

FORN

UPC



0 47700 25716 2

06665676

*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.**

C6665676

20

ORDER NO.**5716**

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



5716 C6665676

ORDER 5716MODEL 700TM M24**UPC**

0 47700 25716 7

ORDER 5716MODEL 700TM M24**UPC**

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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6665676

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/1/91	KH
600	Proof		10/1/91	KH
607	Check Headspace		10/1/91	KH
610	Dis-assemble Gun		10/1/91	KH
612	Magnaflux Barrel Action	OCT	8 1991	KR
	Magnaflux Bolt	OCT	8 1991	KR
615	Rollmark Caliber	OCT	8 1991	LG
617	Drill and Tap Sight Holes	OCT	8 1991	FB
618	Polish Barrel		10/14/91	WB
620	Apply Coatings (Barrel Action)		11-1-91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/5/91	KH
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/5/91	KH
	C) Inspect Ejector Hole for Chamfer		11/5/91	KH
	D) Oil Firing Pin Ass'y		11/5/91	KH
	E) Adjust Trigger Pull to Min Setting and Stake		11-6-91	TH

op. #	BARBER M24 0101216 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			11-6-91	SM
	G) Safety Off Force	3	3	3			11-6-91	SM
	H) Trigger Pull Test & Retainability						11-6-91	SM
	I) Firing Pin Indent	1021	.021	.0215			11-6-91	SM
	J) Assemble Stock						11/6/91	KA
	K) Assemble Swivel Studs						11-19-91	DH
	L) Attach Front and Rear Sight Assemblies						11/6/91	KA
	M) Iron Sight Alignment						11/6/91	KA
	N) Detach Front & Rear Sights & place in numbered container						11/6/91	KA
	O) Attach Scope to Rifle						11/6/91	KA
	P) Detach & Attach Scope 20 Times						11/6/91	KA
640	Gallery Target & Test						11/13/91	KT
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	KT
645	Inspect for Live Ammo						11/13/91	KT
655	Final Inspection							
	A) Headspace						11-19-91	DH
	B) Trigger Pull	2.42	2.47	2.47	2.47	2.51	11-18-91	DH
	C) Function						11-18-91	DH
660	Pack						12-19-91	VF

SWS TRIGGER PULL TEST

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

SERIAL NO C-6665676
DATE 11-6-91
TESTER JM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.59	2.24	2.48	2.42	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.25	2.45	2.50	2.47	
PULL #3	2.24	2.43	2.53	2.47	
PULL #4	2.26	2.37	2.49	2.47	
PULL #5	2.36	2.40	2.38	2.51	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.25	3.35		
PULL #2	3.51	3.37		
PULL #3	3.43	3.41		
PULL #4	3.38	3.36		
PULL #5	3.40	3.40		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.27	4.57		4.57
PULL #2	4.24	4.59		4.59
PULL #3	4.20	4.56		4.54
PULL #4	4.55	4.54		4.59
PULL #5	4.54	4.58		4.56
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665676
13 Nov 1991

CENTROIDAL DISTANCES

0 TO	1	.118966
1 TO	2	.258234
1 TO	3	.368438
1 TO	4	.0761577
1 TO	5	.131883

$\frac{5}{2}$ (----) POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0412
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0088
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0421293
THE AMR FOR THIS RIFLE IS: .9136

13 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/ C6865676

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 10

HS= 2.473

VS= 2.392

GS= 2.550

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.264	1.267	1.155
MINIMUM X	:	-1.209	-1.206	-1.047
MAXIMUM Y	:	.975	.817	.740
MINIMUM Y	:	-1.417	-1.070	-1.147
CENTROID X	:	.052	.049	-.110
CENTROID Y	:	.107	.265	.342
POA TO CENTROID in.	:	.119	.269	.359
MIN RADIUS	:	.171	.103	.223
MEAN RADIUS	:	.942	.844	.773
MAX RADIUS	:	1.417	1.410	1.251
HORIZONTAL SPREAD	:	2.473	2.473	2.202
VERTICAL SPREAD	:	2.392	1.887	1.887
EXTREME SPREAD	:	2.550	2.550	2.227
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

13 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/ 06665678

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 4

2in = 9

3in = 10

HS = 1.672

VS = 1.308

GS = 2.021

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.984	.635	.563
MINIMUM X	:	-.688	-.578	-.554
MAXIMUM Y	:	.633	.701	.788
MINIMUM Y	:	-.675	-.607	-.520
CENTROID X	:	.198	.088	.160
CENTROID Y	:	-.106	-.174	-.261
POA TO CENTROID in.	:	.224	.195	.306
MIN RADIUS	:	.243	.294	.308
MEAN RADIUS	:	.663	.606	.560
MAX RADIUS	:	1.161	.903	.841
HORIZONTAL SPREAD	:	1.672	1.213	1.117
VERTICAL SPREAD	:	1.308	1.308	1.308
EXTREME SPREAD	:	2.021	1.603	1.548
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

13 Nov 1991

FILE://PATTERNING/CENTERFIRE_PATT/C6865676

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 7

HS= 3.098

VS= 2.623

GS= 3.578

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.750	1.638	1.748
MINIMUM X	:	-1.348	-1.153	-1.043
MAXIMUM Y	:	1.514	1.617	1.050
MINIMUM Y	:	-1.109	-1.006	-.804
CENTROID X	:	-.005	-.200	-.310
CENTROID Y	:	-.257	-.360	-.563
POA TO CENTROID in.	:	.257	.412	.642
MIN RADIUS	:	.312	.197	.103
MEAN RADIUS	:	1.163	1.011	.870
MAX RADIUS	:	1.982	1.844	1.749
HORIZONTAL SPREAD	:	3.098	2.791	2.791
VERTICAL SPREAD	:	2.623	2.623	1.854
EXTREME SPREAD	:	3.578	3.129	2.854
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

13 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/ C68B5676

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 4

2in = 7

3in = 10

HS= 1.476

VS= 2.092

GS= 2.490

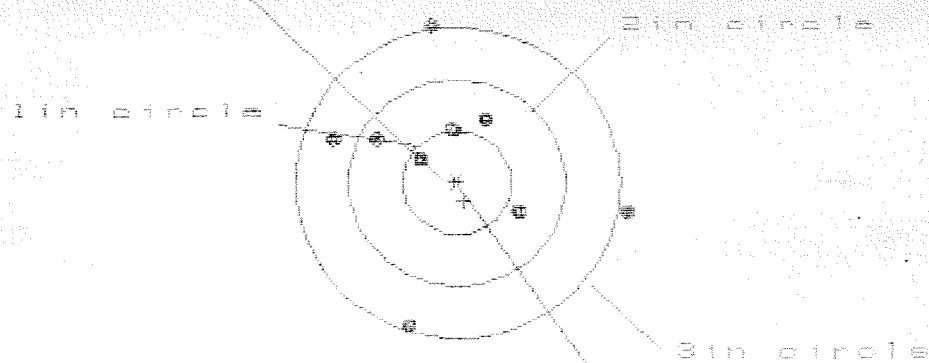
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.750	.670	.752
MINIMUM X	:	-.726	-.613	-.531
MAXIMUM Y	:	1.080	.796	.694
MINIMUM Y	:	-1.012	-.892	-.994
CENTROID X	:	.022	.102	.020
CENTROID Y	:	.037	-.083	.019
POA TO CENTROID in.	:	.043	.132	.028
MIN RADIUS	:	.194	.099	.196
MEAN RADIUS	:	.718	.645	.587
MAX RADIUS	:	1.301	1.047	1.032
HORIZONTAL SPREAD	:	1.476	1.283	1.283
VERTICAL SPREAD	:	2.092	1.688	1.688
EXTREME SPREAD	:	2.490	1.965	1.737
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

13 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/ C86B5876

CENTERFIRE PATTERNS # 5

POA



OF SHOTS = 10

IN CIRCLE

1 in = 1

2 in = 5

3 in = 7

HS = 3.590

VS = 3.465

GS = 3.534

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.556	1.606	1.581
MINIMUM X	:	-1.134	-1.084	-1.110
MAXIMUM Y	:	1.573	1.363	.602
MINIMUM Y	:	-1.892	-1.568	-1.398
CENTROID X	:	-.061	-.111	-.085
CENTROID Y	:	.175	.385	.215
POA TO CENTROID in.	:	.185	.401	.231
MIN RADIUS	:	.408	.279	.365
MEAN RADIUS	:	1.082	.929	.899
MAX RADIUS	:	1.943	1.675	1.610
HORIZONTAL SPREAD	:	2.690	2.690	2.690
VERTICAL SPREAD	:	3.465	2.931	2.000
EXTREME SPREAD	:	3.534	2.935	2.768
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	