

Handwritten mark

FORM

UPC



6665693

*INCLUDES 1 IN CHAMBER

MODEL 780 TM M24

ORDER NO.	5716
BARREL LENGTH	
CAPACITY*	

RemingtonVERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.**MODEL 700™ M24****SERIAL NO.**

C6665693

ORDER NO.**5716**

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

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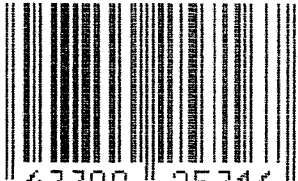
5716 C6665693

ORDER 5716

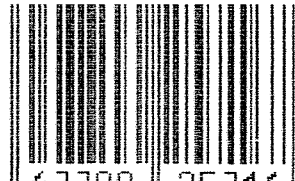
MODEL 700™ M24

UPC**ORDER 5716**

MODEL 700™ M24

UPC

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0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6665693

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 4 1991	KR
	Magnaflux Bolt		OCT 4 1991	KR
615	Rollmark Caliber		OCT 4 1991	JS
617	Drill and Tap Sight Holes		OCT 4 1991	KB
618	Polish Barrel		10/8/91	WB
620	Apply Coatings (Barrel Action)		10-22-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/23/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/23/91	RW
	C) Inspect Ejector Hole for Chamfer		10/23/91	RW
	D) Oil Firing Pin Ass'y		10/23/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/23/91	JL

op. #	BARBER - M24 0101403 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			10/23/91	JH
	G) Safety Off Force	3	3	3			10/23/91	JH
	H) Trigger Pull Test & Retainability						10/23/91	JH
	I) Firing Pin Indent	.0215	.0225	.0225			10/23/91	JH
	J) Assemble Stock						10/23/91	RW
	K) Assemble Swivel Studs						10-30-91	AC
	L) Attach Front and Rear Sight Assemblies						10/23/91	RW
	M) Iron Sight Alignment						10/23/91	RW
	N) Detach Front & Rear Sights & place in numbered container						10/23/91	RW
	O) Attach Scope to Rifle						10/23/91	RW
	P) Detach & Attach Scope 20 Times						10/23/91	RW
640	Gallery Target & Test						10-23-91	N
	A) Time						"	N
	B) Malfunctions						"	N
	C) Pierced Primers						"	N
	D) Optical Clarity of Scope						"	N
645	Inspect for Live Ammo						10-23-91	N
655	Final Inspection							
	A) Headspace						10-30-91	AC
	B) Trigger Pull	2.30	2.18	2.12	2.13	2.13	10-28-91	DH
	C) Function						10-30-91	AC
660	Pack						12-18-91	N

SWS TRIGGER PULL TESTAVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6665693DATE 10/23/91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.55	2.42	2.22	2.30	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.53	2.58	2.28	2.18	
PULL #3	2.64	2.20	2.25	2.12	
PULL #4	2.64	2.36	2.38	2.13	
PULL #5	2.66	2.18	2.20	2.13	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.58	3.16		
PULL #2	3.43	3.39		
PULL #3	3.15	3.29		
PULL #4	3.45	3.23		
PULL #5	3.37	3.29		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.41	4.30		4.47
PULL #2	4.44	4.27		4.38
PULL #3	4.28	4.30		4.35
PULL #4	4.35	4.15		4.20
PULL #5	4.35	4.15		4.38
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665698
23 Oct 1991

CENTROIDAL DISTANCES

0 TO	1	.449855
1 TO	2	.379722
1 TO	3	.6178
1 TO	4	.455703
1 TO	5	.460722

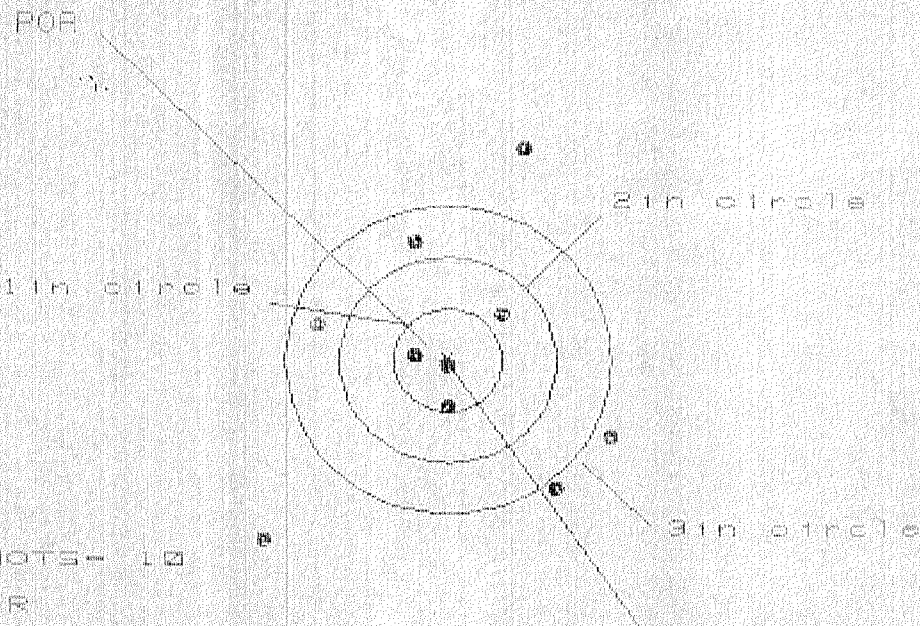
$\bar{x}_1$ (----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1548
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1264
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .199695
THE AMR FOR THIS RIFLE IS: 1.039

23 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8865693

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 4

3 in = 6

HS= 3.201

VS= 3.759

GS= 4.468

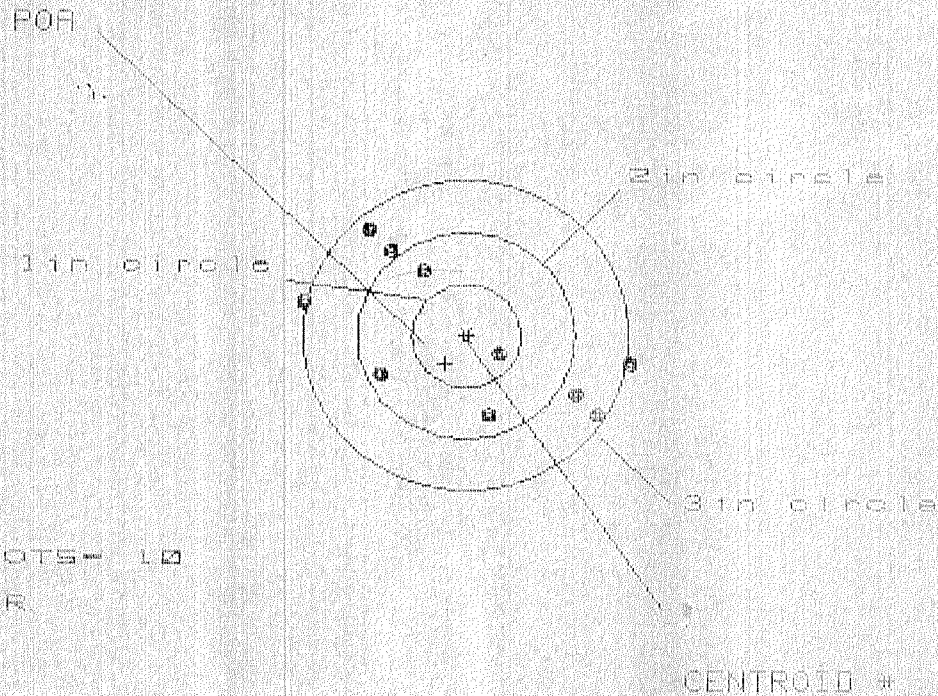
CENTROID +

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.472	1.280	1.342
MINIMUM X	-1.729	-1.434	-1.372
MAXIMUM Y	2.036	1.845	1.195
MINIMUM Y	-1.723	-1.456	-1.226
CENTROID X	.004	.196	.134
CENTROID Y	.046	.237	.087
POA TO CENTROID in.	.046	.308	.134
MIN RADIUS	.039	.266	.100
MEAN RADIUS	1.179	1.058	.914
MAX RADIUS	2.441	1.910	1.501
HORIZONTAL SPREAD	3.201	2.714	2.714
VERTICAL SPREAD	3.759	3.301	2.421
EXTREME SPREAD	4.468	3.315	2.922
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	6		

23 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CBBG5693

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 8

HS= 2.995

VS= 1.803

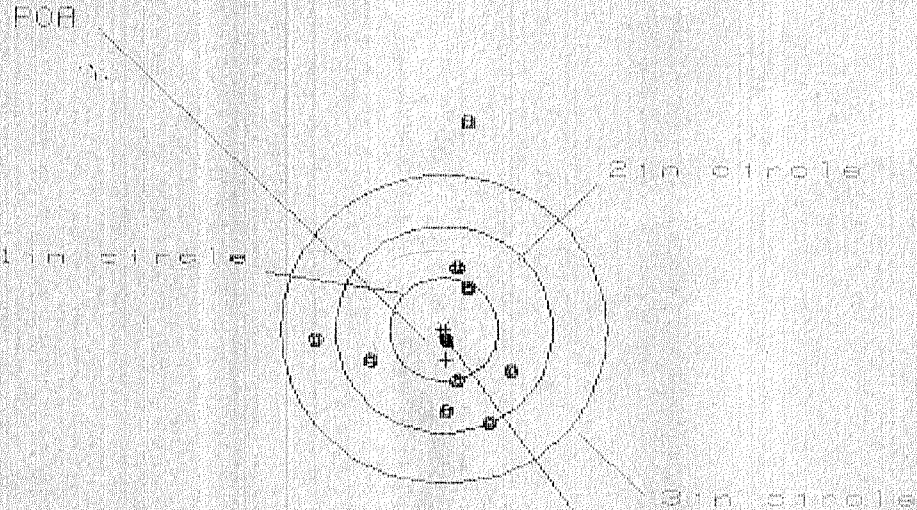
GS= 3.048

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.520	1.407	1.244
MINIMUM X	-1.474	-1.306	-1.881
MAXIMUM Y	1.021	.997	1.037
MINIMUM Y	-.782	-.806	-.766
CENTROID X	.194	.025	.188
CENTROID Y	.266	.290	.250
POA TO CENTROID in.	.329	.291	.312
MIN RADIUS	.399	.558	.395
MEAN RADIUS	1.101	1.042	.993
MAX RADIUS	1.536	1.622	1.461
HORIZONTAL SPREAD	2.995	2.713	2.125
VERTICAL SPREAD	1.803	1.803	1.803
EXTREME SPREAD	3.048	2.939	2.787
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

23 Oct 1991

FILE: /PATTERNING/CENTERFIRE_PATT/C6865693

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 1.860

VS= 2.952

GS= 2.959

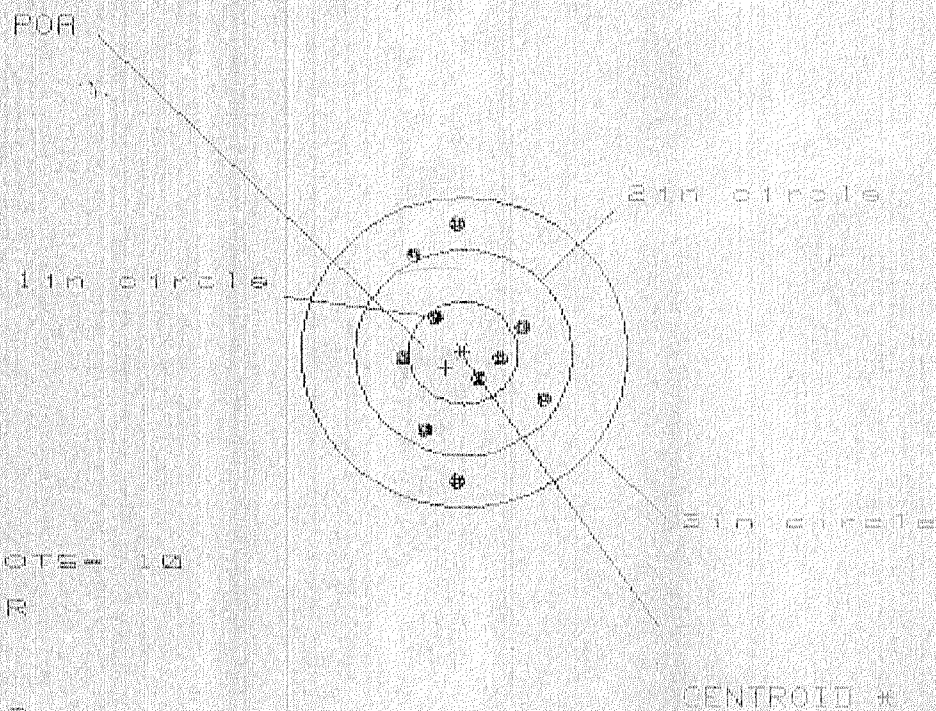
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.665	.693	.545
MINIMUM X	:	-1.215	-1.187	-1.750
MAXIMUM Y	:	2.028	.836	.852
MINIMUM Y	:	-.924	-.699	-.683
CENTROID X	:	-.021	-.049	.099
CENTROID Y	:	.297	.072	.056
POA TO CENTROID in.	:	.298	.087	.114
MIN RADIUS	:	.072	.155	.219
MEAN RADIUS	:	.817	.654	.574
MAX RADIUS	:	2.044	1.194	.853
HORIZONTAL SPREAD	:	1.880	1.880	1.295
VERTICAL SPREAD	:	2.952	1.535	1.535
EXTREME SPREAD	:	2.959	1.900	1.567
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			9	

23 Oct 1981

FILE:/PATTERNING/CENTERFIRE_PATT/C6565899

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 3

2in = 7

3in = 10

HS = 1.270

VS = 2.437

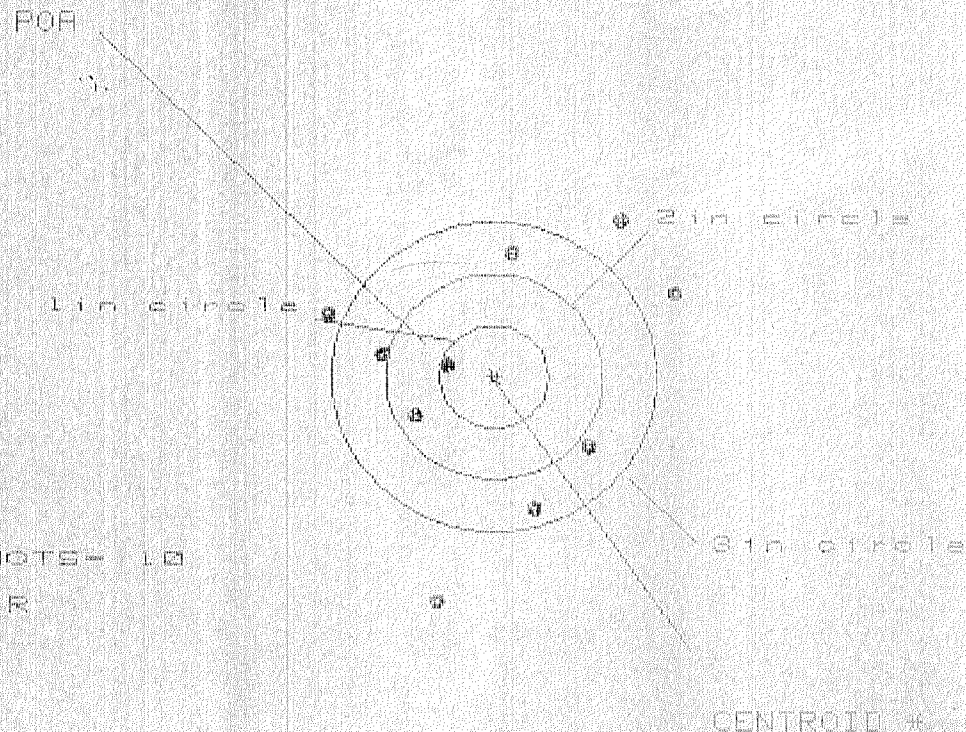
GS = 2.438

PATTERN #	2
SHOTS (BEST OF)	10
MAXIMUM X	.745
MINIMUM X	-.525
MAXIMUM Y	1.240
MINIMUM Y	-1.197
CENTROID X	.163
CENTROID Y	.145
POA TO CENTROID in.	.218
MIN RADIUS	.308
MEAN RADIUS	.744
MAX RADIUS	1.243
HORIZONTAL SPREAD	1.270
VERTICAL SPREAD	2.437
EXTREME SPREAD	2.438
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	7
NUMBER IN THREE INCH CIRCLE =	10

23 Oct 1991

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CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 2

3 in = 6

HS= 3.128

VS= 3.660

GS= 4.028

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.631	1.577	1.720
MINIMUM X	-1.497	-1.551	-1.108
MAXIMUM Y	1.477	1.234	1.097
MINIMUM Y	-2.183	-1.535	-1.380
CENTROID X	.433	.487	.344
CENTROID Y	-.122	.121	-.034
POA TO CENTROID in.	.450	.502	.346
MIN RADIUS	.471	.526	.369
MEAN RADIUS	1.356	1.253	1.158
MAX RADIUS	2.236	1.690	1.881
HORIZONTAL SPREAD	3.128	3.128	3.128
VERTICAL SPREAD	3.660	2.769	2.477
EXTREME SPREAD	4.028	3.140	3.140
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	6		