

FORM

UPC



0 47700 25716 7

C6665902

*INCLUDES 1 IN CHAMBER

CAPACITY*

BARREL LENGTH

5716

ORDER NO.

MODEL 700 TM M24

Remington		 REG. U.S. PAT. & TM. OFF.	VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700TM M24			SERIAL NO. C6665902
		20	ORDER NO. 5716
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.			

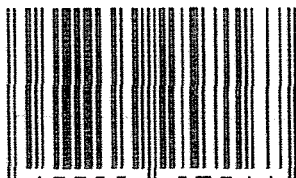


5716 C6665902

ORDER 5716

MODEL 700TM M24

UPC



0 47700 25716 7

ORDER 5716

MODEL 700TM M24

UPC



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6665902

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	9/23/91	KL
600	Proof		9/23/91	KL
607	Check Headspace		9/23/91	KL
610	Dis-assemble Gun		9/23/91	KL
612	Magnaflux Barrel Action		SEP 30 1991	KR
	Magnaflux Bolt		SEP 30 1991	KR
615	Rollmark Caliber		SEP 30 1991	LS
617	Drill and Tap Sight Holes		SEP 30 1991	LB
618	Polish Barrel		OCT 2 1991	WB
620	Apply Coatings (Barrel Action)		11/20/91	JS
	Apply Coating (Bolt)		11/20/91	JS
625	Final Assembly A) Clean inside of Bolt Assembly		10/8/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/8/91	KL
	C) Inspect Ejector Hole for Chamfer		10/8/91	KL
	D) Oil Firing Pin Ass'y		10/8/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		10/9/91	JS

op. #	BARBER - M24 0103838 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			10/14/91	SM
	G) Safety Off Force	4	4	4			10/14/91	SM
	H) Trigger Pull Test & Retainability						10/9/91	SM
	I) Firing Pin Indent	.0205	.0205	.0205			10/14/91	SM
	J) Assemble Stock						10/14/91	SM
	K) Assemble Swivel Studs						10-16-91	SM
	L) Attach Front and Rear Sight Assemblies						10/14/91	SM
	M) Iron Sight Alignment						10/16/91	SM
	N) Detach Front & Rear Sights & place in numbered container						10/16/91	SM
	O) Attach Scope to Rifle						10/16/91	SM
	P) Detach & Attach Scope 20 Times						10/16/91	SM
640	Gallery Target & Test						10-17-91	SM
	A) Time						"	SM
	B) Malfunctions						"	SM
	C) Pierced Primers						"	SM
	D) Optical Clarity of Scope						"	SM
645	Inspect for Live Ammo						10-17-91	SM
655	Final Inspection							
	A) Headspace						10-18-91	SM
	B) Trigger Pull	250	277	278	278	271	10-18-91	SM
	C) Function						10-18-91	SM
660	Pack						12-14-91	SM

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C-6665902DATE 10-9-91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.65	2.60	2.55	250	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.61	2.64	2.61	277	
PULL #3	2.60	2.63	2.65	278	
PULL #4	2.68	2.64	2.60	278	
PULL #5	2.65	2.65	2.44	271	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.50	3.40		
PULL #2	3.46	3.42		
PULL #3	3.43	3.43		
PULL #4	3.43	3.44		
PULL #5	3.43	3.28		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.47	4.36		4.34
PULL #2	4.35	4.35		4.36
PULL #3	4.35	4.34		4.22
PULL #4	4.33	4.36		4.25
PULL #5	4.33	4.38		4.40
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665902
18 Oct 1991

CENTROIDAL DISTANCES

0 TO	1	.623238
1 TO	2	.23342
1 TO	3	.850021
1 TO	4	.943615
1 TO	5	.530506

100000

<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0618
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0978
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .11569

THE AMR FOR THIS RIFLE IS: 1.023

18 Oct 1991

FILE: \PATTERNING\CENTERFIRE_PATT\06885902

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 0

2in = 3

3in = 7

HS= 4.160

VS= 2.490

GS= 4.207

CENTROID #

PATTERN #

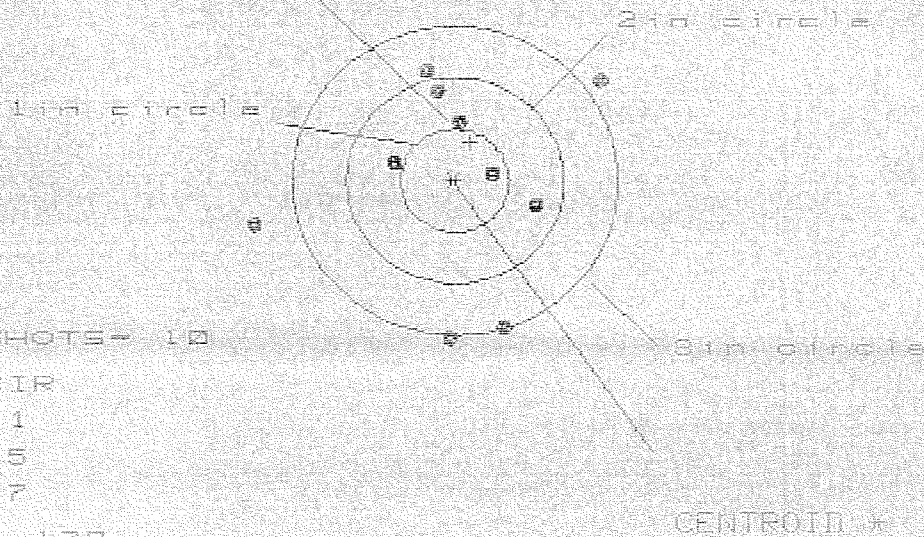
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.498	1.203	1.007
MINIMUM X	-2.662	-1.563	-1.624
MAXIMUM Y	1.286	1.329	1.184
MINIMUM Y	-1.204	-1.161	-0.666
CENTROID X	-0.295	0.000	0.196
CENTROID Y	-0.549	-0.592	-0.447
POA TO CENTROID IN.	0.620	0.592	0.488
MIN RADIUS	0.581	0.515	0.398
MEAN RADIUS	1.360	1.163	1.017
MAX RADIUS	2.689	1.949	1.680
HORIZONTAL SPREAD	4.160	2.766	2.631
VERTICAL SPREAD	2.490	2.490	1.850
EXTREME SPREAD	4.207	3.162	2.632
NUMBER IN ONE INCH CIRCLE	= 0		
NUMBER IN TWO INCH CIRCLE	= 3		
NUMBER IN THREE INCH CIRCLE	= 7		

18 Oct 1991

FILE: PATTERNING/CENTERFIRE_PATT/C6865902

CENTERFIRE PATTERNS # 2

POA



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 7

HS= 3.179

VS= 2.578

GS= 3.481

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.304	1.096	.692
MINIMUM X	-1.875	-.763	-.626
MAXIMUM Y	1.030	.979	1.093
MINIMUM Y	-1.548	-1.593	-1.485
CENTROID X	-.144	.064	-.073
CENTROID Y	-.371	-.320	-.434
POA TO CENTROID in.	.398	.327	.440
MIN RADIUS	.355	.143	.303
MEAN RADIUS	1.082	.955	.913
MAX RADIUS	1.930	1.619	1.490
HORIZONTAL SPREAD	3.179	1.859	1.318
VERTICAL SPREAD	2.578	2.578	2.578
EXTREME SPREAD	3.481	2.851	2.585
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		7	

18 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06663982

CENTERFIRE PATTERNS # 3

POB

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS= 2.186

VS= 2.080

GS= 2.659

PATTERN

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.953

.816

.772

MINIMUM X

-1.233

-.982

-.800

MAXIMUM Y

1.230

.986

1.052

MINIMUM Y

-.850

-.713

-.647

CENTROID X

-.025

.112

.010

CENTROID Y

.257

.120

.054

POB TO CENTROID in.

.258

.165

.055

MIN RADIUS

.438

.306

.423

MEAN RADIUS

.928

.798

.777

MAX RADIUS

1.742

1.218

1.218

HORIZONTAL SPREAD

2.186

1.718

1.572

VERTICAL SPREAD

2.080

1.699

1.699

EXTREME SPREAD

2.659

1.957

1.957

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

7

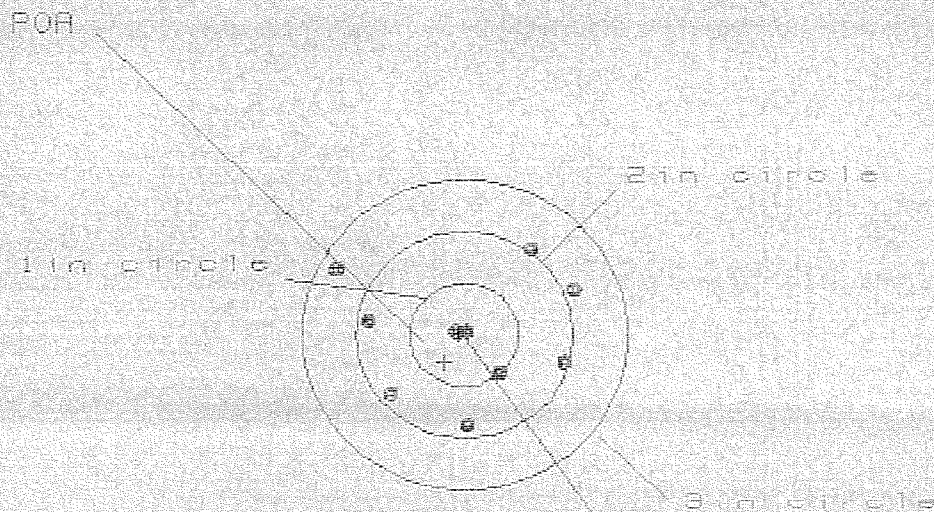
NUMBER IN THREE INCH CIRCLE =

9

18 Oct 1991

FILE: \PATTERNING\CENTERFIRE_PATT\06665902

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 2.157

VS= 1.650

GS= 2.251

PATTERN #	1	4	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.019	.893	.886
MINIMUM X	-1.138	-1.030	-.918
MAXIMUM Y	.792	.863	.921
MINIMUM Y	-.858	-.787	-.730
CENTROID X	.184	.318	.198
CENTROID Y	.264	.193	.136
POA TO CENTROID in.	.322	.365	.240
MIN RADIUS	.056	.160	.180
MEAN RADIUS	.769	.710	.665
MAX RADIUS	1.307	1.057	1.074
HORIZONTAL SPREAD	2.157	1.923	1.804
VERTICAL SPREAD	1.650	1.650	1.650
EXTREME SPREAD	2.251	1.993	1.800
NUMBER IN ONE INCH CIRCLE	=	3	
NUMBER IN TWO INCH CIRCLE	=	8	
NUMBER IN THREE INCH CIRCLE	=	10	

18 Oct 1991

FILE: PATTERNING/CENTERFIRE_PATT/C6665902

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 1.945

VS= 2.857

GS= 2.946

PATTERN #

SHOTS (BEST OF)

	10	9	8
MAXIMUM X	1.138	1.049	1.028
MINIMUM X	-.807	-.896	-.917
MAXIMUM Y	1.316	1.145	1.089
MINIMUM Y	-1.541	-.927	-.784
CENTROID X	-.029	.060	.081
CENTROID Y	-.090	.081	-.062
POA TO CENTROID in.	.095	.101	.102
MIN RADIUS	.288	.459	.360
MEAN RADIUS	.975	.893	.830
MAX RADIUS	1.736	1.157	1.261
HORIZONTAL SPREAD	1.945	1.945	1.945
VERTICAL SPREAD	2.857	2.072	1.873

EXTREME	SPREAD :	2.946	2.149	2.149
NUMBER IN ONE	INCH CIRCLE =	2		
NUMBER IN TWO	INCH CIRCLE =	5		
NUMBER IN THREE	INCH CIRCLE =	9		