

FORM

UPC



0 47700 25716 2

C6649110

*INCLUDES 1 IN CHAMBER

MODEL 700 TM M24

ORDER NO. 5716

BARREL LENGTH

CAPACITY*

RemingtonVERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.**MODEL 700™ M24****SERIAL NO.**
C6649110**ORDER NO.**
5716

20

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



5716 C6649110

ORDER 5716
MODEL 700™ M24
UPC

0 47700 25716 7

ORDER 5716
MODEL 700™ M24
UPC

0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649110

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 25	9 1	RW
600	Proof	6 25	9 1	RW
607	Check Headspace	6 25	9 1	RW
610	Dis-assemble Gun	6 25	9 1	RW
612	Magnaflux Barrel Action		JUL 1 1991	KR
	Magnaflux Bolt		JUL 1 1991	KR
615	Rollmark Caliber		JUL 1 1991	GL
617	Drill and Tap Sight Holes		JUL 1 1991	LB
618	Polish Barrel		JUL 2 1991	WB
620	Apply Coatings (Barrel Action)		7-7-91	DA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/28/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/28/91	RW
	C) Inspect Ejector Hole for Chamfer		8/28/91	RW
	D) Oil Firing Pin Ass'y		8/28/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		7-6-91	DH

op. #	BARBER - M24 0064930	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5 1/2	5			9-6-91	DH
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			9-6-91	DH
	H) Trigger Pull Test & Retainability						9-6-91	DH
	I) Firing Pin Indent	1,023	1,022	1,022			9-6-91	DH
	J) Assemble Stock						9/6/91	RW
	K) Assemble Swivel Studs						9-12-91	DH
	L) Attach Front and Rear Sight Assemblies						9/6/91	RW
	M) Iron Sight Alignment						9/6/91	RW
	N) Detach Front & Rear Sights & place in numbered container						9/6/91	RW
	O) Attach Scope to Rifle						9/6/91	RW
	P) Detach & Attach Scope 20 Times						9/6/91	RW
640	Gallery Target & Test						9-9-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						9-9-91	NF
655	Final Inspection							
	A) Headspace						9-12-91	DH
	B) Trigger Pull	213	213	217	219	215	9-11-91	DH
	C) Function						9-12-91	DH
660	Pack						12-11-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. CC649110

DATE 9-6-91

TESTER D/H

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	243	209	259	213	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	239	207	278	213	
PULL #3	228	206	256	217	
PULL #4	227	210	261	219	
PULL #5	220	211	261	215	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	330	322		
PULL #2	331	322		
PULL #3	312	318		
PULL #4	319	322		
PULL #5	325	317		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.65	4.52		4.23
PULL #2	4.65	4.47		4.00
PULL #3	4.46	4.47		4.27
PULL #4	4.46	4.47		4.29
PULL #5	4.51	4.45		4.04
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649110
9 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.420201
1 TO	2	.305459
1 TO	3	.436033
1 TO	4	.28329
1 TO	5	.434166

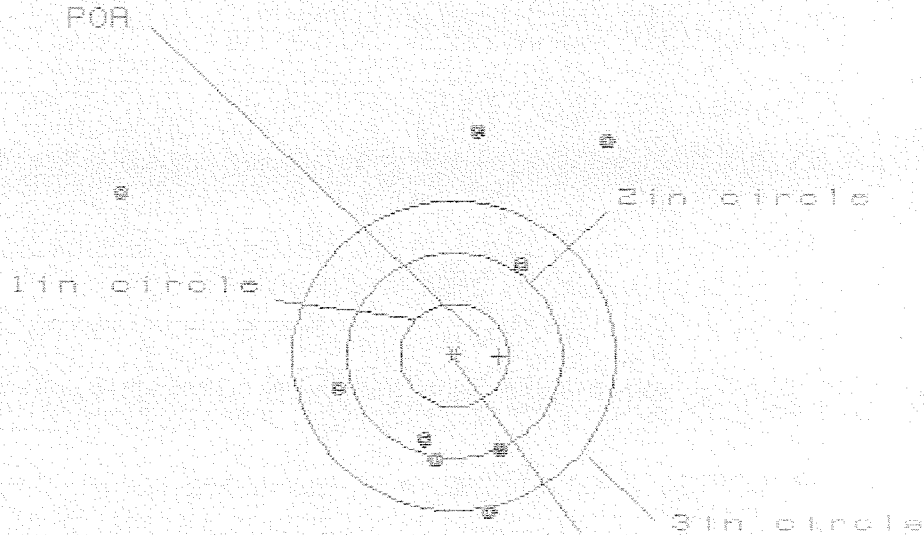
107 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.14
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0868
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .164725
THE AMR FOR THIS RIFLE IS: 1.003

9 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06B49110

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 1

3 in = 5

HS= 4.632

VS= 4.420

GS= 6.019

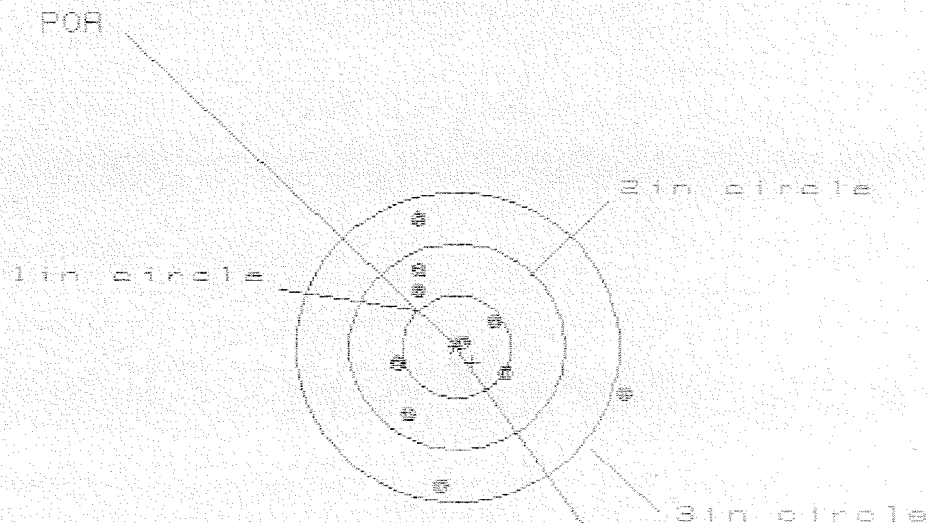
CENTROID *

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.588	1.250	1.222
MINIMUM X	-3.044	-1.425	-1.269
MAXIMUM Y	2.199	2.380	2.125
MINIMUM Y	-2.221	-2.040	-1.552
CENTROID X	-0.420	-0.082	-0.239
CENTROID Y	0.013	-0.168	0.087
POA TO CENTROID in.	0.420	0.187	0.253
MIN RADIUS	0.814	0.774	0.924
MEAN RADIUS	1.755	1.527	1.436
MAX RADIUS	3.450	2.535	2.382
HORIZONTAL SPREAD	4.632	2.675	2.491
VERTICAL SPREAD	4.420	4.420	3.677
EXTREME SPREAD	6.019	4.615	3.771
SHOTS IN ONE INCH CIRCLE	= 0		
SHOTS IN TWO INCH CIRCLE	= 1		
SHOTS IN THREE INCH CIRCLE	= 5		

9 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649110

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 9

HE= 2.103

VS= 2.547

GS= 2.556

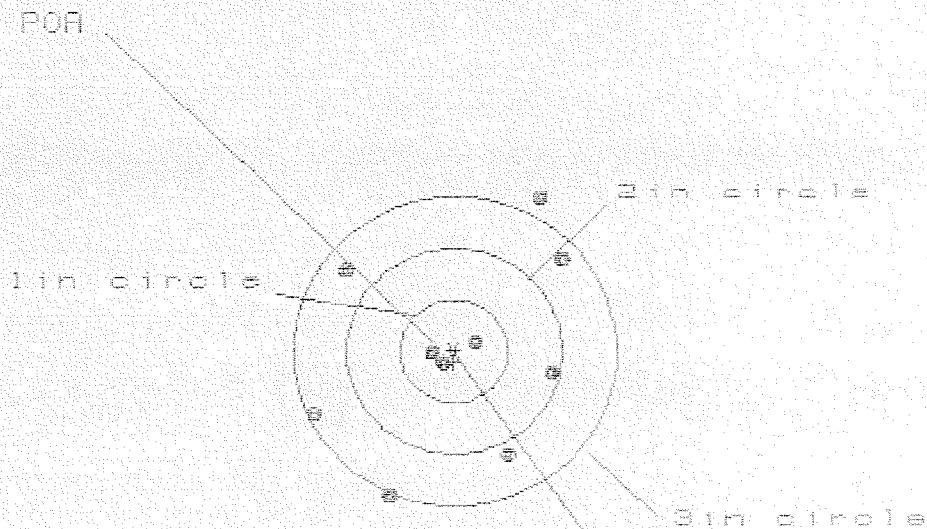
CENTROID #

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.520	.631	.631
MINIMUM X	-.583	-.415	-.415
MAXIMUM Y	1.225	1.179	1.008
MINIMUM Y	-1.321	-1.368	-.871
CENTROID X	-.148	-.316	-.316
CENTROID Y	.152	.199	.370
POA TO CENTROID IN.	.212	.374	.487
MIN RADIUS	.065	.227	.293
MEAN RADIUS	.810	.725	.632
MAX RADIUS	1.577	1.368	1.031
HORIZONTAL SPREAD	2.103	1.046	1.046
VERTICAL SPREAD	2.547	2.547	1.879
EXTREME SPREAD	2.556	2.556	1.880
NUMBER IN ONE INCH CIRCLE	= 2		
NUMBER IN TWO INCH CIRCLE	= 7		
NUMBER IN THREE INCH CIRCLE	= 9		

9 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06849110

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 3

2in = 4

3in = 9

HS = 2.318

VS = 2.877

GS = 3.181

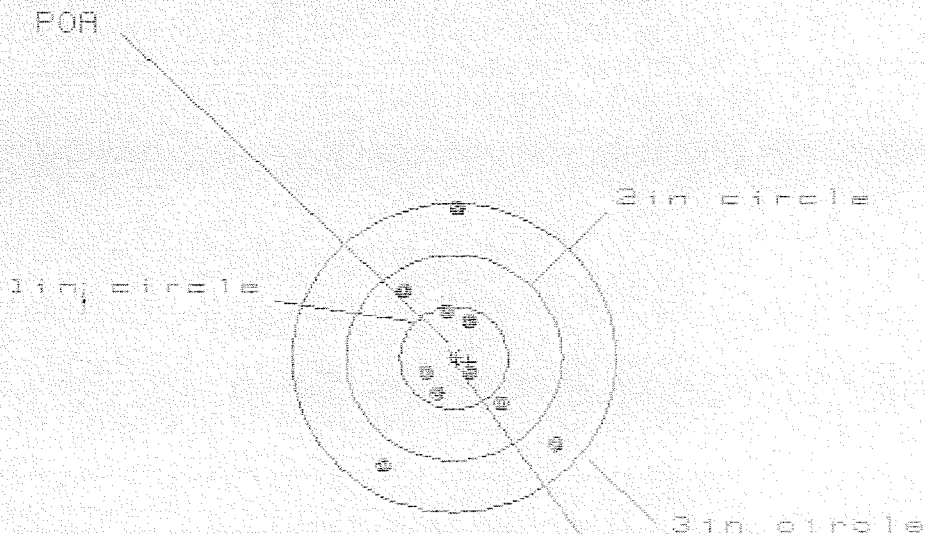
CENTROID #

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.970	1.057	.980
MINIMUM X	-1.348	-1.261	-1.032
MAXIMUM Y	1.503	1.045	.985
MINIMUM Y	-1.374	-1.207	-1.267
CENTROID X	.006	-.081	.076
CENTROID Y	.106	-.061	-.001
POA TO CENTROID in.	.106	.102	.076
MIN RADIUS	.200	.058	.213
MEAN RADIUS	.987	.898	.838
MAX RADIUS	1.698	1.487	1.438
HORIZONTAL SPREAD	2.318	2.318	1.932
VERTICAL SPREAD	2.877	2.252	2.252
EXTREME SPREAD	3.181	2.776	2.741
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		9	

9 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649110

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 5

2 in = 7

3 in = 10

HS = 1.579

VS = 2.460

GS = 2.553

CENTROID *

PATTERN #

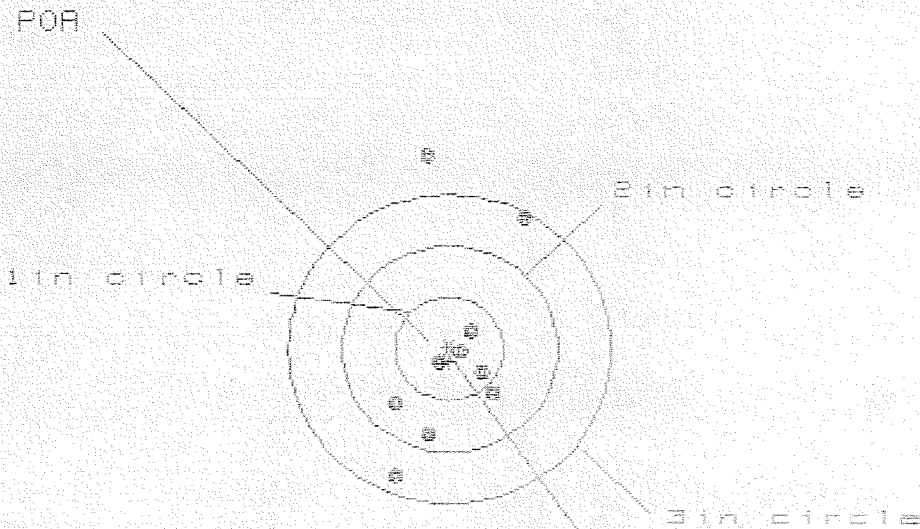
4

	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.924	.927	.524
MINIMUM X	-.655	-.652	-.537
MAXIMUM Y	1.413	.837	.746
MINIMUM Y	-1.047	-.890	-.981
CENTROID X	-.138	-.141	-.256
CENTROID Y	.040	-.117	-.026
POA TO CENTROID in.	.143	.183	.258
MIN RADIUS	.160	.097	.127
MEAN RADIUS	.698	.688	.529
MAX RADIUS	1.413	1.177	1.118
HORIZONTAL SPREAD	1.579	1.579	1.061
VERTICAL SPREAD	2.460	1.727	1.727
EXTREME SPREAD	2.553	2.065	1.742
NUMBER IN ONE INCH CIRCLE =		5	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

20070314

FILE:/PATTERNING/CENTERFIRE PATT/C6649110

CENTERFIRE PATTERNS # 5



* OF SHOTS - 10

INDEX

Figure 1

[illegible]
$$\begin{array}{c} \text{CH}_3 \\ | \\ \text{CH}_3 - \text{C} - \text{CH}_3 \\ | \\ \text{CH}_3 \end{array} + \begin{array}{c} \text{CH}_3 \\ | \\ \text{CH}_3 - \text{C} - \text{CH}_3 \\ | \\ \text{CH}_3 \end{array} \longrightarrow \begin{array}{c} \text{CH}_3 \\ | \\ \text{CH}_3 - \text{C} - \text{CH}_3 \\ | \\ \text{CH}_3 \end{array}$$

H **E** **L** **E** **B**

SECRET

DEBILITATED

PATTERN #	5	10	9	8
SHOTS (BEST OF)		10	9	8
MAXIMUM X	.691	.666	.420	
MINIMUM X	-.547	-.572	-.489	
MAXIMUM Y	1.889	1.511	.532	
MINIMUM Y	-1.179	-.978	-.781	
CENTROID X	-.000	.025	-.058	
CENTROID Y	.123	-.087	-.276	
POA TO CENTROID in.	.123	.091	.282	
MIN RADIUS	.063	.188	.328	
MEAN RADIUS	.764	.611	.495	
MAX RADIUS	1.904	1.652	.921	
HORIZONTAL SPREAD	1.238	1.238	.909	
VERTICAL SPREAD	3.069	2.481	1.313	
EXTREME SPREAD	3.085	2.773	1.496	
NUMBER IN ONE INCH CIRCLE	=	4		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	9		