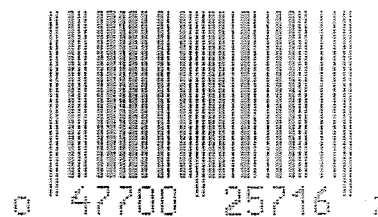


Small
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UPC



06665746

ORDER NO. 571E

BARREL LENGTH

MODEL 700 TM M24

Remington



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

MODEL 700 TM M24

SERIAL NO.

C6665746

ORDER NO.

5716

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

20



5716 C6665746

ORDER 5716

MODEL 700 TM M24

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MODEL 700 TM M24

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0 47700 25716 7



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6665746

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 30 1991	KR
	Magnaflux Bolt		SEP 30 1991	KR
615	Rollmark Caliber		SEP 30 1991	GL
617	Drill and Tap Sight Holes		SEP 30 1991	FB
618	Polish Barrel		OCT 2 1991	WTP
620	Apply Coatings (Barrel Action)		OCT 2 1991	WTP
	Apply Coating (Bolt)		10-13-91	WTP
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		10/16/91	JP

BARBER - M24 0102010									
625 cont.	F) Safety On Force	5	5	5	10/16/91	SH			
	G) Safety Off Force	3	3	3	10/16/91	SH			
	H) Trigger Pull Test & Retainability				10/16/91	SH			
	I) Firing Pin Indent	.021	.020	.020	10/16/91	SH			
	J) Assemble Stock				10/17/91	RW			
	K) Assemble Swivel Studs				10-22-91	RW			
	L) Attach Front and Rear Sight Assemblies				10/17/91	RW			
	M) Iron Sight Alignment				10/17/91	RW			
	N) Detach Front & Rear Sights & place in numbered container				10/17/91	RW			
	O) Attach Scope to Rifle				10/17/91	RW			
	P) Detach & Attach Scope 20 Times				10/17/91	RW			
640	Gallery Target & Test				10-18/91	10/17			
	A) Time					10/17			
	B) Malfunctions					KT			
	C) Pierced Primers					10/17			
	D) Optical Clarity of Scope				1	10/17			
645	Inspect for Live Ammo				10/17/91	10/17			
655	Final Inspection								
	A) Headspace				10-22-91	RW			
	B) Trigger Pull	223	214	210	211	219	10-18-91	014	
	C) Function						10-22-91	RW	
660	Pack						12-17-91	RW	

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO C-6665746

DATE 10/16/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.55	2.31	2.33	223	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.27	2.35	2.38	214	
PULL #3	2.31	2.30	2.38	210	
PULL #4	2.35	2.32	2.40	211	
PULL #5	2.28	2.28	2.32	219	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.40	3.36		
PULL #2	3.42	3.44		
PULL #3	3.41	3.46		
PULL #4	3.44	3.43		
PULL #5	3.42	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	4.35	4.28		4.43
PULL #2	4.29	4.18		4.40
PULL #3	4.28	4.19		4.33
PULL #4	4.28	4.50		4.46
PULL #5	4.24	4.44		4.42
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665746
18 Oct 1991

CENTROIDAL DISTANCES

0 TO 1	.12
1 TO 2	.462277
1 TO 3	.0344093
1 TO 4	.134715
1 TO 5	.399025

$\frac{1}{2}$ <---POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .193
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.084
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .210488

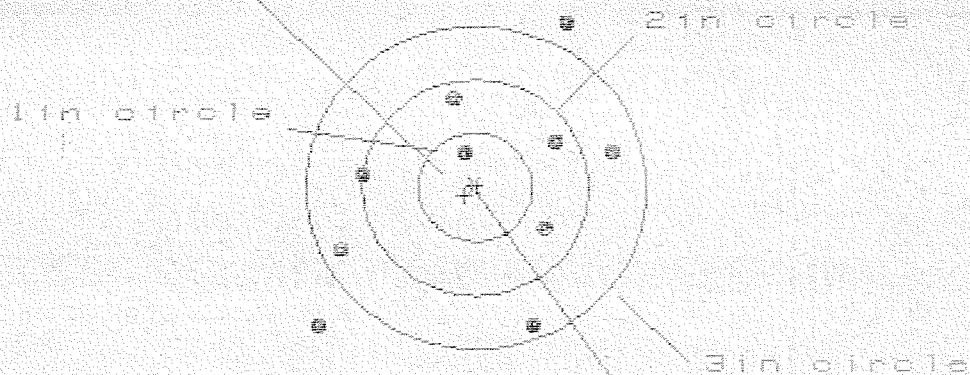
THE AMR FOR THIS RIFLE IS: 1.049

18 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06685746

CENTERFIRE PATTERNS # 1

POA



OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 8

HS= 2.615

VS= 2.854

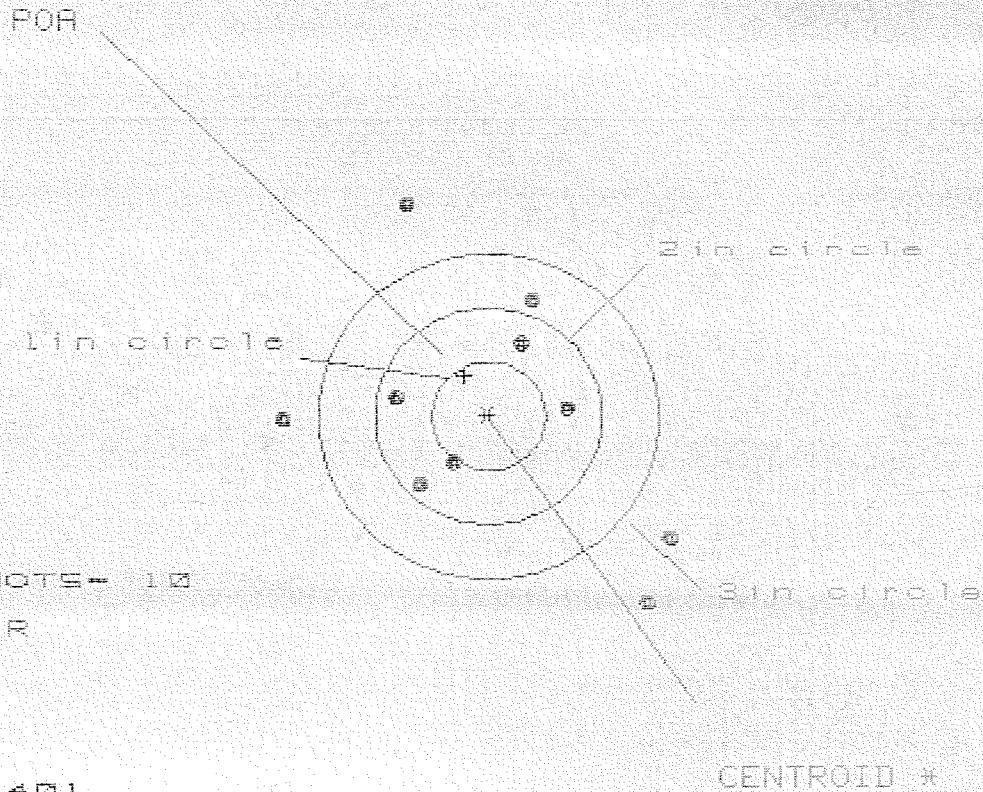
GS= 3.569

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.250	1.099	1.178
MINIMUM X	-1.365	-1.310	-1.231
MAXIMUM Y	1.546	1.401	.891
MINIMUM Y	-1.308	-1.453	-1.278
CENTROID X	.096	.248	.169
CENTROID Y	.072	.217	.042
POA TO CENTROID in.	.121	.330	.174
MIN RADIUS	.323	.320	.384
MEAN RADIUS	1.136	1.022	.967
MAX RADIUS	1.887	1.538	1.359
HORIZONTAL SPREAD	2.615	2.409	2.409
VERTICAL SPREAD	2.854	2.854	2.169
EXTREME SPREAD	3.569	2.899	2.571
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

18 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8665746

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 6

HS= 3.401

VS= 3.739

GS= 4.253

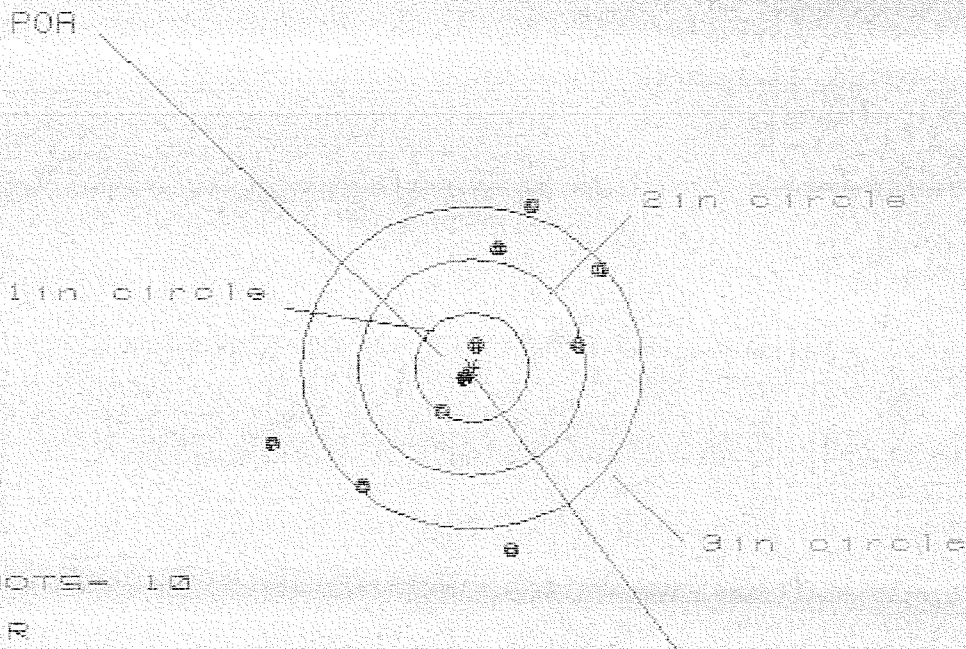
CENTROID *

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.599	1.749	1.684
MINIMUM X	-1.802	-1.652	-1.717
MAXIMUM Y	1.970	1.774	1.095
MINIMUM Y	-1.769	-1.344	-1.123
CENTROID X	.210	.060	.125
CENTROID Y	-.376	-.180	-.401
FOR TO CENTROID in.	.431	.189	.421
MIN RADIUS	.471	.591	.404
MEAN RADIUS	1.281	1.157	1.057
MAX RADIUS	2.226	2.286	2.024
HORIZONTAL SPREAD	3.401	3.401	3.401
VERTICAL SPREAD	3.739	3.118	2.218
EXTREME SPREAD	4.253	3.859	3.578
NUMBER IN ONE INCH CIRCLE	=	1	
NUMBER IN TWO INCH CIRCLE	=	5	
NUMBER IN THREE INCH CIRCLE	=	6	

18 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08685746

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 4

3 in = 7

HS= 2.903

VS= 3.221

GS= 3.306

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.086	.884	.899
MINIMUM X	:	-1.817	-1.178	-1.163
MAXIMUM Y	:	1.493	1.418	1.192
MINIMUM Y	:	-1.728	-1.803	-1.371
CENTROID X	:	.068	.270	.255
CENTROID Y	:	.092	.167	.392
POA TO CENTROID in.:	:	.115	.318	.468
MIN RADIUS	:	.091	.204	.168
MEAN RADIUS	:	1.093	.997	.881
MAX RADIUS	:	1.938	1.807	1.798
HORIZONTAL SPREAD	:	2.903	2.062	2.062
VERTICAL SPREAD	:	3.221	3.221	2.564
EXTREME SPREAD	:	3.306	3.226	2.963
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

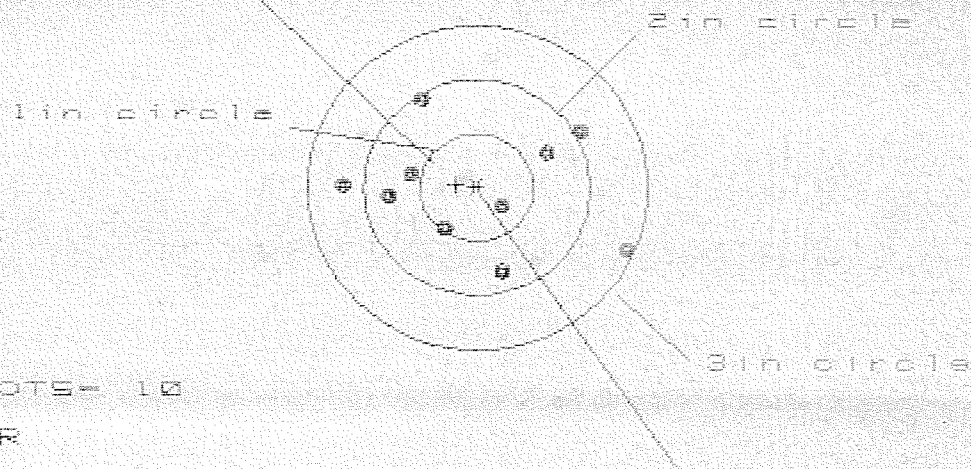
18 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8663748

CENTERFIRE PATTERNS

4

POA



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 2.506

VS= 1.536

GS= 2.576

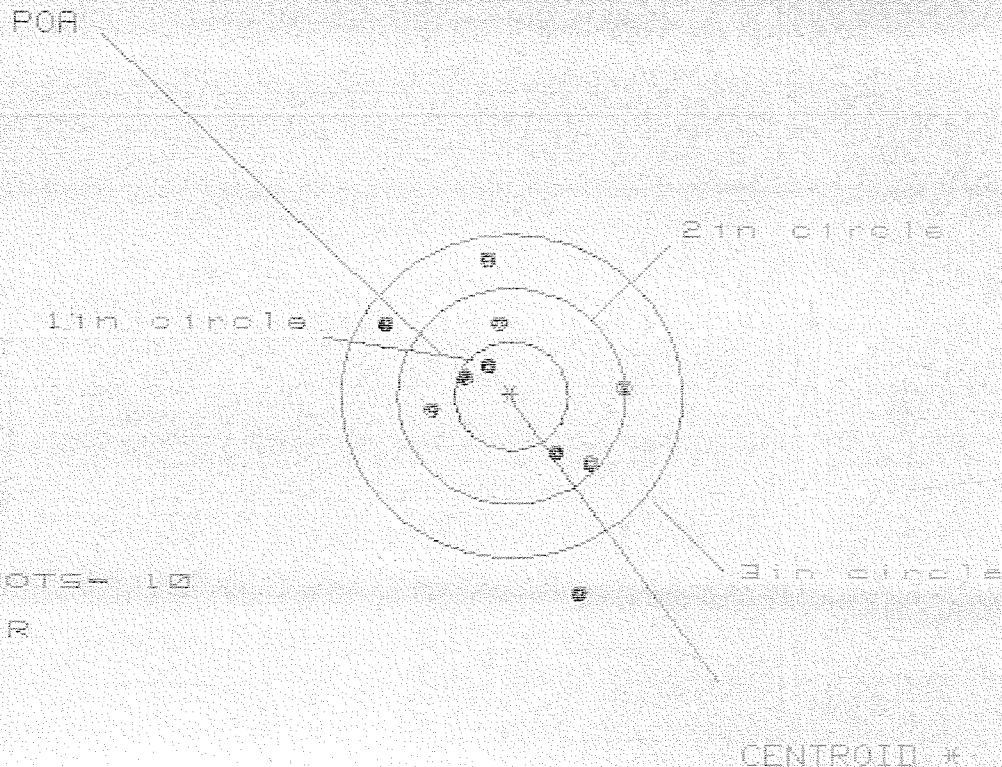
CENTROID *

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.343	1.044	.917
MINIMUM X	-1.163	-1.013	-.762
MAXIMUM Y	.807	.749	.751
MINIMUM Y	-.729	-.787	-.785
CENTROID X	.184	.034	.161
CENTROID Y	-.030	.023	.026
POA TO CENTROID in.	.186	.044	.163
MIN RADIUS	.292	.436	.346
MEAN RADIUS	.819	.738	.702
MAX RADIUS	1.441	1.133	1.018
HORIZONTAL SPREAD	2.506	2.057	1.679
VERTICAL SPREAD	1.536	1.536	1.536
EXTREME SPREAD	2.576	2.100	1.764
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

1B Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8665746

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 2.105

VS= 3.078

GS= 3.173

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.991	1.059	1.047
MINIMUM X	-1.114	-1.046	-1.058
MAXIMUM Y	1.287	1.088	.629
MINIMUM Y	-1.791	-.789	-.653
CENTROID X	.407	.339	.351
CENTROID Y	-.178	.021	-.115
POA TO CENTROID in.	.444	.340	.370
MIN RADIUS	.309	.131	.225
MEAN RADIUS	.914	.766	.729
MAX RADIUS	1.891	1.132	1.201
HORIZONTAL SPREAD	2.105	2.105	2.105
VERTICAL SPREAD	3.078	1.877	1.282
EXTREME SPREAD	3.173	2.188	2.188
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	