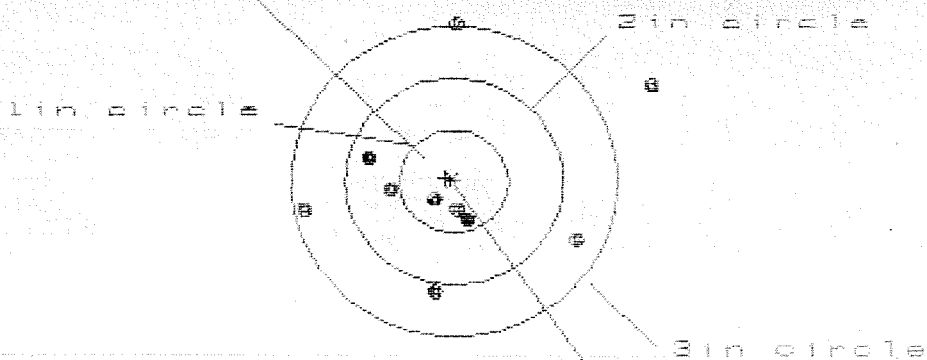
PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.080	.993	.361
MINIMUM X	-.778	-.744	-.619
MAXIMUM Y	.965	.842	.882
MINIMUM Y	-1.111	-1.135	-1.095
CENTROID X	.098	.185	.060
CENTROID Y	.337	.460	.420
POA TO CENTROID in.	.351	.496	.424
MIN RADIUS	.378	.242	.372
MEAN RADIUS	.808	.723	.690
MAX RADIUS	1.356	1.141	1.121
HORIZONTAL SPREAD	1.858	1.737	.980
VERTICAL SPREAD	2.076	1.977	1.977
EXTREME SPREAD	2.423	2.156	2.156
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

6 May 1991

FILE://PATTERNING/CENTERFIRE_PATT/C6685686

CENTERFIRE PATTERNS # 3

FOR



OF SHOTS = 10

IN CIR

1in = 3

2in = 5

3in = 8

HS = 3.117

VS = 2.567

GS = 3.332

CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.790	1.295	1.317
MINIMUM X	:	-1.327	-1.128	-1.186
MAXIMUM Y	:	1.537	1.641	.542
MINIMUM Y	:	-1.030	-.926	-.721
CENTROID X	:	.077	-.122	-.144
CENTROID Y	:	-.031	-.135	-.340
FOR TO CENTROID in.	:	.083	.182	.370
MIN RADIUS	:	.271	.064	.144
MEAN RADIUS	:	.943	.757	.629
MAX RADIUS	:	2.020	1.651	1.341
HORIZONTAL SPREAD	:	3.117	2.423	2.423
VERTICAL SPREAD	:	2.567	2.567	1.263
EXTREME SPREAD	:	3.332	2.569	2.444
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

6 Nov 1991

FILE:\PATTERNING\CENTERFIRE_PATT\08685686

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 2.380

VS= 3.804

CS= 3.826

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.290	1.334	1.422
MINIMUM X	:	-1.090	-1.046	-.958
MAXIMUM Y	:	1.113	.814	.913
MINIMUM Y	:	-2.691	-.623	-.521
CENTROID X	:	.057	.013	-.075
CENTROID Y	:	-.365	-.066	-.168
POA TO CENTROID in.	:	.369	.067	.184
MIN RADIUS	:	.375	.275	.376
MEAN RADIUS	:	1.035	.797	.750
MAX RADIUS	:	2.720	1.369	1.437
HORIZONTAL SPREAD	:	2.380	2.380	2.380
VERTICAL SPREAD	:	3.804	1.437	1.434
EXTREME SPREAD	:	3.826	2.383	2.383
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

8 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8685686

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS = 10

IN CIR

1in = 1

2in = 8

3in = 9

HS = 3.647

VS = .995

GS = 3.733

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.730	.760	.684
MINIMUM X	-.917	-.614	-.553
MAXIMUM Y	.465	.429	.455
MINIMUM Y	-.529	-.566	-.513
CENTROID X	-.166	-.469	-.390
CENTROID Y	-.043	-.006	-.059
POA TO CENTROID in.	.171	.469	.397
MIN RADIUS	.204	.212	.292
MEAN RADIUS	.847	.564	.546
MAX RADIUS	2.750	.860	.821
HORIZONTAL SPREAD	3.647	1.374	1.237
VERTICAL SPREAD	.995	.995	.960
EXTREME SPREAD	3.733	1.532	1.532
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		9	