

FORN

UPC



0 47700 25716 7

C6665769

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 TM M24

SERIAL NO.
C6665769

20

ORDER NO.
5716

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



5716 C6665769

ORDER 5716
MODEL 700 TM M24
UPC



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ORDER 5716
MODEL 700 TM M24
UPC



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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6665769

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	10/1/91	KL
600	Proof		10/1/91	KL
607	Check Headspace		10/1/91	KL
610	Dis-assemble Gun		10/1/91	KL
612	Magnaflux Barrel Action		OCT 8 1991	KR
	Magnaflux Bolt		OCT 8 1991	KR
615	Rollmark Caliber		OCT 8 1991	GB
617	Drill and Tap Sight Holes		OCT 8 1991	LB
618	Polish Barrel		OCT 8 1991	WB
620	Apply Coatings (Barrel Action)		11/1/91	KL
	Apply Coating (Bolt)		11/1/91	KL
625	Final Assembly A) Clean inside of Bolt Assembly		11/7/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/7/91	KL
	C) Inspect Ejector Hole for Chamfer		11/7/91	KL
	D) Oil Firing Pin Ass'y		11/7/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		11/8/91	KL

op. #	NAME BARBER M24 0102307	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			11-8-91	SM
	G) Safety Off Force	3	3	3			11-8-91	SM
	H) Trigger Pull Test & Retainability						11/8/91	SM
	I) Firing Pin Indent	.0205	.0205	.021			11-8-91	SM
	J) Assemble Stock						11/11/91	SM
	K) Assemble Swivel Studs						11-21-91	SM
	L) Attach Front and Rear Sight Assemblies						11/11/91	SM
	M) Iron Sight Alignment						11/11/91	SM
	N) Detach Front & Rear Sights & place in numbered container						11/11/91	SM
	O) Attach Scope to Rifle						11/11/91	SM
	P) Detach & Attach Scope 20 Times						11/11/91	SM
640	Gallery Target & Test						11-19-91	DH
	A) Time						11-19-91	DH
	B) Malfunctions						11-19-91	DH
	C) Pierced Primers						11-19-91	DH
	D) Optical Clarity of Scope						11-19-91	DH
645	Inspect for Live Ammo						11-19-91	DH
655	Final Inspection						11-21-91	SM
	A) Headspace						11-21-91	SM
	B) Trigger Pull	262	263	267	267	263	11-19-91	DH
	C) Function						11-21-91	SM
660	Pack						12-19-91	SM

57AC

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6665769DATE 11-8-91TESTER JF

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.35	2.33	2.62	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.33	2.35	2.44	2.63	
PULL #3	2.36	2.36	2.35	2.67	
PULL #4	2.29	2.37	2.30	2.67	
PULL #5	2.36	2.38	2.38	2.63	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.54	3.49		
PULL #2	3.42	3.49		
PULL #3	3.40	3.46		
PULL #4	3.49	3.49		
PULL #5	3.42	3.49		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.33	4.26		4.36
PULL #2	4.22	4.29		4.29
PULL #3	4.33	4.31		4.36
PULL #4	4.36	4.30		4.30
PULL #5	4.27	4.39		4.32
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665769
19 Nov 1991

CENTROIDAL DISTANCES

0 TO 1	.43754
1 TO 2	.619698
1 TO 3	.537004
1 TO 4	.31232
1 TO 5	.726902

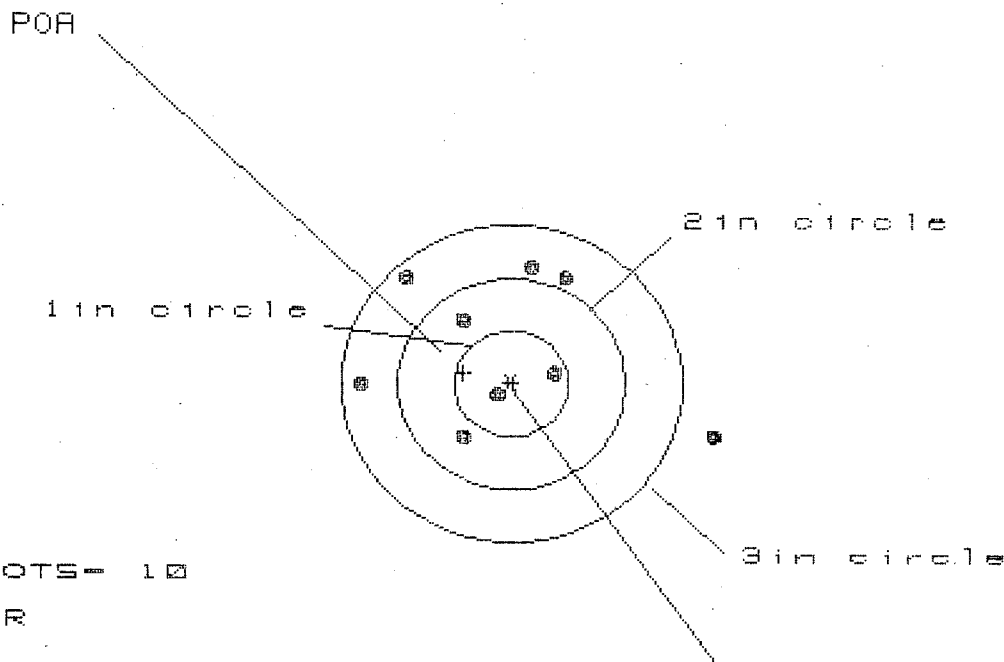
$\frac{1}{5}$ + 1' <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2162
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2328
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .317708
THE AMR FOR THIS RIFLE IS: .961

19 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8665769

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 3.074

VS= 3.844

GS= 3.907

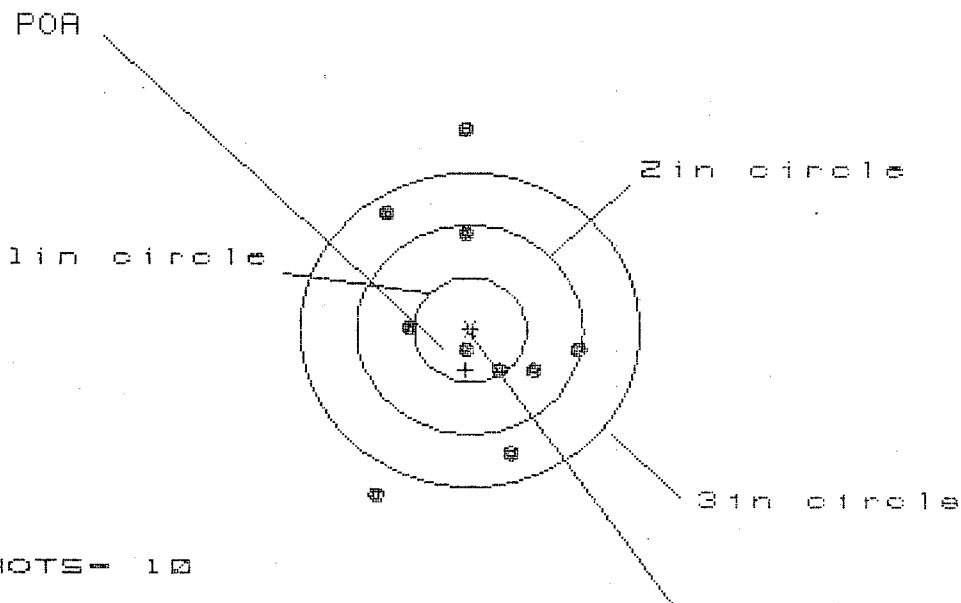
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.757	1.801	.747
MINIMUM X	-1.317	-1.273	-1.048
MAXIMUM Y	1.136	.835	.741
MINIMUM Y	-2.708	-.819	-.913
CENTROID X	.425	.381	.156
CENTROID Y	-.104	.197	.291
POA TO CENTROID in.	.438	.429	.331
MIN RADIUS	.177	.401	.191
MEAN RADIUS	1.134	.916	.763
MAX RADIUS	2.736	1.953	1.122
HORIZONTAL SPREAD	3.074	3.074	1.795
VERTICAL SPREAD	3.844	1.654	1.654
EXTREME SPREAD	3.907	3.107	2.049
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

19 Nov 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS = 1.841

VS = 3.466

GS = 3.579

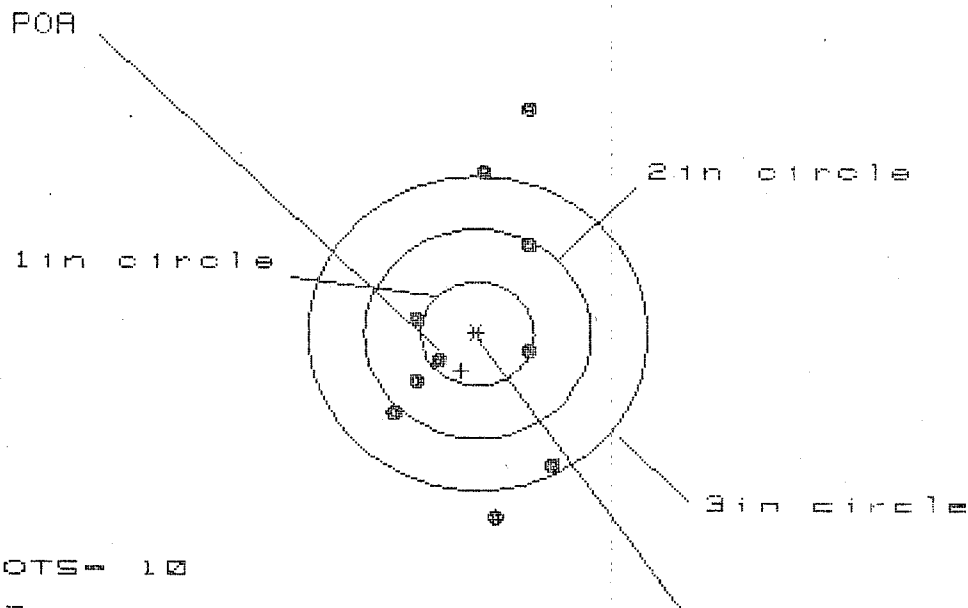
CENTROID *

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.956	.957	.846
MINIMUM X	-.885	-.884	-.856
MAXIMUM Y	1.874	1.295	1.123
MINIMUM Y	-1.592	-1.384	-1.137
CENTROID X	.038	.037	.148
CENTROID Y	.388	.172	.344
POA TO CENTROID in.	.382	.176	.375
MIN RADIUS	.221	.016	.221
MEAN RADIUS	1.000	.860	.772
MAX RADIUS	1.974	1.642	1.412
HORIZONTAL SPREAD	1.841	1.841	1.702
VERTICAL SPREAD	3.466	2.679	2.259
EXTREME SPREAD	3.579	2.683	2.533
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

19 May 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 7

HS = 1.392

VS = 3.947

GS = 3.956

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.634	.685	.715
MINIMUM X	-.758	-.707	-.677
MAXIMUM Y	2.148	1.814	1.619
MINIMUM Y	-1.799	-1.560	-1.208
CENTROID X	.143	.092	.062
CENTROID Y	.353	.114	.309
POA TO CENTROID in.	.381	.147	.316
MIN RADIUS	.399	.261	.310
MEAN RADIUS	1.122	.963	.884
MAX RADIUS	2.195	1.815	1.621
HORIZONTAL SPREAD	1.392	1.392	1.392
VERTICAL SPREAD	3.947	3.374	2.826
EXTREME SPREAD	3.956	3.379	2.894
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

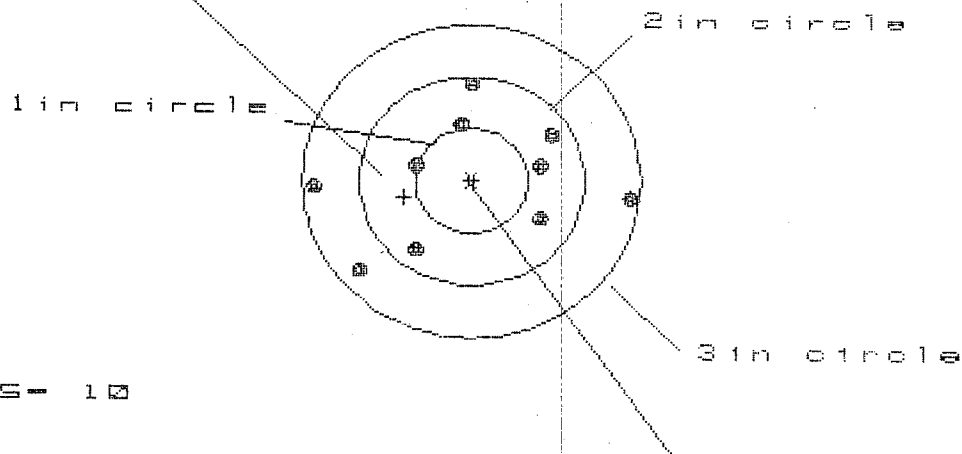
19 Nov 1991

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CENTERFIRE PATTERNS

4

POA



OF SHOTS - 10

IN CIR

1in = 1

2in = 7

3in = 10

HS = 2.813

VS = 1.790

GS = 2.817

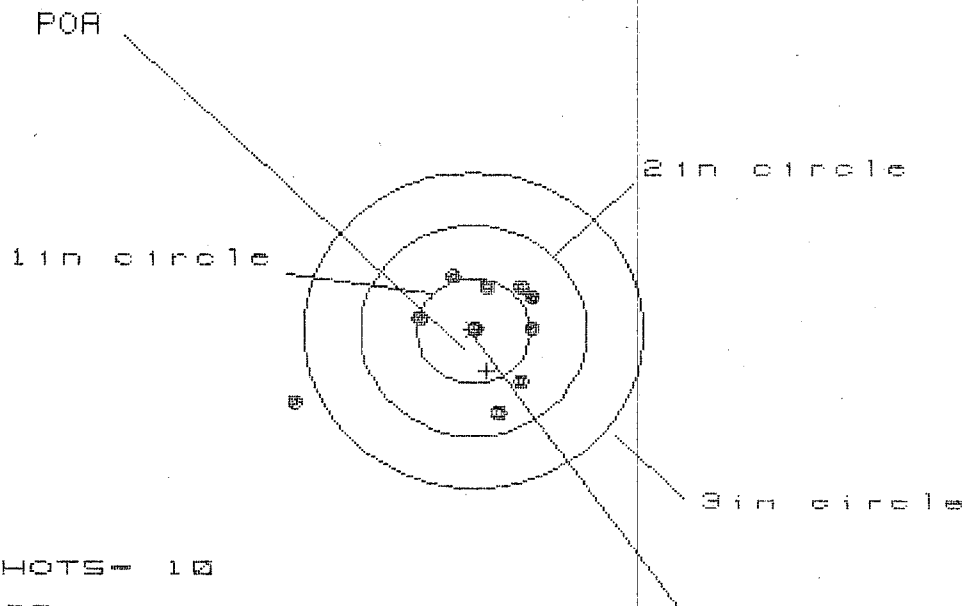
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.435	.903	.751
MINIMUM X	:	-1.378	-1.218	-.966
MAXIMUM Y	:	.942	.921	.912
MINIMUM Y	:	-.848	-.869	-.878
CENTROID X	:	.595	.435	.588
CENTROID Y	:	.158	.179	.188
POA TO CENTROID in.	:	.615	.471	.617
MIN RADIUS	:	.499	.373	.468
MEAN RADIUS	:	.907	.840	.777
MAX RADIUS	:	1.448	1.220	1.305
HORIZONTAL SPREAD	:	2.813	2.121	1.716
VERTICAL SPREAD	:	1.790	1.790	1.790
EXTREME SPREAD	:	2.817	2.167	2.118
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

19 Nov 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 3

2in = 9

3in = 9

HS= 2.159

VS= 1.367

GS= 2.332

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.550	.371	.381
MINIMUM X	:	-1.609	-.631	-.621
MAXIMUM Y	:	.564	.491	.382
MINIMUM Y	:	-.803	-.876	-.619
CENTROID X	:	-.120	.059	.049
CENTROID Y	:	.377	.450	.559
POA TO CENTROID in.	:	.396	.453	.561
MIN RADIUS	:	.028	.190	.233
MEAN RADIUS	:	.642	.489	.422
MAX RADIUS	:	1.735	.879	.657
HORIZONTAL SPREAD	:	2.159	1.002	1.002
VERTICAL SPREAD	:	1.367	1.367	1.001
EXTREME SPREAD	:	2.332	1.433	1.149
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		9	