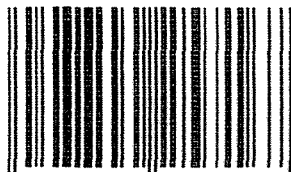


FORM

UPC



0 47700 25716 2

C6649024

*INCLUDES 1 IN CHAMBER

CAPACITY*

BARREL LENGTH

MODEL 700 TM M24

ORDER NO.

5716

Remington



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

MODEL 700™ M24

SERIAL NO.
C6649024

20

ORDER NO.
5716

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



5716 C6649024

ORDER 5716

MODEL 700™ M24

UPC

ORDER 5716

MODEL 700™ M24

UPC



0 47700 25716 7



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649024

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	OCT	3 1991	KCR
	Magnaflux Bolt	OCT	3 1991	KCR
615	Rollmark Caliber	OCT	3 1991	GS.
617	Drill and Tap Sight Holes	OCT	4 1991	LB
618	Polish Barrel	OCT	1 1991	WB
620	Apply Coatings (Barrel Action)		10-18-91	JS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/18/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/18/91	RW
	C) Inspect Ejector Hole for Chamfer		10/18/91	RW
	D) Oil Firing Pin Ass'y		10/18/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11-26-91	JS

op. #	BARBER M24 0030760	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			11-26-91	JK
	G) Safety Off Force	3	3	3			11-26-91	JK
	H) Trigger Pull Test & Retainability						11-26-91	JK
	I) Firing Pin Indent	10215	1021	1021			11-26-91	JK
	J) Assemble Stock						12/2/91	RW
	K) Assemble Swivel Studs						12-12-91	JK
	L) Attach Front and Rear Sight Assemblies						12/2/91	RW
	M) Iron Sight Alignment						12/2/91	RW
	N) Detach Front & Rear Sights & place in numbered container						12/2/91	RW
	O) Attach Scope to Rifle						12/2/91	RW
	P) Detach & Attach Scope 20 Times						12/2/91	RW
640	Gallery Target & Test						12-2-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						12-2-91	NF
655	Final Inspection							
	A) Headspace						12-12-91	JK
	B) Trigger Pull	2.39	2.36	2.50	2.20	2.48	12-12-91	Ac
	C) Function						12-12-91	JK
660	Pack						12-18-91	NF

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF	100 Rcl's test OK 12-12-91	
TEST AC		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

MOD.		GA. CAL.	GUN #	ASSEM. #
# TEST	DATE	MALFUNCTION/DEFECT		
	1st			
V	12/2	Shaves Brass		RW
	2nd			
	12/11/91	Repaired KA		
	3rd			
		100 Rd's OK 12-12-91 AC		
	4th			
		FUNCTION		RD 6654 Rev 1

CENTROIDAL DISTANCE CALCULATIONS

FOR RIFLE # 06649024

2 Dec 1991

CENTROIDAL DISTANCES

0 TO	1	.198595
1 TO	2	.369177
1 TO	3	.350203
1 TO	4	.137539
1 TO	5	.394635

$\frac{2}{49}$

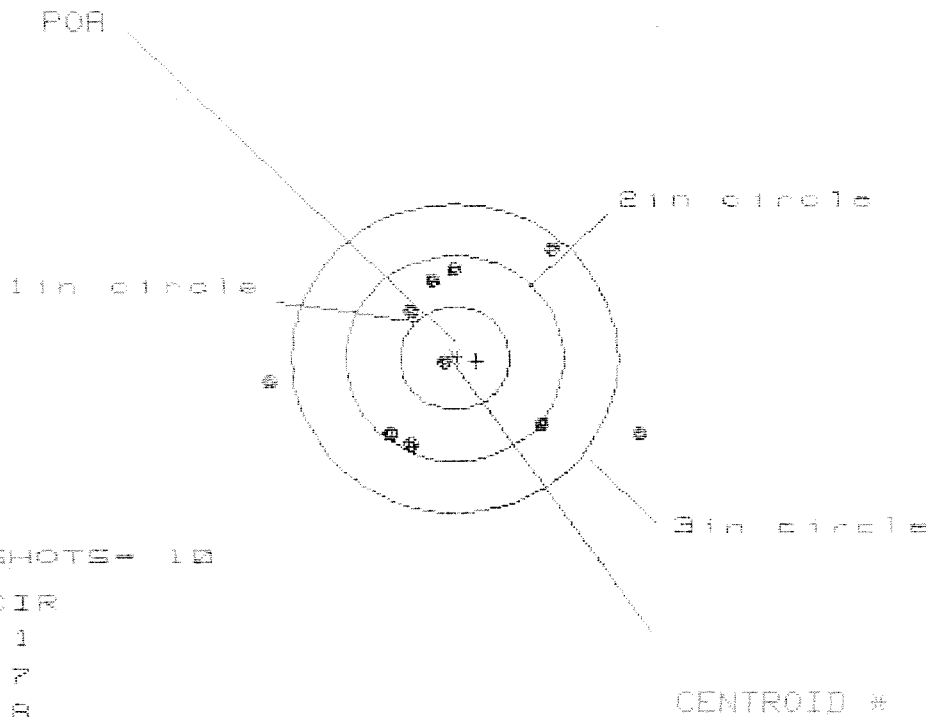
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .01
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .044
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0451221
 THE AMR FOR THIS RIFLE IS: .969

2 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649024

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 1

2in = 7

3in = 8

HS= 3.422

VS= 1.985

GS= 3.453

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.715	1.129	.940
MINIMUM X	-1.707	-1.516	-.586
MAXIMUM Y	1.113	1.036	.999
MINIMUM Y	-.972	-.949	-.986
CENTROID X	-.196	-.387	-.197
CENTROID Y	.032	.109	.146
FOR TO CENTROID in.	.199	.402	.246
MIN RADIUS	.138	.161	.218
MEAN RADIUS	1.032	.915	.840
MAX RADIUS	1.849	1.546	1.371
HORIZONTAL SPREAD	3.422	2.645	1.525
VERTICAL SPREAD	1.985	1.985	1.985
EXTREME SPREAD	3.453	2.964	2.385
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		

2 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B49024

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 9

HS = 1.961

VS = 2.684

GS = 2.747

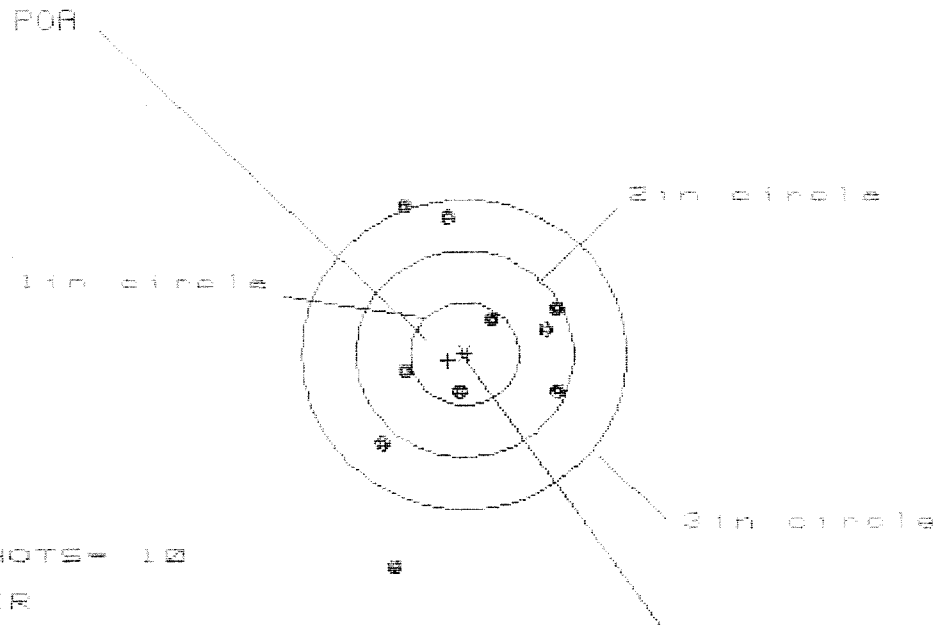
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.090	1.106	.990
MINIMUM X	-.871	-.855	-.717
MAXIMUM Y	.956	.764	.818
MINIMUM Y	-1.728	-1.262	-1.208
CENTROID X	.070	.054	-.084
CENTROID Y	.288	.480	.426
POA TO CENTROID in.	.296	.483	.434
MIN RADIUS	.165	.293	.299
MEAN RADIUS	.950	.843	.777
MAX RADIUS	1.734	1.400	1.295
HORIZONTAL SPREAD	1.961	1.961	1.710
VERTICAL SPREAD	2.684	2.026	2.026
EXTREME SPREAD	2.747	2.436	2.436
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

2 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08645884

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS = 1.672

VS = 3.526

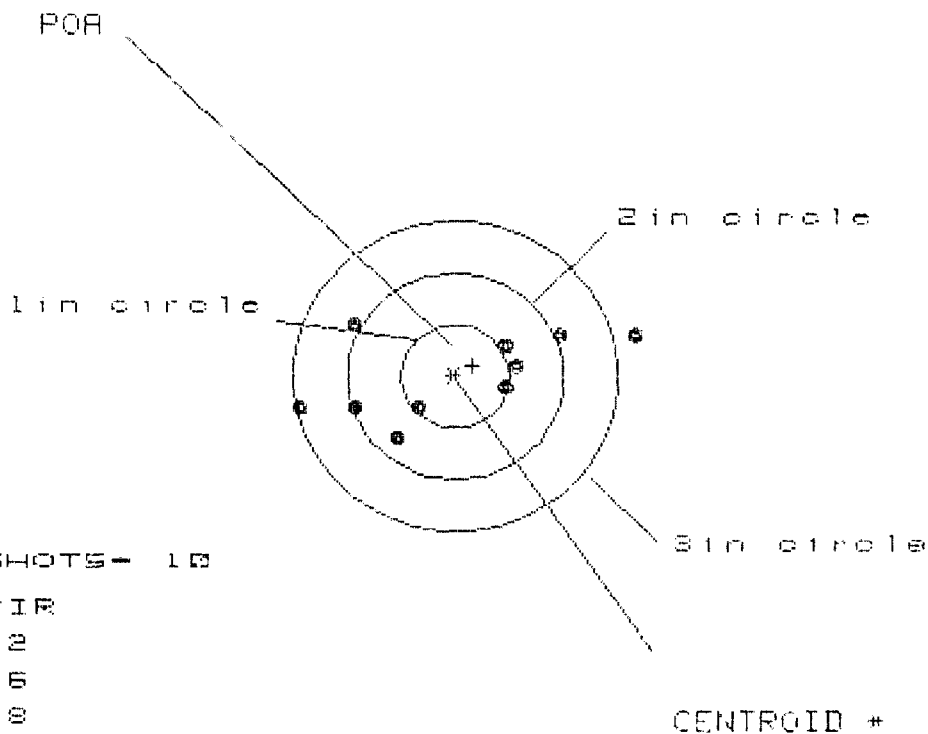
GS = 3.527

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	.885
MINIMUM X	-.787
MAXIMUM Y	1.457
MINIMUM Y	-2.069
CENTROID X	.153
CENTROID Y	.061
POA TO CENTROID in.	.165
MIN RADIUS	.331
MEAN RADIUS	1.034
MAX RADIUS	2.158
HORIZONTAL SPREAD	1.672
VERTICAL SPREAD	3.526
EXTREME SPREAD	3.527
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	8

2 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649024

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS= 3.166

VS= 1.124

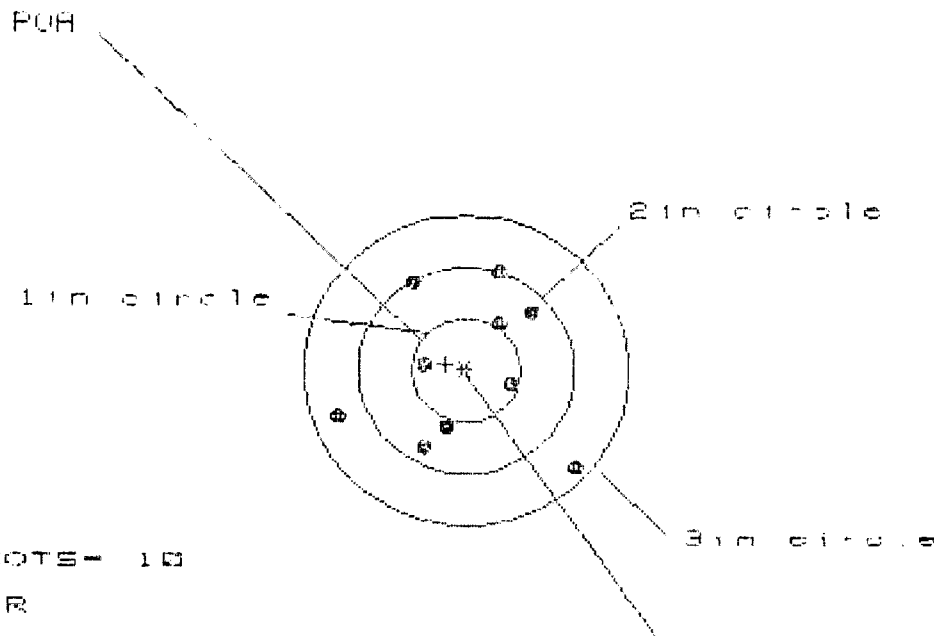
GS= 3.244

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.698	1.181	1.021
MINIMUM X	-1.468	-1.286	-0.879
MAXIMUM Y	.479	.523	.488
MINIMUM Y	-.645	-.601	-.636
CENTROID X	-.165	-.353	-.193
CENTROID Y	-.102	-.146	-.111
POA TO CENTROID in.	.194	.382	.223
MIN RADIUS	.408	.261	.382
MEAN RADIUS	.911	.812	.735
MAX RADIUS	1.742	1.309	1.115
HORIZONTAL SPREAD	3.166	2.461	1.900
VERTICAL SPREAD	1.124	1.124	1.124
EXTREME SPREAD	3.244	2.575	2.1
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

1 Dec 1991

FILE: PATTERNING/CENTERFIRE_PATT/C6649024

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS= 2.215

VS= 1.848

GS= 2.341

CENTROID #

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.993	.742	.603
MINIMUM X	-1.222	-1.112	-1.044
MAXIMUM Y	.918	.814	.741
MINIMUM Y	-.930	-.829	-.401
CENTROID X	.188	.078	.217
CENTROID Y	-.059	.045	.110
POA TO CENTROID in.	.197	.090	.247
MIN RADIUS	.371	.252	.362
MEAN RADIUS	.819	.750	.669
MAX RADIUS	1.360	1.259	.976
HORIZONTAL SPREAD	2.215	1.854	1.141
VERTICAL SPREAD	1.848	1.642	1.442
EXTREME SPREAD	2.341	2.105	1.770
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6649024
DATE 11-26-91
TESTER JPL.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.42	2.37	2.20	2.39	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.44	2.46	2.33	2.36	
PULL #3	2.41	2.41	2.48	2.50	
PULL #4	2.38	2.51	2.44	2.20	
PULL #5	2.48	2.28	2.46	2.48	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.24	3.51		
PULL #2	3.33	3.53		
PULL #3	3.43	3.49		
PULL #4	3.33	3.56		
PULL #5	3.41	3.42		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.38	4.33		4.49
PULL #2	4.54	4.45		4.52
PULL #3	4.60	4.57		4.49
PULL #4	4.52	4.20		4.57
PULL #5	4.58	4.50		4.46
TOTAL				
AVG.				