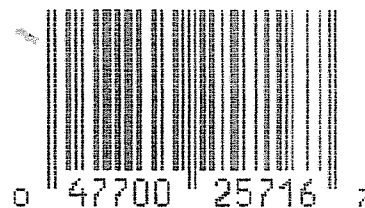


FORM

UPC



06649178

MODEL 700 TM M24

5216

ORDER NO.

BARREL LENGTH

CAPACITY*

*INCLUDES 4 IN CHAMBER

Remington



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

MODEL 700 TM M24

SERIAL NO.

C6649178

ORDER NO.

5716

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

20



5716 C6649178

ORDER 5716

MODEL 700 TM M24

UPC

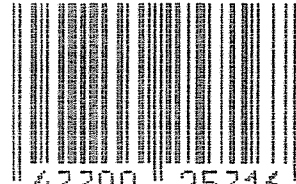
ORDER 5716

MODEL 700 TM M24

UPC



0 47700 25716 7



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649178

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10 1	91	RW
600	Proof	10 1	91	RW
607	Check Headspace	10 1	91	RW
610	Dis-assemble Gun	10 1	91	RW
612	Magnaflux Barrel Action		OCT 10 1991	Re
	Magnaflux Bolt		OCT 10 1991	Re
615	Rollmark Caliber		OCT 10 1991	GS
617	Drill and Tap Sight Holes		OCT 10 1991	LB
618	Polish Barrel		10/15/91	WB
620	Apply Coatings (Barrel Action)		11/8/91	HA
	Apply Coating (Bolt)		11/8/91	HA
625	Final Assembly A) Clean inside of Bolt Assembly		11/11/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/11/91	RW
	C) Inspect Ejector Hole for Chamfer		11/11/91	RW
	D) Oil Firing Pin Ass'y		11/14/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		12-6-91	RM

op. #	BARBER M24 0065733	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			12-6-91	JI
	G) Safety Off Force	3	3	3			12-6-91	JI
	H) Trigger Pull Test & Retainability						12-6-91	JI
	I) Firing Pin Indent	.023	.023	.022			12-6-91	JI
	J) Assemble Stock						12/7/91	RW
	K) Assemble Swivel Studs						12/7/91	RW
	L) Attach Front and Rear Sight Assemblies						12/7/91	RW
	M) Iron Sight Alignment						12/7/91	RW
	N) Detach Front & Rear Sights & place in numbered container						12/7/91	RW
	O) Attach Scope to Rifle						12/7/91	RW
	P) Detach & Attach Scope 20 Times						12/7/91	RW
640	Gallery Target & Test						12-9-91	JE
	A) Time						12-9-91	JE
	B) Malfunctions						12-9-91	JE
	C) Pierced Primers						12-9-91	JE
	D) Optical Clarity of Scope						12-9-91	JE
645	Inspect for Live Ammo						12-9-91	JE
655	Final Inspection						12-13-91	JI
	A) Headspace						12-10-91	JI
	B) Trigger Pull	2.15	2.60	2.48	2.59	2.42	12-13-91	JI
	C) Function						12-13-91	JI
660	Pack						12-17-91	JE

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

SERIAL NO. 06649178
DATE 12-6-91
TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.26	2.33	2.75	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.43	2.41	2.60	
PULL #3	2.34	2.29	2.28	2.48	
PULL #4	2.34	2.39	2.34	2.59	
PULL #5	2.45	2.40	2.30	2.62	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.48	3.36		
PULL #2	3.44	3.49		
PULL #3	3.36	3.55		
PULL #4	3.51	3.51		
PULL #5	3.55	3.55		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.47	4.48		4.48
PULL #2	4.33	4.57		4.48
PULL #3	4.50	4.66		4.20
PULL #4	4.50	4.49		4.42
PULL #5	4.57	4.50		4.53
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06649178
9 Dec 1991

CENTROIDAL DISTANCES

0 TO	1	.238918
1 TO	2	.269453
1 TO	3	.285848
1 TO	4	.483741
1 TO	5	.22211

⊙ <----POA

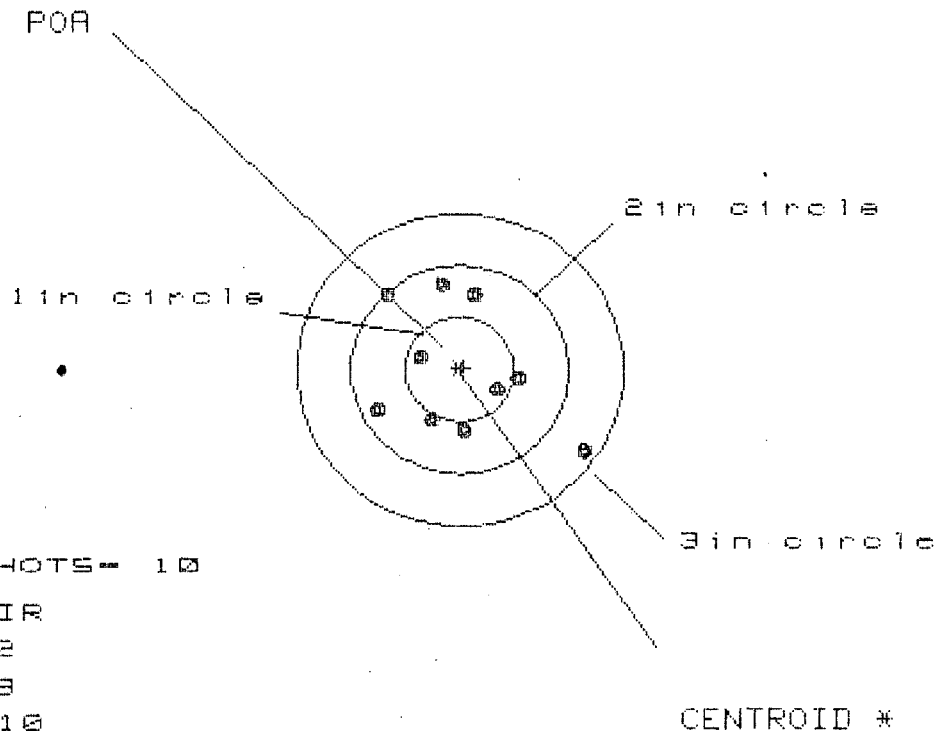
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0474
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.015
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0497168

THE AMR FOR THIS RIFLE IS: .8996

9 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649178

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 8

3in = 10

HS= 1.916

VS= 1.595

GS= 2.399

PATTERN #

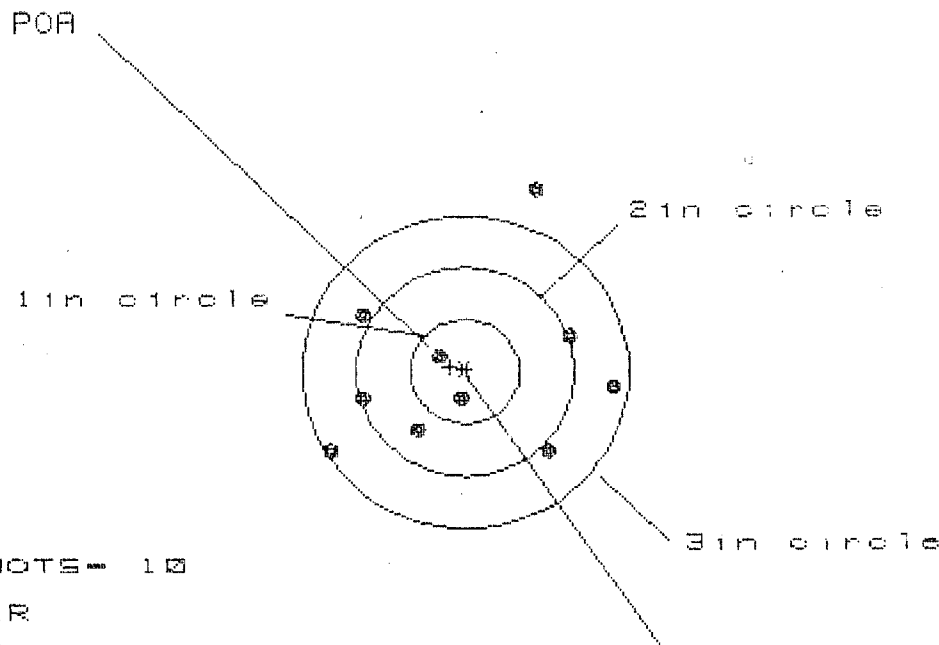
2

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.174	.662	.592
MINIMUM X	-.742	-.611	-.681
MAXIMUM Y	.810	.723	.803
MINIMUM Y	-.785	-.650	-.570
CENTROID X	-.037	-.168	-.098
CENTROID Y	-.020	.067	-.013
POA TO CENTROID in.	.042	.181	.099
MIN RADIUS	.342	.203	.289
MEAN RADIUS	.712	.626	.587
MAX RADIUS	1.412	.849	.817
HORIZONTAL SPREAD	1.916	1.273	1.273
VERTICAL SPREAD	1.595	1.373	1.373
EXTREME SPREAD	2.399	1.501	1.403
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	

9 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649178

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 9

HS= 2.626

VS= 2.489

GS= 3.153

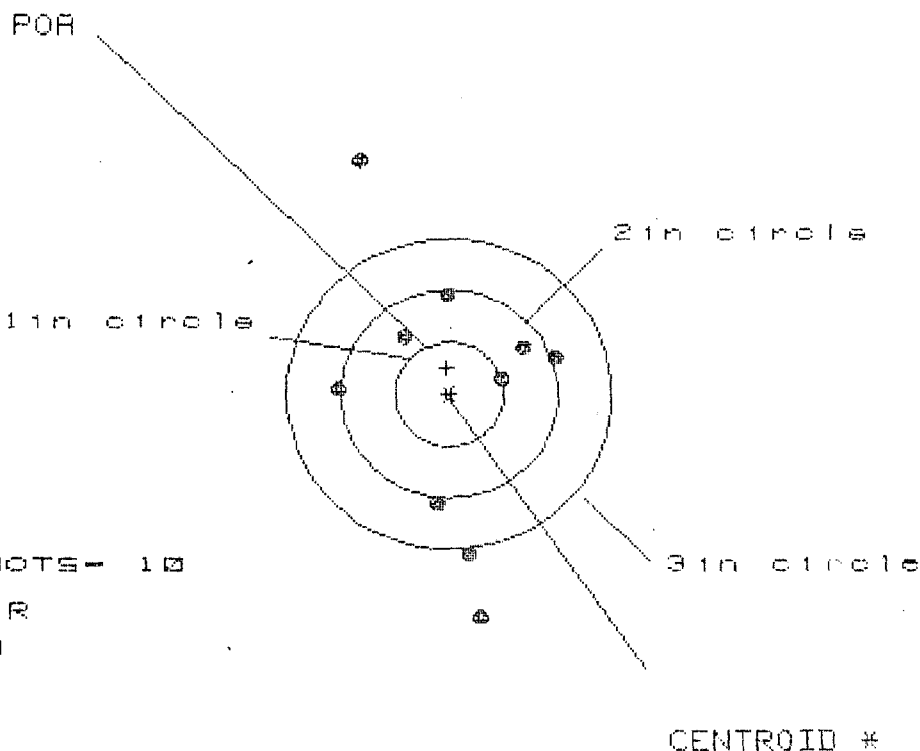
CENTROID *

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.382	1.459	1.313
MINIMUM X	-1.244	-1.167	-1.030
MAXIMUM Y	1.708	.684	.610
MINIMUM Y	-.781	-.592	-.606
CENTROID X	.139	.062	.208
CENTROID Y	-.044	-.233	-.159
POA TO CENTROID in.	.145	.241	.262
MIN RADIUS	.245	.067	.164
MEAN RADIUS	.999	.867	.828
MAX RADIUS	1.843	1.459	1.316
HORIZONTAL SPREAD	2.626	2.626	2.343
VERTICAL SPREAD	2.489	1.276	1.216
EXTREME SPREAD	3.153	2.690	2.408
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	9		

9 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649178

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 7

HS= 2.017

VS= 4.348

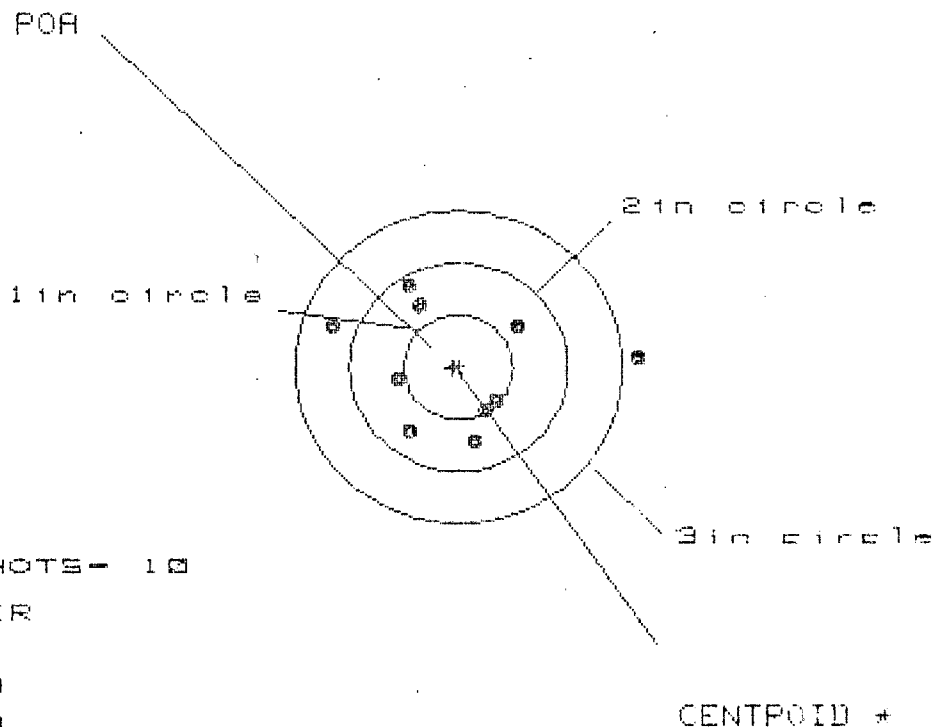
GS= 4.488

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.969	.873	.897
MINIMUM X	-1.048	-1.144	-1.120
MAXIMUM Y	2.211	1.169	.933
MINIMUM Y	-2.137	-1.891	-1.561
CENTROID X	.020	.116	.092
CENTROID Y	-.251	-.497	-.261
POA TO CENTROID in.	.252	.510	.276
MIN RADIUS	.512	.568	.449
MEAN RADIUS	1.215	1.096	.946
MAX RADIUS	2.373	1.901	1.562
HORIZONTAL SPREAD	2.017	2.017	2.017
VERTICAL SPREAD	4.348	3.060	2.494
EXTREME SPREAD	4.488	3.081	2.502
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

9 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649178

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 8

3 in = 9

HS= 2.8008

VS= 1.482

GS= 2.820

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.683	.688	.571
MINIMUM X	:	-1.125	-.938	-.484
MAXIMUM Y	:	.784	.796	.844
MINIMUM Y	:	-.698	-.686	-.638
CENTROID X	:	.054	-.133	-.016
CENTROID Y	:	.009	-.003	-.051
POA TO CENTROID in.	:	.055	.133	.053
MIN RADIUS	:	.407	.395	.428
MEAN RADIUS	:	.796	.684	.628
MAX RADIUS	:	1.686	1.014	.917
HORIZONTAL SPREAD	:	2.808	1.626	1.055
VERTICAL SPREAD	:	1.482	1.482	1.482
EXTREME SPREAD	:	2.820	1.645	1.582
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	