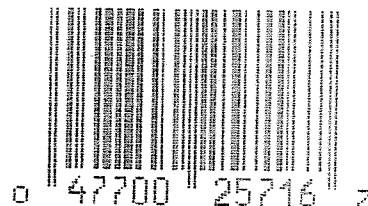


FORM

UPC



06649176

INVOICE TO 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.

C6649176

ORDER NO.

5716

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

28

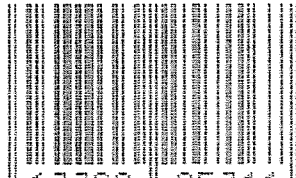


5716 C6649176

ORDER 5716

MODEL 700 TM M24

UPC

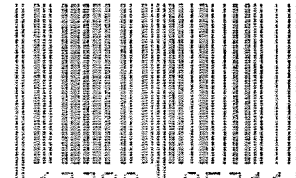


0 47700 25716 7

ORDER 5716

MODEL 700 TM M24

UPC



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6649176

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		9/24/91	KA
600	Proof		9/24/91	KA
607	Check Headspace		9/24/91	KA
610	Dis-assemble Gun		9/24/91	KA
612	Magnaflux Barrel Action		SEP 30 1991	KR
	Magnaflux Bolt		SEP 30 1991	KR
615	Rollmark Caliber		SEP 30 1991	JS
617	Drill and Tap Sight Holes		SEP 30 1991	FB
618	Polish Barrel		OCT 2 1991	WB
620	Apply Coatings (Barrel Action)		11/2/91	KA
	Apply Coating (Bolt)			KA
625	Final Assembly A) Clean inside of Bolt Assembly		10/8/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/8/91	KA
	C) Inspect Ejector Hole for Chamfer		10/8/91	KA
	D) Oil Firing Pin Ass'y		10/8/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		10/10/91	DH

op. #	BARBER - M24 0065709 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			10-10-91	AK
	G) Safety Off Force	4	4	3			10-10-91	AK
	H) Trigger Pull Test & Retainability						10-10-91	DH
	I) Firing Pin Indent	.022	.021	.020			10-10-91	AK
	J) Assemble Stock						10/14/91	AK
	K) Assemble Swivel Studs						10-11-91	AC
	L) Attach Front and Rear Sight Assemblies						10/14/91	AK
	M) Iron Sight Alignment						10/14/91	AK
	N) Detach Front & Rear Sights & place in numbered container						10/14/91	AK
	O) Attach Scope to Rifle						10/14/91	AK
	P) Detach & Attach Scope 20 Times						10/14/91	AK
640	Gallery Target & Test						10-15-91	AC
	A) Time						10-15-91	AC
	B) Malfunctions						10-15-91	AC
	C) Pierced Primers						10-15-91	AC
	D) Optical Clarity of Scope						10-15-91	AC
645	Inspect for Live Ammo						10-15-91	AC
655	Final Inspection							
	A) Headspace						10-11-91	AC
	B) Trigger Pull	2.53	2.56	2.56	2.48	2.54	10-15-91	DH
	C) Function						10-11-91	AK
660	Pack						12-11-91	VF

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

SERIAL NO. CC649176DATE 10-10-91TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.55	2.47	2.70	2.53	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.59	2.38	2.73	2.56	
PULL #3	2.65	2.46	2.68	2.56	
PULL #4	2.58	2.52	2.61	2.48	
PULL #5	2.50	2.44	2.71	2.54	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.35	3.17		
PULL #2	3.47	3.52		
PULL #3	3.47	3.56		
PULL #4	3.58	3.70		
PULL #5	3.12	3.70		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.63	4.61		4.14
PULL #2	4.48	4.73		4.50
PULL #3	4.73	4.63		4.47
PULL #4	4.48	4.75		4.44
PULL #5	4.62	4.68		4.45
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649176
15 Oct 1991

CENTROIDAL DISTANCES

0 TO	1	.101
1 TO	2	.432436
1 TO	3	.11625
1 TO	4	.248294
1 TO	5	.0910824

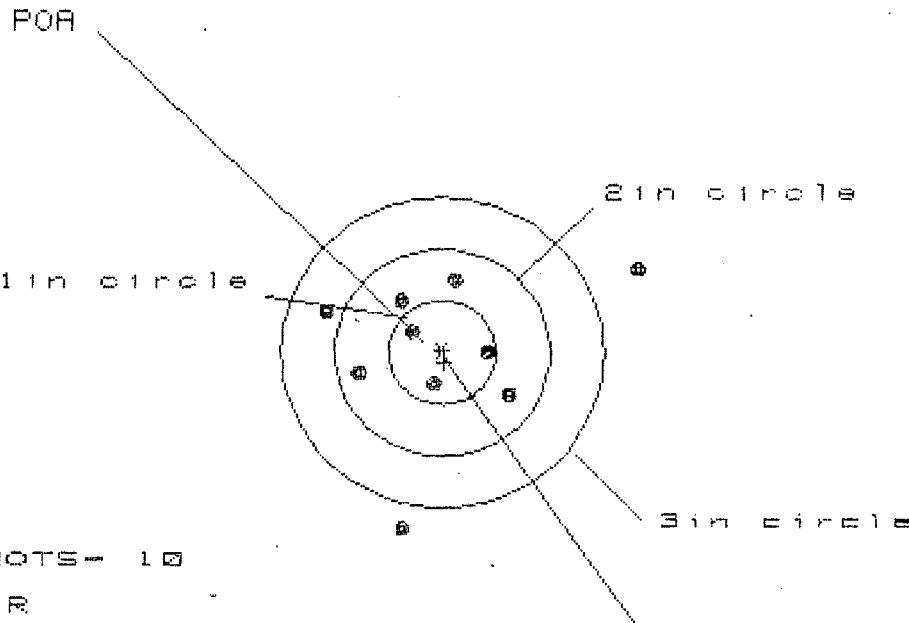
2nd <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .03
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0104
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0317515
THE AMR FOR THIS RIFLE IS: .0258

15 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649176

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 7

3 in = 8

HS = 2.851

VS = 2.494

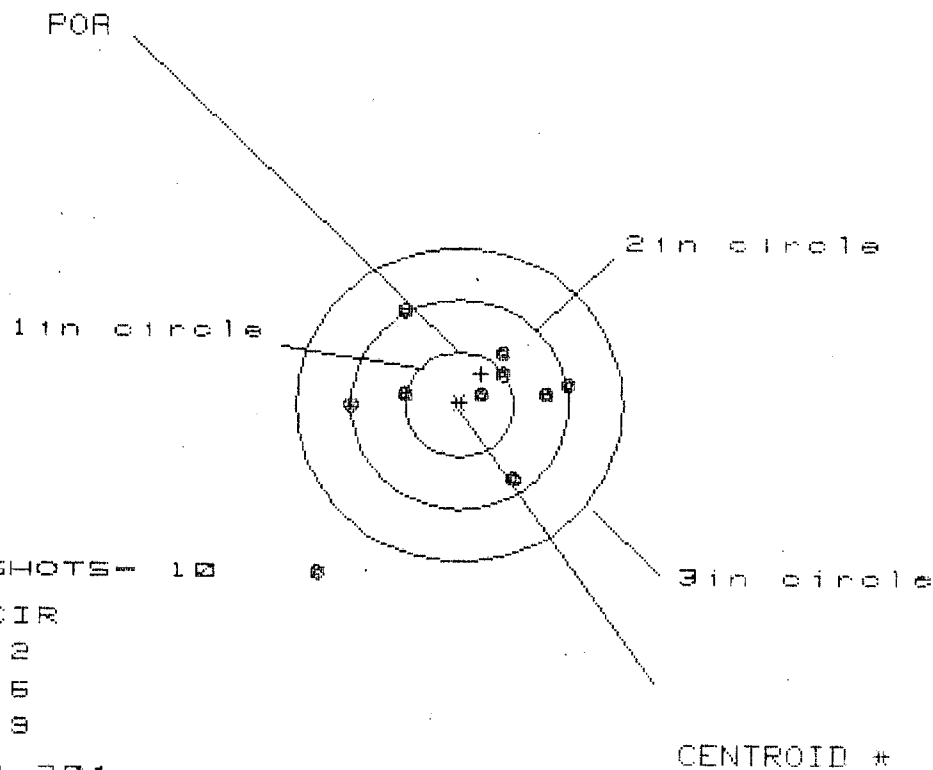
GS = 3.301

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.815	.775	.757
MINIMUM X	-1.036	-.835	-.853
MAXIMUM Y	.756	.798	.591
MINIMUM Y	-1.738	-1.654	-.510
CENTROID X	-.020	-.221	-.203
CENTROID Y	.099	.015	.222
POA TO CENTROID in.	.101	.222	.301
MIN RADIUS	.282	.193	.142
MEAN RADIUS	.875	.737	.588
MAX RADIUS	1.966	1.660	.913
HORIZONTAL SPREAD	2.851	1.610	1.610
VERTICAL SPREAD	2.494	2.452	1.101
EXTREME SPREAD	3.301	2.499	1.794
NUMBER IN ONE INCH CIRCLE =	3	2	
NUMBER IN TWO INCH CIRCLE =	7	7	
NUMBER IN THREE INCH CIRCLE =	8	8	

15 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649176

CENTERFIRE PATTERNS #. 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.304

VS= 2.545

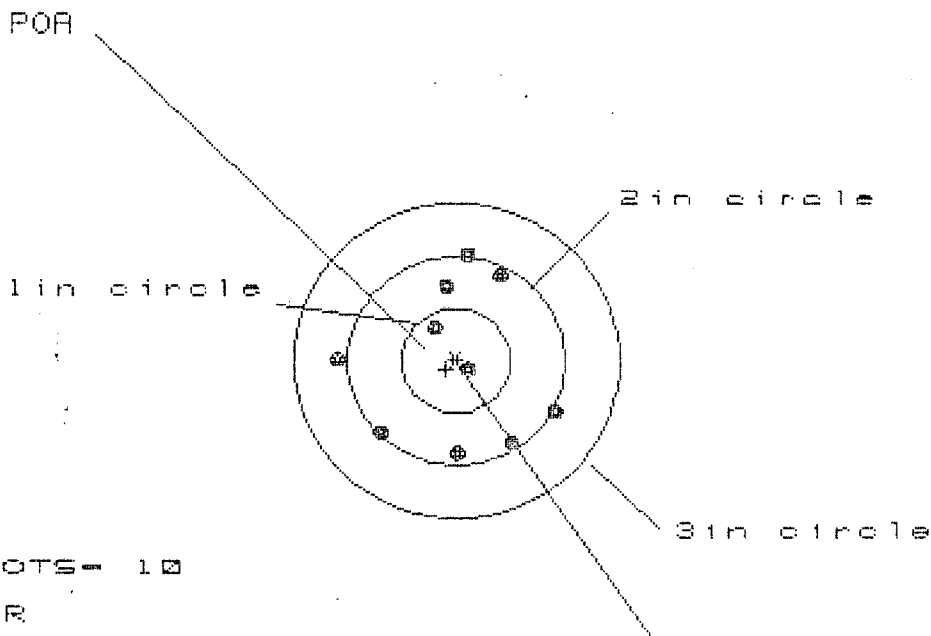
GS= 2.959

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.007	.863	.784
MINIMUM X	-1.297	-1.188	-1.267
MAXIMUM Y	.928	.748	.451
MINIMUM Y	-1.617	-.867	-.773
CENTROID X	-.196	-.052	.027
CENTROID Y	-.296	-.116	-.210
POA TO CENTROID in.	.355	.127	.211
MIN RADIUS	.271	.118	.038
MEAN RADIUS	.885	.686	.630
MAX RADIUS	2.073	1.205	1.272
HORIZONTAL SPREAD	2.304	2.051	2.051
VERTICAL SPREAD	2.545	1.615	1.224
EXTREME SPREAD	2.959	2.067	2.067
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

15 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649176

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 10

HS = 1.954

VS = 1.861

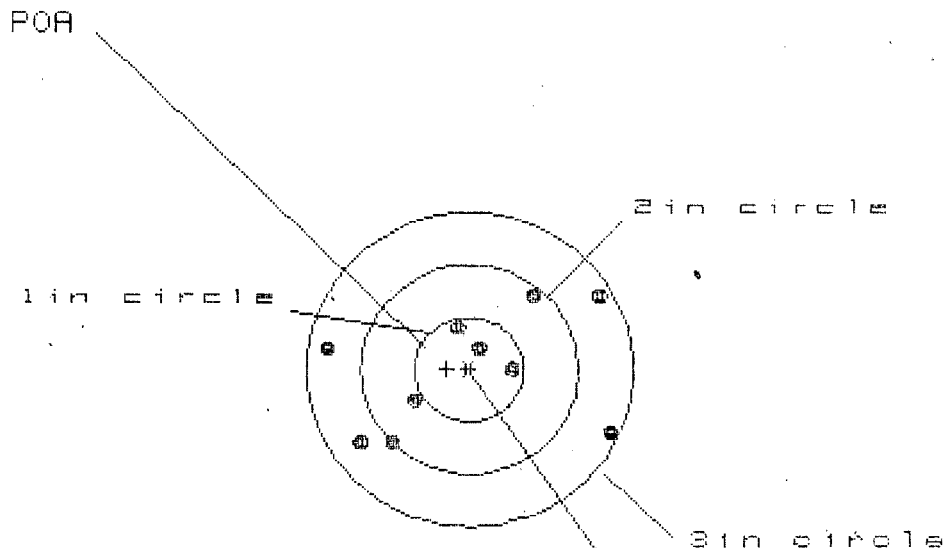
GS = 2.013

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.902	.785	.450
MINIMUM X	-1.052	-.849	-.750
MAXIMUM Y	1.015	1.012	.948
MINIMUM Y	-.846	-.849	-.913
CENTROID X	.095	.212	.113
CENTROID Y	.082	.085	.149
POA TO CENTROID in.	.125	.228	.187
MIN RADIUS	.197	.132	.234
MEAN RADIUS	.810	.773	.747
MAX RADIUS	1.052	1.085	1.054
HORIZONTAL SPREAD	1.954	1.634	1.200
VERTICAL SPREAD	1.861	1.861	1.861
EXTREME SPREAD	2.013	1.916	1.916
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

15 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C0649176

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 6

3 in = 10

HS = 2.633

VS = 1.448

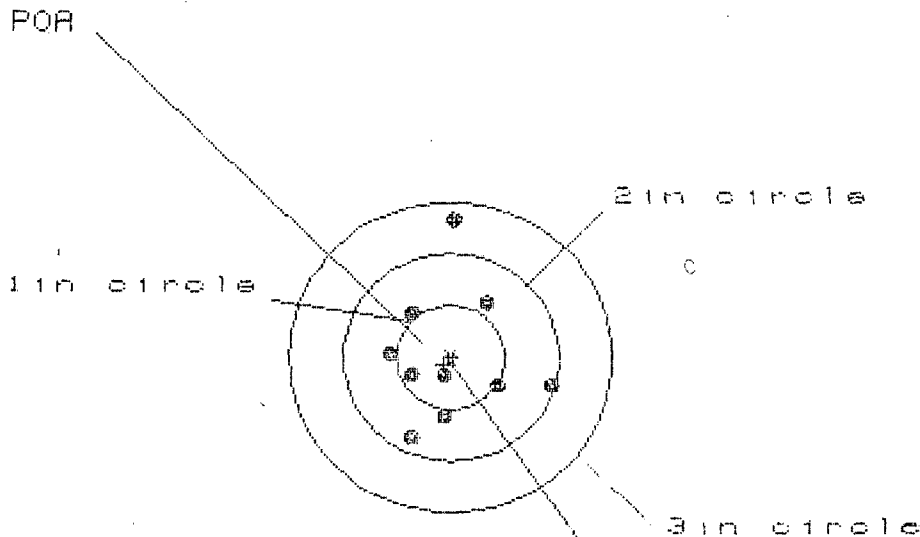
GS = 2.759

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.325	1.354	.960
MINIMUM X	-1.308	-1.161	-.992
MAXIMUM Y	.731	.666	.711
MINIMUM Y	-.717	-.782	-.699
CENTROID X	.205	.058	-.111
CENTROID Y	-.006	.059	-.024
POA TO CENTROID in.	.205	.083	.114
MIN RADIUS	.213	.246	.341
MEAN RADIUS	.890	.818	.731
MAX RADIUS	1.448	1.509	1.195
HORIZONTAL SPREAD	2.633	2.515	1.952
VERTICAL SPREAD	1.448	1.448	1.410
EXTREME SPREAD	2.759	2.607	2.126
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

15 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649176

CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1in = 3

2in = 8

3in = 10

HS = 1.503

VS = 2.108

GS = 2.153

CENTROID #

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.982	.986	.545
MINIMUM X	-.521	-.517	-.394
MAXIMUM Y	1.331	.698	.677
MINIMUM Y	-.777	-.630	-.651
CENTROID X	.066	.062	-.061
CENTROID Y	.069	-.078	-.057
POA TO CENTROID in.	.096	.100	.083
MIN RADIUS	.221	.078	.127
MEAN RADIUS	.669	.565	.495
MAX RADIUS	1.331	1.000	.821
HORIZONTAL SPREAD	1.503	1.503	.940
VERTICAL SPREAD	2.108	1.328	1.328
EXTREME SPREAD	2.153	1.541	1.521
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	