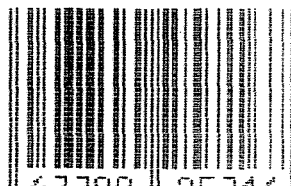


SHIELD
III

FOEN

UPC



0 47700 25716 7

06665747

MODEL 700 TM M24

ORDER NO.	5716
BARREL LENGTH	
CAPACITY*	

Remington

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

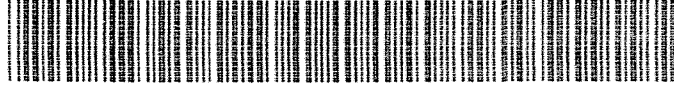
MODEL 700TM M24**SERIAL NO.**

C6665747

ORDER NO.**5716**

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

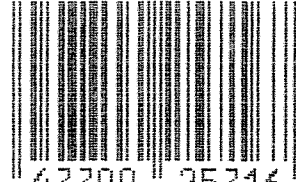
20



5716 C6665747

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 # C6665747

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 26	91	PW
600	Proof	9 26	91	PW
607	Check Headspace	9 26	91	PW
610	Dis-assemble Gun	9 26	91	PW
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	KB
618	Polish Barrel		OCT 2 1991	WT
620	Apply Coatings (Barrel Action)		10-13-91	JS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/13/91	PW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/13/91	PW
	C) Inspect Ejector Hole for Chamfer		10/13/91	PW
	D) Oil Firing Pin Ass'y		10/15/91	PW
	E) Adjust Trigger Pull to Min Setting and Stake		10/21/91	PW

op. #	BARBER - M24 0102028	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 $\frac{3}{4}$	4 $\frac{1}{4}$	4 $\frac{1}{4}$			10-23-91	DH
	G) Safety Off Force	2	2	2			10-22-91	DH
	H) Trigger Pull Test & Retainability						10/21/91	JH
	I) Firing Pin Indent	.020	.020	.020			10-22-91	DH
	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	NF
	A) Time						"	
	B) Malfunctions						"	
	C) Pierced Primers						"	
	D) Optical Clarity of Scope						"	
645	Inspect for Live Ammo						10-23-91	NF
655	Final Inspection							
	A) Headspace						10-30-91	AC
	B) Trigger Pull	245	243	253	251	253	10-28-91	DH
	C) Function						10-30-91	AC
660	Pack						12-18-91	DH

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

SERIAL NO. C-6665747
DATE 10/21/91
TESTER [Signature]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.23	2.32	2.30	2.45	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.25	2.25	2.38	2.43	
PULL #3	2.34	2.35	2.28	2.53	
PULL #4	2.24	2.26	2.40	2.51	
PULL #5	2.46	2.25	2.44	2.53	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.64	3.59		
PULL #2	3.62	3.56		
PULL #3	3.54	3.51		
PULL #4	3.55	3.58		
PULL #5	3.54	3.52		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.32	4.37		4.41
PULL #2	4.54	4.43		4.48
PULL #3	4.39	4.45		4.44
PULL #4	4.48	4.45		4.45
PULL #5	4.49	4.36		4.48
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665747
23 Oct 1991

CENTROIDAL DISTANCES

0 TO 1	.421
1 TO 2	.288376
1 TO 3	.5445
1 TO 4	.384012
1 TO 5	.566167

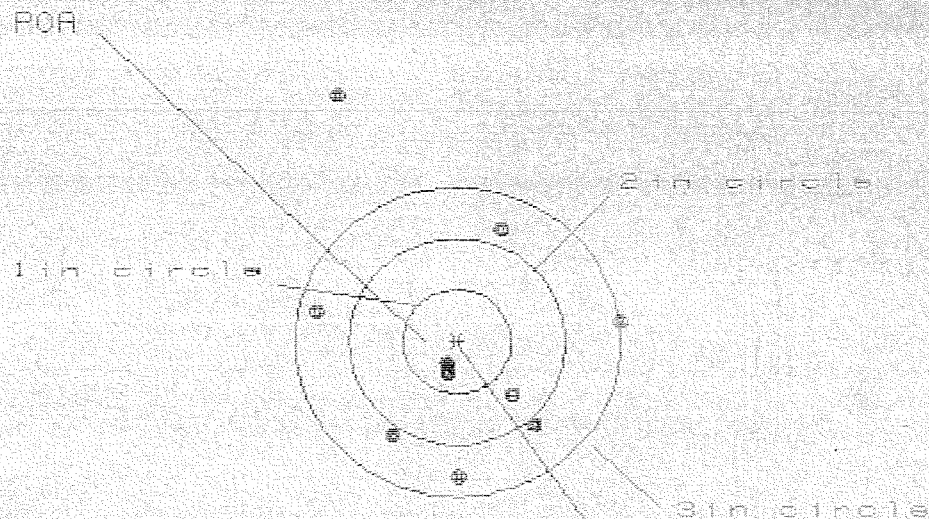
125 ← POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0792
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0252
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0831125
THE AMR FOR THIS RIFLE IS: .9594

23 Oct 1991

FILE: \PATTERNING\CENTERFIRE_PATT\CB665747

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 3

3 in = 8

HS = 2.925

VS = 3.632

GS = 3.798

CENTROID #

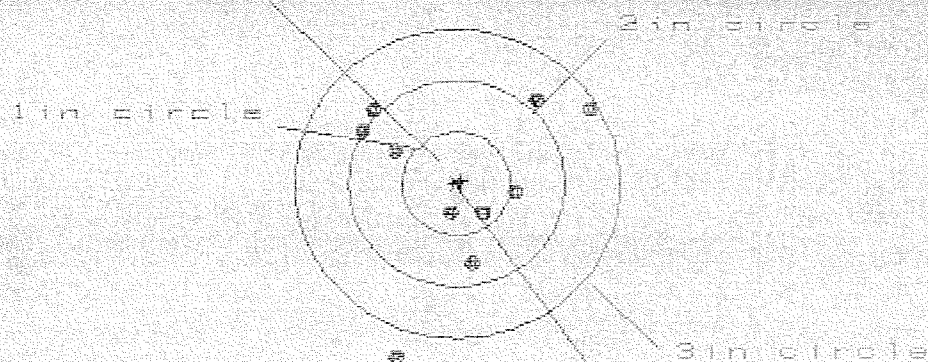
PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.504	1.386	.748
MINIMUM X	-1.321	-1.439	-1.265
MAXIMUM Y	2.370	1.315	1.377
MINIMUM Y	-1.262	-.999	-.937
CENTROID X	.096	.213	.039
CENTROID Y	.204	-.059	-.121
POA TO CENTROID in.	.226	.221	.127
MIN RADIUS	.245	.229	.072
MEAN RADIUS	1.121	.885	.775
MAX RADIUS	2.594	1.542	1.458
HORIZONTAL SPREAD	2.825	2.825	2.813
VERTICAL SPREAD	3.632	2.314	2.314
EXTREME SPREAD	3.796	2.826	2.345
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		8	

23 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06665747

CENTERFIRE PATTERNS # 4

POB



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS= 2.156

VS= 2.465

GS= 2.966

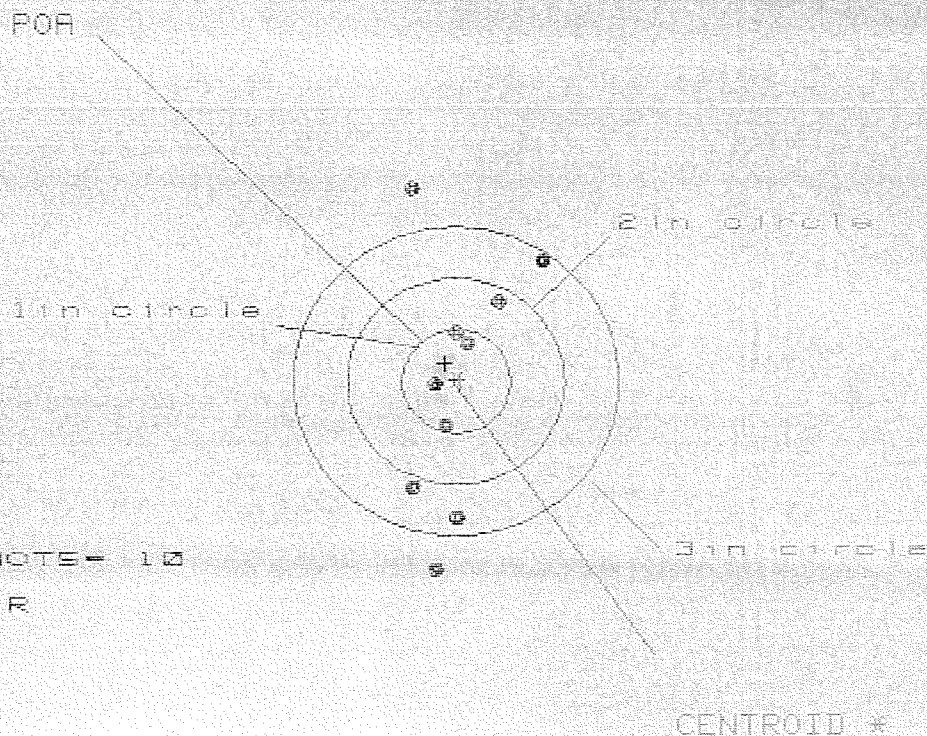
CENTROID *

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.265	1.208	.796
MINIMUM X	-.891	-.948	-.798
MAXIMUM Y	.792	.606	.670
MINIMUM Y	-1.673	-.958	-.894
CENTROID X	-.036	.021	-.130
CENTROID Y	-.026	.160	.096
POB TO CENTROID in.	.044	.161	.161
MIN RADIUS	.303	.466	.410
MEAN RADIUS	.896	.811	.728
MAX RADIUS	1.750	1.312	1.041
HORIZONTAL SPREAD	2.156	2.156	1.594
VERTICAL SPREAD	2.465	1.564	1.564
EXTREME SPREAD	2.966	2.167	1.747
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

23 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8665747

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 3

2in = 5

3in = 8

HS = 1.193

VS = 3.669

GS = 3.674

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.760	.720	.690
MINIMUM X	:	-.433	-.473	-.500
MAXIMUM Y	:	1.844	1.339	1.137
MINIMUM Y	:	-1.825	-1.620	-1.313
CENTROID X	:	.104	.144	.171
CENTROID Y	:	-.177	-.382	-.100
POA TO CENTROID in.	:	.205	.408	.248
MIN RADIUS	:	.202	.294	.268
MEAN RADIUS	:	.999	.909	.791
MAX RADIUS	:	1.880	1.634	1.331
HORIZONTAL SPREAD	:	1.193	1.193	1.193
VERTICAL SPREAD	:	3.669	2.959	2.450
EXTREME SPREAD	:	3.674	3.103	2.558
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

23 Oct 1991

FILE: /PATTERNING/CENTERFIRE_PATT/C6685747

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 5

2 in = 8

3 in = 10

HS= 2.174

VS= 1.562

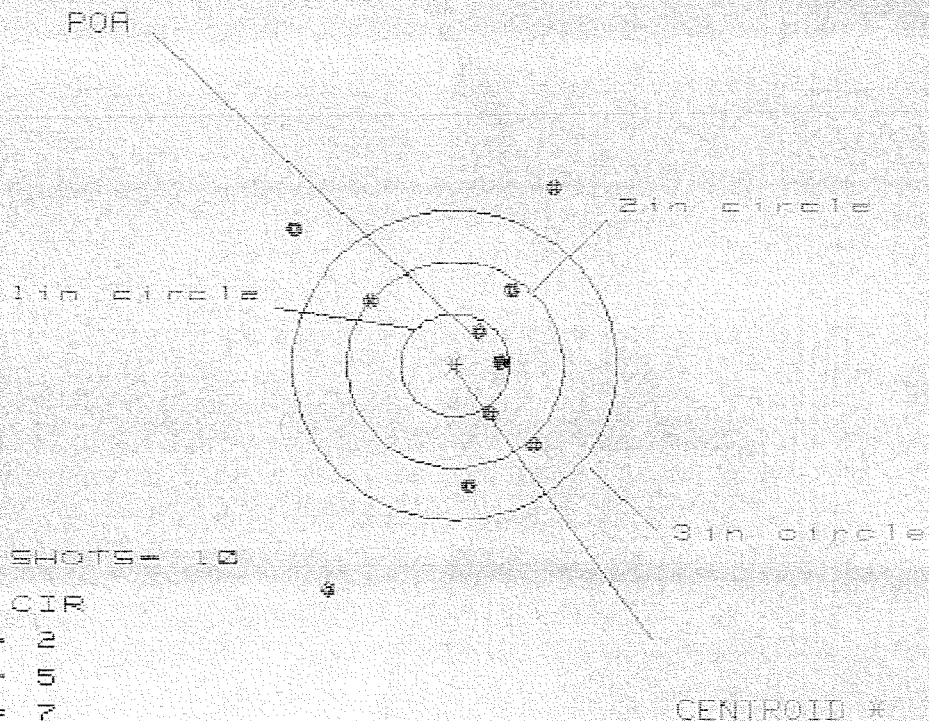
GS= 2.301

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.903	.761	.663
MINIMUM X	:	-1.272	-.785	-.447
MAXIMUM Y	:	.854	.799	.504
MINIMUM Y	:	-.708	-.763	-.663
CENTROID X	:	-.140	.002	.100
CENTROID Y	:	-.098	-.043	-.143
POA TO CENTROID in.	:	.170	.043	.174
MIN RADIUS	:	.123	.085	.055
MEAN RADIUS	:	.586	.452	.343
MAX RADIUS	:	1.366	1.120	.800
HORIZONTAL SPREAD	:	2.174	1.546	1.110
VERTICAL SPREAD	:	1.562	1.562	1.168
EXTREME SPREAD	:	2.301	1.657	1.471
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

23 Oct 1991

FILE:XPATTERNING/CENTERFIRE_PATT/C8665747

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 7

HS = 2.413

VS = 3.934

GS = 4.474

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.967	.838	.725
MINIMUM X	-1.446	-1.575	-1.470
MAXIMUM Y	1.722	1.476	1.222
MINIMUM Y	-2.212	-1.426	-1.241
CENTROID X	-.420	-.291	-.396
CENTROID Y	-.029	.217	.032
FOR TO CENTROID in.	.421	.363	.397
MIN RADIUS	.412	.140	.348
MEAN RADIUS	1.195	1.005	.926
MAX RADIUS	2.499	1.886	1.912
HORIZONTAL SPREAD	2.413	2.413	2.195
VERTICAL SPREAD	3.934	2.902	2.463
EXTREME SPREAD	4.474	3.032	3.027
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		