

FORM

UPC



0 47700 25716 7

C6665837

*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 700TM M24

SERIAL NO.

C6665837

ORDER NO.

5716

20

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



5716 C6665837

ORDER 5716

MODEL 700TM M24

UPC

ORDER 5716

MODEL 700TM M24

UPC



0 47700 25716 7



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6665837

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		9/24/91	KH
600	Proof		9/24/91	KH
607	Check Headspace		9/24/91	KH
610	Dis-assemble Gun		9/24/91	KH
612	Magnaflux Barrel Action		OCT 2 1991	KR
	Magnaflux Bolt		OCT 2 1991	KR
615	Rollmark Caliber		OCT 2 1991	GL
617	Drill and Tap Sight Holes		OCT 2 1991	LB
618	Polish Barrel		OCT 4 1991	WB
620	Apply Coatings (Barrel Action)		10-14-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/30/91	KH
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/30/91	KH
	C) Inspect Ejector Hole for Chamfer		10/30/91	KH
	D) Oil Firing Pin Ass'y		10/30/91	KH
	E) Adjust Trigger Pull to Min Setting and Stake		10/31/91	JA

op. #	BARBER - M24 0103180		READINGS					DATE	INIT
	OP. NAME								
625 cont.	F) Safety On Force		5	5	5			10/31/91	JK
	G) Safety Off Force		3	3	3			10/31/91	JK
	H) Trigger Pull Test & Retainability							10/31/91	JK
	I) Firing Pin Indent		1020	1020	1020			10/31/91	JK
	J) Assemble Stock							10/31/91	JK
	K) Assemble Swivel Studs							11-19-91	D/H
	L) Attach Front and Rear Sight Assemblies							10/31/91	JK
	M) Iron Sight Alignment							10/31/91	JK
	N) Detach Front & Rear Sights & place in numbered container							10/31/91	JK
	O) Attach Scope to Rifle							10/31/91	JK
	P) Detach & Attach Scope 20 Times							10/31/91	JK
640	Gallery Target & Test							11-1-91	AC
	A) Time							11-1-91	AC
	B) Malfunctions							11-1-91	AC
	C) Pierced Primers							11-1-91	AC
	D) Optical Clarity of Scope							11-1-91	AC
645	Inspect for Live Ammo							11-1-91	AC
655	Final Inspection							11-1-91	D/H
	A) Headspace							11-1-91	AC
	B) Trigger Pull		2.63	2.61	2.66	2.63	2.67	11-13-91	AC
	C) Function							11-19-91	D/H
660	Pack							12-19-91	JK

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6665837DATE 10/31/91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.39	2.51	2.63	MIN. SETTING,
PULL #2	2.49	2.47	2.48	2.61	NO AVG. OF 5
PULL #3	2.47	2.47	2.46	2.66	READINGS ACCEPT-
PULL #4	2.43	2.34	2.40	2.63	ABLE LESS THAN 2#
PULL #5	2.43	2.46	2.46	2.67	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.39	3.22		
PULL #2	3.39	3.28		
PULL #3	3.34	3.25		
PULL #4	3.31	3.26		
PULL #5	3.23	3.30		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.66	4.23		4.23
PULL #2	4.33	4.58		4.33
PULL #3	4.48	4.46		4.22
PULL #4	4.66	4.42		4.30
PULL #5	4.68	4.48		4.25
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06665837
1 NOV 1991

CENTROIDAL DISTANCES

0 TO	1	.182157
1 TO	2	.354216
1 TO	3	.133544
1 TO	4	.382341
1 TO	5	.0948736

←----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0424
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.192
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .202489
THE ANR FOR THIS RIFLE IS: 1.024

1 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08685837

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 3

2in = 6

3in = 8

HS = 3.925

VS = 2.075

GS = 4.307

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.575	1.314	1.282
MINIMUM X	-2.350	-.848	-.684
MAXIMUM Y	.925	.797	.859
MINIMUM Y	-1.150	-1.172	-1.110
CENTROID X	.166	.427	.263
CENTROID Y	-.075	.053	-.009
POA TO CENTROID in.	.182	.431	.263
MIN RADIUS	.053	.050	.120
MEAN RADIUS	.993	.796	.696
MAX RADIUS	2.617	1.425	1.338
HORIZONTAL SPREAD	3.925	2.162	1.966
VERTICAL SPREAD	2.075	1.969	1.969
EXTREME SPREAD	4.307	2.701	2.170
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

1 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8865837

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 8

HS = 2.905

VS = 2.753

GS = 3.293

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.319	1.142	1.209
MINIMUM X	-1.587	-.988	-.921
MAXIMUM Y	1.087	.966	.742
MINIMUM Y	-1.666	-1.797	-.678
CENTROID X	.004	.181	.114
CENTROID Y	-.390	-.269	-.045
POA TO CENTROID in.	.390	.324	.122
MIN RADIUS	.264	.308	.240
MEAN RADIUS	1.071	.961	.810
MAX RADIUS	1.924	1.866	1.215
HORIZONTAL SPREAD	2.906	2.130	2.130
VERTICAL SPREAD	2.753	2.753	1.420
EXTREME SPREAD	3.293	3.065	2.156
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		8	

1 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8885837

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS = 10

IN CIR

1in = 0

2in = 4

3in = 5

HS = 3.033

VS = 2.181

GS = 3.111

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.411	1.230	1.145
MINIMUM X	-1.622	-1.741	-1.826
MAXIMUM Y	.644	.644	.452
MINIMUM Y	-1.537	-1.537	-.911
CENTROID X	.081	.262	.347
CENTROID Y	-.178	-.178	.014
POA TO CENTROID in.	.196	.317	.347
MIN RADIUS	.601	.516	.384
MEAN RADIUS	1.195	1.109	.990
MAX RADIUS	1.623	1.788	1.838
HORIZONTAL SPREAD	3.033	2.971	2.971
VERTICAL SPREAD	2.181	2.181	1.363
EXTREME SPREAD	3.111	3.111	3.111
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		5	

1 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8565837

CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 3

2 in = 5

3 in = 7

HS= 1.680

VS= 3.145

GS= 3.345

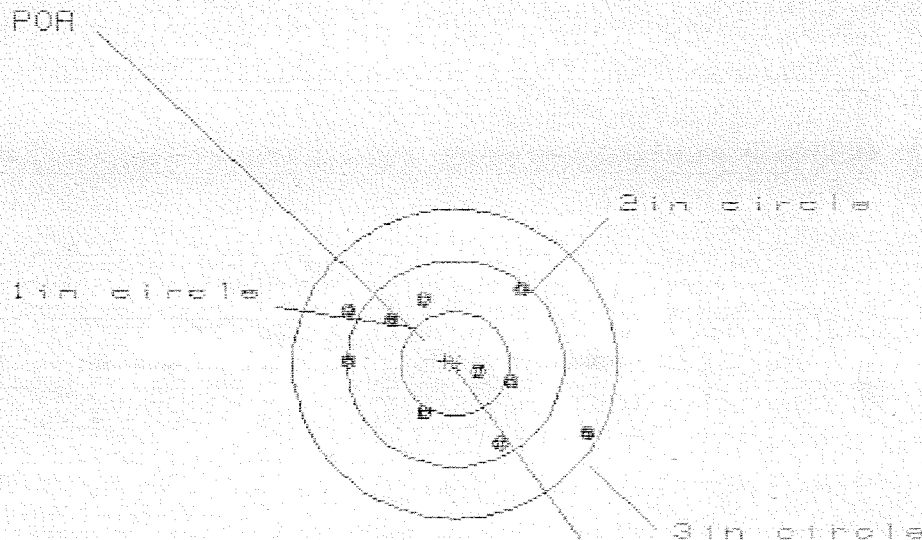
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.855	.763	.791
MINIMUM X	:	-.825	-.522	-.584
MAXIMUM Y	:	1.599	1.428	1.353
MINIMUM Y	:	-1.546	-1.583	-1.405
CENTROID X	:	-.125	-.033	.029
CENTROID Y	:	-.323	-.152	-.330
POA TO CENTROID in.	:	.347	.155	.331
MIN RADIUS	:	.334	.350	.386
MEAN RADIUS	:	1.057	.966	.890
MAX RADIUS	:	1.752	1.628	1.524
HORIZONTAL SPREAD	:	1.680	1.285	1.285
VERTICAL SPREAD	:	3.145	3.011	2.758
EXTREME SPREAD	:	3.345	3.013	2.984
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

1 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665837

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 10

HS= 2.217

VS= 1.566

GS= 2.484

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.209	.783	.681
MINIMUM X	-1.008	-.870	-.976
MAXIMUM Y	.747	.669	.723
MINIMUM Y	-.819	-.897	-.843
CENTROID X	.086	-.048	.054
CENTROID Y	-.024	.054	-.000
POA TO CENTROID in.	.090	.073	.054
MIN RADIUS	.248	.398	.285
MEAN RADIUS	.805	.732	.698
MAX RADIUS	1.402	1.046	.994
HORIZONTAL SPREAD	2.217	1.657	1.657
VERTICAL SPREAD	1.566	1.566	1.566
EXTREME SPREAD	2.484	1.902	1.827
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		