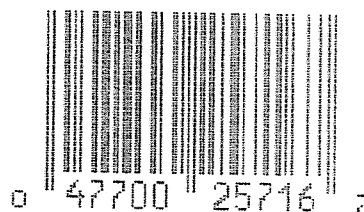


FORM

UPC



06665784

*INCLUDES 1 IN CHAMBER

MODEL 700 TH 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.

C6665784

ORDER NO.

5716

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

20



5716 C6665784

ORDER 5716

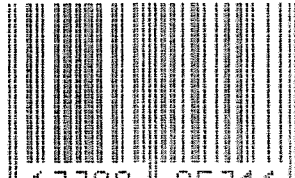
MODEL 700 TM M24

UPC

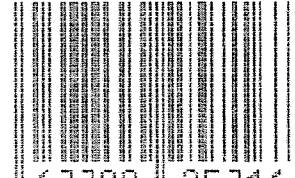
ORDER 5716

MODEL 700 TM M24

UPC



0 47700 25716 7



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # *C6665784*

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 26 91		<i>RW</i>
600	Proof	9 26 91		<i>RW</i>
607	Check Headspace	9 26 91		<i>RW</i>
610	Dis-assemble Gun	9 26 91		<i>RW</i>
612	Magnaflux Barrel Action		SEP 30 1991	<i>KR</i>
	Magnaflux Bolt		SEP 30 1991	<i>KR</i>
615	Rollmark Caliber		SEP 30 1991	<i>LL</i>
617	Drill and Tap Sight Holes		SEP 30 1991	<i>FB</i>
618	Polish Barrel		OCT 2 1991	<i>WB</i>
620	Apply Coatings (Barrel Action)		10-13-91	<i>JA</i>
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/13/91	<i>RW</i>
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/13/91	<i>RW</i>
	C) Inspect Ejector Hole for Chamfer		10/13/91	<i>RW</i>
	D) Oil Firing Pin Ass'y		10/13/91	<i>RW</i>
	E) Adjust Trigger Pull to Min Setting and Stake		10/17/91	<i>JH</i>

op. #	BARBER M24 0102490	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			10/17/91	SP
	G) Safety Off Force	3.5	3	3			10/17/91	SP
	H) Trigger Pull Test & Retainability						10/17/91	SP
	I) Firing Pin Indent	.0215	.0225	.0225			10/17/91	SP
	J) Assemble Stock						10/17/91	PW
	K) Assemble Swivel Studs						10-22-91	AC
	L) Attach Front and Rear Sight Assemblies						10/17/91	PW
	M) Iron Sight Alignment						10/17/91	PW
	N) Detach Front & Rear Sights & place in numbered container						10/17/91	PW
	O) Attach Scope to Rifle						10/17/91	PW
	P) Detach & Attach Scope 20 Times						10/17/91	PW
640	Gallery Target & Test						10-17-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						10-17-91	NF
655	Final Inspection							
	A) Headspace						10-22-91	AC
	B) Trigger Pull	222	226	226	212	228	10-18-91	D/H
	C) Function						10-22-91	AC
660	Pack						12-20-91	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6665784

DATE 10/16/91

TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.42	2.45	222	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.39	2.41	2.48	226	
PULL #3	2.40	2.30	2.44	226	
PULL #4	2.43	2.44	2.38	212	
PULL #5	2.40	2.39	2.44	228	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.28		
PULL #2	3.35	3.19		
PULL #3	3.35	3.38		
PULL #4	3.34	3.19		
PULL #5	3.20	3.24		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.41	4.49		4.46
PULL #2	4.51	4.47		4.46
PULL #3	4.55	4.57		4.54
PULL #4	4.58	4.46		4.56
PULL #5	4.48	4.57		4.52
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06665784
18 Oct 1991

CENTROIDAL DISTANCES

0 TO 1	.284703
1 TO 2	.355928
1 TO 3	.782001
1 TO 4	.226491
1 TO 5	1.07978

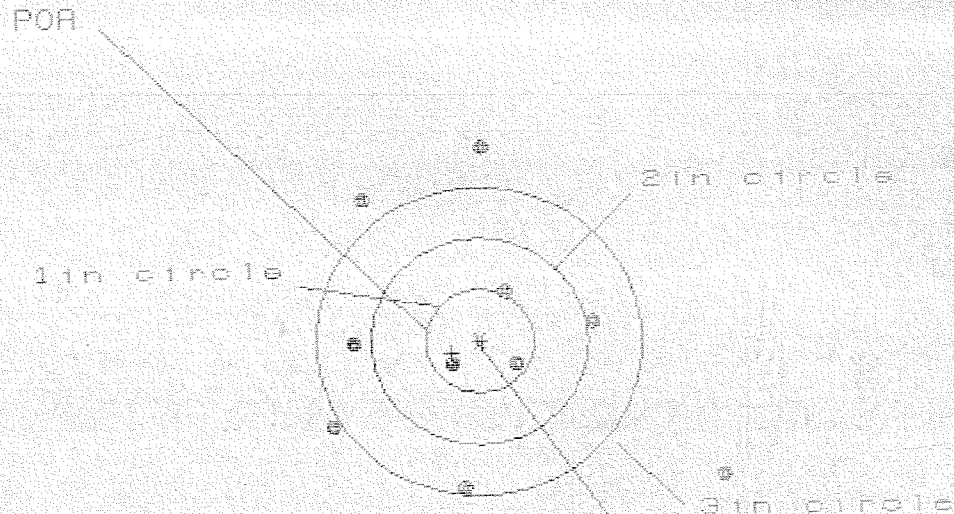
1 <----POB
5 3

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0336
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.267
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .269106
THE AMR FOR THIS RIFLE IS: .0922

18 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665784

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 3

3in = 5

HS= 3.532

VS= 3.255

GS= 4.261

CENTROID *

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.222	1.326	1.357
MINIMUM X	-1.310	-1.063	-1.032
MAXIMUM Y	1.853	1.705	1.404
MINIMUM Y	-1.402	-1.550	-1.337
CENTROID X	.260	.013	-.019
CENTROID Y	.116	.264	.051
POA TO CENTROID in.	.285	.265	.054
MIN RADIUS	.358	.373	.158
MEAN RADIUS	1.277	1.130	1.021
MAX RADIUS	2.593	1.723	1.662
HORIZONTAL SPREAD	3.532	2.389	2.389
VERTICAL SPREAD	3.255	3.255	2.921
EXTREME SPREAD	4.261	3.259	2.954
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	6		

18 Oct 1991

FILE: PATTERNING/CENTERFIRE_PATT/C86657B1

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 9

HS= 2.535

VS= 1.419

GS= 2.797

CENTROID +

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.140	.985	.725
MINIMUM X	-1.395	-.770	-.647
MAXIMUM Y	.675	.612	.681
MINIMUM Y	-.744	-.807	-.738
CENTROID X	.018	.173	.050
CENTROID Y	-.145	-.082	-.151
POA TO CENTROID in.	.147	.192	.159
MIN RADIUS	.289	.221	.274
MEAN RADIUS	.746	.651	.582
MAX RADIUS	1.507	1.128	.916
HORIZONTAL SPREAD	2.535	1.755	1.372
VERTICAL SPREAD	1.419	1.419	1.419
EXTREME SPREAD	2.797	1.888	1.672
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		9	

18 Oct 1991

FILE: PATTERNING/CENTERFIRE_PATT/060657B1

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 2.533

VS= 3.363

GS= 3.564

CENTROID #

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.468
MINIMUM X	-1.073
MAXIMUM Y	1.369
MINIMUM Y	-1.994
CENTROID X	.339
CENTROID Y	-.662
POA TO CENTROID in.	.744
MIN RADIUS	.063
MEAN RADIUS	1.065
MAX RADIUS	2.130
HORIZONTAL SPREAD	2.533
VERTICAL SPREAD	3.363
EXTREME SPREAD	3.564
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	8

18 Oct 1991

FILE: \PATTERNING\CENTERFIRE_PATT\08685784

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 4

2 in = 7

3 in = 8

HS= 1.836

VS= 3.428

GS= 3.486

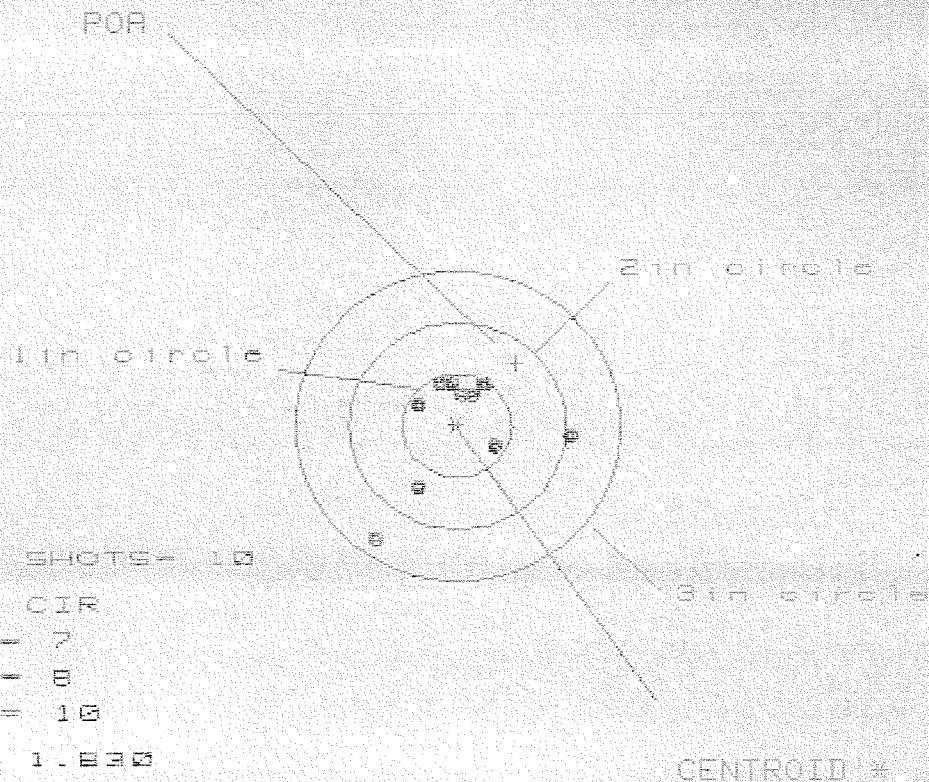
CENTROID *

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.193	1.125	1.120
MINIMUM X	-.643	-.711	-.716
MAXIMUM Y	1.767	1.582	.569
MINIMUM Y	-1.661	-.809	-.611
CENTROID X	.093	.161	.166
CENTROID Y	-.037	.148	-.050
POA TO CENTROID in.	.100	.218	.174
MIN RADIUS	.015	.200	.062
MEAN RADIUS	.793	.709	.559
MAX RADIUS	1.770	1.583	1.143
HORIZONTAL SPREAD	1.836	1.936	1.836
VERTICAL SPREAD	3.428	2.391	1.130
EXTREME SPREAD	3.486	2.482	2.020
NUMBER IN ONE INCH CIRCLE	= 4		
NUMBER IN TWO INCH CIRCLE	= 7		
NUMBER IN THREE INCH CIRCLE	= 8		

18 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66657B4

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 7

2in = 8

3in = 10

HS= 1.830

VS= 1.559

GS= 2.103

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.030
MINIMUM X	-0.800
MAXIMUM Y	0.439
MINIMUM Y	-1.120
CENTROID X	-0.542
CENTROID Y	-0.607
POA TO CENTROID in.	0.814
MIN RADIUS	0.307
MEAN RADIUS	0.530
MAX RADIUS	1.376
HORIZONTAL SPREAD	1.830
VERTICAL SPREAD	1.559
EXTREME SPREAD	2.103
NUMBER IN ONE INCH CIRCLE	7
NUMBER IN TWO INCH CIRCLE	8
NUMBER IN THREE INCH CIRCLE	10