

FORM

UPC



0 47700 25716 7

06665714

*INCLUDES 1 IN CHAMBER

MODEL 700 TM M24

ORDER NO.	5716
BARREL LENGTH	
CAPACITY*	

Remington

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

MODEL 700 TM M24

SERIAL NO.

C6665714

ORDER NO.

5716

20

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



5716 C6665714

ORDER 5716MODEL 700 TM M24**UPC****ORDER 5716**MODEL 700 TM M24**UPC**

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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6665714

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 26	9 1	RW
600	Proof	9 26	9 1	RW
607	Check Headspace	9 26	9 1	RW
610	Dis-assemble Gun	9 26	9 1	RW
612	Magnaflux Barrel Action		SEP 30 1991	KR
	Magnaflux Bolt		SEP 30 1991	KR
615	Rollmark Caliber		SEP 30 1991	LS
617	Drill and Tap Sight Holes		SEP 30 1991	FB
618	Polish Barrel		OCT 2 1991	WT
620	Apply Coatings (Barrel Action)		10-13-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/13/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/13/91	RW
	C) Inspect Ejector Hole for Chamfer		10/13/91	RW
	D) Oil Firing Pin Ass'y		10/13/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/18/91	JA

op. #	BARBER M24 0101657	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	5	5	5	10/18/91	JH		
	G) Safety Off Force	3	3	3	10/18/91	JH		
	H) Trigger Pull Test & Retainability				10/18/91	JH		
	I) Firing Pin Indent	1020	.0205	.0205	10/18/91	JH		
	J) Assemble Stock				10/21/91	RW		
	K) Assemble Swivel Studs				10-22-91	AC		
	L) Attach Front and Rear Sight Assemblies				10/18/91	RW		
	M) Iron Sight Alignment				10/18/91	RW		
	N) Detach Front & Rear Sights & place in numbered container				10/18/91	RW		
	O) Attach Scope to Rifle				10/18/91	RW		
	P) Detach & Attach Scope 20 Times				10/18/91	RW		
640	Gallery Target & Test				10/21/91	KT		
	A) Time				"	KT		
	B) Malfunctions				"	KT		
	C) Pierced Primers				"	KT		
	D) Optical Clarity of Scope				"	KT		
645	Inspect for Live Ammo				10/21/91	KT		
655	Final Inspection							
	A) Headspace				10-22-91	AC		
	B) Trigger Pull	236	236	214	221	245	10-22-91	D/H
	C) Function						10-22-91	AC
660	Pack						12-20-91	N

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6665714

DATE 10-18-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.24	2.19	2.51	2.36	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.24	2.60	2.48	2.36	
PULL #3	2.32	2.60	2.55	2.14	
PULL #4	2.21	2.28	2.50	2.21	
PULL #5	2.23	2.46	2.51	2.45	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.37	3.30		
PULL #2	3.37	3.21		
PULL #3	3.17	3.27		
PULL #4	3.34	3.20		
PULL #5	3.27	3.23		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.49	4.51		4.51
PULL #2	4.46	4.37		4.50
PULL #3	4.45	4.26		4.65
PULL #4	4.41	4.49		4.54
PULL #5	4.49	4.38		4.56
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06665714
22 Oct 1991

CENTROIDAL DISTANCES

0 TO	1	.527243
1 TO	2	.755381
1 TO	3	.50096
1 TO	4	.628555
1 TO	5	.908183

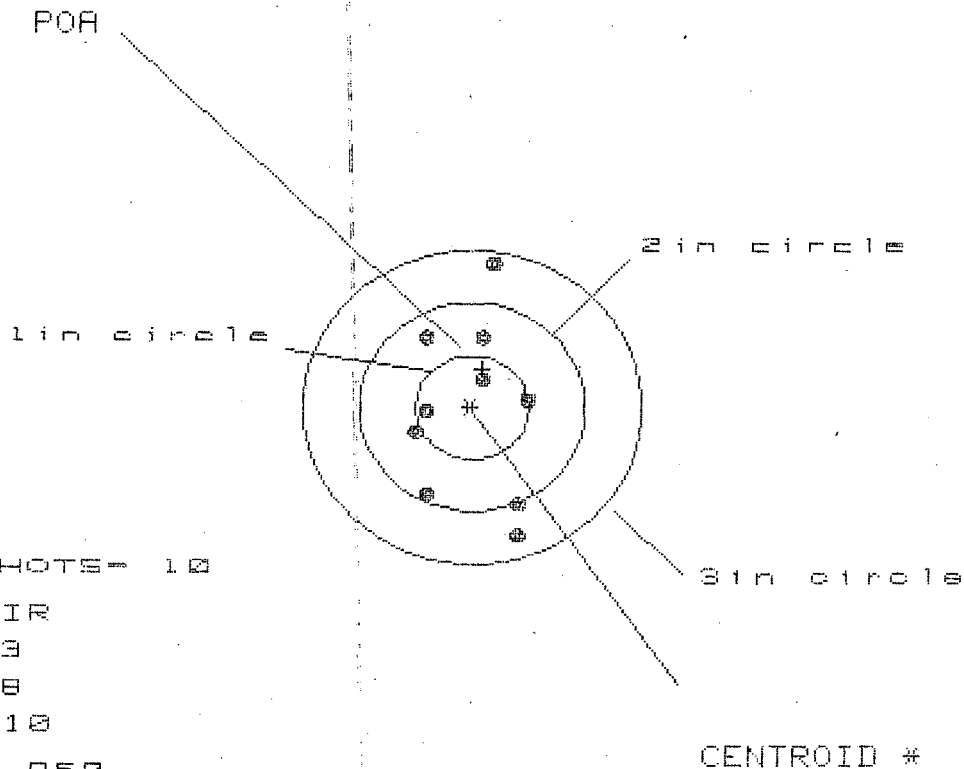
1
3
5
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THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0082
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0226
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0240416
THE AMR FOR THIS RIFLE IS: .9978

21 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8665714

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in - 3

2 in - 8

3 in - 10

HS= .958

VS= 2.581

GS= 2.588

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.481	.584	.557
MINIMUM X	-.477	-.454	-.401
MAXIMUM Y	1.400	.823	.695
MINIMUM Y	-1.181	-1.025	-.871
CENTROID X	-.098	-.121	-.174
CENTROID Y	-.374	-.530	-.402
POA TO CENTROID in.	.387	.543	.438
MIN RADIUS	.320	.423	.335
MEAN RADIUS	.777	.713	.634
MAX RADIUS	1.415	1.110	.992
HORIZONTAL SPREAD	.958	.958	.958
VERTICAL SPREAD	2.581	1.848	1.565
EXTREME SPREAD	2.588	2.008	1.750
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

21 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665714

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 4

2in = 6

3in = 9

HS= 3.191

VS= 2.363

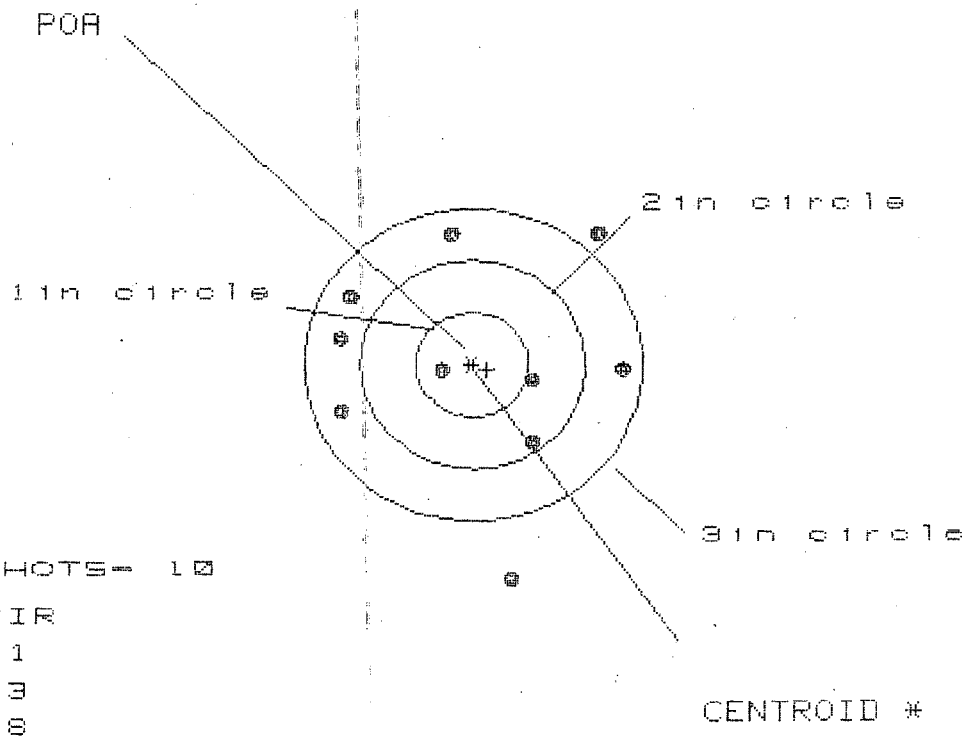
GS= 3.267

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.909	.691	.722
MINIMUM X	:	-1.282	-1.070	-.984
MAXIMUM Y	:	1.271	1.150	.701
MINIMUM Y	:	-1.092	-.672	-.528
CENTROID X	:	.141	-.071	-.157
CENTROID Y	:	-.089	.032	-.112
POA TO CENTROID in.	:	.167	.078	.193
MIN RADIUS	:	.366	.484	.520
MEAN RADIUS	:	.940	.798	.733
MAX RADIUS	:	2.199	1.342	1.051
HORIZONTAL SPREAD	:	3.191	1.761	1.706
VERTICAL SPREAD	:	2.363	1.822	1.229
EXTREME SPREAD	:	3.267	2.421	1.733
NUMBER IN ONE INCH CIRCLE	=	4		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	9		

21 Oct 1991

FILE: PATTERNING/CENTERFIRE_PATT/C6665714

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 1

2in = 3

3in = 8

HS = 2.460

VS = 3.312

GS = 3.409

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.299	1.339	1.489
MINIMUM X	-1.161	-1.121	-.971
MAXIMUM Y	1.294	1.070	1.165
MINIMUM Y	-2.018	-.922	-.789
CENTROID X	-.124	-.164	-.314
CENTROID Y	.046	.270	.137
POA TO CENTROID in.	.133	.316	.343
MIN RADIUS	.284	.363	.165
MEAN RADIUS	1.162	1.065	.958
MAX RADIUS	2.049	1.609	1.498
HORIZONTAL SPREAD	2.460	2.460	2.460
VERTICAL SPREAD	3.312	1.992	1.954
EXTREME SPREAD	3.409	2.890	2.485
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	8		

21 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6685714

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.400

VS= 2.435

GS= 2.471

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.041	.890	.885
MINIMUM X	-1.359	-1.050	-1.055
MAXIMUM Y	1.386	1.459	.788
MINIMUM Y	-1.049	-.976	-.793
CENTROID X	.106	.257	.262
CENTROID Y	-.223	-.296	-.479
POA TO CENTROID in.	.247	.392	.546
MIN RADIUS	.267	.348	.441
MEAN RADIUS	.914	.830	.736
MAX RADIUS	1.510	1.460	1.185
HORIZONTAL SPREAD	2.400	1.940	1.940
VERTICAL SPREAD	2.435	2.435	1.581
EXTREME SPREAD	2.471	2.471	2.080
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

EXTRACTION SPEECH: **BARBER - M24 0101664**

NUMBER IN ONE INCH CIRCLE = 3.368

NUMBER IN TWO INCH CIRCLE =

NUMBER IN THREE INCH CIRCLE =

3.037

3.037

0

3

7

21 Oct 1991

FILE:/PHI/TERMINING/CENTERFIRE_PHI/08665/14

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 0

2in = 3

3in = 7

HS= 2.836

VS= 3.026

GS= 3.388

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.336	.984	.815
MINIMUM X	-1.500	-1.352	-.966
MAXIMUM Y	1.585	1.728	1.681
MINIMUM Y	-1.441	-1.298	-1.346
CENTROID X	.016	-.132	.037
CENTROID Y	.527	.384	.432
POA TO CENTROID in.	.527	.406	.433
MIN RADIUS	.633	.744	.586
MEAN RADIUS	1.196	1.104	1.051
MAX RADIUS	1.856	1.729	1.684
HORIZONTAL SPREAD	2.836	2.336	1.781
VERTICAL SPREAD	3.026	3.026	3.026