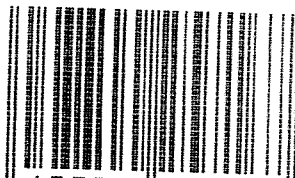


FORM

UPC



0 47700 25716 7

06665710

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.**

C6665710

ORDER NO.**5716**

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

20



5716 C6665710

ORDER 5716MODEL 700TM M24**UPC****ORDER 5716**MODEL 700TM M24**UPC**

0 47700 25716 7



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6665710

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 26	91	RW
600	Proof	9 26	91	RW
607	Check Headspace	9 26	91	RW
610	Dis-assemble Gun	9 26	91	RW
612	Magnaflux Barrel Action	SEP 30	1991	KR
	Magnaflux Bolt	SEP 30	1991	KR
615	Rollmark Caliber	SEP 30	1991	LS
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	AS
	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		10/21/91	JS

op. #	NAME BARBER - M24 0101609	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	5.5	6			10/21/91	JK
	G) Safety Off Force	4	3.5	3			10/21/91	JK
	H) Trigger Pull Test & Retainability						10/21/91	JK
	I) Firing Pin Indent	.0205	.0215	.021			10/21/91	JK
	J) Assemble Stock						10/21/91	RW
	K) Assemble Swivel Studs						10-30-91	Ac
	L) Attach Front and Rear Sight Assemblies						10/21/91	RW
	M) Iron Sight Alignment						10/21/91	RW
	N) Detach Front & Rear Sights & place in numbered container						10/21/91	RW
	O) Attach Scope to Rifle						10/21/91	RW
	P) Detach & Attach Scope 20 Times						10/21/91	RW
640	Gallery Target & Test						10/22/91	KI
	A) Time							KI
	B) Malfunctions							KI
	C) Pierced Primers							KI
	D) Optical Clarity of Scope							KI
645	Inspect for Live Ammo						10/22/91	KI
655	Final Inspection							
	A) Headspace						10-30-91	Ac
	B) Trigger Pull	251	251	234	234	229	10-23-91	DH
	C) Function						10-30-91	Ac
660	Pack						12-18-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6665710

DATE 10/21/91

TESTER JP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.25	2.22	2.51	2.51	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.24	2.40	2.49	2.51	
PULL #3	2.63	2.48	2.50	2.34	
PULL #4	2.30	2.44	2.48	2.34	
PULL #5	2.20	2.49	2.51	2.29	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.62	3.63		
PULL #2	3.55	3.63		
PULL #3	3.57	3.58		
PULL #4	3.67	3.67		
PULL #5	3.66	3.60		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.30	4.28		4.40
PULL #2	4.31	4.37		4.39
PULL #3	4.23	4.45		4.41
PULL #4	4.25	4.38		4.49
PULL #5	4.29	4.28		4.38
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665710
22 Oct 1991

CENTROIDAL DISTANCES

0 TO 1	.107075
1 TO 2	.236019
1 TO 3	.0979439
1 TO 4	.271017
1 TO 5	.383537

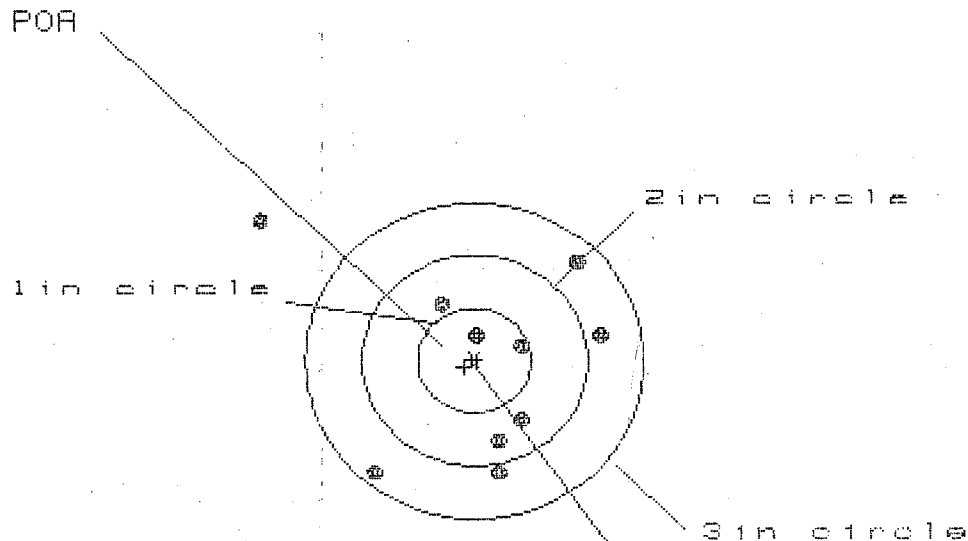
27 <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .011
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0454
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0467106
THE AMR FOR THIS RIFLE IS: .901

22 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665710

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS= 2.994

VS= 2.440

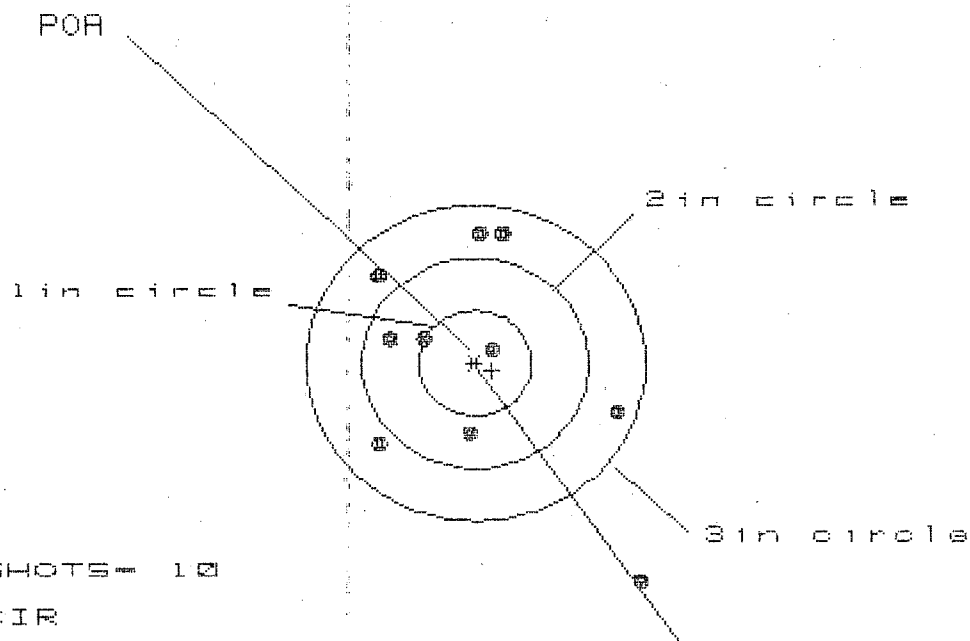
GS= 3.188

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.079	.866	.727
MINIMUM X	-1.915	-1.116	-.663
MAXIMUM Y	1.352	1.044	.927
MINIMUM Y	-1.088	-.938	-1.029
CENTROID X	.088	.301	.440
CENTROID Y	.061	-.089	.028
POA TO CENTROID in.	.107	.314	.441
MIN RADIUS	.221	.342	.185
MEAN RADIUS	.993	.805	.705
MAX RADIUS	2.344	1.457	1.076
HORIZONTAL SPREAD	2.994	1.982	1.390
VERTICAL SPREAD	2.440	1.982	1.956
EXTREME SPREAD	3.188	2.678	2.088
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

22 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665710

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS= 2.359

VS= 3.327

GS= 3.748

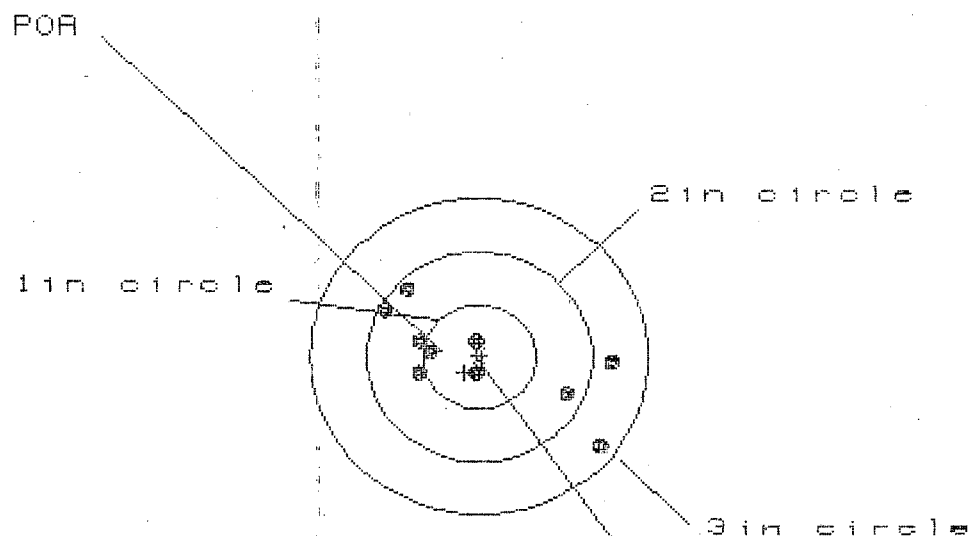
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.465	1.405	.543
MINIMUM X	:	-.894	-.731	-.555
MAXIMUM Y	:	1.275	1.047	.958
MINIMUM Y	:	-2.052	-.999	-1.088
CENTROID X	:	-.148	-.311	-.487
CENTROID Y	:	.064	.292	.381
POA TO CENTROID in.	:	.161	.427	.618
MIN RADIUS	:	.216	.316	.173
MEAN RADIUS	:	1.095	.889	.772
MAX RADIUS	:	2.521	1.576	1.211
HORIZONTAL SPREAD	:	2.359	2.136	1.098
VERTICAL SPREAD	:	3.327	2.046	2.046
EXTREME SPREAD	:	3.748	2.525	2.238
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

22 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665710

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 2.002

VS= 1.459

GS= 2.307

CENTROID *

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.214	1.338	1.018
MINIMUM X	:	-.788	-.664	-.497
MAXIMUM Y	:	.635	.544	.527
MINIMUM Y	:	-.824	-.396	-.413
CENTROID X	:	.131	.007	-.160
CENTROID Y	:	.149	.240	.257
POA TO CENTROID in.	:	.198	.240	.303
MIN RADIUS	:	.179	.101	.158
MEAN RADIUS	:	.720	.608	.477
MAX RADIUS	:	1.388	1.345	1.099
HORIZONTAL SPREAD	:	2.002	2.002	1.515
VERTICAL SPREAD	:	1.459	.940	.940
EXTREME SPREAD	:	2.307	2.069	1.705
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	8		
NUMBER IN THREE INCH CIRCLE	=	10		

22 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08685710

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS= 1.957

VS= 2.424

GS= 2.498

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.021	1.068	.711
MINIMUM X	:	-.936	-.889	-.756
MAXIMUM Y	:	1.488	1.108	1.011
MINIMUM Y	:	-.936	-.770	-.610
CENTROID X	:	-.019	-.066	-.199
CENTROID Y	:	-.188	-.354	-.257
POA TO CENTROID in.	:	.189	.360	.325
MIN RADIUS	:	.207	.121	.062
MEAN RADIUS	:	.857	.754	.680
MAX RADIUS	:	1.546	1.317	1.062
HORIZONTAL SPREAD	:	1.957	1.957	1.467
VERTICAL SPREAD	:	2.424	1.878	1.621
EXTREME SPREAD	:	2.498	2.420	1.848
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

22 Oct 1991

FILE: /PATTERNING/CENTERFIRE_PATT/C8685710

CENTERFIRE PATTERNS

5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 6

3 in = 10

HS = 1.622

VS = 2.430

GS = 2.666

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

:

.901

.763

.752

MINIMUM X

:

-.721

-.621

-.632

MAXIMUM Y

:

1.087

1.077

.924

MINIMUM Y

:

-1.343

-1.222

-.862

CENTROID X

:

.003

-.097

-.085

CENTROID Y

:

-.313

-.434

-.281

POA TO CENTROID in.:

.313

.445

.294

MIN RADIUS

:

.106

.067

.141

MEAN RADIUS

:

.840

.753

.696

MAX RADIUS

:

1.412

1.266

1.140

HORIZONTAL SPREAD

:

1.622

1.384

1.384

VERTICAL SPREAD

:

2.430

2.299

1.786

EXTREME SPREAD

:

2.666

2.392

2.052

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

6

NUMBER IN THREE INCH CIRCLE =

10