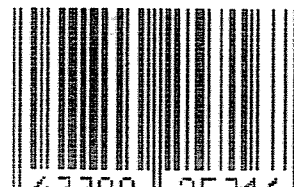


FOR

UPC



0 47700 25716 2

06665859

*INCLUDES 1 IN CHAMBER

CAPACITY*

Remington

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

MODEL 700™ M24**SERIAL NO.****C6665859****ORDER NO.****5716**

20

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



5716 C6665859

ORDER 5716

MODEL 700™ M24

UPC

0 47700 25716 7

ORDER 5716

MODEL 700™ M24

UPC

0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6665859

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		9/26/91	KA
600	Proof		9/26/91	KA
607	Check Headspace		9/26/91	KA
610	Dis-assemble Gun		9/26/91	KA
612	Magnaflux Barrel Action	OCT	4 1991	KCH
	Magnaflux Bolt	OCT	4 1991	KCH
615	Rollmark Caliber	OCT	4 1991	CS
617	Drill and Tap Sight Holes	OCT	4 1991	FB
618	Polish Barrel	OCT	4 1991	CSB
620	Apply Coatings (Barrel Action)		10-18-91	DA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/7/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/7/91	KA
	C) Inspect Ejector Hole for Chamfer		11/7/91	KA
	D) Oil Firing Pin Ass'y		11/7/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		11-8-91	KA

op. #	BARBER M24 0103417	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	5	5	5 1/4	11/8/91	KS		
	G) Safety Off Force	2 1/2	2 3/4	2 1/2	11/8/91	KS		
	H) Trigger Pull Test & Retainability				11-8-91	SL		
	I) Firing Pin Indent	.021	.0215	.0205	11-8-91	KS		
	J) Assemble Stock				11/8/91	KS		
	K) Assemble Swivel Studs				11-8-91	D/H		
	L) Attach Front and Rear Sight Assemblies				11/8/91	KS		
	M) Iron Sight Alignment				11/8/91	KS		
	N) Detach Front & Rear Sights & place in numbered container				11/8/91	KS		
	O) Attach Scope to Rifle				11/8/91	KS		
	P) Detach & Attach Scope 20 Times				11/8/91	KS		
640	Gallery Target & Test				11/13/91	KT		
	A) Time					KT		
	B) Malfunctions					KT		
	C) Pierced Primers					KT		
	D) Optical Clarity of Scope					KT		
645	Inspect for Live Ammo				11/13/91	KT		
655	Final Inspection							
	A) Headspace				11-18-91	D/H		
	B) Trigger Pull	260	256	258	261	262	11-18-91	D/H
	C) Function						11-18-91	D/H
660	Pack						12-19-91	N

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C-6665859

DATE 11-8-91

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.39	2.40	2.60	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.30	2.25	2.44	2.56	
PULL #3	2.38	2.30	2.39	2.58	
PULL #4	2.38	2.39	2.35	2.61	
PULL #5	2.27	2.37	2.37	2.62	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.48	3.23		
PULL #2	3.68	3.55		
PULL #3	3.60	3.56		
PULL #4	3.28	3.30		
PULL #5	3.64	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	4.34	4.58		4.57
PULL #2	4.53	4.59		4.37
PULL #3	4.32	4.61		4.60
PULL #4	4.56	4.30		4.59
PULL #5	4.55	4.60		4.41
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665859
13 Nov 1991

CENTROIDAL DISTANCES

0 TO 1	.104307
1 TO 2	.114039
1 TO 3	.119331
1 TO 4	.276355
1 TO 5	.399531

Unit <----POA

.0472
.0473
.0473984

13 NOV 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8665959.1

CENTERFIRE PATTERNS # 1

FOR

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

CENTROID *

CENTROID

10

9

8

.843

.843

.924

.932

.932

.851

.642

.642

.627

.010

.010

.985

.132

.132

.233

.257

.257

.150

.236

.236

.277

.100

.100

.221

.731

.731

.770

1.089

1.089

1.081

1.775

1.775

1.775

1.531

1.531

1.531

1.745

1.745

1.868

13 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8885959.1

CENTERFIRE PATTERNS

2

FOR

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 1

2in = 7

3in = 10

MEAN = 2.438

SD = 3.114

MOD = 3.180

CENTROID #

PATTERN #

E

	10	9	8
SHOTS (2400 FPS)	10	9	8
MEAN	.686	.696	.599
MIN	-.786	-.779	-.761
MAX	1.142	.764	.682
MIN	-.972	-.845	-.927
SD	.619	.683	.100
MOD	.005	-.132	-.050
FOR CL (in)	.011	.132	.112
MIN RADII	.360	.388	.267
MEAN RADII	.750	.712	.652
MAX RADII	1.144	1.016	1.042
HORIZONTAL (in)	1.475	1.475	1.360
VERTICAL (in)	2.114	1.609	1.609
EXTENSION (in)	2.180	1.832	1.780
NUMBER OF SHOTS IN 1in CIRCLE	= 1		
NUMBER OF SHOTS IN 2in CIRCLE	= 7		
NUMBER OF SHOTS IN 3in CIRCLE	= 10		

13 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08665959.1

CENTERFIRE PATTERNS # 3

POR

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 3

2in = 6

3in = 9

HGT = 1.974

VGR = 6.600

GB = 3.037

CENTROID *

PATTERN #

3

SHOTS TEST OF	10	9	8
MAXIMUM	.626	.476	.485
MINIMUM	-1.349	-.394	-1.385
MAXIMUM	1.161	1.001	.975
MINIMUM	-1.439	-1.168	-1.043
CENTROID	.060	.209	.200
CENTROID	.116	.276	.151
POR TO CENTROID	.130	.346	.251
MIN RADII	.188	.251	.289
MEAN RADII	.816	.660	.622
MAX RADII	1.972	1.233	1.112
HORIZONTAL SPREAD	1.974	.870	.870
VERTICAL SPREAD	2.600	2.169	2.018
EXTREME SPREAD	3.037	2.218	2.029
NUMBER IN ONE INCH CIRCLE	=	3	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	9	

(3 May 1991)

FILE:/PATTERNING/CENTERFIRE_PATT/06685959.1

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 8

1in = 1.435

2in = 2.185

3in = 2.615

CENTROID *

PATTERN #

SHOTS (BEST OF)

10

9

8

MAXIMUM

.901

.732

.634

MINIMUM

-1.324

-.956

-1.054

MAXIMUM

.944

1.003

.865

MINIMUM

1.159

-1.100

-1.074

CENTROID

.218

.387

.485

CENTROID

.124

.065

.203

POA TO CENTROID

.251

.393

.525

MIN RADII

.397

.247

.351

MEAN RADII

.933

.819

.729

MAX RADII

1.614

1.349

1.218

HORIZONTAL SPREAD

2.425

1.688

1.688

VERTICAL SPREAD

2.185

2.183

1.939

EXTREME SPREAD

2.615

2.187

2.161

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

7

NUMBER IN THREE INCH CIRCLE =

9

13 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8865959.1

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS= 10

IN CIR

1in = 2

2in = 8

3in = 9

MEAN = 1.184

SE = 2.728

SE = 1.655

PATTERN #

5

	1	9	8
SHOTS BASED ON	10	9	8
MINIMUM	.513	.446	.471
MINIMUM	-.671	-.738	-.713
MAXIMUM	1.638	1.081	.968
MINIMUM	-1.082	-.900	-.844
CENTROID	.084	.071	.046
SE	2.728	2.489	2.376
POA	1.007	1.494	1.379
1in circle	2.426	2.236	2.351
MEAN	1.820	1.676	1.655
SE	1.745	1.127	1.012
HORIZONTAL CENTER	1.184	1.184	1.184
VERTICAL CENTER	2.728	1.981	1.812
EXTREMES	2.955	2.048	1.830
NUMBER OF SHOTS IN 1in circle	2	2	2
NUMBER OF SHOTS IN 2in circle	8	8	8
NUMBER OF SHOTS IN 3in circle	9	9	9