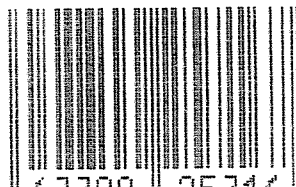


FILED

UPC



0 47700 25716 7

6665785

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.
C6665785

20

ORDER NO.
5716

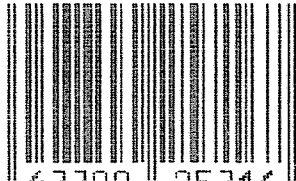
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.



5716 C6665785

ORDER **5716**
MODEL 700 TM M24

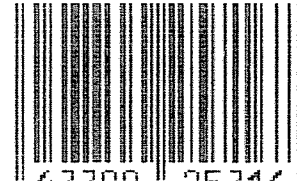
UPC



0 47700 25716 7

ORDER **5716**
MODEL 700 TM M24

UPC



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6665785

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		9/30/91	KK
600	Proof		9/30/91	KK
607	Check Headspace		9/30/91	KK
610	Dis-assemble Gun		9/30/91	KK
612	Magnaflux Barrel Action		OCT 8 1991	KR
	Magnaflux Bolt		OCT 8 1991	KR
615	Rollmark Caliber		OCT 8 1991	LS
617	Drill and Tap Sight Holes		OCT 8 1991	FB
618	Polish Barrel		10/14/91	WB
620	Apply Coatings (Barrel Action)		11-1-91	TH
	Apply Coating (Bolt)		11-1-91	TH
625	Final Assembly A) Clean inside of Bolt Assembly		11/12/91	KK
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/12/91	KK
	C) Inspect Ejector Hole for Chamfer		11/12/91	KK
	D) Oil Firing Pin Ass'y		11/12/91	KK
	E) Adjust Trigger Pull to Min Setting and Stake		11-13-91	JK

op. #	BARBER - M24 0102502		READINGS					DATE	INIT
	OP. NAME								
625 cont.	F) Safety On Force		4	4	4			11-13-91	SH
	G) Safety Off Force		3	3	3			11-13-91	SH
	H) Trigger Pull Test & Retainability							11-13-91	SH
	I) Firing Pin Indent		.0205	.0205	.0205			11-13-91	SH
	J) Assemble Stock							11-13-91	SH
	K) Assemble Swivel Studs							11-27-91	AC
	L) Attach Front and Rear Sight Assemblies							11-13-91	SH
	M) Iron Sight Alignment							11-13-91	SH
	N) Detach Front & Rear Sights & place in numbered container							11-13-91	SH
	O) Attach Scope to Rifle							11-13-91	SH
	P) Detach & Attach Scope 20 Times							11-13-91	SH
640	Gallery Target & Test							11-19-91	K
	A) Time							11-19-91	K
	B) Malfunctions							11-19-91	K
	C) Pierced Primers							11-19-91	K
	D) Optical Clarity of Scope							11-19-91	K
645	Inspect for Live Ammo							11-19-91	K
655	Final Inspection								
	A) Headspace							11-27-91	AC
	B) Trigger Pull		234	236	234	237	237	11-20-91	SH
	C) Function							11-27-91	AC
660	Pack								

EPAO

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6665785DATE 11-13-91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.43	2.51	2.34	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.30	2.42	2.44	2.36	
PULL #3	2.45	2.44	2.50	2.34	
PULL #4	2.35	2.41	2.55	2.37	
PULL #5	2.43	2.48	2.48	2.37	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.25	3.50		
PULL #2	3.56	3.49		
PULL #3	3.44	3.42		
PULL #4	3.50	3.41		
PULL #5	3.51	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	4.59	4.31		4.25
PULL #2	4.38	4.23		4.29
PULL #3	4.32	4.32		4.25
PULL #4	4.20	4.20		4.27
PULL #5	4.32	4.18		4.28
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665785
20 Nov 1991

CENTROIDAL DISTANCES

0 TO	1	.106
1 TO	2	.260415
1 TO	3	.174522
1 TO	4	.228037
1 TO	5	.0657343

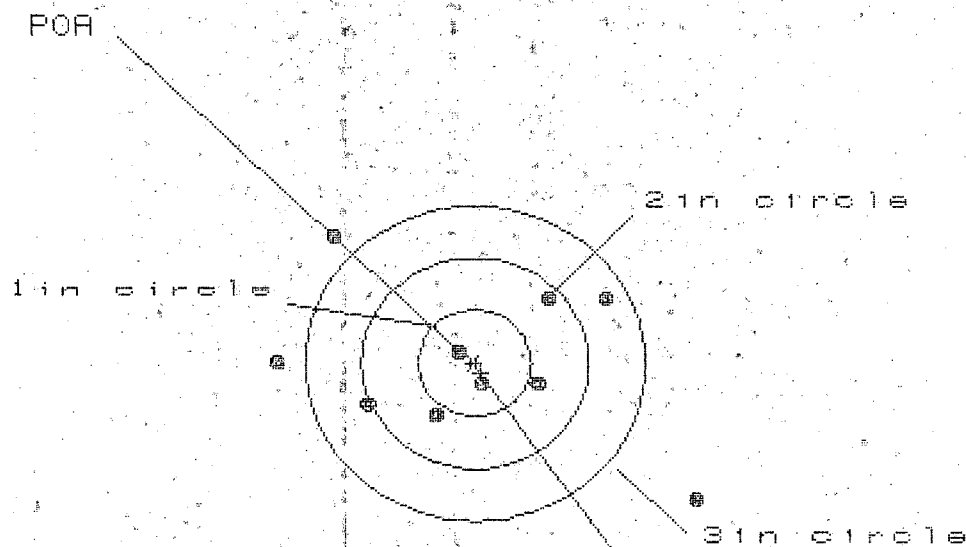
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0194
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .011
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0223016
THE AMR FOR THIS RIFLE IS: .9868

19 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C68657B5

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 6

3 in = 7

HS= 3.717

VS= 2.468

GS= 4.019

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.958	1.334	1.141
MINIMUM X	-1.759	-1.541	-1.189
MAXIMUM Y	1.193	1.051	1.030
MINIMUM Y	-1.275	-.588	-.609
CENTROID X	-.056	-.274	-.081
CENTROID Y	.090	.232	.253
POA TO CENTROID in.	.106	.359	.266
MIN RADIUS	.174	.087	.127
MEAN RADIUS	1.043	.913	.810
MAX RADIUS	2.337	1.551	1.573
HORIZONTAL SPREAD	3.717	2.875	2.330
VERTICAL SPREAD	2.468	1.639	1.639
EXTREME SPREAD	4.019	2.942	2.406
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	7		

19 Nov 1991

FILE: PATTERNING/CENTERFIRE_PATT/C66657B5

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS= 1.752

VS= 2.392

GS= 2.965

PATTERN #	2
SHOTS (BEST OF)	10
MAXIMUM X	.967
MINIMUM X	-.785
MAXIMUM Y	1.170
MINIMUM Y	-1.222
CENTROID X	.098
CENTROID Y	-.120
POA TO CENTROID in.	.155
MIN RADIUS	.253
MEAN RADIUS	.768
MAX RADIUS	1.518
HORIZONTAL SPREAD	1.752
VERTICAL SPREAD	2.392
EXTREME SPREAD	2.965
NUMBER IN ONE INCH CIRCLE	3
NUMBER IN TWO INCH CIRCLE	6
NUMBER IN THREE INCH CIRCLE	9

19 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66657B5

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

HS = 2.112

VS = 3.126

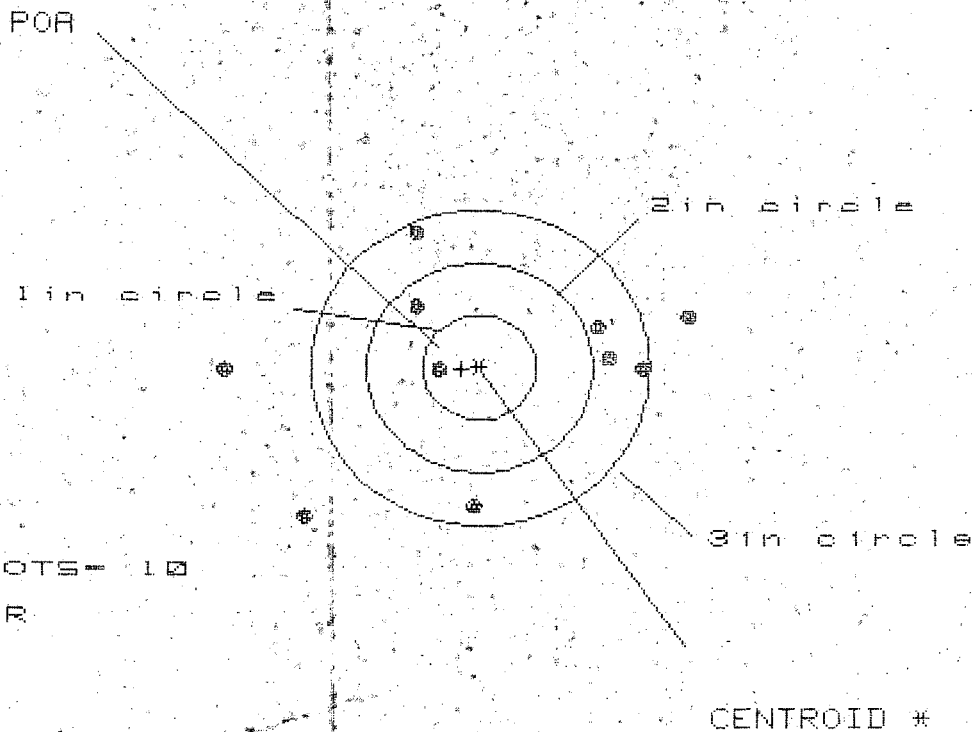
GS = 3.316

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	9
MAXIMUM X	1.170	1.143	1.247
MINIMUM X	-.942	-.969	-.865
MAXIMUM Y	1.346	1.148	.984
MINIMUM Y	-1.780	-.791	-.647
CENTROID X	-.7033	-.006	-.110
CENTROID Y	-.083	.115	-.029
POA TO CENTROID in.	.089	.115	.114
MIN RADIUS	.339	.323	.288
MEAN RADIUS	1.011	.916	.837
MAX RADIUS	1.796	1.419	1.376
HORIZONTAL SPREAD	2.112	2.112	2.112
VERTICAL SPREAD	3.126	1.939	1.631
EXTREME SPREAD	3.316	2.576	2.569
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

19 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66657B5

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 2

3 in = 7

HS = 4.051

VS = 2.693

GS = 4.086

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.821

1.573

1.348

MINIMUM X

-2.231

-1.795

-1.080

MAXIMUM Y

1.296

1.290

1.115

MINIMUM Y

-1.397

-1.403

-1.455

CENTROID X

.159

.407

.632

CENTROID Y

.014

.020

.195

POA TO CENTROID in.

.160

.408

.661

MIN RADIUS

.370

.618

.596

MEAN RADIUS

1.372

1.257

1.086

MAX RADIUS

2.231

2.278

1.552

HORIZONTAL SPREAD

4.051

3.368

2.428

VERTICAL SPREAD

2.693

2.693

2.570

EXTREME SPREAD

4.086

3.860

2.627

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

2

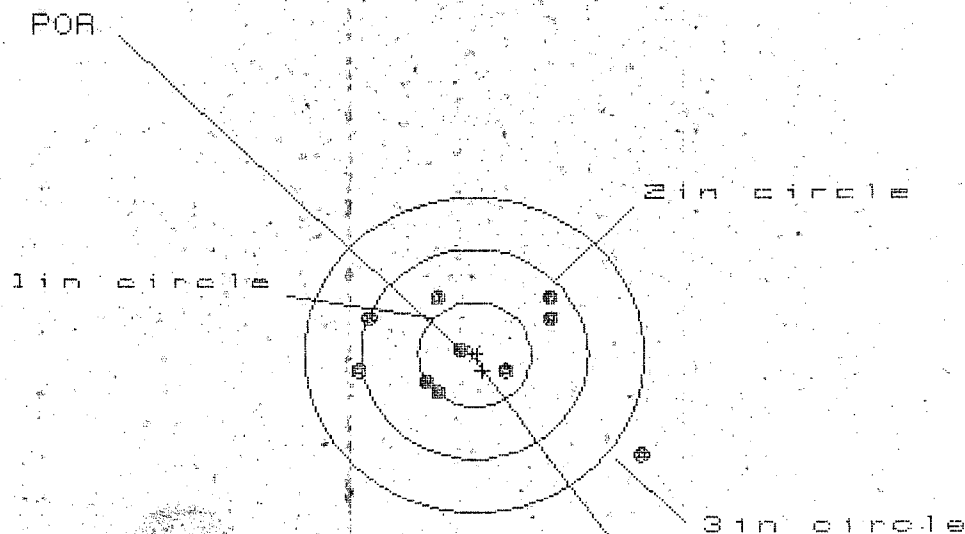
NUMBER IN THREE INCH CIRCLE =

7

19 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08665785

CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 8

3 in = 9

HS = 2.507

VS = 1.469

GS = 2.798

CENTROID *

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.518	.883	.783
MINIMUM X	-.989	-.820	-.920
MAXIMUM Y	.548	.446	.479
MINIMUM Y	-.921	-.411	-.378
CENTROID X	-.071	-.240	-.140
CENTROID Y	.154	.256	.223
POA TO CENTROID in.	.169	.351	.264
MIN RADIUS	.089	.109	.032
MEAN RADIUS	.740	.610	.566
MAX RADIUS	1.776	.978	.941
HORIZONTAL SPREAD	2.507	1.703	1.703
VERTICAL SPREAD	1.469	.857	.857
EXTREME SPREAD	2.798	1.823	1.823
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		9	