

FORM

UPC



0 47700 25716 7

C6665820

INCLUDES 1 IN CHAMBER

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™ M24**SERIAL NO.****C6665820****ORDER NO.****5716**

20

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



5716 C6665820

ORDER 5716

MODEL 700™ M24

UPC

0 47700 25716 7

ORDER 5716

MODEL 700™ M24

UPC

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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

26665820

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		9/27/91	KH
600	Proof		9/27/91	KH
607	Check Headspace		9/27/91	KH
610	Dis-assemble Gun		9/27/91	KH
612	Magnaflux Barrel Action	OCT 4 1991		Kcd
	Magnaflux Bolt	OCT 4 1991		Kcd
615	Rollmark Caliber	OCT 4 1991		CS
617	Drill and Tap Sight Holes	OCT 4 1991		FB
618	Polish Barrel	OCT 4 1991		WB
620	Apply Coatings (Barrel Action)		10-12-91	JD
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/14/91	KH
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/14/91	KH
	C) Inspect Ejector Hole for Chamfer		11/14/91	KH
	D) Oil Firing Pin Ass'y		11/14/91	KH
	E) Adjust Trigger Pull to Min Setting and Stake		11/15/91	JH

op. #	OP NAME	READINGS					DATE	INIT
	BARBER - M24 0102991							
625 cont.	F) Safety On Force	4	4	4			11/15/91	JK
	G) Safety Off Force	3	3	3			11/15/91	JK
	H) Trigger Pull Test & Retainability						11/15/91	JK
	I) Firing Pin Indent	1022	1028	1022			11/15/91	JK
	J) Assemble Stock						11/25/91	JK
	K) Assemble Swivel Studs						11-27-91	D/H
	L) Attach Front and Rear Sight Assemblies						11/25/91	JK
	M) Iron Sight Alignment						11/25/91	JK
	N) Detach Front & Rear Sights & place in numbered container						11/25/91	JK
	O) Attach Scope to Rifle						11/25/91	JK
	P) Detach & Attach Scope 20 Times						11/25/91	JK
640	Gallery Target & Test						11/21/91	K/T
	A) Time							K/T
	B) Malfunctions							14
	C) Pierced Primers							14
	D) Optical Clarity of Scope							14
645	Inspect for Live Ammo						11/22/91	K/T
655	Final Inspection							
	A) Headspace						11-27-91	D/H
	B) Trigger Pull	225	228	239	250	251	11-27-91	D/H
	C) Function						11-27-91	D/H
660	Pack						12-19-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6665820DATE 11-15-91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.48	2.40	2.45	2.25	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.49	2.34	2.48	2.28	
PULL #3	2.51	2.44	2.43	2.39	
PULL #4	2.62	2.35	2.36	2.50	
PULL #5	2.40	2.37	2.40	2.51	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.67	3.63		
PULL #2	3.61	3.63		
PULL #3	3.57	3.58		
PULL #4	3.62	3.66		
PULL #5	3.59	3.58		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.65	4.68		4.55
PULL #2	4.60	4.63		4.49
PULL #3	4.45	4.56		4.31
PULL #4	4.50	4.62		4.55
PULL #5	4.33	4.29		4.53
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665820
26 Nov 1991

CENTROIDAL DISTANCES

0 TO	1	.0827345
1 TO	2	.32039
1 TO	3	.372787
1 TO	4	.26711
1 TO	5	.121655

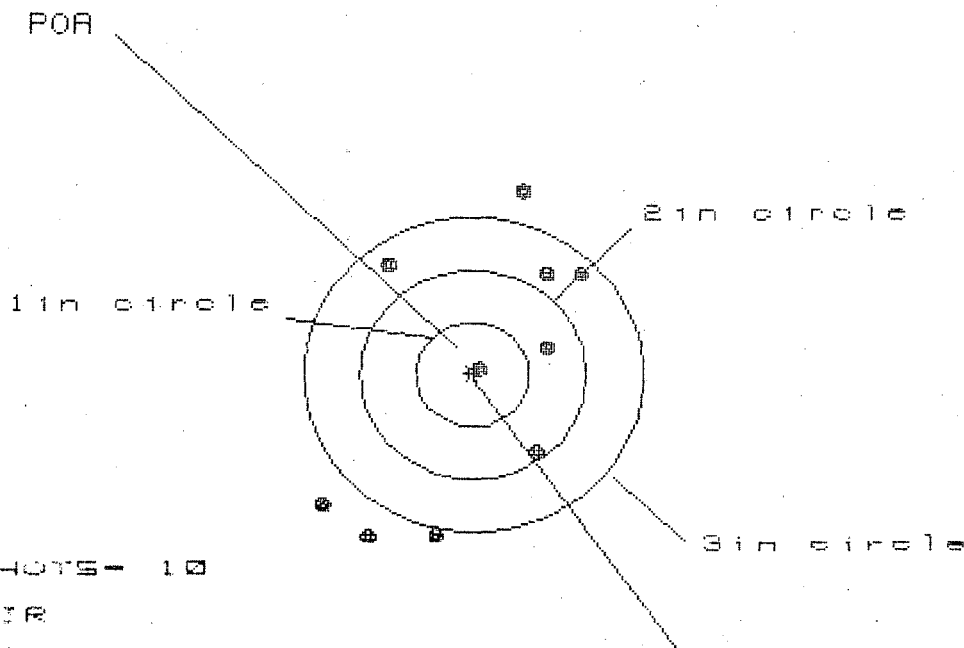
4.83
3 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0246
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0723
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0756584
THE ANR FOR THIS RIFLE IS: 1.020

200 151

FILE:/PATTERNING/CENTERFIRE_PATT/C6665820

CENTERFIRE PATTERNS # 1



TOTAL SHOTS- 10

IN AIR

1000

1000

1000

MS- 2.321

MS- 3.270

MS- 3.537

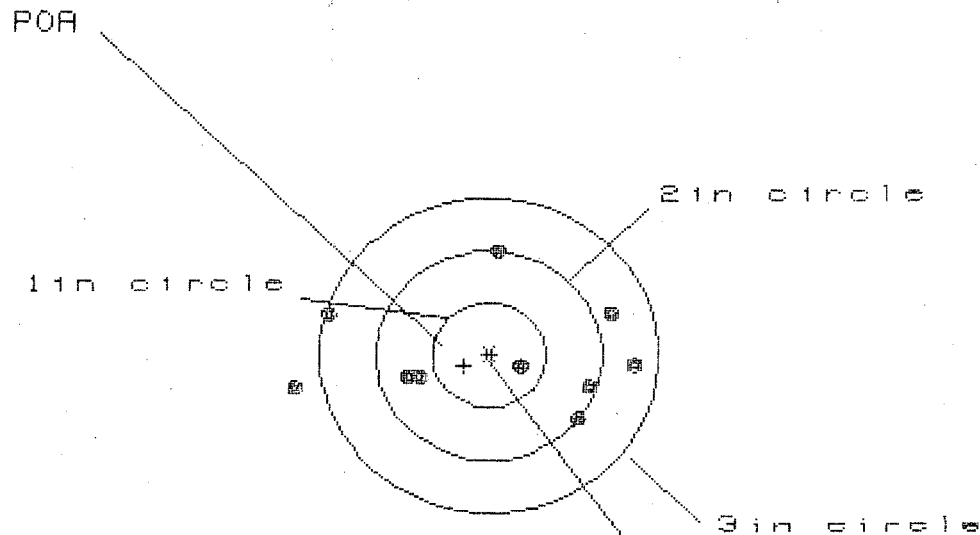
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MINIMUM X	.937	.783	.817
MINIMUM Y	-1.334	-1.077	-1.043
MAXIMUM X	1.749	1.609	1.089
MAXIMUM Y	-1.521	-1.661	-1.460
CENTROID X	-.059	.095	.061
CENTROID Y	-.058	.082	-.119
SHOT TO CENTROID in.	.083	.126	.134
MIN RADIUS	.054	.165	.096
MAX RADIUS	1.251	1.153	1.093
AVG RADIUS	1.873	1.980	1.795
EXTREMUM SPREAD	2.321	1.860	1.860
VERTICAL SPREAD	3.270	3.270	2.549
HORIZONTAL SPREAD	3.537	3.537	3.110
SHOTS IN ONE INCH CIRCLE	=	1	
SHOTS IN TWO INCH CIRCLE	=	3	
SHOTS IN THREE INCH CIRCLE	=	6	

26 Nov 1931

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in - 1

2in - 6

3in = 9

HS= 2.997

VS= 1.539

SS= 3.004

CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.287	1.097	.897
MINIMUM X	-1.710	-1.596	-1.084
MAXIMUM Y	.964	.932	.978
MINIMUM Y	-.575	-.607	-.560
CENTROID X	.218	.408	.608
CENTROID Y	.103	.135	.089
POA TO CENTROID in.	.241	.430	.614
MIN RADIUS	.278	.138	.144
MEAN RADIUS	1.015	.905	.781
MAX RADIUS	1.735	1.639	1.101
HORIZONTAL SPREAD	2.997	2.693	1.981
VERTICAL SPREAD	1.539	1.539	1.539
EXTREME SPREAD	3.004	2.737	1.985
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

26 Nov 1991

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CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS= 3.720

VS= 2.391

GS= 3.885

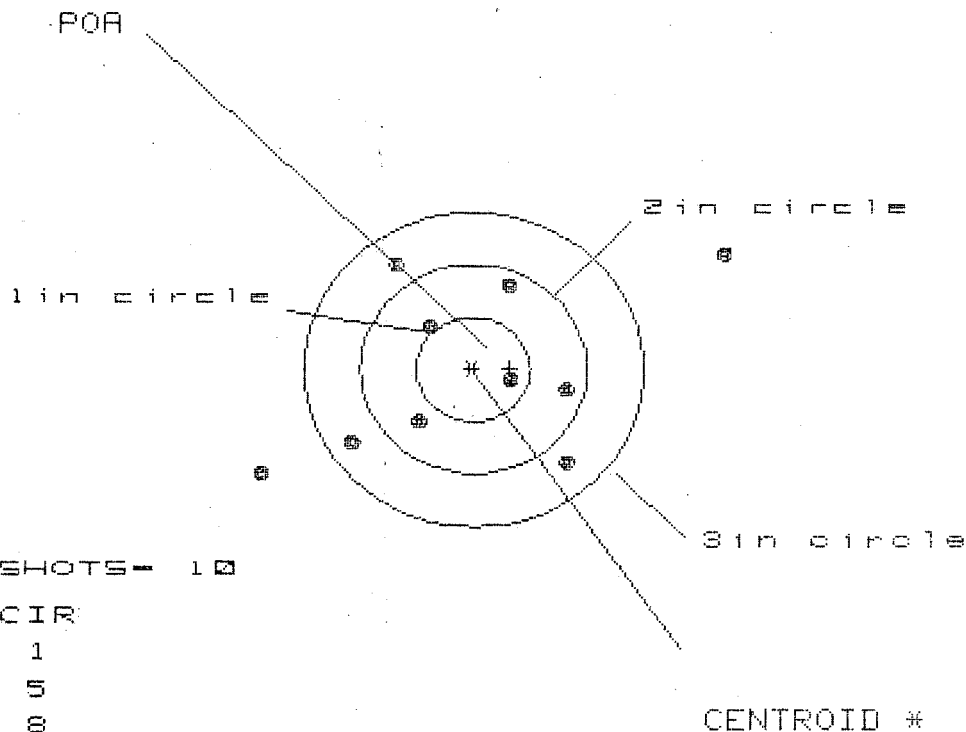
CENTROID #

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.801	1.588	1.485
MINIMUM X	:	-1.919	-1.261	-1.062
MAXIMUM Y	:	1.167	1.030	1.000
MINIMUM Y	:	-1.224	-.717	-.747
CENTROID X	:	.268	.481	.282
CENTROID Y	:	-.237	-.101	-.071
POA TO CENTROID in.	:	.358	.491	.291
MIN RADIUS	:	.323	.397	.453
MEAN RADIUS	:	1.083	.940	.836
MAX RADIUS	:	2.276	1.606	1.432
HORIZONTAL SPREAD	:	3.720	2.849	2.467
VERTICAL SPREAD	:	2.391	1.747	1.747
EXTREME SPREAD	:	3.885	2.849	2.467
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS = 4.104

VS = 2.153

GS = 4.634

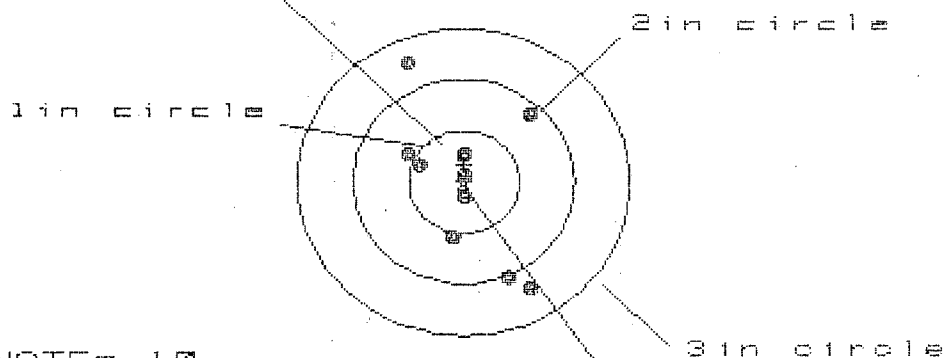
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.193	1.072	.863
MINIMUM X	-1.911	-1.667	-1.031
MAXIMUM Y	1.130	1.102	.990
MINIMUM Y	-1.023	-.897	-.861
CENTROID X	-.321	-.565	-.356
CENTROID Y	-.006	-.132	-.020
POA TO CENTROID in.	.321	.580	.357
MIN RADIUS	.312	.447	.345
MEAN RADIUS	1.154	1.007	.864
MAX RADIUS	2.467	1.893	1.219
HORIZONTAL SPREAD	4.104	2.739	1.894
VERTICAL SPREAD	2.153	1.999	1.851
EXTREME SPREAD	4.634	2.899	2.385
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

25 May 1991

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CENTERFIRE PATTERNS # 5

POA



OF SHOTS- 10

IN CIR

1 in - 4

2 in - 7

3 in = 10

HS- 1.132

VS= 2.137

GS= 2.395

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.618	.561	.625
MINIMUM X	-.514	-.568	-.504
MAXIMUM Y	1.153	.828	.721
MINIMUM Y	-.984	-.856	-.954
CENTROID X	-.003	.054	-.010
CENTROID Y	-.166	-.294	-.187
POA TO CENTROID in.	.166	.299	.187
MIN RADIUS	.081	.071	.103
MEAN RADIUS	.639	.581	.501
MAX RADIUS	1.262	1.000	1.032
HORIZONTAL SPREAD	1.132	1.129	1.129
VERTICAL SPREAD	2.137	1.684	1.675
EXTREME SPREAD	2.395	1.691	1.691
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		