

FORM

UPC



0 47700 25716 7

C6665811

*INCLUDES 1 IN CHAMBER

MODEL 700 TM M24

ORDER NO. 5716

BARREL LENGTH

CAPACITY*

BARBER - M24 0102871

Remington



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

MODEL 700TM M24

SERIAL NO.

C6665811

ORDER NO.

5716

20

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



5716 C6665811

ORDER 5716

MODEL 700TM M24

UPC



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ORDER 5716

MODEL 700TM M24

UPC



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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6665811

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		9/25/91	KL
600	Proof		9/25/91	KL
607	Check Headspace		9/25/91	KL
610	Dis-assemble Gun		9/25/91	KL
612	Magnaflux Barrel Action		OCT 2 1991	KR
	Magnaflux Bolt		OCT 2 1991	KR
615	Rollmark Caliber		OCT 2 1991	LS
617	Drill and Tap Sight Holes		OCT 2 1991	FB
618	Polish Barrel		OCT 4 1991	WB
620	Apply Coatings (Barrel Action)		10-14-91	KL
	Apply Coating (Bolt)			KL
625	Final Assembly A) Clean inside of Bolt Assembly		10/28/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/28/91	KL
	C) Inspect Ejector Hole for Chamfer		10/28/91	KL
	D) Oil Firing Pin Ass'y		10/28/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		10/29/91	KL

op. #	OP NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			10/29/91	JK
	G) Safety Off Force	4	4	4			10/29/91	JK
	H) Trigger Pull Test & Retainability						10/29/91	JK
	I) Firing Pin Indent	.0215	.0215	.0215			10/29/91	JK
	J) Assemble Stock						10/30/91	JK
	K) Assemble Swivel Studs						11-12-91	AC
	L) Attach Front and Rear Sight Assemblies						10/30/91	JK
	M) Iron Sight Alignment						10/30/91	JK
	N) Detach Front & Rear Sights & place in numbered container						10/30/91	JK
	O) Attach Scope to Rifle						10/30/91	JK
	P) Detach & Attach Scope 20 Times						10/30/91	JK
640	Gallery Target & Test						10-31-91	DH
	A) Time						10-31-91	DH
	B) Malfunctions						10-31-91	DH
	C) Pierced Primers						10-31-91	DH
	D) Optical Clarity of Scope						10-31-91	DH
645	Inspect for Live Ammo						10-31-91	DH
655	Final Inspection							
	A) Headspace						11-12-91	AC
	B) Trigger Pull	253	257	252	262	257	11-4-91	DH
	C) Function						11-12-91	AC
660	Pack						12-18-91	N

SWS TRIGGER PULL TESTAVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6665811DATE 10/29/91TESTER JK

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.20	2.56	2.52	2.53	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.51	2.52	2.50	2.57	
PULL #3	2.51	2.58	2.55	2.52	
PULL #4	2.44	2.52	2.58	2.62	
PULL #5	2.50	2.44	2.48	2.57	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.29	3.32		
PULL #2	3.33	3.31		
PULL #3	3.36	3.35		
PULL #4	3.35	3.32		
PULL #5	3.31	3.31		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.24	4.25		4.28
PULL #2	4.43	4.23		4.37
PULL #3	4.31	4.27		4.32
PULL #4	4.33	4.27		4.28
PULL #5	4.42	4.22		4.30
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665811
31 Oct 1991

CENTROIDAL DISTANCES

0 TO	1	.21225
1 TO	2	.165952
1 TO	3	.183068
1 TO	4	.162754
1 TO	5	.1486

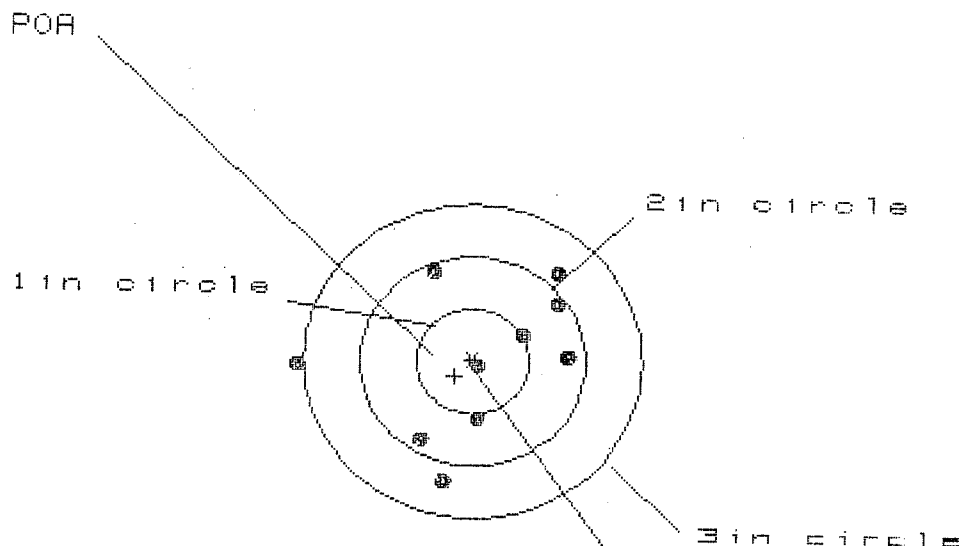
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THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1282
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0968
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .154821
THE AMR FOR THIS RIFLE IS: .8662

31 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8665811

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 2.385

VS= 2.053

GS= 2.483

CENTROID #

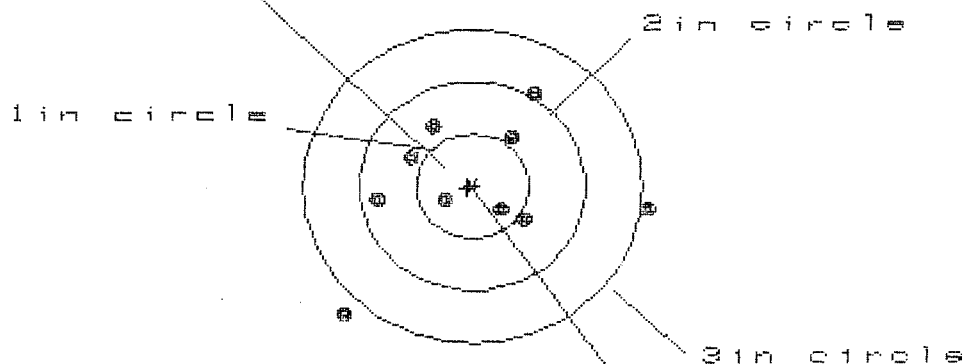
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.886	.631	.571
MINIMUM X	-1.579	-.628	-.688
MAXIMUM Y	.874	.869	.721
MINIMUM Y	-1.179	-1.184	-.944
CENTROID X	.155	.330	.390
CENTROID Y	.145	.150	.298
POA TO CENTROID in.	.212	.363	.491
MIN RADIUS	.104	.160	.193
MEAN RADIUS	.873	.770	.690
MAX RADIUS	1.580	1.276	1.168
HORIZONTAL SPREAD	2.385	1.259	1.259
VERTICAL SPREAD	2.053	2.053	1.665
EXTREME SPREAD	2.483	2.295	2.039
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 2

POA



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 8

HS= 2.684

VS= 2.109

GS= 2.882

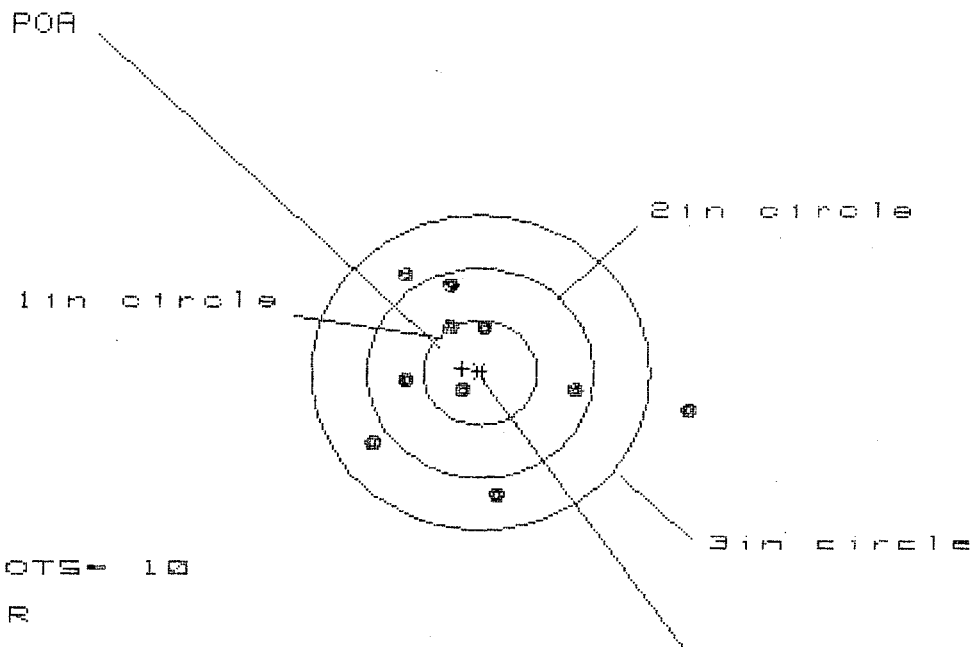
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.505	1.374	.608
MINIMUM X	:	-1.179	-.930	-.759
MAXIMUM Y	:	.857	.718	.675
MINIMUM Y	:	-1.252	-.451	-.494
CENTROID X	:	.047	.178	.007
CENTROID Y	:	.019	.158	.201
POA TO CENTROID in.	:	.051	.239	.201
MIN RADIUS	:	.320	.367	.418
MEAN RADIUS	:	.829	.723	.619
MAX RADIUS	:	1.720	1.416	.909
HORIZONTAL SPREAD	:	2.684	2.304	1.367
VERTICAL SPREAD	:	2.109	1.169	1.169
EXTREME SPREAD	:	2.882	2.304	1.701
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS = 2.836

VS = 2.151

GS = 2.913

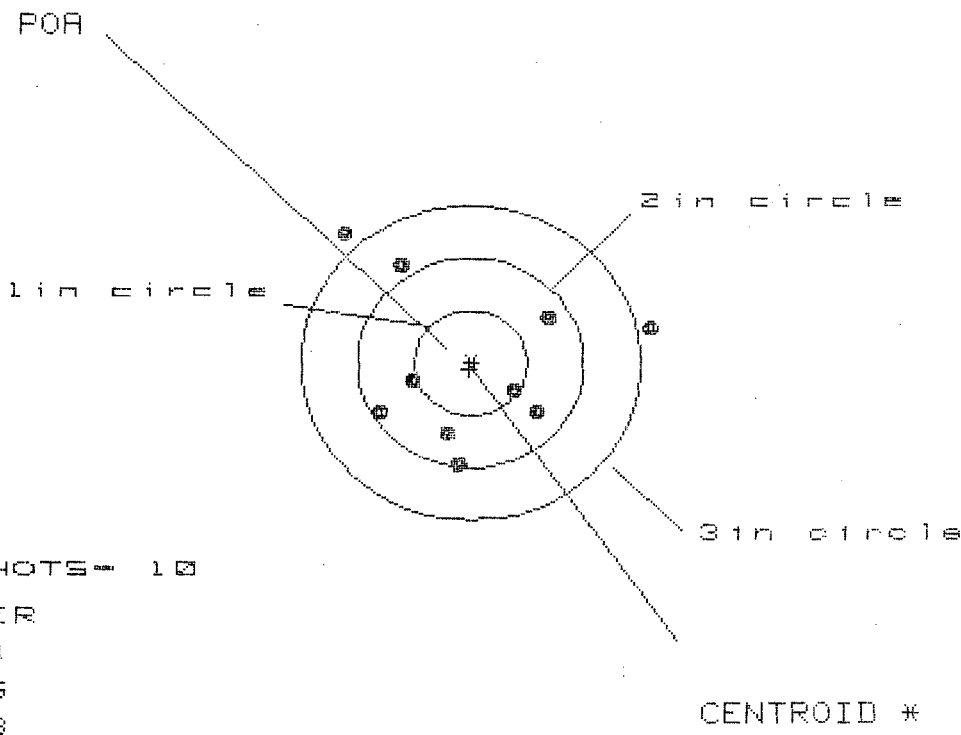
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.877	1.081	1.126
MINIMUM X	:	-.959	-.750	-.705
MAXIMUM Y	:	.968	.923	.769
MINIMUM Y	:	-1.183	-1.228	-.833
CENTROID X	:	.160	-.049	-.094
CENTROID Y	:	-.038	.006	.160
POA TO CENTROID in.	:	.164	.049	.185
MIN RADIUS	:	.271	.258	.234
MEAN RADIUS	:	.905	.753	.660
MAX RADIUS	:	1.920	1.280	1.187
HORIZONTAL SPREAD	:	2.836	1.831	1.831
VERTICAL SPREAD	:	2.151	2.151	1.602
EXTREME SPREAD	:	2.913	2.311	1.941
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			9	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 6

3 in = 8

HS= 2.689

VS= 2.265

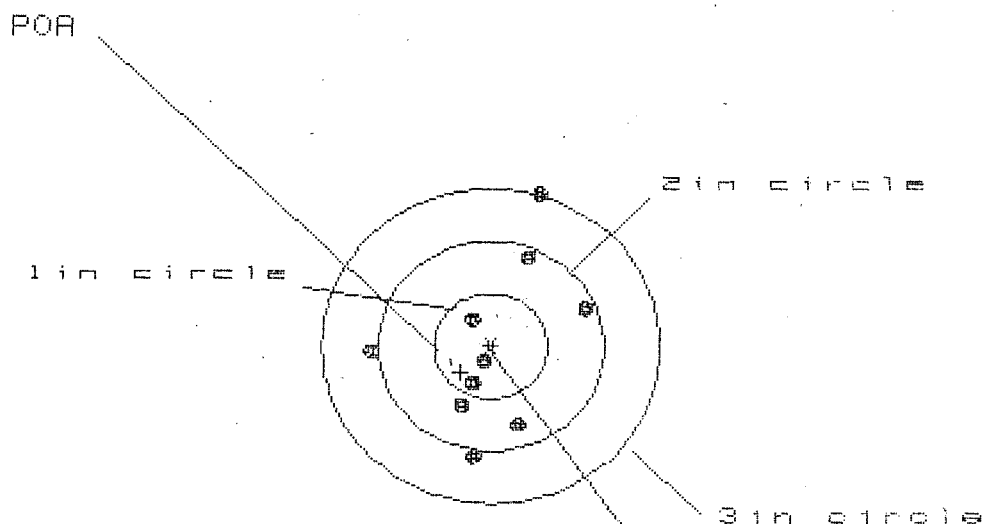
GS= 2.838

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.599	1.478	.734
MINIMUM X	:	-1.090	-.911	-.726
MAXIMUM Y	:	1.258	1.126	1.188
MINIMUM Y	:	-1.007	-.868	-.806
CENTROID X	:	.015	.136	-.049
CENTROID Y	:	.062	-.077	-.139
POA TO CENTROID in.	:	.064	.156	.147
MIN RADIUS	:	.456	.283	.432
MEAN RADIUS	:	.965	.853	.747
MAX RADIUS	:	1.664	1.558	1.297
HORIZONTAL SPREAD	:	2.689	2.389	1.460
VERTICAL SPREAD	:	2.265	1.994	1.994
EXTREME SPREAD	:	2.838	2.534	2.058
NUMBER IN ONE INCH CIRCLE =	:		1	
NUMBER IN TWO INCH CIRCLE =	:		6	
NUMBER IN THREE INCH CIRCLE =	:		8	

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

HS = 1.896

VS = 2.448

GS = 2.507

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.823	.868	.739
MINIMUM X	-1.073	-1.028	-.395
MAXIMUM Y	1.417	.997	1.013
MINIMUM Y	-1.031	-.874	-.858
CENTROID X	.264	.219	.348
CENTROID Y	.246	.089	.073
POA TO CENTROID in.	.361	.237	.355
MIN RADIUS	.138	.025	.127
MEAN RADIUS	.759	.638	.606
MAX RADIUS	1.473	1.085	1.056
HORIZONTAL SPREAD	1.896	1.896	1.134
VERTICAL SPREAD	2.448	1.871	1.871
EXTREME SPREAD	2.507	1.942	1.942
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		