C652316

MODEL 700 TM M24

Model 5HS TM

Action

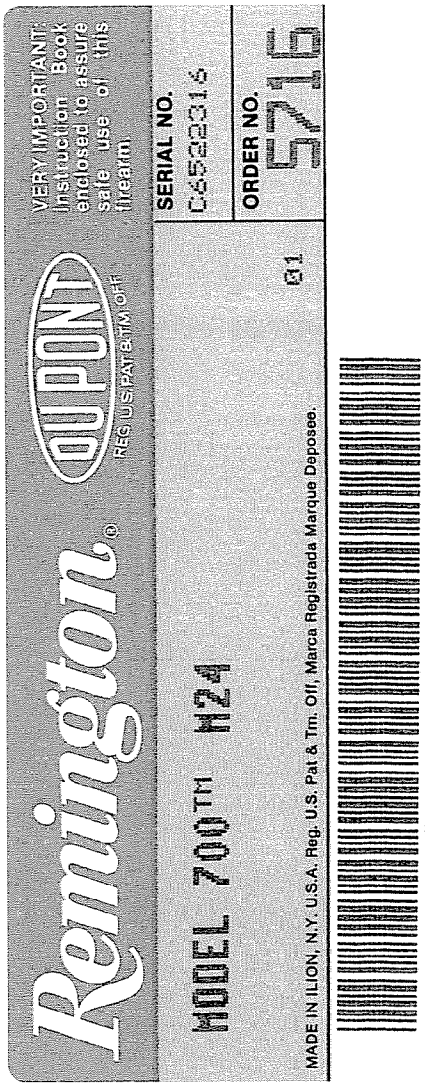
Barrel Length

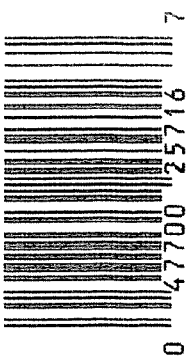
Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

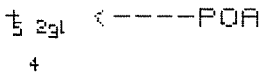

Remington
DUPONT
REG. U.S. PAT. & TM. OFF.
VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm
SERIAL NO.
C6522316
MODEL 700TM M24
ORDER NO.
5716
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off., Marca Registrada Marque Deposee.
01
5716 C6522316


UPC
0 47700 25716 7

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522316
14 Aug 1990

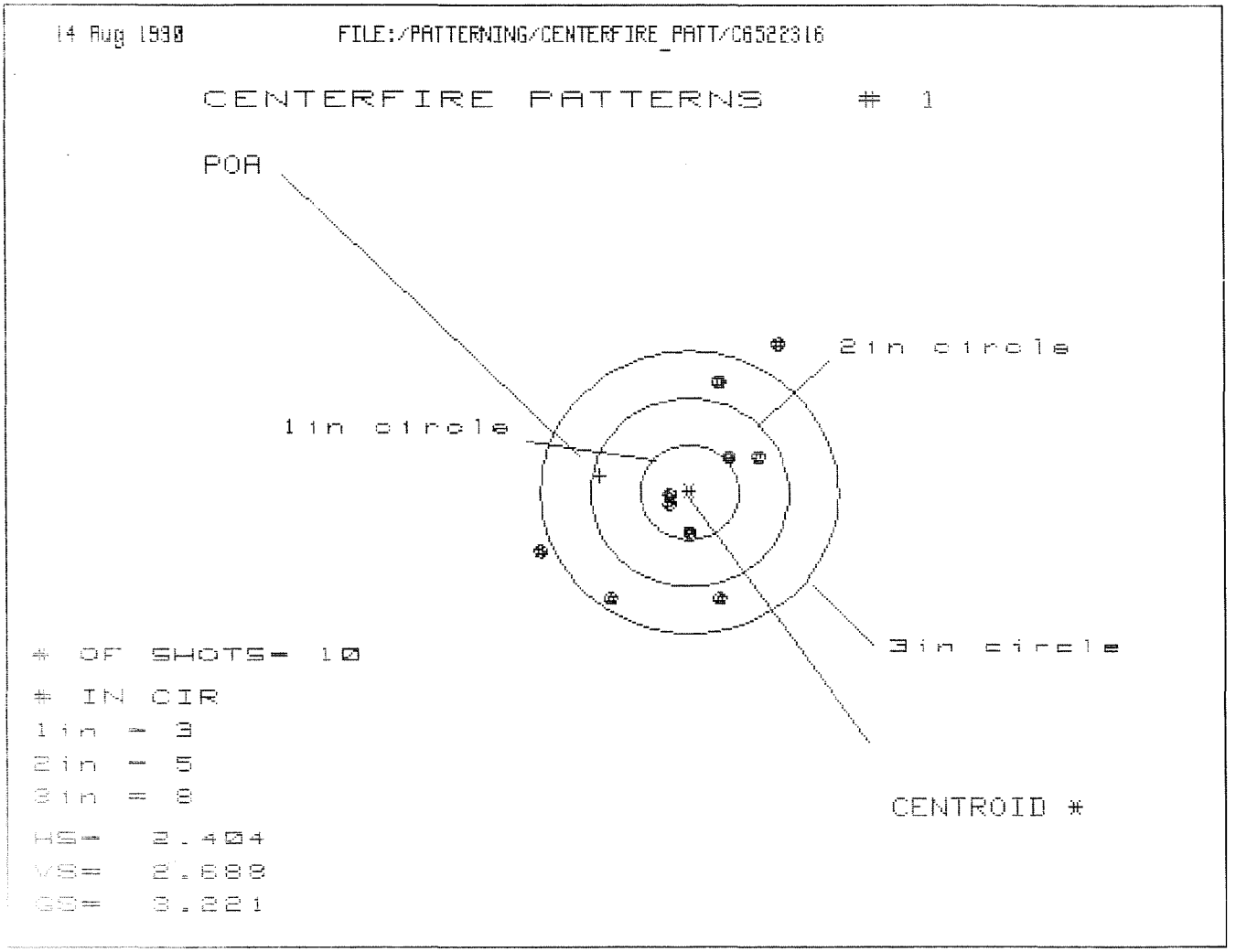
CENTROIDAL DISTANCES

0	TO	1	.921165
1	TO	2	.385012
1	TO	3	.178718
1	TO	4	.859843
1	TO	5	.82118

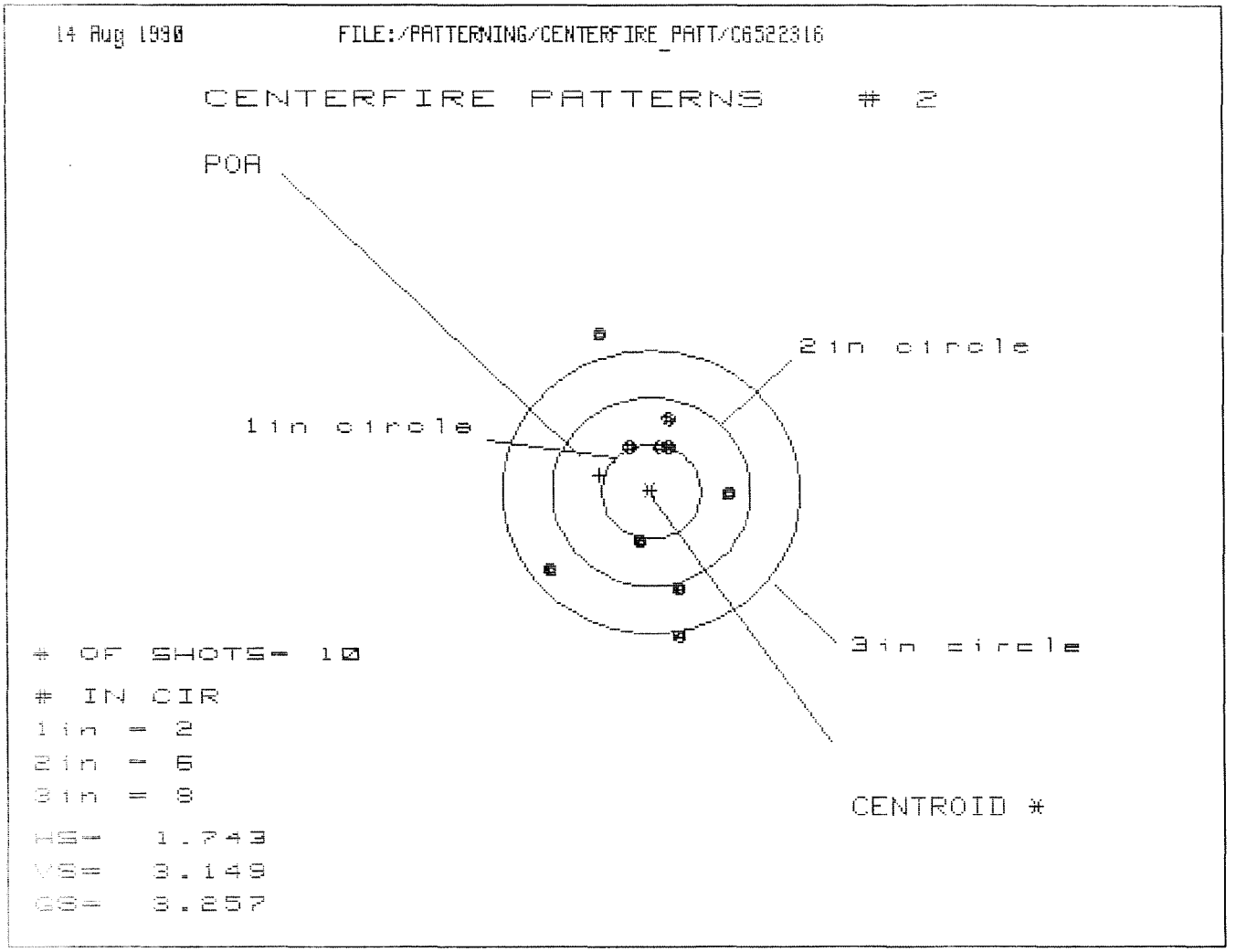


THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .5308
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.3426
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .631762

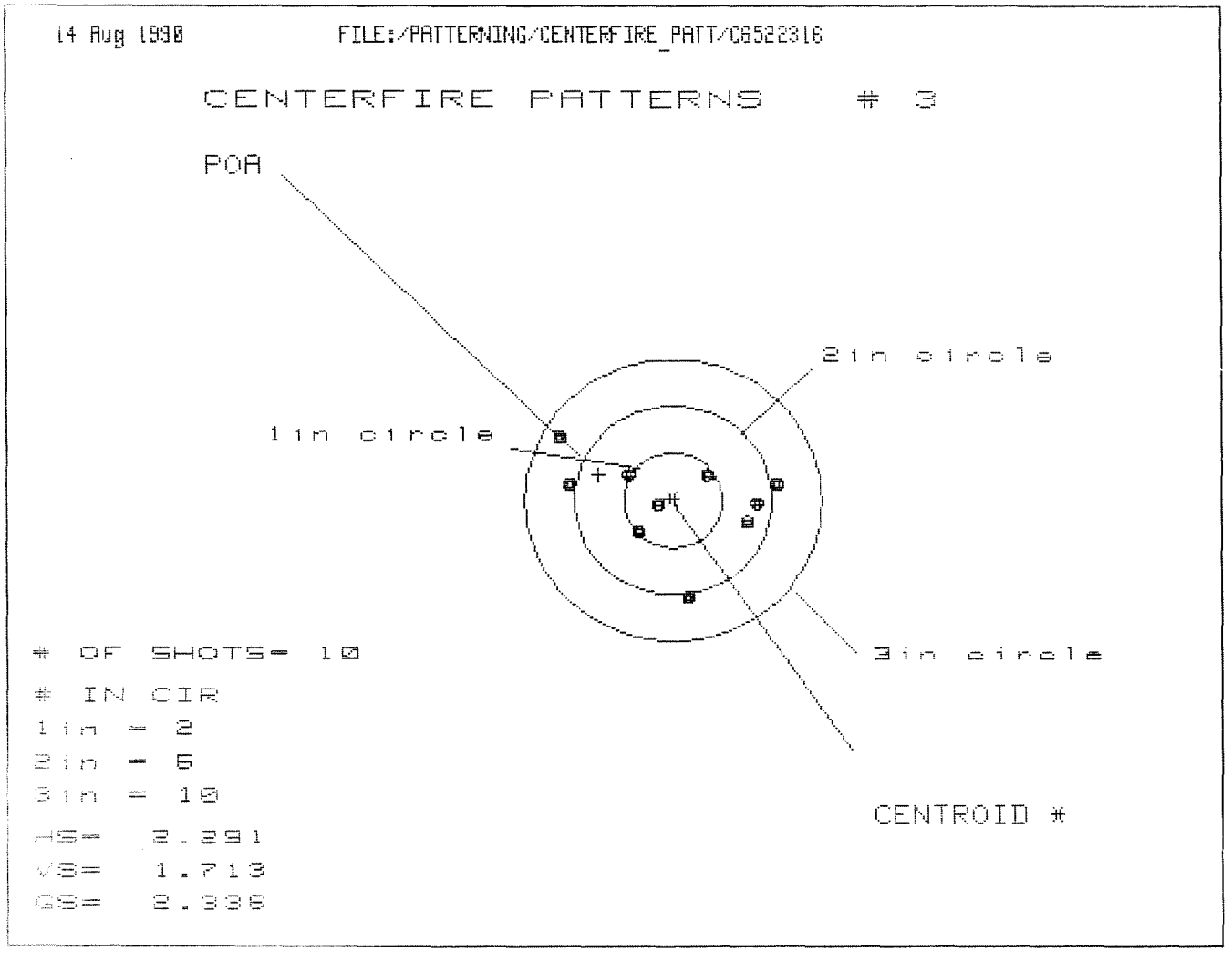
THE AMR FOR THIS RIFLE IS: .9388



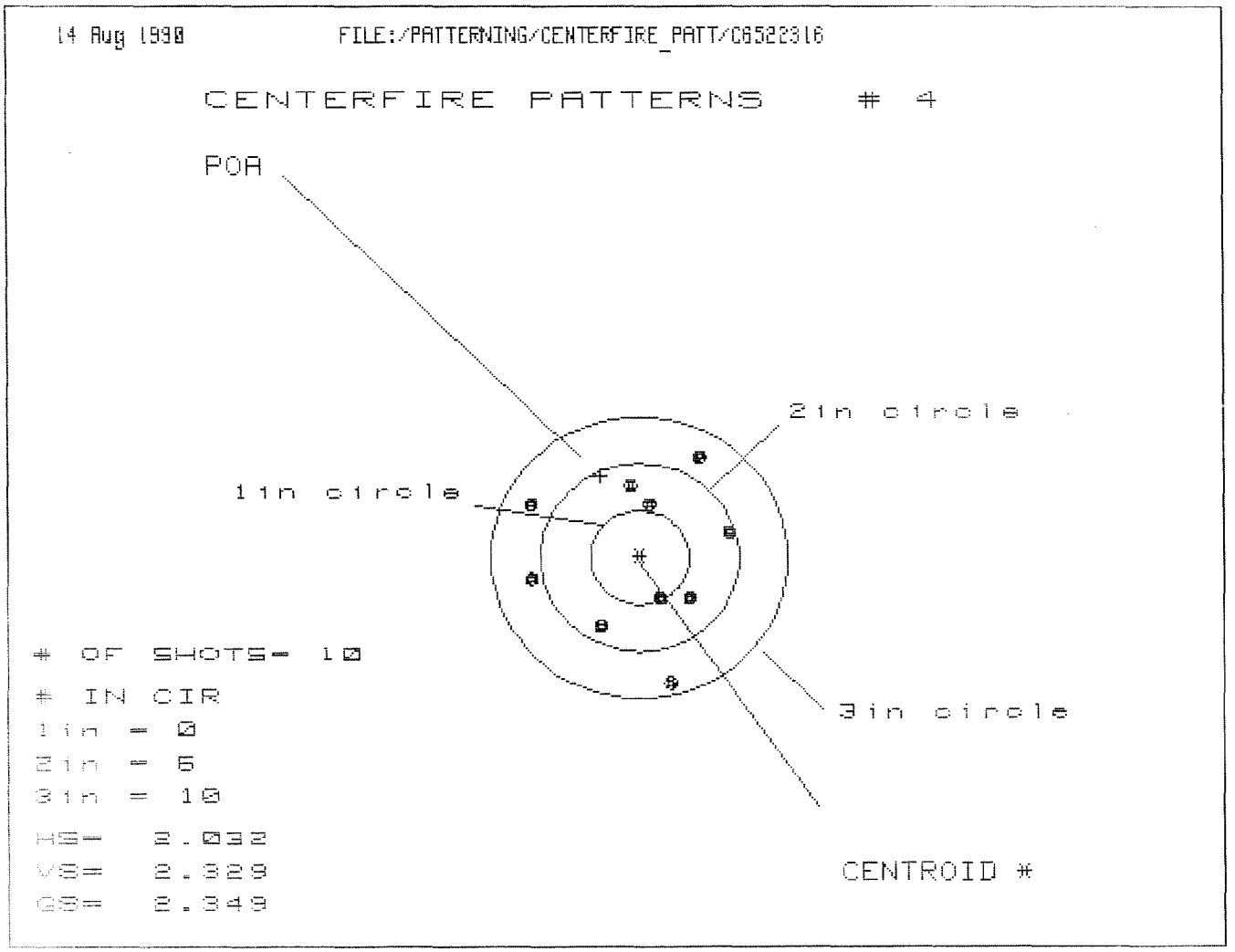
PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.942	.797	.627
MINIMUM X	:	-1.462	-1.357	-.855
MAXIMUM Y	:	1.539	1.375	1.321
MINIMUM Y	:	-1.149	-.978	-1.032
CENTROID X	:	.904	.799	.969
CENTROID Y	:	-.177	-.348	-.294
POA TO CENTROID in.	:	.921	.872	1.013
MIN RADIUS	:	.204	.119	.253
MEAN RADIUS	:	.943	.823	.752
MAX RADIUS	:	1.805	1.425	1.340
HORIZONTAL SPREAD	:	2.404	2.154	1.482
VERTICAL SPREAD	:	2.688	2.353	2.353
EXTREME SPREAD	:	3.221	2.580	2.580
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	



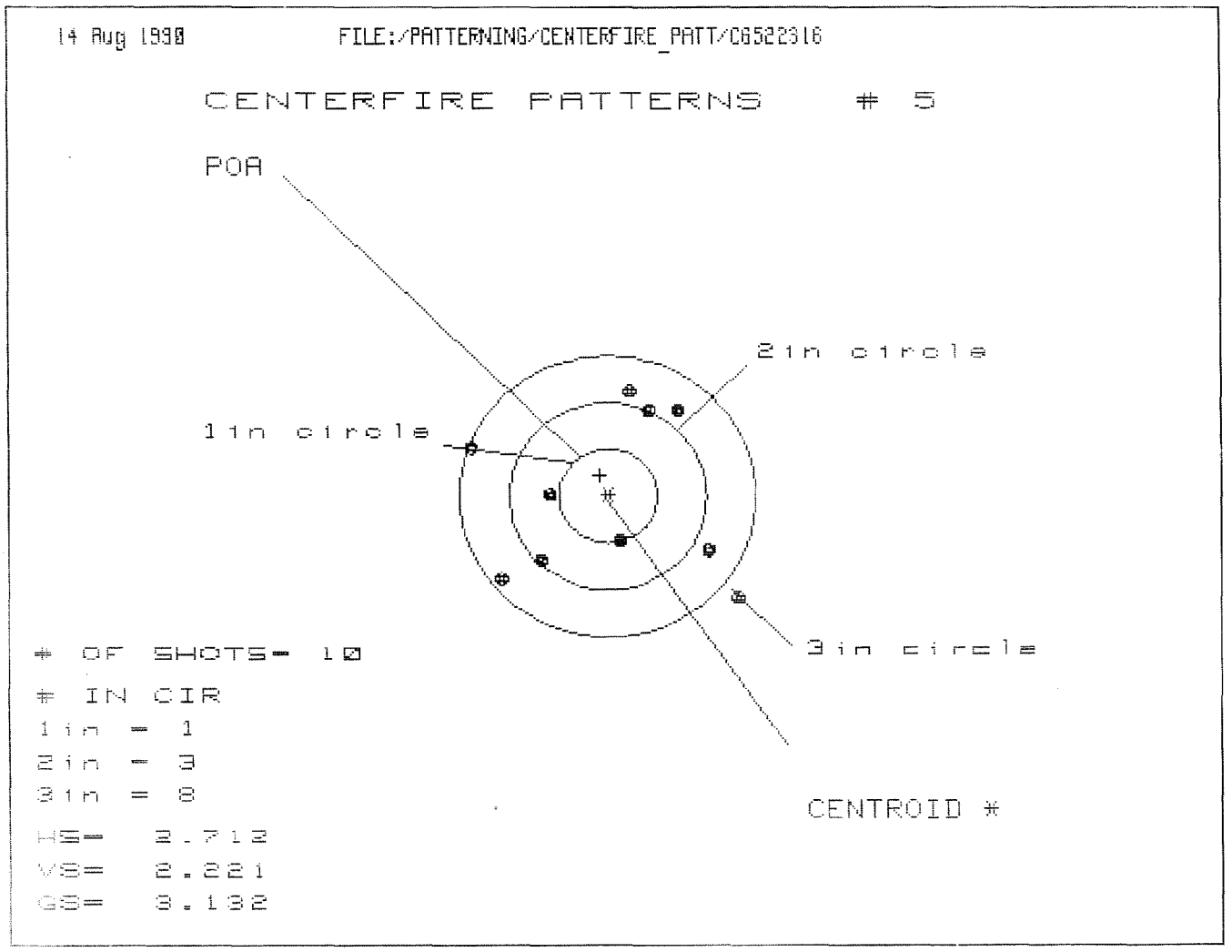
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.738	.680	.712
MINIMUM X	:	-1.005	-1.063	-1.030
MAXIMUM Y	:	1.634	.935	.768
MINIMUM Y	:	-1.515	-1.333	-.993
CENTROID X	:	.519	.577	.544
CENTROID Y	:	-.174	-.356	-.189
POA TO CENTROID in.	:	.548	.678	.576
MIN RADIUS	:	.479	.363	.483
MEAN RADIUS	:	.916	.835	.738
MAX RADIUS	:	1.714	1.358	1.304
HORIZONTAL SPREAD	:	1.743	1.743	1.743
VERTICAL SPREAD	:	3.149	2.268	1.761
EXTREME SPREAD	:	3.257	2.275	1.938
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	



PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.095	.963	.885
MINIMUM X	:	-1.196	-1.220	-1.100
MAXIMUM Y	:	.637	.386	.418
MINIMUM Y	:	-1.076	-1.006	-.974
CENTROID X	:	.752	.884	.764
CENTROID Y	:	-.271	-.341	-.373
POA TO CENTROID in.	:	.799	.948	.850
MIN RADIUS	:	.141	.285	.190
MEAN RADIUS	:	.797	.736	.692
MAX RADIUS	:	1.354	1.248	1.139
HORIZONTAL SPREAD	:	2.291	2.183	1.985
VERTICAL SPREAD	:	1.713	1.392	1.392
EXTREME SPREAD	:	2.336	2.183	1.993
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	



PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.922	.956	.824
MINIMUM X	:	-1.110	-1.076	-1.208
MAXIMUM Y	:	1.046	.903	.957
MINIMUM Y	:	-1.283	-.841	-.787
CENTROID X	:	.395	.361	.493
CENTROID Y	:	-.870	-.727	-.781
POA TO CENTROID in.	:	.955	.812	.923
MIN RADIUS	:	.526	.402	.441
MEAN RADIUS	:	.915	.862	.811
MAX RADIUS	:	1.318	1.151	1.259
HORIZONTAL SPREAD	:	2.032	2.032	2.032
VERTICAL SPREAD	:	2.329	1.744	1.744
EXTREME SPREAD	:	2.349	2.161	2.161
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	



PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.287	1.145	.985
MINIMUM X	:	-1.425	-1.282	-1.147
MAXIMUM Y	:	1.153	1.034	1.082
MINIMUM Y	:	-1.068	-.982	-.934
CENTROID X	:	.084	-.059	.101
CENTROID Y	:	-.221	-.102	-.150
POA TO CENTROID in.	:	.236	.118	.181
MIN RADIUS	:	.450	.476	.515
MEAN RADIUS	:	1.123	1.052	1.008
MAX RADIUS	:	1.672	1.392	1.480
HORIZONTAL SPREAD	:	2.712	2.427	2.132
VERTICAL SPREAD	:	2.221	2.016	2.016
EXTREME SPREAD	:	3.132	2.658	2.606
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

SWS TRIGGER PULL TEST

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

SERIAL NO. C6522316

DATE 9-15-90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.45	2.21	2.17	2.44	MIN. SETTING,
PULL #2	2.32	2.29	2.29	2.33	NO AVG. OF 5
PULL #3	2.22	2.29	2.29	2.33	READINGS ACCEPT-
PULL #4	2.24	2.27	2.28	2.23	ABLE LESS THAN 2#
PULL #5	2.23	2.33	2.35	2.18	
TOTAL	11.46	11.39	11.38	11.51	
AVG.	2.292	2.278	2.276	2.302	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.38	3.41		
PULL #2	3.40	3.40		
PULL #3	3.39	3.48		
PULL #4	3.27	3.46		
PULL #5	3.44	3.43		
TOTAL	16.88	17.18		
AVG.	3.376	3.436		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.17	4.15		4.13
PULL #2	4.19	4.18		4.24
PULL #3	4.19	4.25		4.24
PULL #4	4.14	4.22		4.16
PULL #5	4.27	4.20		4.14
TOTAL	21.01	21.00		20.91
AVG.	4.202	4.2		4.182

MOD. _____ GA. CAL. _____ GUN # _____

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st	Tight Magazine Box	
	2nd	adjusted Box OK	8/13/ KS
	3rd		
	4th		

FUNCTION RD 6654 Rev 1

TEST	INIT.	ACTION TO CORRECT	ASSEM. #
PROOF			
TEST			
TGT			
PROOF			
TEST			
TGT			
		ENGINEER	
PROOF			
TEST			
TGT			
		ENGINEER	
PROOF			
TEST			
TGT			

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6522316

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		7/9/90	KS
600	Proof		7/9/90	KS
607	Check Headspace		7/9/90	KS
610	Dis-assemble Gun		7/9/90	KS
612	Magnaflux Barrel Action		7/10/90	KR
	Magnaflux Bolt		7/10/90	KR
615	Rollmark Caliber		7/10/90	DS
617	Drill and Tap Sight Holes		7/23/90	ES
618	Polish Barrel MB		7/24/90	WB
620	Apply Coatings (Barrel Action)		7/26/90	DH
	Apply Coating (Bolt)			DH
625	Final Assembly A) Clean inside of Bolt Assembly		8/10/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/10/90	KS
	C) Inspect Ejector Hole for Chamfer		8/10/90	KS
	D) Oil Firing Pin Ass'y		8/10/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		9-15-90	KS

op. #	OP. NAME	READINGS	DATE	INIT
625 cont.	F) Safety On Force	4 : 4 : 4	8/13/90	
	G) Safety Off Force	3 : 3 : 3	8/13/90	
	H) Trigger Pull Test & Retainability		9-15-90	
	I) Firing Pin Indent	.0215 : .0215 : .0215	8/13/90	
	J) Assemble Stock		8/13/90	KS
	K) Assemble Swivel Studs		9/16/90	
	L) Attach Front and Rear Sight Assemblies		8/13/90	KS
	M) Iron Sight Alignment		8/13/90	KS
	N) Detach Front & Rear Sights & place in numbered container		8/13/90	KS
	O) Attach Scope to Rifle		8/13/90	KS
	P) Detach & Attach Scope 20 Times		8/13/90	KS
640	Gallery Target & Test		8-14-90	KJ
	A) Time		8-14-90	KJ
	B) Malfunctions		8-14-90	KJ
	C) Pierced Primers		8-14-90	KJ
	D) Optical Clearity of Scope		8-14-90	KJ
645	Inspect for Live Ammo		8-14-90	KJ
655	Final Inspection A) Headspace		9/16/90	
	B) Trigger Pull	2.44 : 2.33 : 2.33 : 2.23 : 2.18	9-15-90	
	C) Function		9/16/90	
660	Pack		9/19/90	