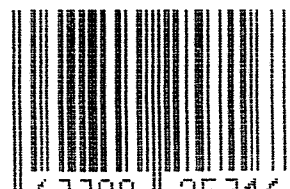


FURN

UPC



0 47700 25716 7

06665674

*INCLUDES 1 IN 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 700TM M24**SERIAL NO.**

C6665674

ORDER NO.**5716**

20

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



5716 C6665674

ORDER 5716MODEL 700TM M24**UPC**

0 47700 25716 7

ORDER 5716MODEL 700TM M24**UPC**

0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6665674

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 26	91	AW
600	Proof	9 26	91	AW
607	Check Headspace	9 26	91	AW
610	Dis-assemble Gun	9 26	91	AW
612	Magnaflux Barrel Action		SEP 30 1991	KR
	Magnaflux Bolt		SEP 30 1991	KR
615	Rollmark Caliber		SEP 30 1991	SB
617	Drill and Tap Sight Holes		SEP 30 1991	FB
618	Polish Barrel		OCT 2 1991	WT
620	Apply Coatings (Barrel Action)		10-13-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10-14-91	JA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10-14-91	JA
	C) Inspect Ejector Hole for Chamfer		10-14-91	JA
	D) Oil Firing Pin Ass'y		10-14-91	JA
	E) Adjust Trigger Pull to Min Setting and Stake		10-14-91	JA

op. #	BARBER - M24 0101192	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	4	5			10-14-91	Ac
	G) Safety Off Force	4	3	4			10-14-91	Ac
	H) Trigger Pull Test & Retainability						10/14/91	RF
	I) Firing Pin Indent	.020	.020	.021			10-14-91	Ac
	J) Assemble Stock						10/15/91	Rev
	K) Assemble Swivel Studs						10-18-91	Ac
	L) Attach Front and Rear Sight Assemblies						10/15/91	Rev
	M) Iron Sight Alignment						10/15/91	Rev
	N) Detach Front & Rear Sights & place in numbered container						10/15/91	Rev
	O) Attach Scope to Rifle						10/15/91	Rev
	P) Detach & Attach Scope 20 Times						10/15/91	Rev
640	Gallery Target & Test						10-16-91	DH
	A) Time						10-16-91	DH
	B) Malfunctions						10-16-91	DH
	C) Pierced Primers						10-16-91	DH
	D) Optical Clarity of Scope						10-16-91	DH
645	Inspect for Live Ammo						10-16-91	DH
655	Final Inspection							
	A) Headspace						10-18-91	Ac
	B) Trigger Pull	262	270	264	276	274	10-17-91	DH
	C) Function						10-18-91	Ac
660	Pack						12-20-91	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6665674

DATE 10-14-91

TESTER JJ

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.32	2.49	2.40	2.62	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.55	2.29	2.44	2.70	
PULL #3	2.54	2.27	2.38	2.64	
PULL #4	2.59	2.42	2.38	2.76	
PULL #5	2.65	2.32	2.44	2.74	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.49	3.37		
PULL #2	3.44	3.44		
PULL #3	3.43	3.34		
PULL #4	3.41	3.41		
PULL #5	3.28	3.32		
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	4.21		4.30
PULL #2	4.28	4.23		4.42
PULL #3	4.32	4.31		4.31
PULL #4	4.25	4.39		4.26
PULL #5	4.26	4.36		4.32
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665674
16 Oct 1991

CENTROIDAL DISTANCES

0 TO	1	.17427
1 TO	2	.43915
1 TO	3	.330048
1 TO	4	.403149
1 TO	5	.142562

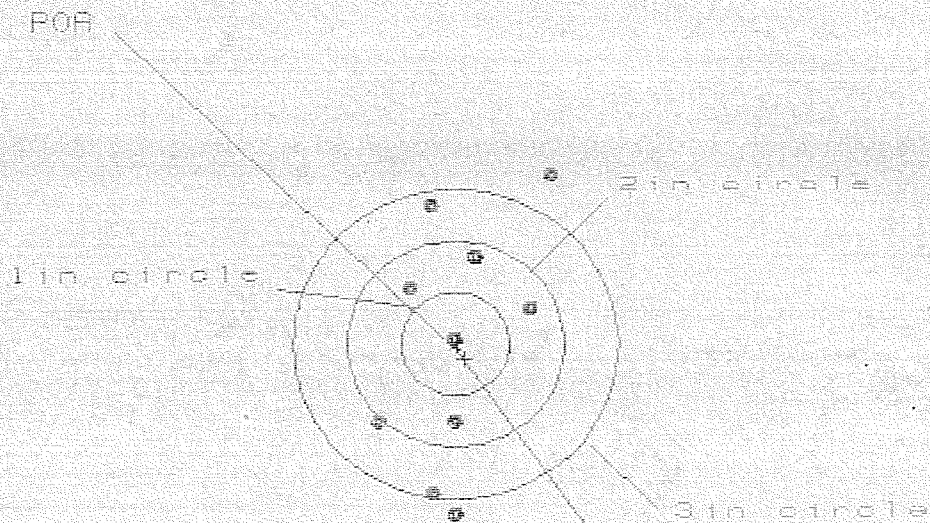
42
34 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2564
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2048
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .328152
THE AMR FOR THIS RIFLE IS: .9494

18 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8865674

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS = 1.557

VS = 3.285

GS = 3.405

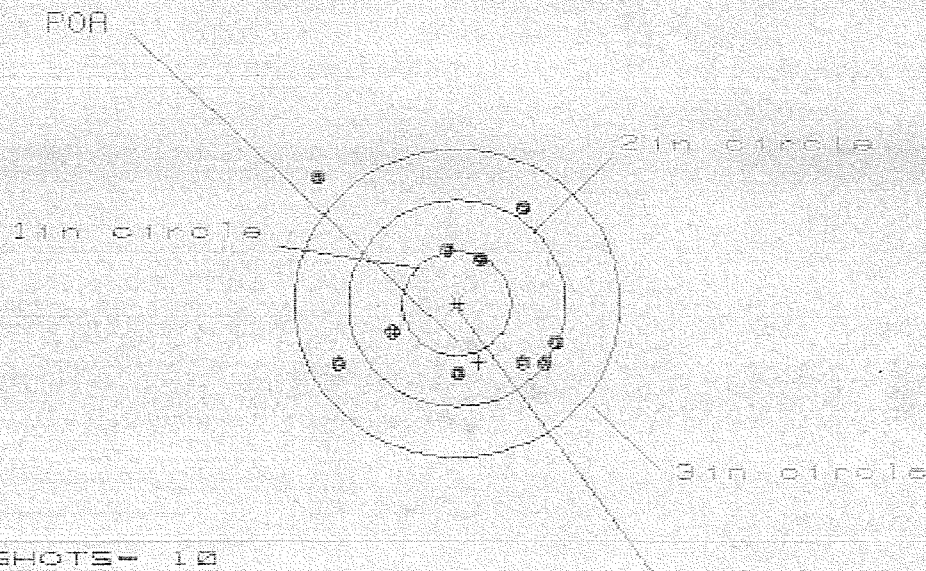
CENTROID #

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.840	.741	.745
MINIMUM X	-.717	-.623	-.619
MAXIMUM Y	1.643	1.509	1.327
MINIMUM Y	-1.642	-1.460	-1.479
CENTROID X	-.087	-.181	-.185
CENTROID Y	.151	-.031	.151
POA TO CENTROID in.	.175	.183	.239
MIN RADIUS	.054	.254	.111
MEAN RADIUS	1.042	.963	.869
MAX RADIUS	1.845	1.514	1.482
HORIZONTAL SPREAD	1.557	1.364	1.364
VERTICAL SPREAD	3.285	2.969	2.886
EXTREME SPREAD	3.405	2.973	2.886
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

16 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06665674

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 2.174

VS= 1.864

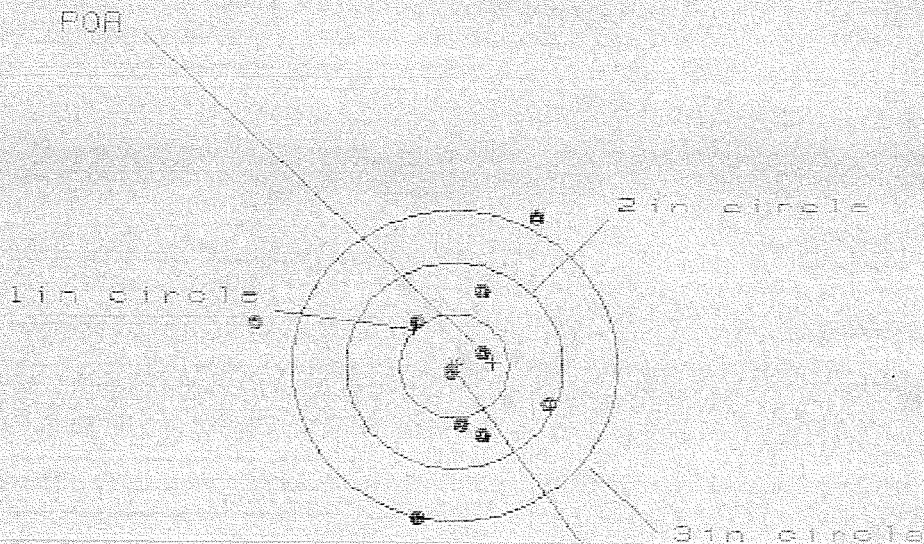
GS= 2.780

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.873	.729	.570
MINIMUM X	-1.301	-1.266	-.893
MAXIMUM Y	1.187	1.083	1.030
MINIMUM Y	-.677	-.545	-.598
CENTROID X	-.205	-.061	.098
CENTROID Y	.574	.442	.495
POA TO CENTROID in.	.610	.446	.504
MIN RADIUS	.483	.553	.498
MEAN RADIUS	.933	.818	.737
MAX RADIUS	1.761	1.334	1.072
HORIZONTAL SPREAD	2.174	1.995	1.463
VERTICAL SPREAD	1.864	1.628	1.628
EXTREME SPREAD	2.780	2.286	1.741
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

16 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06665074

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 8

HS= 2.681

VS= 2.872

GS= 3.082

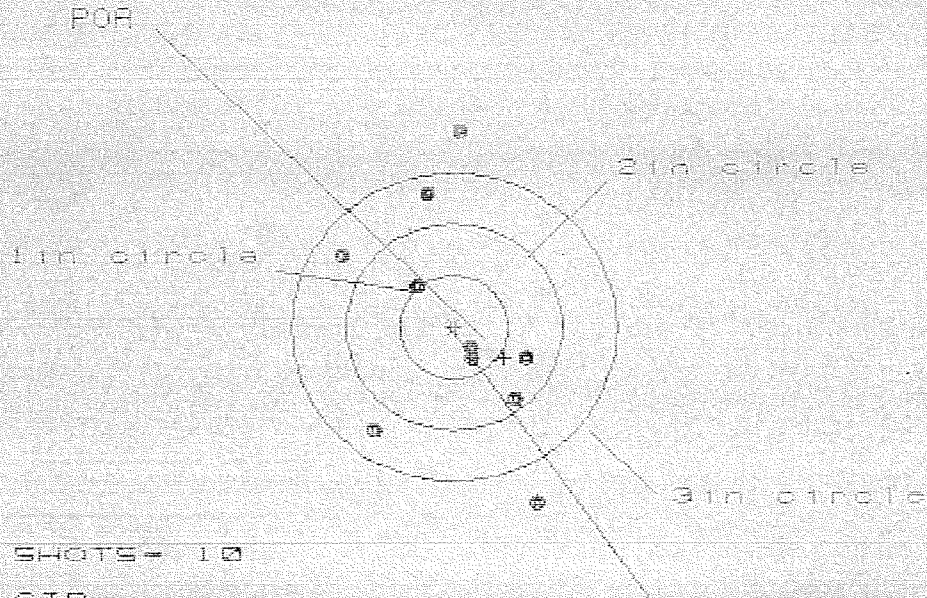
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.862	.660	.735
MINIMUM X	:	-1.819	-.516	-.441
MAXIMUM Y	:	1.449	1.495	.916
MINIMUM Y	:	-1.423	-1.377	-1.190
CENTROID X	:	-.361	-.159	-.234
CENTROID Y	:	-.033	-.079	-.266
POA TO CENTROID in.	:	.362	.177	.354
MIN RADIUS	:	.106	.156	.222
MEAN RADIUS	:	.888	.763	.647
MAX RADIUS	:	1.866	1.612	1.269
HORIZONTAL SPREAD	:	2.681	1.176	1.176
VERTICAL SPREAD	:	2.872	2.872	2.106
EXTREME SPREAD	:	3.082	3.082	2.171
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

18 Oct 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 1.829

VS= 3.579

GS= 3.648

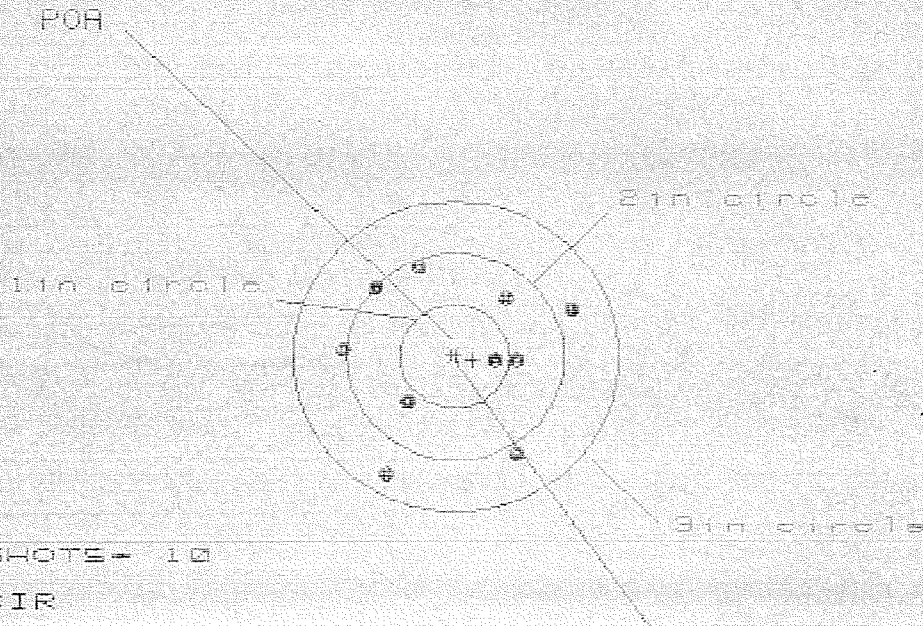
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.772	.760	.779
MINIMUM X	:	-1.057	-.971	-.952
MAXIMUM Y	:	1.851	1.659	1.283
MINIMUM Y	:	-1.728	-1.159	-.951
CENTROID X	:	-.462	-.548	-.567
CENTROID Y	:	.299	.491	.283
POA TO CENTROID in.	:	.550	.735	.634
MIN RADIUS	:	.252	.319	.311
MEAN RADIUS	:	1.015	.935	.808
MAX RADIUS	:	1.892	1.666	1.290
HORIZONTAL SPREAD	:	1.829	1.731	1.731
VERTICAL SPREAD	:	3.579	2.818	2.234
EXTREME SPREAD	:	3.648	2.918	2.278
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			8	

18 Oct 1991

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CENTERFIRE PATTERNS # 5



PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.080	1.006	.656
MINIMUM X	:	-.987	-1.061	-.936
MAXIMUM Y	:	.869	.748	.792
MINIMUM Y	:	-1.084	-1.086	-1.042
CENTROID X	:	-.167	-.093	-.218
CENTROID Y	:	.033	.154	.119
POA TO CENTROID in.	:	.170	.179	.245
MIN RADIUS	:	.347	.321	.416
MEAN RADIUS	:	.869	.807	.779
MAX RADIUS	:	1.275	1.208	1.232
HORIZONTAL SPREAD	:	2.067	2.067	1.592
VERTICAL SPREAD	:	1.953	1.834	1.834
EXTREME SPREAD	:	2.338	2.110	2.074
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	10		