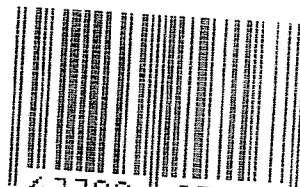


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FORM

UPC



0 47700 25716 7

06665770

INCLUDES 1 IN CHAMBER

MODEL 700 TM M24

5716

ORDER NO.

BARREL LENGTH

CAPACITY*

Remington



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

MODEL 700 TM M24

SERIAL NO.

C6665770

ORDER NO.

5716

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

20



5716 C6665770

ORDER 5716

MODEL 700 TM M24

UPC

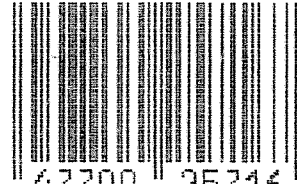
ORDER 5716

MODEL 700 TM M24

UPC



0 47700 25716 7



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6665770

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		9/24/91	KA
600	Proof		9/24/91	KA
607	Check Headspace		9/24/91	KA
610	Dis-assemble Gun		9/24/91	KA
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	WB
620	Apply Coatings (Barrel Action)		10/8/91	JS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/8/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/8/91	RW
	C) Inspect Ejector Hole for Chamfer		10/8/91	RW
	D) Oil Firing Pin Ass'y		10/8/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/8/91	RW

op. #	BARBER - M24 0102319 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	5.5	5			10/8/91	RW
	G) Safety Off Force	2.5	2.5	2			10/8/91	RW
	H) Trigger Pull Test & Retainability						10/8/91	RW
	I) Firing Pin Indent	.0225	.023	.023			10/8/91	RW
	J) Assemble Stock						10/9/91	RW
	K) Assemble Swivel Studs						10-17-91	AC
	L) Attach Front and Rear Sight Assemblies						10/9/91	RW
	M) Iron Sight Alignment						10/9/91	RW
	N) Detach Front & Rear Sights & place in numbered container						10/9/91	RW
	O) Attach Scope to Rifle						10/9/91	RW
	P) Detach & Attach Scope 20 Times						10/9/91	RW
640	Gallery Target & Test						10/11/91	KT
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	FT
645	Inspect for Live Ammo						10/11/91	KT
655	Final Inspection							
	A) Headspace						10-17-91	AC
	B) Trigger Pull	2.33	2.52	2.52	2.55	2.50	10/14/91	RW
	C) Function						10-17-91	AC
660	Pack						12-17-91	VF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6665770

DATE 10/8/91

TESTER RW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.56	2.43	2.64	2.33	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.46	2.36	2.57	2.52	
PULL #3	2.54	2.37	2.66	2.52	
PULL #4	2.48	2.41	2.49	2.55	
PULL #5	2.47	2.41	2.59	2.50	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.25	3.26		
PULL #2	3.26	3.09		
PULL #3	3.23	3.34		
PULL #4	3.24	3.45		
PULL #5	3.19	3.34		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.08	4.28		4.35
PULL #2	4.17	4.21		4.33
PULL #3	4.13	4.13		4.38
PULL #4	4.01	4.21		4.26
PULL #5	4.02	4.17		4.12
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665770
11 Oct 1991

CENTROIDAL DISTANCES

0 TO 1	.310161
1 TO 2	.441702
1 TO 3	.39298
1 TO 4	.439164
1 TO 5	.372336

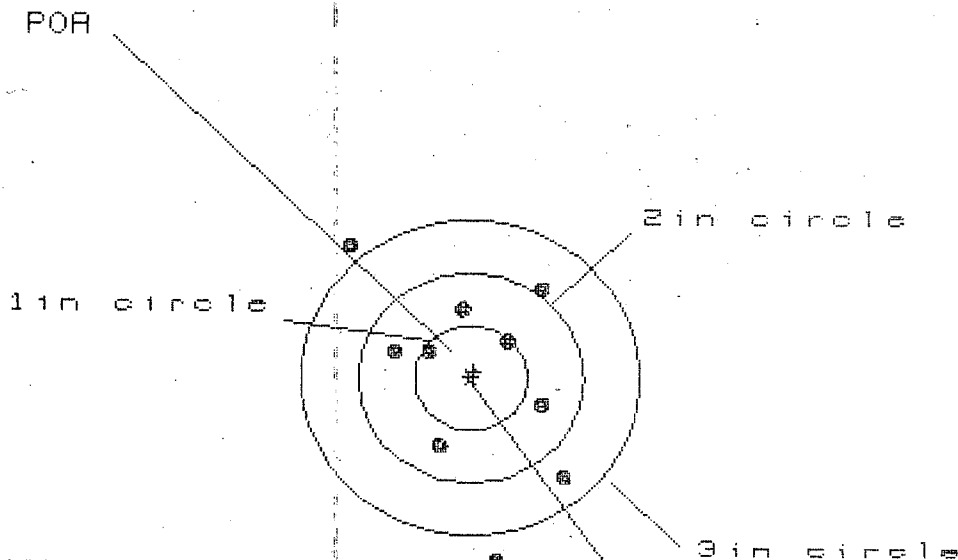
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0476
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0298
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0561587
THE AMR FOR THIS RIFLE IS: .7908

11 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665770

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in - 1

2in - 6

3in - 8

HS- 1.825

VS- 3.007

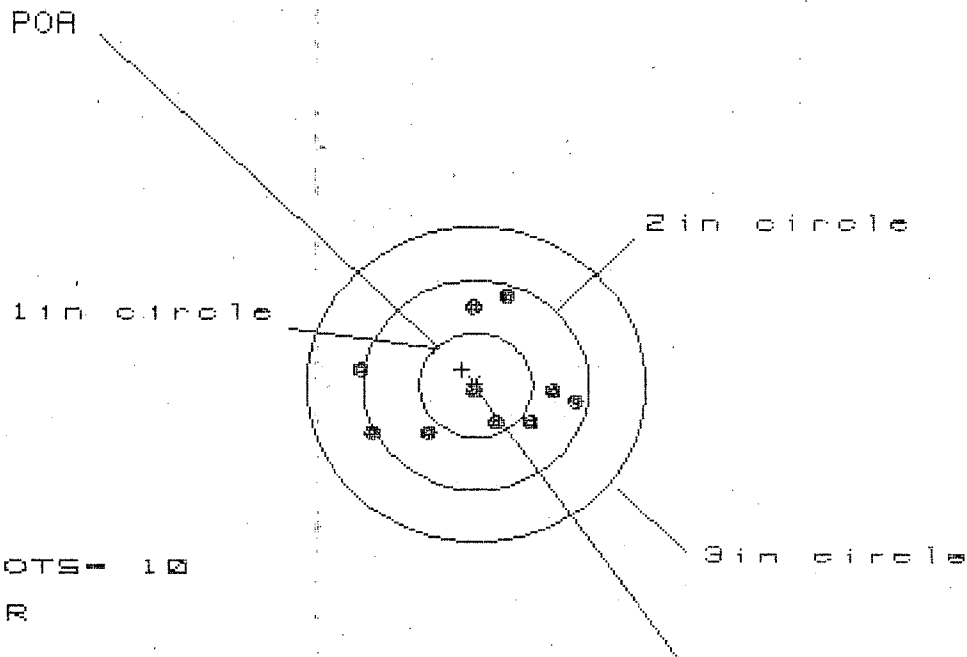
GS- 3.247

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.781	.802	.674
MINIMUM X	:	-1.043	-1.023	-.799
MAXIMUM Y	:	1.266	1.073	.788
MINIMUM Y	:	-1.741	-1.126	-.992
CENTROID X	:	-.025	-.046	.082
CENTROID Y	:	-.057	.136	.002
POA TO CENTROID in.	:	.063	.144	.082
MIN RADIUS	:	.493	.402	.386
MEAN RADIUS	:	.946	.828	.749
MAX RADIUS	:	1.750	1.482	1.199
HORIZONTAL SPREAD	:	1.825	1.825	1.473
VERTICAL SPREAD	:	3.007	2.199	1.780
EXTREME SPREAD	:	3.247	2.858	1.874
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	8		

11 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665770

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in - 2

2 in - 8

3 in = 10

HS- 1.878

VS= 1.336

GS= 1.893

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.845	.738	.595
MINIMUM X	-1.033	-1.140	-.690
MAXIMUM Y	.884	.834	.845
MINIMUM Y	-.452	-.492	-.481
CENTROID X	.122	.229	.372
CENTROID Y	-.149	-.099	-.110
POA TO CENTROID in.	.193	.250	.388
MIN RADIUS	.068	.152	.263
MEAN RADIUS	.699	.651	.572
MAX RADIUS	1.070	1.144	.845
HORIZONTAL SPREAD	1.878	1.878	1.285
VERTICAL SPREAD	1.336	1.326	1.326
EXTREME SPREAD	1.893	1.893	1.505
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

11 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665770

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 9

HS= 2.230

VS= 2.704

GS= 2.719

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.171	1.126	.988
MINIMUM X	:	-1.059	-1.104	-.832
MAXIMUM Y	:	1.620	1.248	1.168
MINIMUM Y	:	-1.084	-.904	-.984
CENTROID X	:	.022	.067	.205
CENTROID Y	:	-.093	-.273	-.193
POA TO CENTROID in.	:	.095	.281	.282
MIN RADIUS	:	.263	.147	.306
MEAN RADIUS	:	1.000	.897	.861
MAX RADIUS	:	1.670	1.423	1.289
HORIZONTAL SPREAD	:	2.230	2.230	1.820
VERTICAL SPREAD	:	2.704	2.152	2.152
EXTREME SPREAD	:	2.719	2.597	2.470
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

11 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665720

CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 9

3 in = 10

HS= 1.957

VS= 1.559

GS= 2.060

PATTERN #

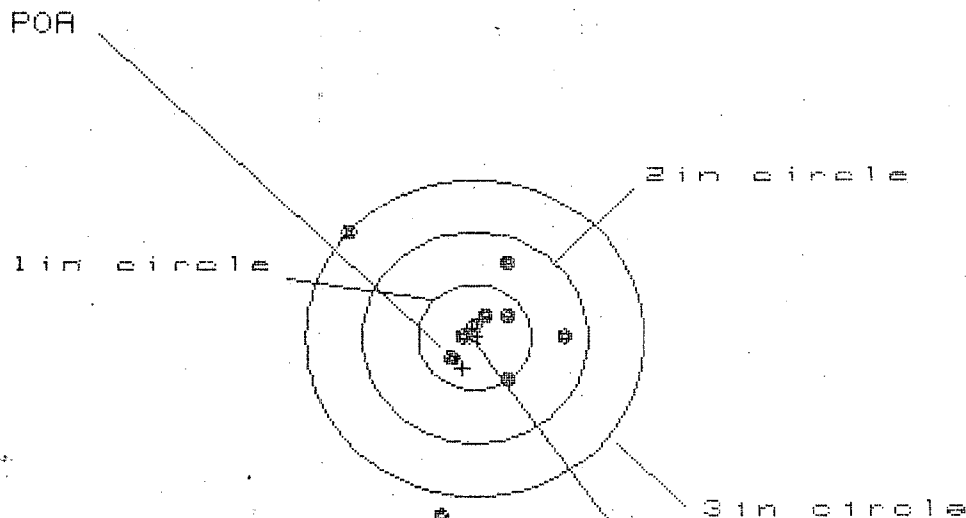
4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.228	.462	.480
MINIMUM X	-.729	-.593	-.575
MAXIMUM Y	.732	.774	.676
MINIMUM Y	-.827	-.785	-.665
CENTROID X	.009	-.127	-.145
CENTROID Y	-.140	-.182	-.084
POA TO CENTROID in.	.141	.222	.168
MIN RADIUS	.176	.254	.191
MEAN RADIUS	.667	.584	.541
MAX RADIUS	1.284	.895	.822
HORIZONTAL SPREAD	1.957	1.055	1.055
VERTICAL SPREAD	1.559	1.559	1.341
EXTREME SPREAD	2.060	1.589	1.444
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	

11 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06065770

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in - 5

2in - 8

3in = 9

HS- 1.865

VS= 2.608

GS= 2.743

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.754	.725	.583
MINIMUM X	:	-1.111	-1.140	-.411
MAXIMUM Y	:	.967	.785	.638
MINIMUM Y	:	-1.641	-.616	-.518
CENTROID X	:	.110	.139	.281
CENTROID Y	:	.290	.472	.374
POA TO CENTROID in.	:	.310	.492	.468
MIN RADIUS	:	.126	.072	.171
MEAN RADIUS	:	.642	.509	.396
MAX RADIUS	:	1.662	1.384	.656
HORIZONTAL SPREAD	:	1.865	1.865	.994
VERTICAL SPREAD	:	2.608	1.401	1.156
EXTREME SPREAD	:	2.743	2.093	1.157
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	