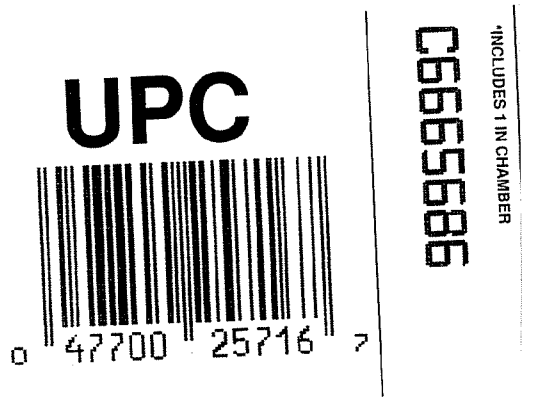

UPC
0 47700 25716 7
C6665686
*INCLUDES 1 IN CHAMBER


ORDER NO. 5716
BARREL LENGTH
CAPACITY*
MODEL 700 TM M24

Remington® DUPONT REG. U.S. PAT. & TM. OFF.

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

MODEL 700 TM M24

SERIAL NO. C6665686

20

ORDER NO. 5716

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

5716 C6665686

ORDER 5716
MODEL 700 TM M24

UPC

0 47700 25716 7

ORDER 5716
MODEL 700 TM M24

UPC

0 47700 25716 7

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF	Test OK	
TEST 11-26-91	DH	
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

MOD. _____ GA. _____ CAL. _____ GUN # 5686

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
KT	1st	Sham brass Ejecter stuck	RW
	2nd 11/12/91	Polished face of bolt & reamed ejector hole	IES
	3rd 11/26/91	Bolt sticks	RW
	4th	Bolt won't open ~~when~~ after 5th shot. 11/26/91	WB

FUNCTION [illegible] RD 6654 Rev 1

M-24

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6665686

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 26	9 1	RW
600	Proof	9 26	9 1	RW
607	Check Headspace	9 26	9 1	RW
610	Dis-assemble Gun	9 26	9 1	RW
612	Magnaflux Barrel Action	SEP	3 0 1991	KR
	Magnaflux Bolt	SEP	3 0 1991	KR
615	Rollmark Caliber	SEP	3 0 1991	DS
617	Drill and Tap Sight Holes	SEP	3 0 1991	KB
618	Polish Barrel	OCT	2 1991	CW
620	Apply Coatings (Barrel Action)		10-13-91	DH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/13/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/13/91	RW
	C) Inspect Ejector Hole for Chamfer		10/13/91	RW
	D) Oil Firing Pin Ass'y		10/13/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/15/91	JH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			10/16/91	
	G) Safety Off Force	3	3	3			10/16/91	
	H) Trigger Pull Test & Retainability						10/15/91	
	I) Firing Pin Indent	.022	.0225	.0225			10/16/91	
	J) Assemble Stock						10/16/91	RW
	K) Assemble Swivel Studs						10-18-91	AC
	L) Attach Front and Rear Sight Assemblies						10/16/91	RW
	M) Iron Sight Alignment						10/16/91	RW
	N) Detach Front & Rear Sights & place in numbered container						10/16/91	RW
	O) Attach Scope to Rifle						10/16/91	RW
	P) Detach & Attach Scope 20 Times						10/16/91	RW
640	Gallery Target & Test						10-17-91	DH
	A) Time						10-17-91	DH
	B) Malfunctions						10-17-91	DH
	C) Pierced Primers						10-17-91	DH
	D) Optical Clearity of Scope						10-17-91	DH
645	Inspect for Live Ammo						10-17-91	DH
655	Final Inspection A) Headspace						10-18-91	AC
	B) Trigger Pull	235	226	220	220	219	10-18-91	DH
	C) Function						10-18-91	AC
660	Pack						12-19-91	NF

SWS TRIGGER PULL TEST

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

SERIAL NO. C-66665686

DATE 10-15-91

TESTER [illegible]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.35	2.30	2.39	235	MIN. SETTING,
PULL #2	2.32	2.28	2.24	226	NO AVG. OF 5
PULL #3	2.30	2.23	2.31	220	READINGS ACCEPT-
PULL #4	2.19	2.20	2.44	220	ABLE LESS THAN 2#
PULL #5	2.23	2.35	2.44	219	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.62	3.60		
PULL #2	3.64	3.41		
PULL #3	3.60	3.40		
PULL #4	3.60	3.29		
PULL #5	3.31	3.41		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.49	4.46		4.39
PULL #2	4.15	4.49		4.46
PULL #3	4.41	4.45		4.39
PULL #4	4.49	4.48		4.30
PULL #5	4.41	4.46		4.49
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665686
18 Oct 1991

CENTROIDAL DISTANCES

0	TO	1	.0534509
1	TO	2	.04880104
1	TO	3	.10171
1	TO	4	.177882
1	TO	5	.318628

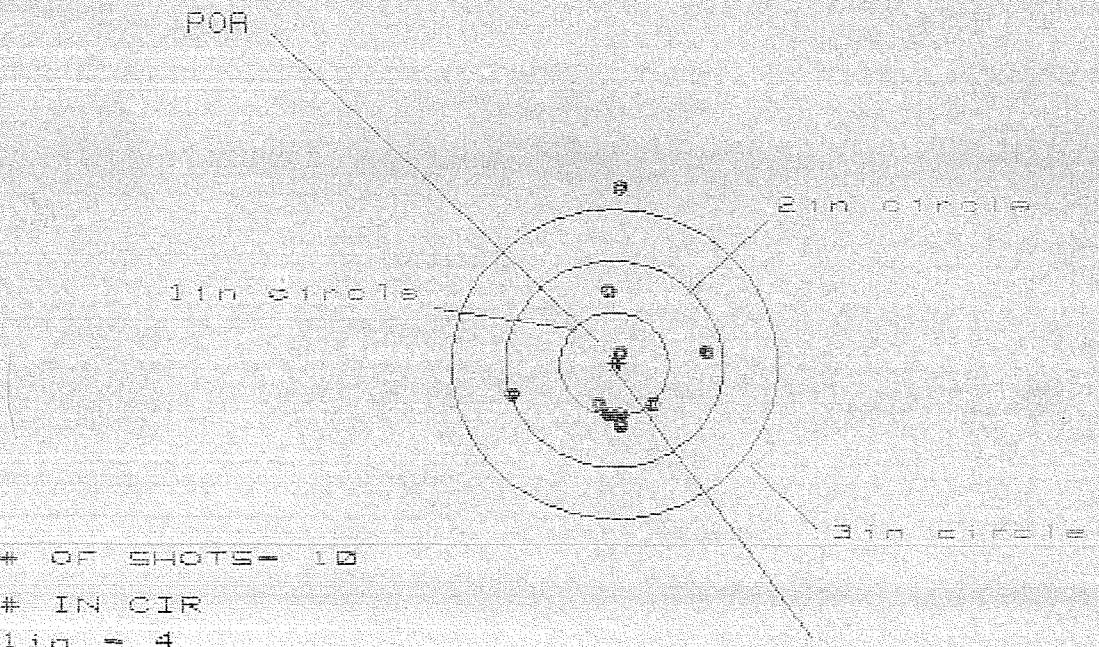
#5 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0482
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.036
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0601601

THE AMR FOR THIS RIFLE IS: .852

LB Oct 1991 FILE:/PATTERNING/CENTERFIRE_PATT/C08656B8

CENTERFIRE PATTERNS # 1



# OF SHOTS= 10
# IN CIR
1in = 4
2in = 8
3in = 9
HS= 1.773
VS= 2.353
GS= 2.353

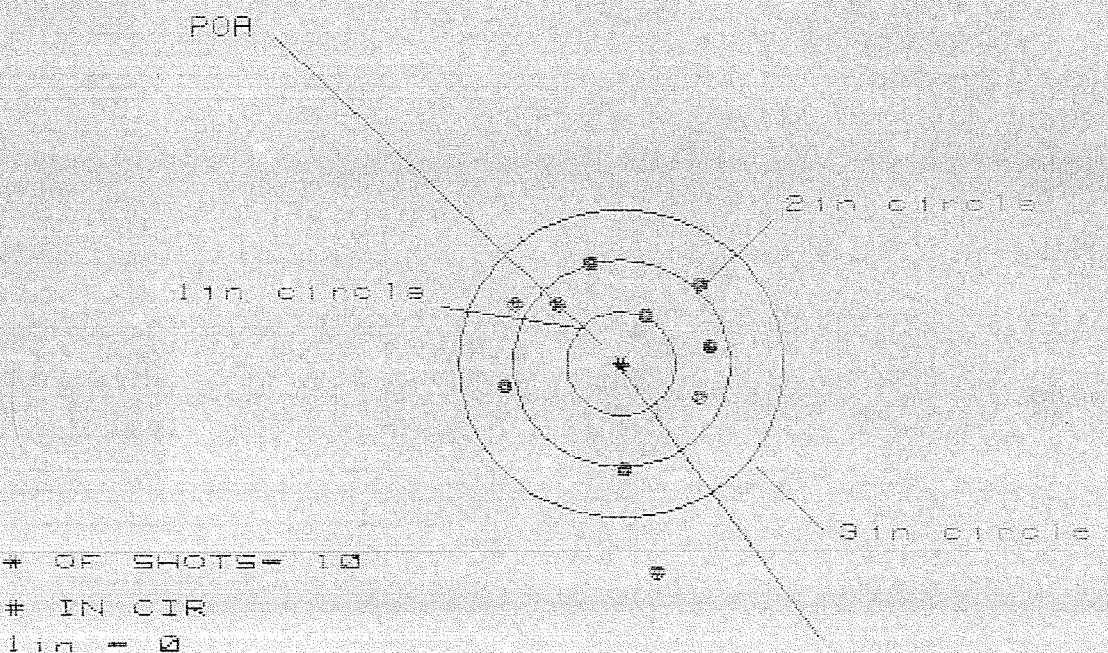
PATTERN # : 1

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.809	.814	.694
MINIMUM X	:	-.964	-.959	-.304
MAXIMUM Y	:	1.742	.938	.925
MINIMUM Y	:	-.611	-.418	-.431
CENTROID X	:	-.051	-.056	.064
CENTROID Y	:	-.016	-.209	-.196
POA TO CENTROID in.	:	.053	.216	.206
MIN RADIUS	:	.100	.285	.257
MEAN RADIUS	:	.696	.527	.468
MAX RADIUS	:	1.742	.965	.945
HORIZONTAL SPREAD	:	1.773	1.773	.998
VERTICAL SPREAD	:	2.353	1.356	1.356
EXTREME SPREAD	:	2.353	1.819	1.359

NUMBER IN ONE INCH CIRCLE = 4
NUMBER IN TWO INCH CIRCLE = 8
NUMBER IN THREE INCH CIRCLE = 9

18 Oct 1991 FILE:/PATTERNING/CENTERFIRE_PATT/08865686

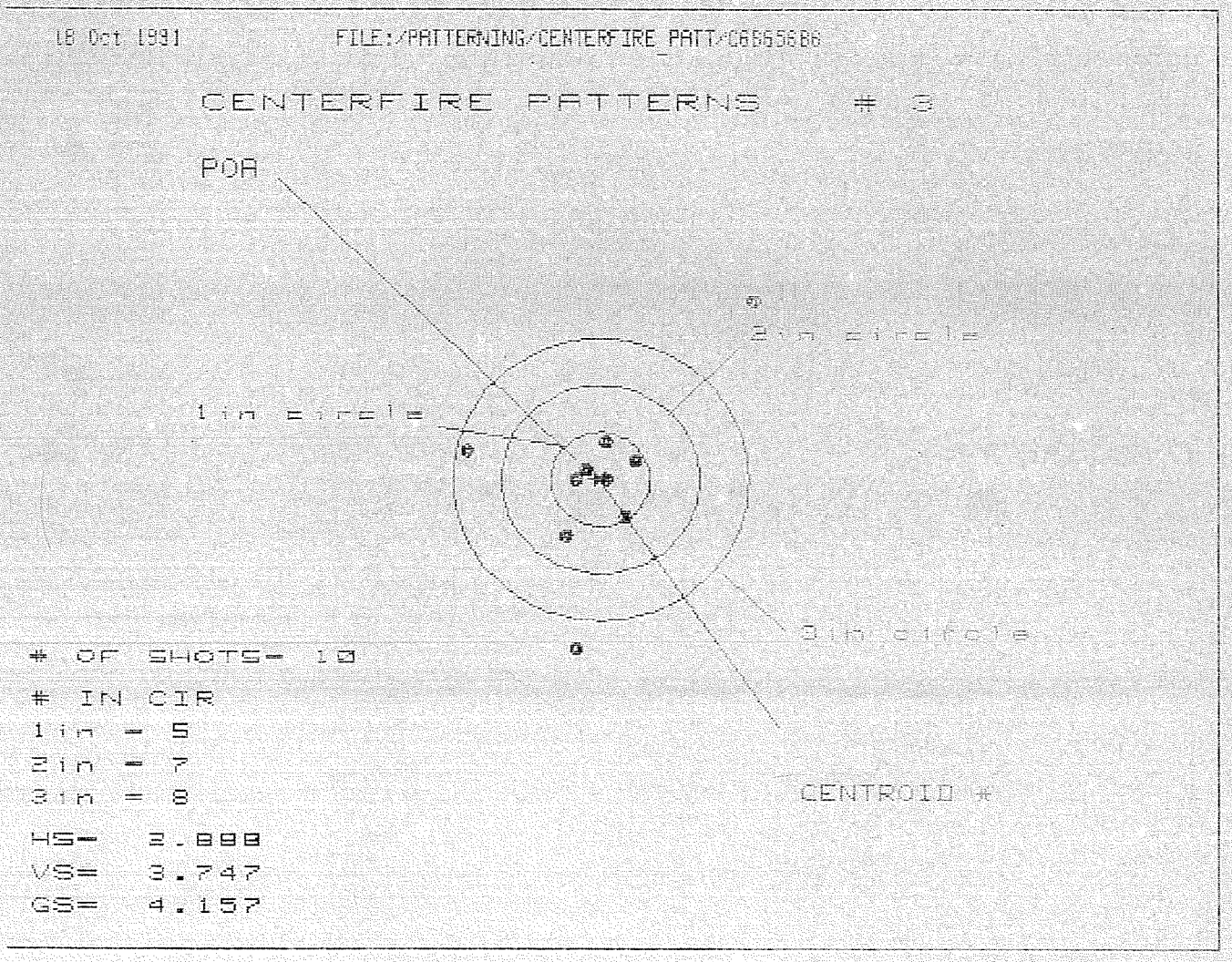
CENTERFIRE PATTERNS # 2



# OF SHOTS= 10
# IN CIR
1in = 0
2in = 4
3in = 9
HS= 1.954
VS= 2.985
GS= 3.041

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.833	.870	.735
MINIMUM X	:	-1.121	-1.084	-1.043
MAXIMUM Y	:	1.007	.788	.730
MINIMUM Y	:	-1.978	-1.281	-1.339
CENTROID X	:	-.023	-.060	.075
CENTROID Y	:	.023	.243	.300
POA TO CENTROID in.	:	.033	.251	.310
MIN RADIUS	:	.507	.338	.214
MEAN RADIUS	:	1.042	.889	.827
MAX RADIUS	:	2.006	1.282	1.342
HORIZONTAL SPREAD	:	1.954	1.954	1.778
VERTICAL SPREAD	:	2.985	2.069	2.069
EXTREME SPREAD	:	3.041	2.140	2.083

NUMBER IN ONE INCH CIRCLE = 0
NUMBER IN TWO INCH CIRCLE = 4
NUMBER IN THREE INCH CIRCLE = 9



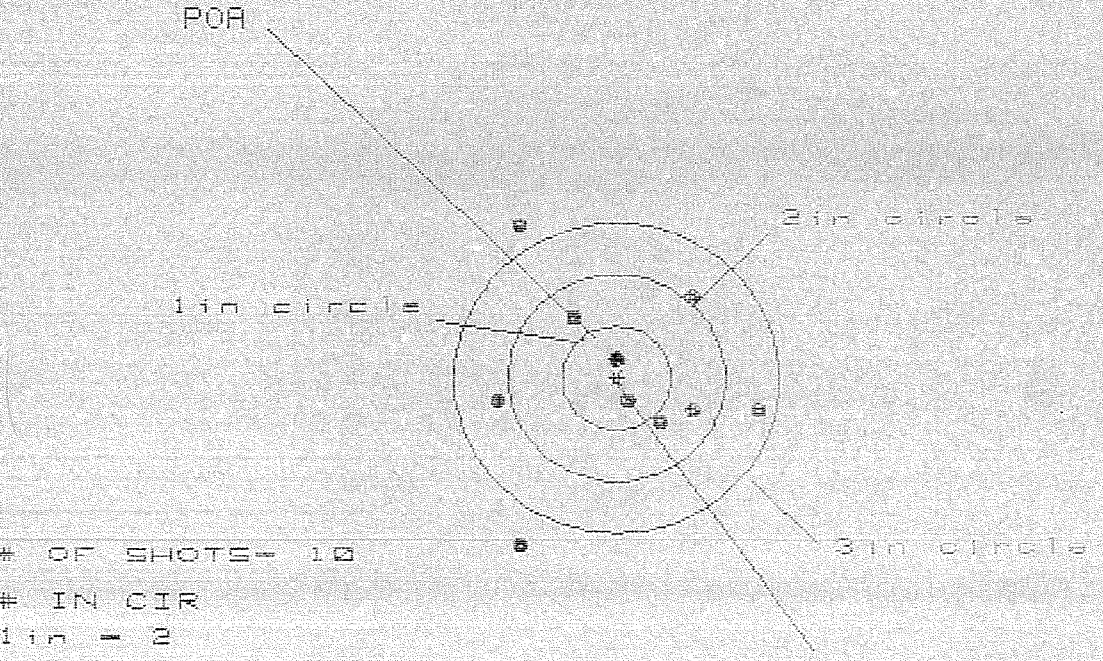
PATTERN # : 3

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.569	.569	.562
MINIMUM X	-1.319	-1.144	-1.151
MAXIMUM Y	1.949	.623	.425
MINIMUM Y	-1.798	-1.581	-.549
CENTROID X	.050	-.125	-.118
CENTROID Y	-.004	-.221	-.023
POA TO CENTROID in.	.050	.254	.120
MIN RADIUS	.038	.205	.096
MEAN RADIUS	.820	.653	.484
MAX RADIUS	2.503	1.582	1.184
HORIZONTAL SPREAD	2.888	1.713	1.713
VERTICAL SPREAD	3.747	2.204	.974
EXTREME SPREAD	4.157	2.325	1.760

NUMBER IN ONE INCH CIRCLE = 5
NUMBER IN TWO INCH CIRCLE = 7
NUMBER IN THREE INCH CIRCLE = 8

18 Oct 1991 FILE:/PATTERNING/CENTERFIRE_PATT/C6865686

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

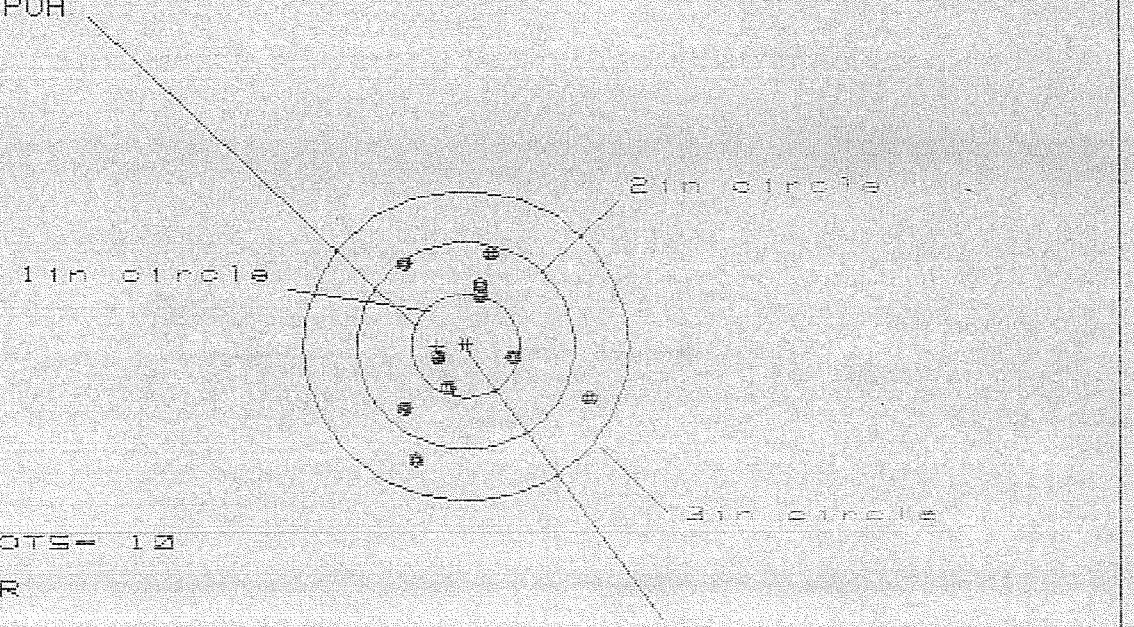
# IN CIR
1in = 2
2in = 5
3in = 8

HS= 2.353
VS= 3.137
GS= 3.137

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.283	1.189	1.069
MINIMUM X	:	-1.070	-1.164	-1.284
MAXIMUM Y	:	1.517	1.337	.821
MINIMUM Y	:	-1.620	-.562	-.395
CENTROID X	:	-.002	.092	.212
CENTROID Y	:	-.187	-.007	-.174
POA TO CENTROID in.	:	.187	.092	.274
MIN RADIUS	:	.186	.072	.358
MEAN RADIUS	:	.960	.852	.729
MAX RADIUS	:	1.829	1.644	1.305
HORIZONTAL SPREAD	:	2.353	2.353	2.353
VERTICAL SPREAD	:	3.137	1.899	1.216
EXTREME SPREAD	:	3.137	2.844	2.357
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

18 Oct 1991 FILE:/PATTERNING/CENTERFIRE_PATT/C86856B6

CENTERFIRE PATTERNS # 5



# OF SHOTS= 10
# IN CIR
1in = 4
2in = 8
3in = 10

HS= 1.748
VS= 2.036
GS= 2.155

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.148	.591	.546
MINIMUM X	:	-.600	-.472	-.517
MAXIMUM Y	:	.921	.863	.716
MINIMUM Y	:	-1.115	-1.173	-.783
CENTROID X	:	.267	.139	.184
CENTROID Y	:	.004	.062	.209
POA TO CENTROID in.	:	.267	.152	.278
MIN RADIUS	:	.294	.198	.318
MEAN RADIUS	:	.742	.671	.589
MAX RADIUS	:	1.260	1.228	.938
HORIZONTAL SPREAD	:	1.748	1.063	1.063
VERTICAL SPREAD	:	2.036	2.036	1.499
EXTREME SPREAD	:	2.155	2.155	1.706
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	