

FORM

UPC



06665689

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 700™ M24**SERIAL NO.**

C6665689

ORDER NO.**5716**

20

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



5716 C6665689

ORDER 5716

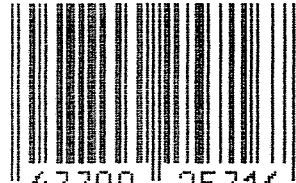
MODEL 700™ M24

UPC**ORDER 5716**

MODEL 700™ M24

UPC

0 47700 25716 7



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6665689

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	LS.
617	Drill and Tap Sight Holes	SEP	3 0 1991	FB
618	Polish Barrel	OCT	2 1991	WT
620	Apply Coatings (Barrel Action)		10-13-91	DA
	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		10/18/91	AL

op. #	BARBER M24 0101349	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			10/21/91	JK
	G) Safety Off Force	4	4	4			10/21/91	JM
	H) Trigger Pull Test & Retainability						10/18/91	JK
	I) Firing Pin Indent	.0225	.0225	.0225			10/21/91	JK
	J) Assemble Stock						10/22/91	RW
	K) Assemble Swivel Studs						10-30-91	AC
	L) Attach Front and Rear Sight Assemblies						10/22/91	RW
	M) Iron Sight Alignment						10/22/91	RW
	N) Detach Front & Rear Sights & place in numbered container						10/22/91	RW
	O) Attach Scope to Rifle						10/22/91	RW
	P) Detach & Attach Scope 20 Times						10/22/91	RW
640	Gallery Target & Test						10/22/91	ICF
	A) Time							ICF
	B) Malfunctions							ICF
	C) Pierced Primers							ICF
	D) Optical Clarity of Scope							ICF
645	Inspect for Live Ammo						10/22/91	ICF
655	Final Inspection							
	A) Headspace						10-30-91	AC
	B) Trigger Pull	263	247	262	257	260	10-23-91	10/4
	C) Function						10-30-91	AC
660	Pack						12-20-91	NF

SWS TRIGGER PULL TEST

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

SERIAL NO C6665689
DATE 10/18/91
TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.42	2.52	2.43	263	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.42	2.49	2.50	247	
PULL #3	2.30	2.45	2.48	262	
PULL #4	2.42	2.50	2.62	257	
PULL #5	2.44	2.52	2.50	260	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.43	3.57		
PULL #2	3.41	3.48		
PULL #3	3.45	3.49		
PULL #4	3.40	3.55		
PULL #5	3.49	3.56		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.23	4.31		4.29
PULL #2	4.24	4.34		4.35
PULL #3	4.30	4.34		4.33
PULL #4	4.29	4.35		4.37
PULL #5	4.32	4.34		4.44
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06665689
22 Oct 1991

CENTROIDAL DISTANCES

0 TO	1	.316172
1 TO	2	.206712
1 TO	3	.364033
1 TO	4	.392594
1 TO	5	.317593

4 ←---POB

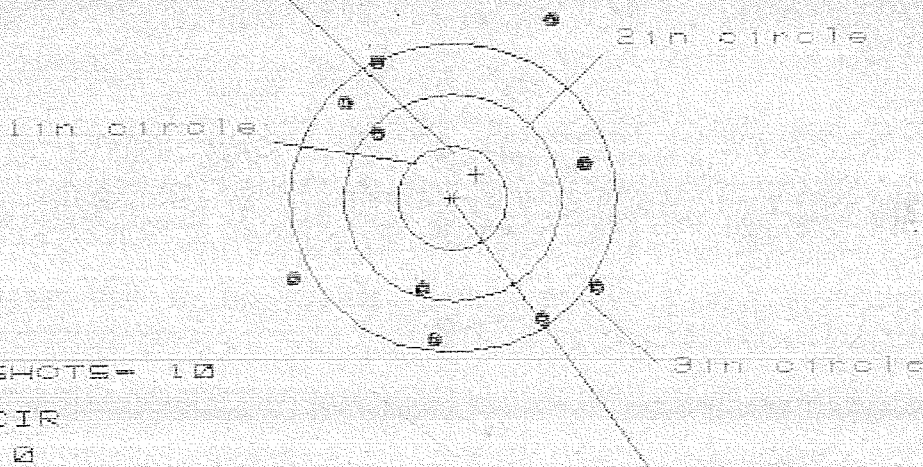
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0796
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0288
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0846493
THE AMR FOR THIS RIFLE IS: 1.021

22 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/Q8685689

CENTERFIRE PATTERNS # 1

POB



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 2

3 in = 6

HS= 2.808

VS= 3.115

GS= 3.481

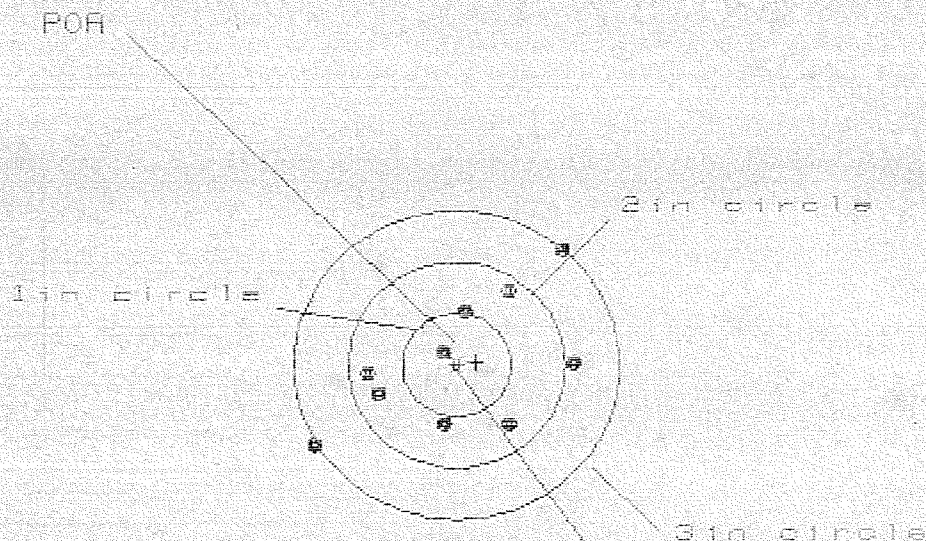
CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.294	1.397	1.220
MINIMUM X	:	-1.514	-1.411	-1.066
MAXIMUM Y	:	1.744	1.568	1.500
MINIMUM Y	:	-1.371	-1.177	-1.245
CENTROID X	:	-.218	-.321	-.144
CENTROID Y	:	-.229	-.423	-.355
POB TO CENTROID in.	:	.316	.531	.383
MIN RADIUS	:	.933	.727	.849
MEAN RADIUS	:	1.408	1.320	1.292
MAX RADIUS	:	1.975	1.663	1.668
HORIZONTAL SPREAD	:	2.808	2.808	2.286
VERTICAL SPREAD	:	3.115	2.745	2.745
EXTREME SPREAD	:	3.481	3.009	3.009
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	2		
NUMBER IN THREE INCH CIRCLE	=	6		

22 Oct 1991

FILE: PATTERNING/CENTERFIRE_PATT/06605689

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS= 2.379

VS= 1.832

GS= 2.950

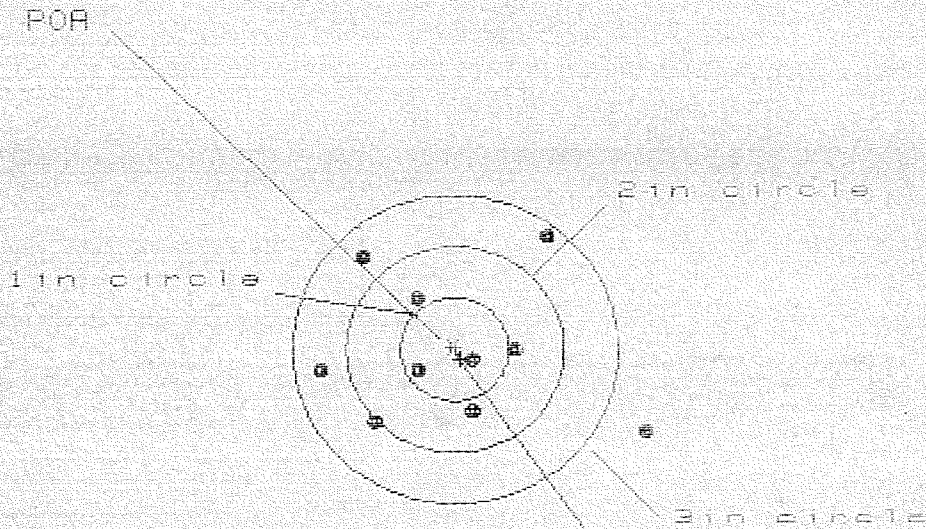
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.036	.987	.990
MINIMUM X	:	-1.343	-.940	-.837
MAXIMUM Y	:	1.099	1.017	.738
MINIMUM Y	:	-.733	-.695	-.567
CENTROID X	:	-.179	-.030	-.133
CENTROID Y	:	-.026	.056	-.072
POA TO CENTROID in.	:	.181	.063	.151
MIN RADIUS	:	.107	.224	.172
MEAN RADIUS	:	.849	.775	.692
MAX RADIUS	:	1.530	1.307	.990
HORIZONTAL SPREAD	:	2.379	1.827	1.827
VERTICAL SPREAD	:	1.832	1.712	1.305
EXTREME SPREAD	:	2.950	2.231	1.828
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS= 2.987

VS= 1.953

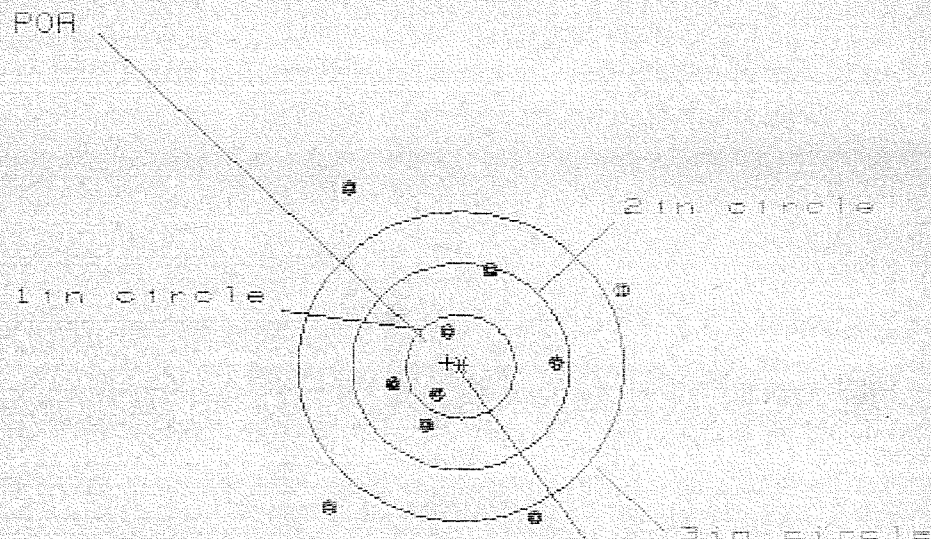
GS= 3.147

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.772	1.064	.875
MINIMUM X	:	-1.215	-1.018	-.885
MAXIMUM Y	:	1.135	1.044	.956
MINIMUM Y	:	-.819	-.759	-.629
CENTROID X	:	-.056	-.253	-.386
CENTROID Y	:	.097	.187	.057
POA TO CENTROID in.	:	.112	.315	.390
MIN RADIUS	:	.190	.330	.156
MEAN RADIUS	:	.921	.800	.690
MAX RADIUS	:	1.952	1.490	1.090
HORIZONTAL SPREAD	:	2.987	2.082	1.760
VERTICAL SPREAD	:	1.953	1.803	1.585
EXTREME SPREAD	:	3.147	2.475	1.825
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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FILE://PATTERNING/CENTERFIRE_PATT/06665689

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 6

HS = 2.618

VS = 3.277

GS = 3.675

CENTROID #

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.431	1.322	1.160
MINIMUM X	:	-1.187	-1.296	-1.851
MAXIMUM Y	:	1.766	1.085	.941
MINIMUM Y	:	-1.511	-1.315	-1.459
CENTROID X	:	.125	.234	.396
CENTROID Y	:	-.038	-.234	-.090
POA TO CENTROID in.	:	.130	.331	.486
MIN RADIUS	:	.318	.327	.520
MEAN RADIUS	:	1.086	.987	.899
MAX RADIUS	:	2.022	1.736	1.515
HORIZONTAL SPREAD	:	2.618	2.618	2.011
VERTICAL SPREAD	:	3.277	2.400	2.400
EXTREME SPREAD	:	3.675	3.329	2.426
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			6	

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 1

2in = 8

3in = 9

HS = 3.230

VS = 1.488

GS = 3.556

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	9
MAXIMUM X	:	2.416	.799	.730
MINIMUM X	:	-.814	-.545	-.394
MAXIMUM Y	:	.783	.705	.600
MINIMUM Y	:	-.705	-.663	-.575
CENTROID X	:	-.070	-.339	-.270
CENTROID Y	:	.052	.130	.042
POA TO CENTROID in.	:	.087	.363	.274
MIN RADIUS	:	.344	.394	.365
MEAN RADIUS	:	.840	.604	.565
MAX RADIUS	:	2.517	.891	.733
HORIZONTAL SPREAD	:	3.230	1.344	1.124
VERTICAL SPREAD	:	1.488	1.368	1.175
EXTREME SPREAD	:	3.556	1.595	1.230
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	