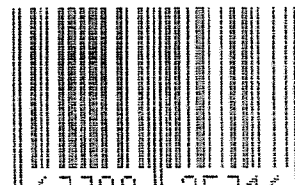


FIG 20

UPC



0 47700 25716 7

05665779

INCLUDED IN DISK

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.

C6665779

ORDER NO.

5716

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

20



5716 C6665779

ORDER 5716

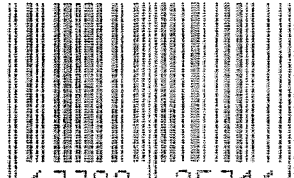
MODEL 700 TM M24

UPC

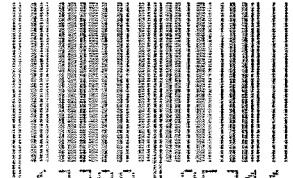
ORDER 5716

MODEL 700 TM M24

UPC



0 47700 25716 7



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6665779

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		9/23/91	KR
600	Proof		9/23/91	KR
607	Check Headspace		9/23/91	KR
610	Dis-assemble Gun		9/23/91	KR
612	Magnaflux Barrel Action		SEP 30 1991	KR
	Magnaflux Bolt		SEP 30 1991	KR
615	Rollmark Caliber		SEP 30 1991	JS
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	JA
	Apply Coating (Bolt)		10-8-91	JA
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	JA

op. #	BARBER - M24 0102429		READINGS					DATE	INIT
	OP. NAME								
625 cont.	F) Safety On Force		6	6	6 6			10/8/91	RW
	G) Safety Off Force		3	2 1/2	2 1/2			10/8/91	RW
	H) Trigger Pull Test & Retainability							10-8-91	JH
	I) Firing Pin Indent		.023	.022	.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	DH
	A) Time							10-11-91	DH
	B) Malfunctions							10-11-91	DH
	C) Pierced Primers							10-11-91	DH
	D) Optical Clarity of Scope							10-11-91	DH
645	Inspect for Live Ammo							10-11-91	DH
655	Final Inspection								
	A) Headspace							10-17-91	AC
	B) Trigger Pull		2.52	2.55	2.56	2.60	2.57	10-11-91	DH
	C) Function							10-17-91	AC
660	Pack							12-17-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6665779

DATE 10-8-91

TESTER gll

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.24	2.57	2.54	2.52	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.42	2.53	2.50	2.55	
PULL #3	2.55	2.52	2.48	2.56	
PULL #4	2.53	2.43	2.48	2.60	
PULL #5	2.47	2.44	2.40	2.57	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.68	3.48		
PULL #2	3.66	3.57		
PULL #3	3.48	3.66		
PULL #4	3.67	3.69		
PULL #5	3.66	3.60		
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	4.55		4.34
PULL #2	4.21	4.38		4.30
PULL #3	4.13	4.58		4.29
PULL #4	4.45	4.47		4.24
PULL #5	4.57	4.30		4.26
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665779
14 Oct 1991

CENTROIDAL DISTANCES

0 TO 1	.45326
1 TO 2	.672334
1 TO 3	.473173
1 TO 4	.902222
1 TO 5	.888079

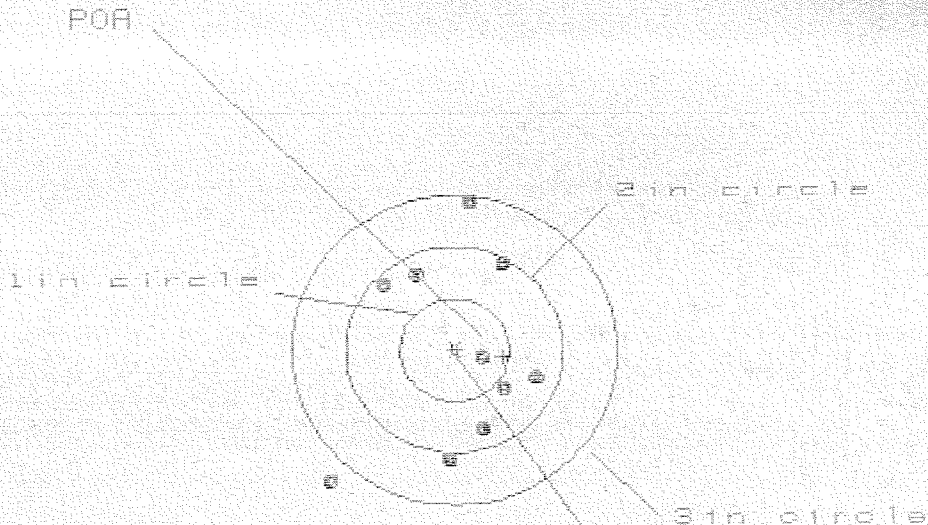
$\frac{32^4}{15}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0584
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .3248
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .330003
THE AMR FOR THIS RIFLE IS: .0710

14 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8865729

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS= 1.861

VS= 2.740

GS= 3.005

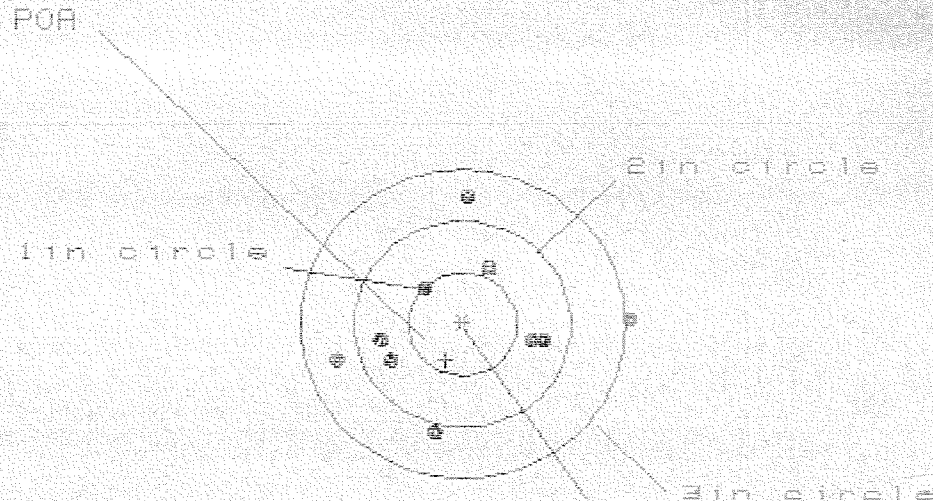
PATTERN # : 1

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.728	.602	.599
MINIMUM X	-1.133	-.819	-.822
MAXIMUM Y	1.458	1.316	.868
MINIMUM Y	-1.282	-1.164	-.999
CENTROID X	-.449	-.323	-.320
CENTROID Y	.062	.205	.040
POA TO CENTROID in.	.453	.383	.323
MIN RADIUS	.246	.206	.115
MEAN RADIUS	.933	.826	.736
MAX RADIUS	1.710	1.316	1.038
HORIZONTAL SPREAD	1.861	1.421	1.421
VERTICAL SPREAD	2.740	2.480	1.867
EXTREME SPREAD	3.005	2.486	1.937
NUMBER IN ONE INCH CIRCLE =	1	7	9
NUMBER IN TWO INCH CIRCLE =	7	9	9
NUMBER IN THREE INCH CIRCLE =	9	9	9

14 Oct 1991

FILE: <PATTERNING/CENTERFIRE_PATT/C6665729

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 6

3 in = 9

HS= 2.681

VS= 2.232

GS= 2.716

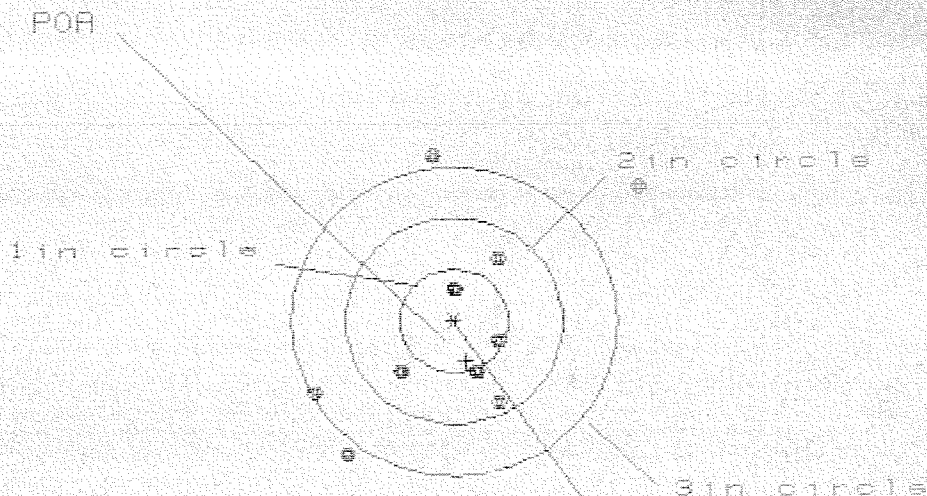
CENTROID *

PATTERN #	2
SHOTS (BEST OF)	10
MAXIMUM X	1.551
MINIMUM X	-1.130
MAXIMUM Y	1.215
MINIMUM Y	-1.017
CENTROID X	.159
CENTROID Y	.349
POA TO CENTROID in.	.384
MIN RADIUS	.489
MEAN RADIUS	.900
MAX RADIUS	1.553
HORIZONTAL SPREAD	2.691
VERTICAL SPREAD	2.232
EXTREME SPREAD	2.716
NUMBER IN ONE INCH CIRCLE	1
NUMBER IN TWO INCH CIRCLE	6
NUMBER IN THREE INCH CIRCLE	9

(4 Oct 1991)

FILE: /PATTERNING/CENTERFIRE_PATT/06685729

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 7

HS= 2.956

VS= 2.907

GS= 3.712

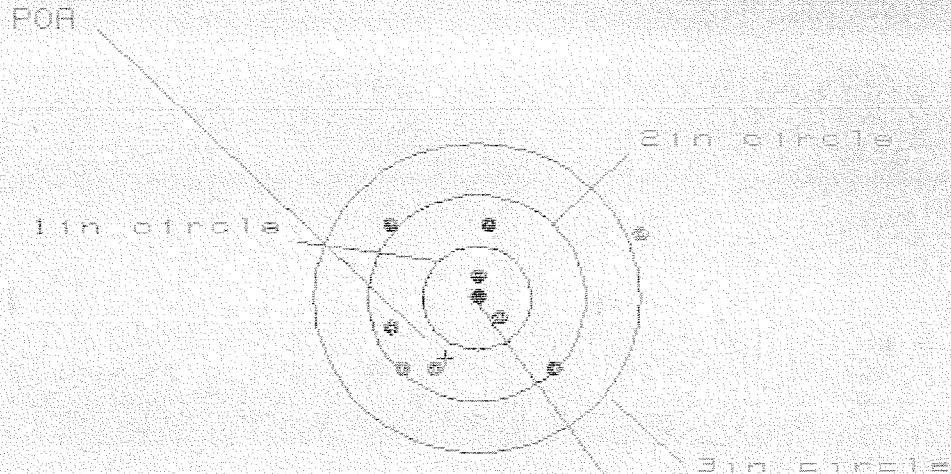
CENTROID *

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.671
MINIMUM X	-1.285
MAXIMUM Y	1.635
MINIMUM Y	-1.272
CENTROID X	-.107
CENTROID Y	.389
POA TO CENTROID in.	.403
MIN RADIUS	.305
MEAN RADIUS	1.042
MAX RADIUS	2.145
HORIZONTAL SPREAD	2.956
VERTICAL SPREAD	2.907
EXTREME SPREAD	3.712
NUMBER IN ONE INCH CIRCLE	3
NUMBER IN TWO INCH CIRCLE	6
NUMBER IN THREE INCH CIRCLE	7

14 Oct 1991

FILE: \PATTERNS\CENTERFIRE_PATT\C8685779

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 8

3 in = 9

HS= 2.293

VS= 1.447

GS= 2.537

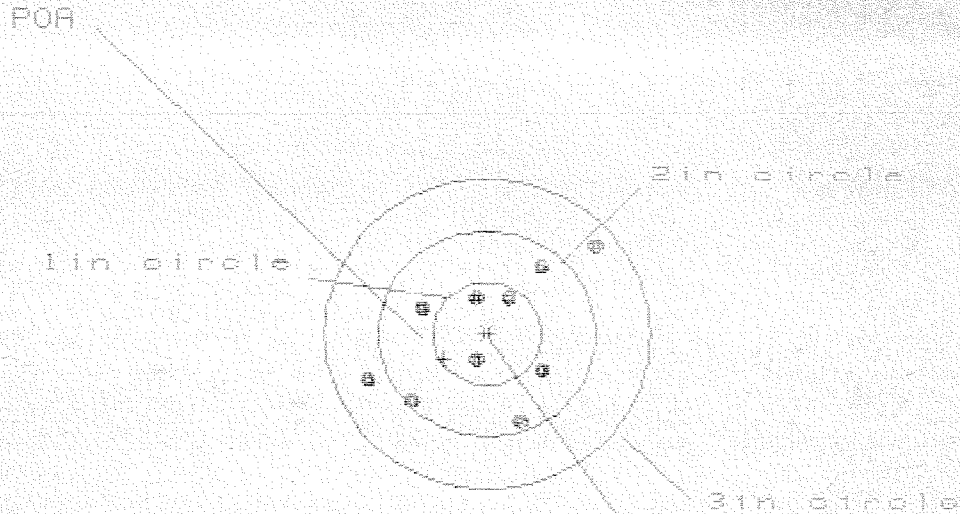
CENTROID X

PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	1.497
MINIMUM X	-0.796
MAXIMUM Y	0.762
MINIMUM Y	-0.685
CENTROID X	0.289
CENTROID Y	0.531
POA TO CENTROID in.	0.649
MIN RADIUS	0.065
MEAN RADIUS	0.751
MAX RADIUS	1.635
HORIZONTAL SPREAD	2.293
VERTICAL SPREAD	1.447
EXTREME SPREAD	2.537
NUMBER IN ONE INCH CIRCLE	3
NUMBER IN TWO INCH CIRCLE	8
NUMBER IN THREE INCH CIRCLE	9

14 Oct 1991

FILE: PATTERNING/CENTERFIRE_PATT/C6565729

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 8

3 in = 10

HS= 2.079

VS= 1.638

GS= 2.430

CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.028	.645	.528
MINIMUM X	-1.050	-.936	-.656
MAXIMUM Y	.834	.743	.701
MINIMUM Y	-.804	-.711	-.753
CENTROID X	.400	.285	.402
CENTROID Y	.243	.150	.192
POA TO CENTROID in.	.468	.322	.446
MIN RADIUS	.234	.117	.191
MEAN RADIUS	.733	.659	.610
MAX RADIUS	1.324	.993	.901
HORIZONTAL SPREAD	2.079	1.581	1.184
VERTICAL SPREAD	1.638	1.454	1.454
EXTREME SPREAD	2.430	1.882	1.749
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	