

FORM

UPC



0 47700 25716 7

C6649021

CAPACITY*
*INCLUDES 1 IN CHAMBER

5716

ORDER NO.

BARREL LENGTH

MODEL 700 TM M24

Remington



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

MODEL 700 TM M24

SERIAL NO.

C6649021

ORDER NO.

5716

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

20



5716 C6649021

ORDER 5716

MODEL 700 TM M24

UPC

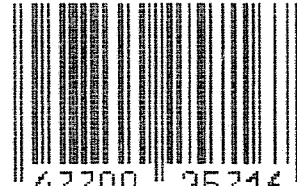
ORDER 5716

MODEL 700 TM M24

UPC



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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649021

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 26	91	RW
600	Proof	9 26	91	RW
607	Check Headspace	9 26	91	RW
610	Dis-assemble Gun	9 26		RW
612	Magnaflux Barrel Action	OCT	3 1991	KCR
	Magnaflux Bolt	OCT	3 1991	KCR
615	Rollmark Caliber	OCT	3 1991	GB
617	Drill and Tap Sight Holes	OCT	4 1991	LB
618	Polish Barrel	OCT	4 1991	WB
620	Apply Coatings (Barrel Action)		10-18-91	TS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		12/3/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/3/91	KS
	C) Inspect Ejector Hole for Chamfer		12/3/91	KS
	D) Oil Firing Pin Ass'y		12/3/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		12/9/91	JS

op. #	BARBER M24 0030724	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			12-9-91	JY
	G) Safety Off Force	3	3	3			12-9-91	JY
	H) Trigger Pull Test & Retainability						12-9-91	JY
	I) Firing Pin Indent	10205	10205	10205			12-9-91	JY
	J) Assemble Stock						12-9-91	KS
	K) Assemble Swivel Studs						12-13-91	JY
	L) Attach Front and Rear Sight Assemblies						12-9-91	KS
	M) Iron Sight Alignment						12-9-91	KS
	N) Detach Front & Rear Sights & place in numbered container						12-9-91	KS
	O) Attach Scope to Rifle						12-9-91	KS
	P) Detach & Attach Scope 20 Times						12-9-91	KS
640	Gallery Target & Test						12-10-91	JY
	A) Time						12-10-91	JY
	B) Malfunctions						12-10-91	JY
	C) Pierced Primers						12-10-91	JY
	D) Optical Clarity of Scope						12-10-91	JY
645	Inspect for Live Ammo						12-10-91	JY
655	Final Inspection							
	A) Headspace						12-13-91	JY
	B) Trigger Pull	2.61	2.63	2.64	2.62	2.64	12-11-91	JY
	C) Function						12-13-91	JY
660	Pack						12-20-91	JY

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

SERIAL NO. C6649021DATE 12-9-91TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.35	2.35	2.41	2.61	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.37	2.38	2.44	2.63	
PULL #3	2.36	2.30	2.38	2.64	
PULL #4	2.38	2.38	2.49	2.62	
PULL #5	2.33	2.38	2.25	2.64	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.22	3.44		
PULL #2	3.25	3.50		
PULL #3	3.38	3.55		
PULL #4	3.36	3.38		
PULL #5	3.41	3.38		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.43	4.42		4.39
PULL #2	4.46	4.40		4.43
PULL #3	4.47	4.45		4.50
PULL #4	4.48	4.52		4.49
PULL #5	4.46	4.38		4.39
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649021
10 Dec 1991

CENTROIDAL DISTANCES

0 TO	1	.707107
1 TO	2	.501036
1 TO	3	1.00111
1 TO	4	.739757
1 TO	5	1.25316

$S^2 = 1$ (----POA)

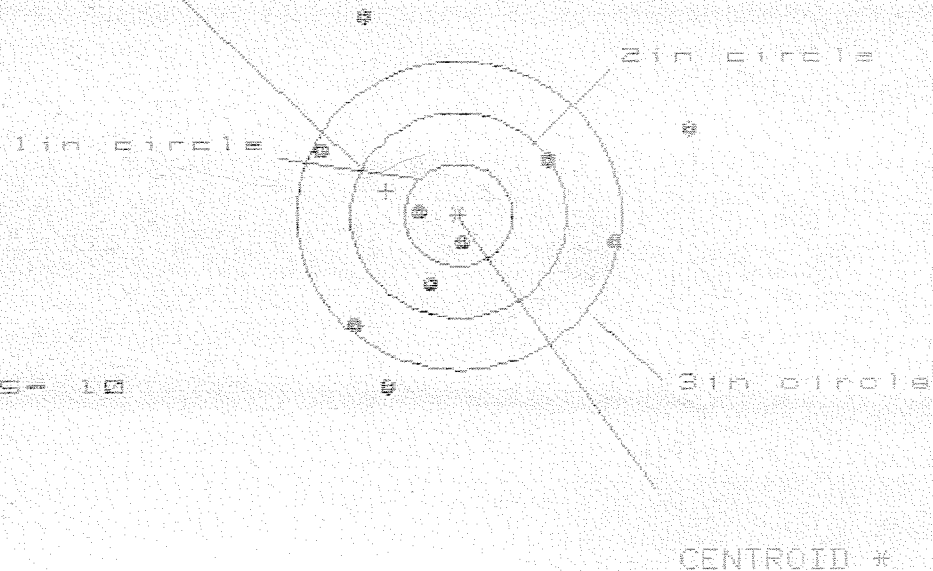
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0142
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.119
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .119844
THE AMR FOR THIS RIFLE IS: 1.098

18 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B49021

CENTERFIRE PATTERNS # 1

POA



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 4

3 in = 7

HS = 3.407

VS = 3.608

CS = 3.770

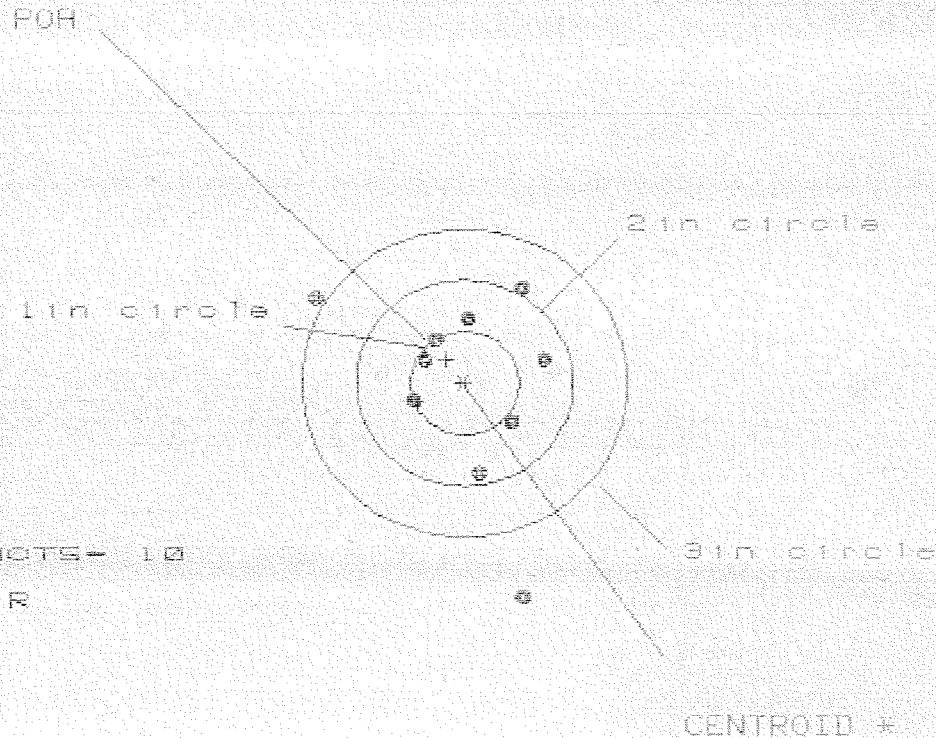
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.135	1.636	1.554
MINIMUM X	-1.272	-1.034	-1.115
MAXIMUM Y	1.914	2.008	.993
MINIMUM Y	-1.694	-1.600	-1.349
CENTROID X	.667	.429	.511
CENTROID Y	-.235	-.329	-.580
POA TO CENTROID in.	.707	.541	.772
MIN RADIUS	.221	.214	.223
MEAN RADIUS	1.286	1.143	.997
MAX RADIUS	2.296	2.110	1.555
HORIZONTAL SPREAD	3.407	2.670	2.670
VERTICAL SPREAD	3.608	3.608	2.342
EXTREME SPREAD	3.770	3.616	2.835
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

10 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CAB45021

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 7

3 in = 8

HS = 2.005

VS = 3.003

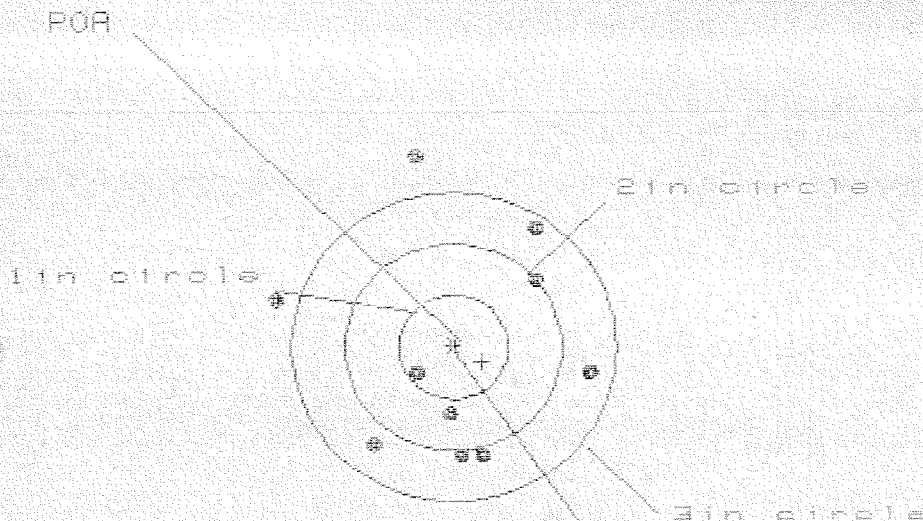
GS = 3.452

PATTERN #	2
SHOTS (BEST OF)	10
MAXIMUM X	.688
MINIMUM X	-1.317
MAXIMUM Y	.969
MINIMUM Y	-2.034
CENTROID X	.166
CENTROID Y	-.229
POH TO CENTROID in.	.283
MIN RADIUS	.449
MEAN RADIUS	.897
MAX RADIUS	2.112
HORIZONTAL SPREAD	2.005
VERTICAL SPREAD	3.003
EXTREME SPREAD	3.452
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	7
NUMBER IN THREE INCH CIRCLE =	8

10 Dec 1981

FILE: \PATTERNING\CENTERFIRE_PATT\08649021

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 1

2in = 3

3in = 6

HS= 2.900

VS= 2.918

GS= 2.992

CENTROID *

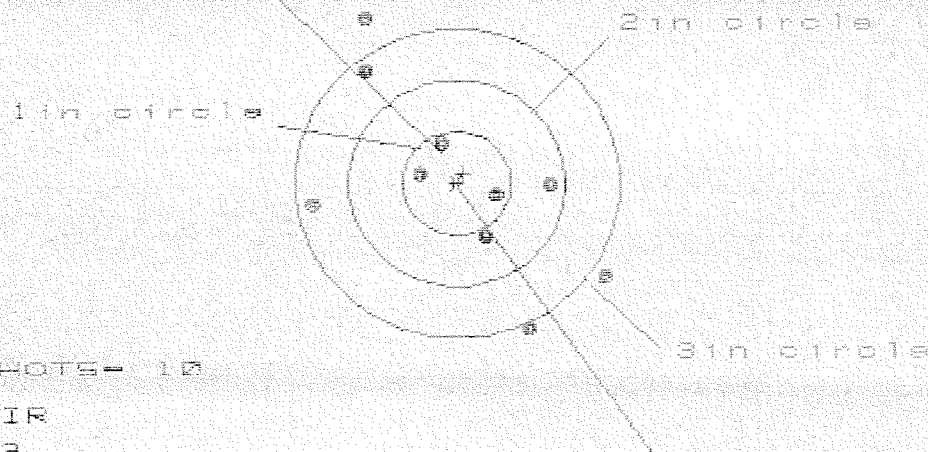
PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.259
MINIMUM X	-1.641
MAXIMUM Y	1.851
MINIMUM Y	-1.067
CENTROID X	-.260
CENTROID Y	.143
POA TO CENTROID in.	.297
MIN RADIUS	.409
MEAN RADIUS	1.163
MAX RADIUS	1.880
HORIZONTAL SPREAD	2.900
VERTICAL SPREAD	2.918
EXTREME SPREAD	2.992
NUMBER IN ONE INCH CIRCLE	1
NUMBER IN TWO INCH CIRCLE	3
NUMBER IN THREE INCH CIRCLE	6

18 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08649021

CENTERFIRE PATTERNS # 4

POA



OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 7

HS= 3.739

VS= 2.976

GS= 3.342

CENTROID *

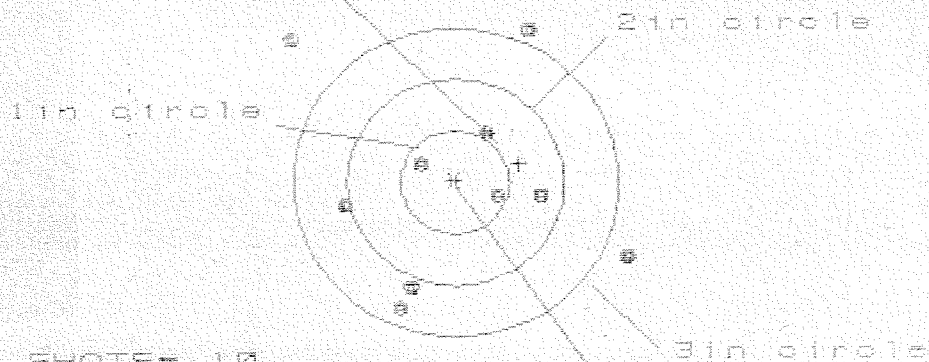
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.408	1.314	.970
MINIMUM X	:	-1.331	-1.425	-1.260
MAXIMUM Y	:	1.553	1.242	1.151
MINIMUM Y	:	-1.423	-1.251	-1.342
CENTROID X	:	-.059	.035	-.130
CENTROID Y	:	-.093	-.265	-.174
POA TO CENTROID in.	:	.110	.268	.217
MIN RADIUS	:	.351	.253	.356
MEAN RADIUS	:	1.033	.938	.864
MAX RADIUS	:	1.768	1.562	1.536
HORIZONTAL SPREAD	:	2.739	2.739	2.230
VERTICAL SPREAD	:	2.976	2.493	2.493
EXTREME SPREAD	:	3.342	3.003	2.925
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

18 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06049021

CENTERFIRE PATTERNS # 5

POA



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 7

HS= 3.097

VS= 2.723

GS= 3.742

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.612
MINIMUM X	-1.485
MAXIMUM Y	-1.504
MINIMUM Y	-1.219
CENTROID X	-.585
CENTROID Y	-.181
POA TO CENTROID in.	.613
MIN RADIUS	.372
MEAN RADIUS	1.112
MAX RADIUS	2.004
HORIZONTAL SPREAD	3.097
VERTICAL SPREAD	2.723
EXTREME SPREAD	3.742
NUMBER IN ONE INCH CIRCLE	2
NUMBER IN TWO INCH CIRCLE	4
NUMBER IN THREE INCH CIRCLE	7