

FORM

UPC



0 47700 25716 7

06665824

*INCLUDES 1 IN CHAMBER

MODEL 700 TM M24

5716

ORDER NO.

BARREL LENGTH

CAPACITY*

Remington		DU PONT REG. U.S. PAT. & TM. OFF.	VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700 TM M24		SERIAL NO. C6665824	
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		20	ORDER NO. 5716



5716 C6665824

ORDER 5716
MODEL 700 TM M24
UPC



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MODEL 700 TM M24
UPC



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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6665824

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	GS
617	Drill and Tap Sight Holes		OCT 2 1991	KB
618	Polish Barrel		OCT 4 1991	WB
620	Apply Coatings (Barrel Action)		10-14-91	KL
	Apply Coating (Bolt)		10-14-91	KL
625	Final Assembly A) Clean inside of Bolt Assembly		10/18/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/18/91	KL
	C) Inspect Ejector Hole for Chamfer		10/18/91	KL
	D) Oil Firing Pin Ass'y		10/18/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		10/23/91	KL

op. #	BARBER M24 0103015	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7	7	7			10-23-91	DH
	G) Safety Off Force	3 1/4	3	3			10-23-91	DH
	H) Trigger Pull Test & Retainability						10/23/91	JL
	I) Firing Pin Indent	.021	.020	.021			10-23-91	DH
	J) Assemble Stock						10/23/91	JK
	K) Assemble Swivel Studs						10-30-91	AC
	L) Attach Front and Rear Sight Assemblies						10/23/91	JK
	M) Iron Sight Alignment						10/23/91	JK
	N) Detach Front & Rear Sights & place in numbered container						10/23/91	JK
	O) Attach Scope to Rifle						10/23/91	JK
	P) Detach & Attach Scope 20 Times						10/23/91	JK
640	Gallery Target & Test						10-24-91	DH
	A) Time						10-24-91	DH
	B) Malfunctions						10-24-91	DH
	C) Pierced Primers						10-24-91	DH
	D) Optical Clarity of Scope						10-24-91	DH
645	Inspect for Live Ammo						10-24-91	DH
655	Final Inspection							
	A) Headspace						10-30-91	AC
	B) Trigger Pull	251	254	261	249	255	10-28-91	DH
	C) Function						10-30-91	AC
660	Pack						12-18-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO C-6665824

DATE 10/23/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.58	2.31	2.39	2.51	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.22	2.35	2.30	2.54	
PULL #3	2.25	2.35	2.36	2.61	
PULL #4	2.28	2.34	2.39	2.49	
PULL #5	2.38	2.36	2.43	2.55	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.38	3.27		
PULL #2	3.20	3.24		
PULL #3	3.33	3.36		
PULL #4	3.43	3.43		
PULL #5	3.40	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	4.56	4.30		4.38
PULL #2	4.39	4.33		4.44
PULL #3	4.50	4.52		4.44
PULL #4	4.42	4.29		4.40
PULL #5	4.28	4.47		4.34
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665824
24 Oct 1991

CENTROIDAL DISTANCES

0 TO	1	.140943
1 TO	2	.496695
1 TO	3	.064405
1 TO	4	.251287
1 TO	5	.511157

32
44

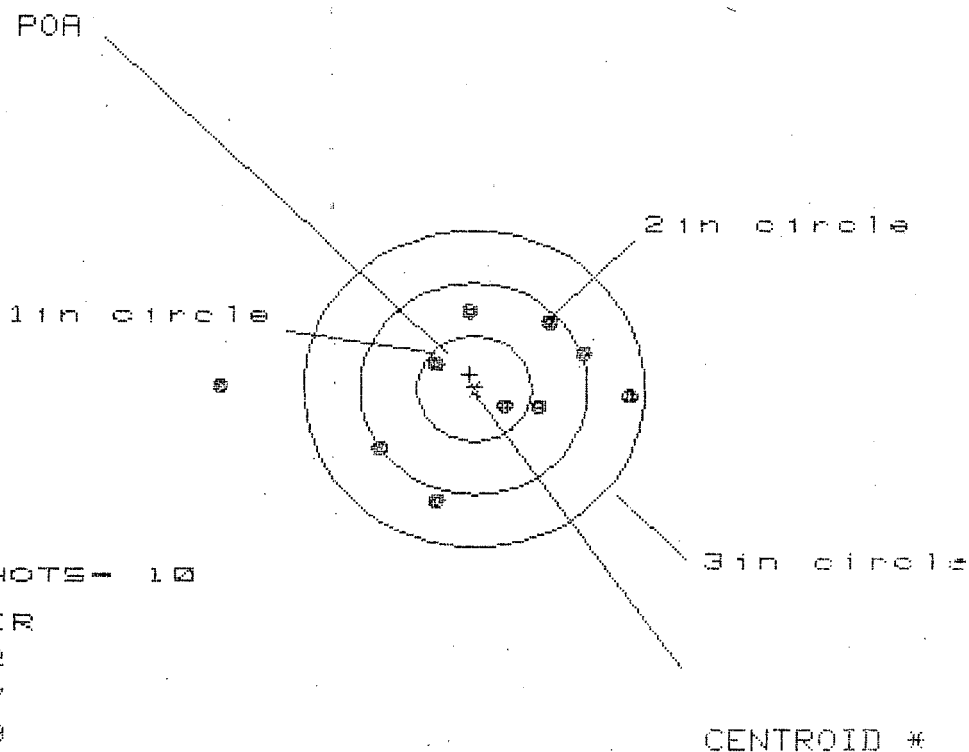
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0618
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0908
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .109826
THE AMR FOR THIS RIFLE IS: .8694

24 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8685824

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 8

HS= 3.585

VS= 1.795

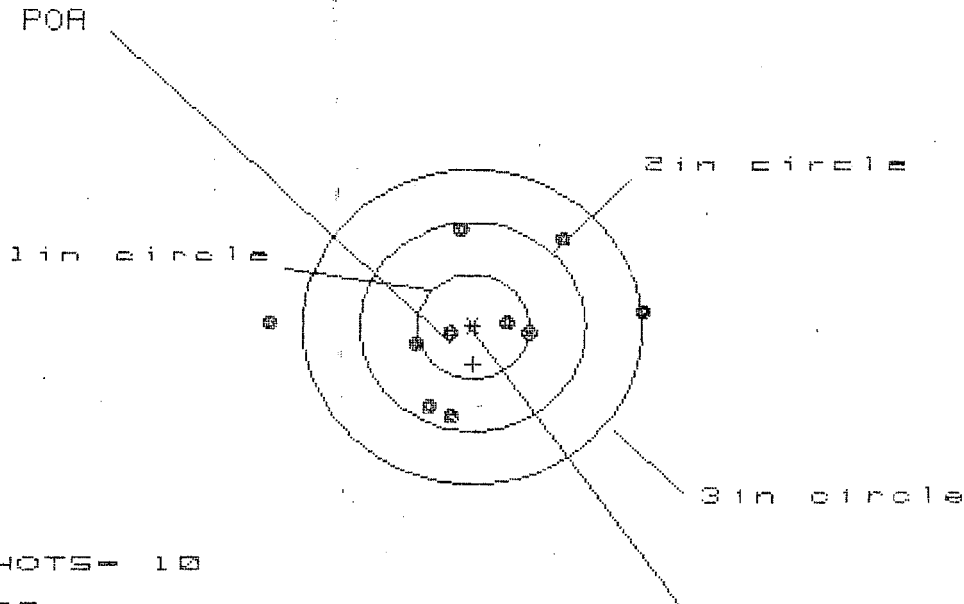
GS= 3.585

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.357	1.110	.815
MINIMUM X	-2.228	-1.093	-.955
MAXIMUM Y	.738	.737	.733
MINIMUM Y	-1.057	-1.058	-1.062
CENTROID X	.037	.284	.146
CENTROID Y	-.136	-.135	-.131
POA TO CENTROID in.	.141	.315	.196
MIN RADIUS	.283	.174	.212
MEAN RADIUS	.974	.791	.754
MAX RADIUS	2.228	1.217	1.143
HORIZONTAL SPREAD	3.585	2.203	1.770
VERTICAL SPREAD	1.795	1.795	1.795
EXTREME SPREAD	3.585	2.259	2.007
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

24 Oct 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 7

3 in = 9

HS= 3.309

VS= 1.776

GS= 3.309

CENTROID #

PATTERN #	2	2	2
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.483	1.280	.750
MINIMUM X	-1.826	-.663	-.503
MAXIMUM Y	.891	.899	.914
MINIMUM Y	-.885	-.877	-.862
CENTROID X	-.004	.199	.039
CENTROID Y	.359	.351	.336
POA TO CENTROID in.	.359	.404	.338
MIN RADIUS	.193	.154	.229
MEAN RADIUS	.863	.741	.663
MAX RADIUS	1.828	1.286	1.111
HORIZONTAL SPREAD	3.309	1.943	1.253
VERTICAL SPREAD	1.776	1.776	1.776
EXTREME SPREAD	3.309	2.052	1.962
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

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FILE:/PATTERNING/CENTERFIRE_PATT/C6665824

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 7

HS= 4.028

VS= 1.551

GS= 4.243

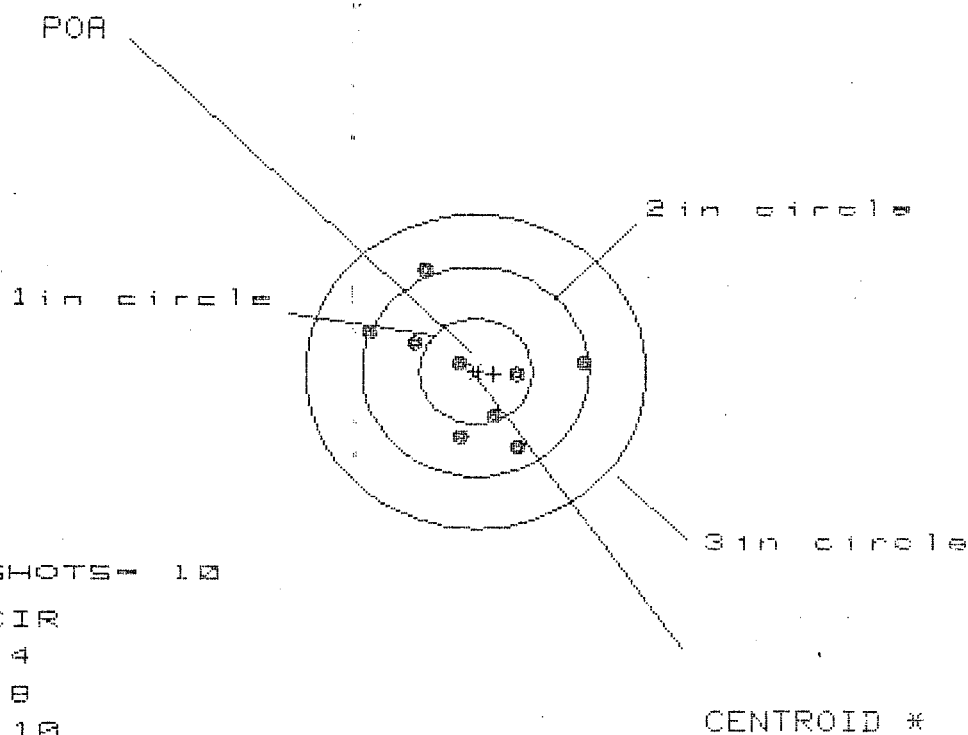
PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.096	1.223	1.011
MINIMUM X	-1.932	-1.699	-1.541
MAXIMUM Y	.809	.882	.807
MINIMUM Y	-.742	-.669	-.744
CENTROID X	.065	-.168	.044
CENTROID Y	-.078	-.151	-.076
POA TO CENTROID in.	.102	.226	.088
MIN RADIUS	.311	.327	.298
MEAN RADIUS	1.097	.975	.841
MAX RADIUS	2.197	1.802	1.621
HORIZONTAL SPREAD	4.028	2.922	2.552
VERTICAL SPREAD	1.551	1.551	1.551
EXTREME SPREAD	4.243	2.923	2.840
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		7	

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CENTERFIRE PATTERNS

4



OF SHOTS = 10

IN CIR

1 in = 4

2 in = 8

3 in = 10

HS = 1.902

VS = 1.710

GS = 1.936

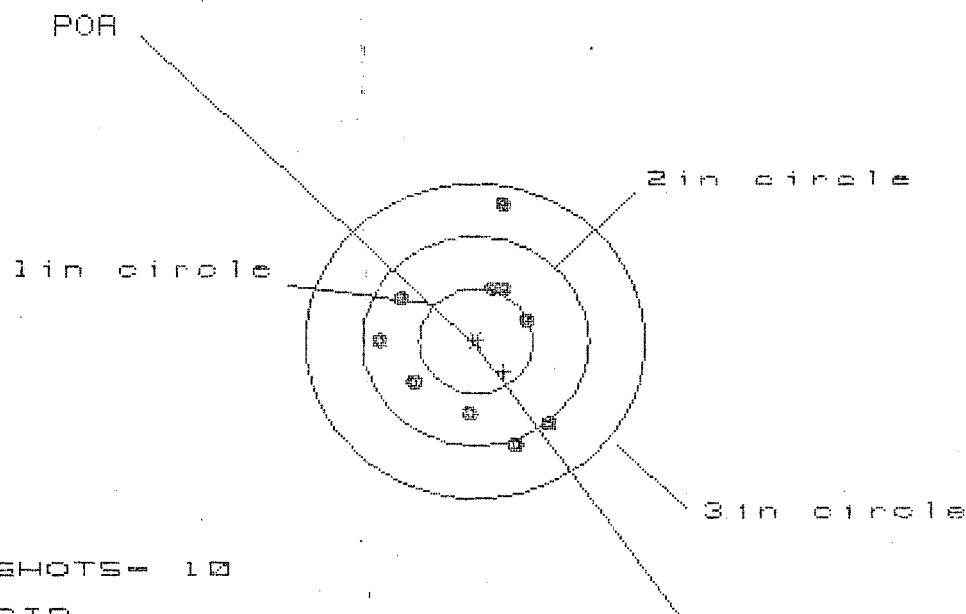
CENTROID *

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.922	.873	.744
MINIMUM X	-.980	-1.029	-.691
MAXIMUM Y	1.004	.507	.430
MINIMUM Y	-.706	-.595	-.531
CENTROID X	-.160	-.111	.018
CENTROID Y	.020	-.091	-.155
POA TO CENTROID in.	.161	.144	.156
MIN RADIUS	.130	.244	.241
MEAN RADIUS	.634	.566	.469
MAX RADIUS	1.098	1.147	.814
HORIZONTAL SPREAD	1.902	1.902	1.435
VERTICAL SPREAD	1.710	1.102	.961
EXTREME SPREAD	1.936	1.936	1.452
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 1.510

VS= 2.231

GS= 2.238

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.679	.701	.518
MINIMUM X	-.831	-.809	-.721
MAXIMUM Y	1.286	.618	.540
MINIMUM Y	-.945	-.802	-.880
CENTROID X	-.247	-.269	-.357
CENTROID Y	.289	.146	.224
POA TO CENTROID in.	.380	.307	.421
MIN RADIUS	.482	.566	.558
MEAN RADIUS	.779	.720	.681
MAX RADIUS	1.302	.936	1.008
HORIZONTAL SPREAD	1.510	1.510	1.239
VERTICAL SPREAD	2.231	1.420	1.420
EXTREME SPREAD	2.238	1.738	1.667
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		