

FILED

UPC



0 47700 25716 7

6665771

*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.
C6665771

ORDER NO.
5716

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

20



5716 C6665771

ORDER 5716
MODEL 700 TM M24
UPC

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MODEL 700 TM M24
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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6665771

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		9/26/91	KA
600	Proof		9/26/91	KA
607	Check Headspace		9/26/91	KA
610	Dis-assemble Gun		9/26/91	KA
612	Magnaflux Barrel Action	OCT	4 1991	KCR
	Magnaflux Bolt	OCT	4 1991	KCR
615	Rollmark Caliber	OCT	4 1991	GS
617	Drill and Tap Sight Holes	OCT	4 1991	LB
618	Polish Barrel	OCT	4 1991	WB
620	Apply Coatings (Barrel Action)		10-18-91	KA
	Apply Coating (Bolt)		10-18-91	KA
625	Final Assembly A) Clean inside of Bolt Assembly		11/7/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/7/91	KA
	C) Inspect Ejector Hole for Chamfer		11/7/91	KA
	D) Oil Firing Pin Ass'y		11/7/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		11-8-91	KA

op. #	BARBER M24 0102331	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			11-8-91	JK
	G) Safety Off Force	3	3	3			11-8-91	JK
	H) Trigger Pull Test & Retainability						11-8-91	JK
	I) Firing Pin Indent	0205	022	022			11-8-91	JK
	J) Assemble Stock						11/8/91	JK
	K) Assemble Swivel Studs						11-19-91	D/H
	L) Attach Front and Rear Sight Assemblies						11/8/91	JK
	M) Iron Sight Alignment						11/8/91	JK
	N) Detach Front & Rear Sights & place in numbered container						11/8/91	JK
	O) Attach Scope to Rifle						11/8/91	JK
	P) Detach & Attach Scope 20 Times						11/8/91	JK
640	Gallery Target & Test						11/13/91	KT
	A) Time							14
	B) Malfunctions							14
	C) Pierced Primers							14
	D) Optical Clarity of Scope							14
645	Inspect for Live Ammo						11/13/91	KT
655	Final Inspection						11-18-91	D/H
	A) Headspace						11-18-91	D/H
	B) Trigger Pull	262	271	257	273	281	11-18-91	D/H
	C) Function						11-18-91	D/H
660	Pack						12-19-96	NE

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO 26665771DATE 11-8-91TESTER JP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.32	2.27	2.38	2.62	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.23	2.27	2.30	2.71	
PULL #3	2.32	2.20	2.35	2.57	
PULL #4	2.32	2.28	2.38	2.73	
PULL #5	2.43	2.36	2.38	2.81	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.32	3.23		
PULL #2	3.49	3.46		
PULL #3	3.40	3.47		
PULL #4	2.26	3.59		
PULL #5	3.23	3.45		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.29	4.49		4.53
PULL #2	4.42	4.46		4.48
PULL #3	4.25	4.19		4.45
PULL #4	4.54	4.51		4.48
PULL #5	4.22	4.55		4.45
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665771
13 Nov 1991

CENTROIDAL DISTANCES

0 TO 1	.106024
1 TO 2	.15103
1 TO 3	.177519
1 TO 4	.280409
1 TO 5	.126574

←---POR

THE AVERAGE X COORDINATE FOR THIS RIFLE IS: -.0674
THE AVERAGE Y COORDINATE FOR THIS RIFLE IS: -.0054
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .067616

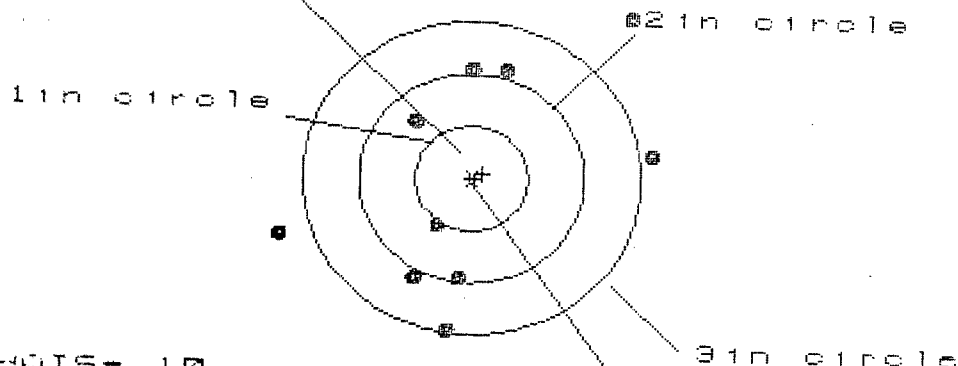
THE AMP FOR THIS RIFLE IS: 1.123

LS No. 591

FILE: PATTERNING/CENTERFIRE_PATT/C6665771

CENTERFIRE PATTERNS # 1

POF



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 3

3 in = 7

IS = 3.213

VS = 2.981

CS = 3.636

CENTROID *

PATTERN #	10	9	8
NOTS (BEST OF)			
MINIMUM X	1.546	1.696	1.507
MINIMUM X	-1.667	-1.517	-.533
MINIMUM Y	1.513	1.258	1.214
MINIMUM Y	-1.468	-1.300	-1.344
CENTROID X	-.096	-.246	-.057
CENTROID Y	-.045	-.214	-.170
IN TO CENTROID in.	.106	.326	.179
RADIUS	.569	.350	.492
RADIUS	1.236	1.109	1.065
RADIUS	2.028	1.743	1.548
HORIZONTAL SPREAD	3.213	3.213	2.040
VERTICAL SPREAD	2.981	2.558	2.558
EXTREME SPREAD	3.636	3.298	2.602
DEEP IN ONE INCH CIRCLE =		0	
DEEP IN TWO INCH CIRCLE =		3	
DEEP IN THREE INCH CIRCLE =		7	

13 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8865771

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 7

HS= 2.549

VS= 3.035

GS= 3.700

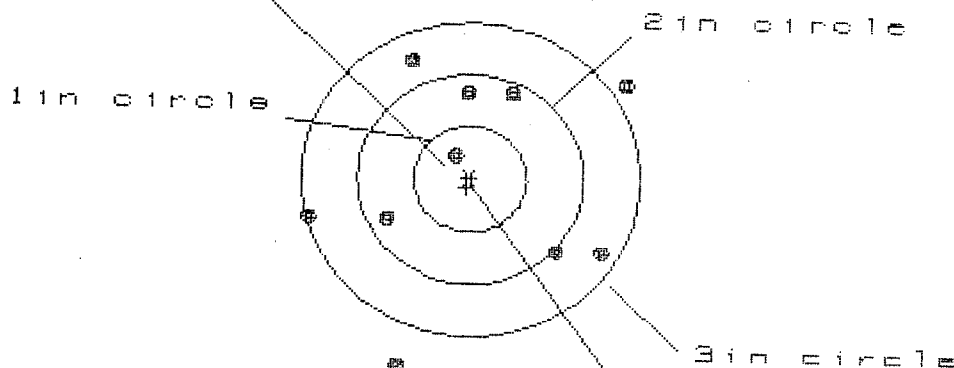
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.199	1.091	.909
MINIMUM X	-1.350	-1.458	-1.602
MAXIMUM Y	1.692	1.424	.789
MINIMUM Y	-1.343	-1.154	-.977
CENTROID X	.055	.163	.345
CENTROID Y	-.042	-.231	-.408
POA TO CENTROID in.	.069	.282	.535
MIN RADIUS	.039	.236	.280
MEAN RADIUS	1.148	1.035	.890
MAX RADIUS	1.953	2.038	1.646
HORIZONTAL SPREAD	2.549	2.549	2.511
VERTICAL SPREAD	3.035	2.578	1.766
EXTREME SPREAD	3.700	3.586	2.802
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		7	

13 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665721

CENTERFIRE PATTERNS # 3

POA



OF SHOTS- 10

IN CIR

1 in - 1

2 in - 5

3 in - 8

HS- 2.792

VS- 2.927

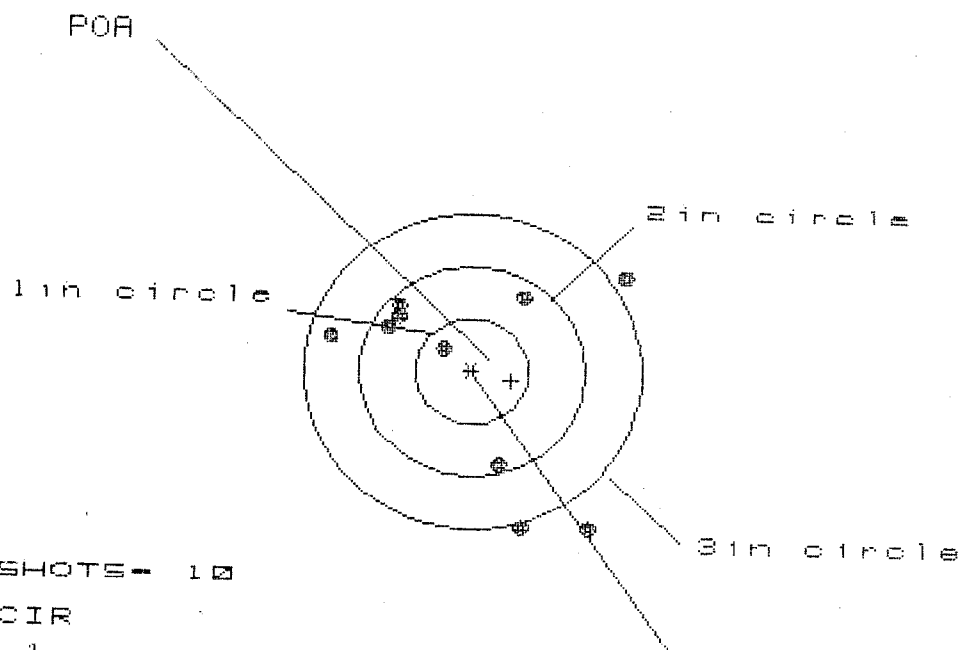
GS- 3.308

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.344	1.275	1.241
MINIMUM X	-1.448	-1.517	-1.358
MAXIMUM Y	1.152	.954	1.040
MINIMUM Y	-1.775	-.872	-.786
CENTROID X	.032	.101	-.058
CENTROID Y	.078	.276	.190
POA TO CENTROID in.	.085	.294	.198
MIN RADIUS	.244	.166	.114
MEAN RADIUS	1.139	1.019	.958
MAX RADIUS	1.882	1.626	1.460
HORIZONTAL SPREAD	2.792	2.792	2.599
VERTICAL SPREAD	2.927	1.826	1.826
EXTREME SPREAD	3.308	3.068	2.613
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

3 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6685771

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 6

3 in = 7

HS= 2.531

VS= 2.446

GS= 2.907

CENTROID *

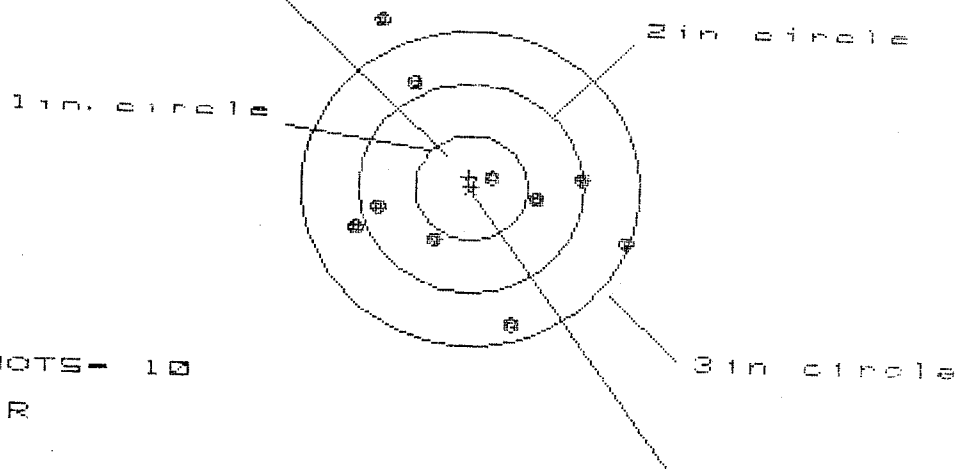
PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.307	1.425	1.499
MINIMUM X	-1.224	-1.106	-1.032
MAXIMUM Y	.916	.757	.545
MINIMUM Y	-1.530	-1.689	-1.262
CENTROID X	-.346	-.464	-.538
CENTROID Y	.082	.241	.453
POA TO CENTROID in.	.356	.523	.703
MIN RADIUS	.346	.149	.111
MEAN RADIUS	1.099	.960	.799
MAX RADIUS	1.783	1.790	1.595
HORIZONTAL SPREAD	2.531	2.531	2.531
VERTICAL SPREAD	2.446	2.446	1.807
EXTREME SPREAD	2.907	2.590	2.590
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	7		

13 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6865771

CENTERFIRE PATTERNS # 5

POA



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 2.398

VS= 2.848

GS= 3.107

CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.405	1.308	1.033
MINIMUM X	-.993	-1.090	-.926
MAXIMUM Y	1.594	1.174	1.140
MINIMUM Y	-1.254	-1.077	-1.111
CENTROID X	.018	.115	-.049
CENTROID Y	-.100	-.277	-.243
POA TO CENTROID in.	.102	.300	.247
MIN RADIUS	.195	.307	.344
MEAN RADIUS	.991	.887	.820
MAX RADIUS	1.814	1.337	1.226
HORIZONTAL SPREAD	2.398	2.398	1.959
VERTICAL SPREAD	2.848	2.251	2.251
EXTREME SPREAD	3.107	2.422	2.422
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	