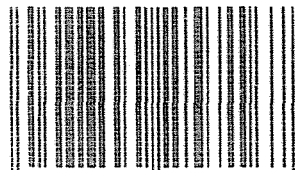


FIRE

UPC



0 47700 25716 7

6665947

*INCLUDES 1 IN CHAMBER

CAPACITY*

BARREL LENGTH

5716

ORDER NO.

MODEL 700 TM M24

Remington



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

MODEL 700 TM M24

SERIAL NO.
C6665947

20

ORDER NO.
5716

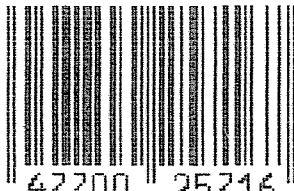
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.



5716 C6665947

ORDER **5716**
MODEL 700 TM M24

UPC



0 47700 25716 7

ORDER **5716**
MODEL 700 TM M24

UPC



0 47700 25716 7

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF	11-26-91 OK	AS
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

MOD. _____		GA. CAL. _____	GUN # <u>5947</u>
# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st	<i>Bolt Drags</i>	
	2nd		
	3rd		
	4th		
		FUNCTION	RD 6654 Rev 1

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6665947

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		9/30/91	KL
600	Proof		9/30/91	KL
607	Check Headspace		9/30/91	KL
610	Dis-assemble Gun		9/30/91	KL
612	Magnaflux Barrel Action	OCT	8 1991	KR
	Magnaflux Bolt	OCT	8 1991	KR
615	Rollmark Caliber	OCT	8 1991	LS
617	Drill and Tap Sight Holes	OCT.	8 1991	LB
618	Polish Barrel		10/14/91	WB
620	Apply Coatings (Barrel Action)		11-1-91	JA
	Apply Coating (Bolt)		11-1-91	JA
625	Final Assembly A) Clean inside of Bolt Assembly		11/6/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/6/91	KL
	C) Inspect Ejector Hole for Chamfer		11/6/91	KL
	D) Oil Firing Pin Ass'y		11/6/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		11-7-91	KL

op. #	BARBER - M24 0104370 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			11-7-91	JU
	G) Safety Off Force	3	3	3			11-7-91	JU
	H) Trigger Pull Test & Retainability						11-7-91	JU
	I) Firing Pin Indent	10205	1020	10205			11-7-91	JU
	J) Assemble Stock						11/7/91	JK
	K) Assemble Swivel Studs						11-27-91	D/H
	L) Attach Front and Rear Sight Assemblies						11/7/91	JK
	M) Iron Sight Alignment						11/7/91	JK
	N) Detach Front & Rear Sights & place in numbered container						11/7/91	JK
	O) Attach Scope to Rifle						11/7/91	JK
	P) Detach & Attach Scope 20 Times						11/7/91	JK
640	Gallery Target & Test						11-14-91	N
	A) Time						"	N
	B) Malfunctions						"	N
	C) Pierced Primers						"	N
	D) Optical Clarity of Scope						"	N
645	Inspect for Live Ammo						11-14-91	N
655	Final Inspection							
	A) Headspace	2.54	2.57	2.50	2.60	2.65	11-27-91	D/H
	B) Trigger Pull	291	292	297	297	299	11-18-91	D/H
	C) Function						11-27-91	D/H
660	Pack						12-7-91	D/H

STAT

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

SERIAL NO. C-6665947DATE 11-7-91TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.58	2.53	2.40	2.91	2.59 MIN. SETTING,
PULL #2	2.47	2.39	2.35	2.92	2.57 NO AVG. OF 5
PULL #3	2.44	2.42	2.30	2.97	2.50 READINGS ACCEPT-
PULL #4	2.49	2.47	2.44	2.97	2.60 ABLE LESS THAN 2#
PULL #5	2.50	2.45	2.48	2.99	2.65
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.26	3.44		
PULL #2	3.59	3.37		
PULL #3	3.52	3.25		
PULL #4	3.50	3.44		
PULL #5	3.58	3.29		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.60	4.39		4.24
PULL #2	4.43	4.48		4.59
PULL #3	4.43	4.43		4.58
PULL #4	4.50	4.59		4.38
PULL #5	4.41	4.47		4.47
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665947
15 Nov 1991

CENTROIDAL DISTANCES

0 TO	1	.209308
1 TO	2	.25773
1 TO	3	.112379
1 TO	4	.0186815
1 TO	5	.581627

#5 <----POA

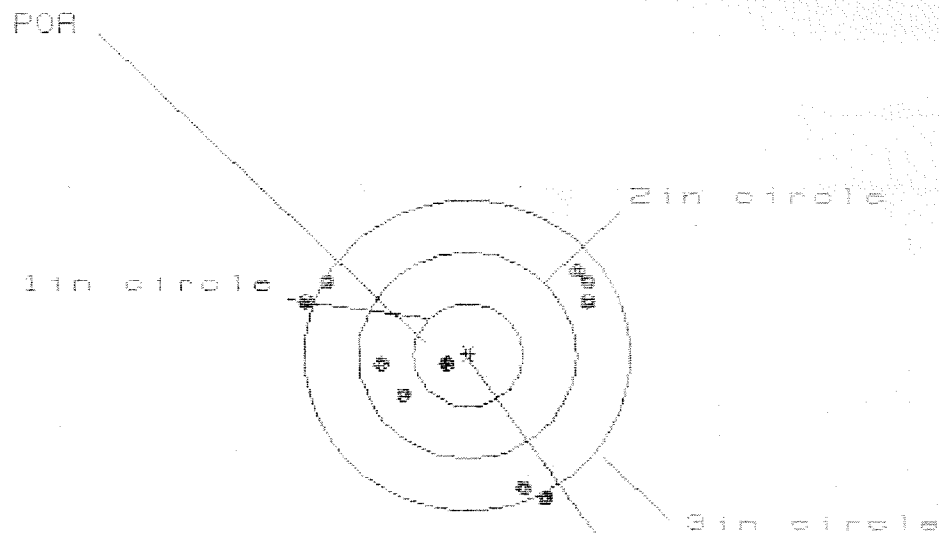
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .333
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0464
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .335442

THE SMP FOR THIS RIFLE IS: .975

15 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8685947

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 1

2in = 3

3in = 8

HS= 2.658

VS= 2.199

GS= 2.916

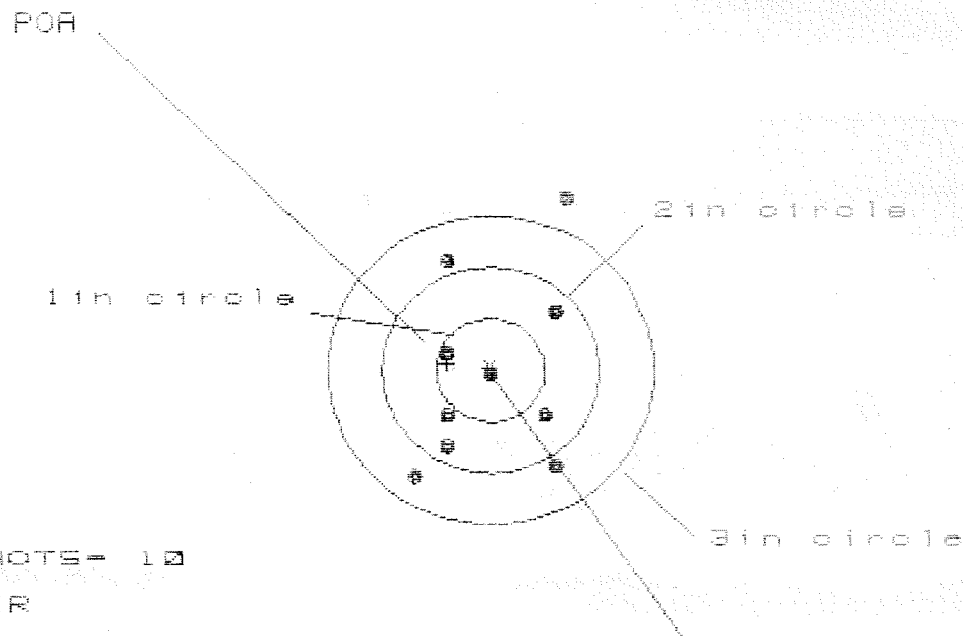
CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.145	.977	1.040
MINIMUM X	:	-1.513	-1.445	-1.382
MAXIMUM Y	:	.792	.847	.678
MINIMUM Y	:	-1.407	-1.352	-1.382
CENTROID X	:	.193	.361	.298
CENTROID Y	:	.081	.026	.195
POR TO CENTROID in.	:	.210	.362	.356
MIN RADIUS	:	.189	.323	.343
MEAN RADIUS	:	1.156	1.114	1.063
MAX RADIUS	:	1.591	1.657	1.523
HORIZONTAL SPREAD	:	2.658	2.422	2.422
VERTICAL SPREAD	:	2.199	2.199	2.060
EXTREME SPREAD	:	2.916	2.916	2.698
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

15 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665347

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 1.430

VS= 2.650

GS= 3.011

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.717	.633	.554
MINIMUM X	-.713	-.633	-.422
MAXIMUM Y	1.636	1.294	1.190
MINIMUM Y	-1.014	-.833	-.806
CENTROID X	.404	.324	.403
CENTROID Y	-.067	-.248	-.144
POA TO CENTROID in.	.409	.408	.428
MIN RADIUS	.045	.175	.080
MEAN RADIUS	.861	.736	.694
MAX RADIUS	1.786	1.339	1.263
HORIZONTAL SPREAD	1.430	1.266	.976
VERTICAL SPREAD	2.650	2.127	1.996
EXTREME SPREAD	3.011	2.232	2.222
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

15 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08685947

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 8

HS = 2.678

VS = 3.053

GS = 3.624

CENTROID #

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.294
MINIMUM X	-1.384
MAXIMUM Y	1.681
MINIMUM Y	-1.372
CENTROID X	.083
CENTROID Y	.059
POA TO CENTROID in.	.162
MIN RADIUS	.085
MEAN RADIUS	1.076
MAX RADIUS	1.859
HORIZONTAL SPREAD	2.678
VERTICAL SPREAD	3.053
EXTREME SPREAD	3.624
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	8

15 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665947

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 5

2in = 7

3in = 8

HS= 2.265

VS= 3.193

GS= 3.341

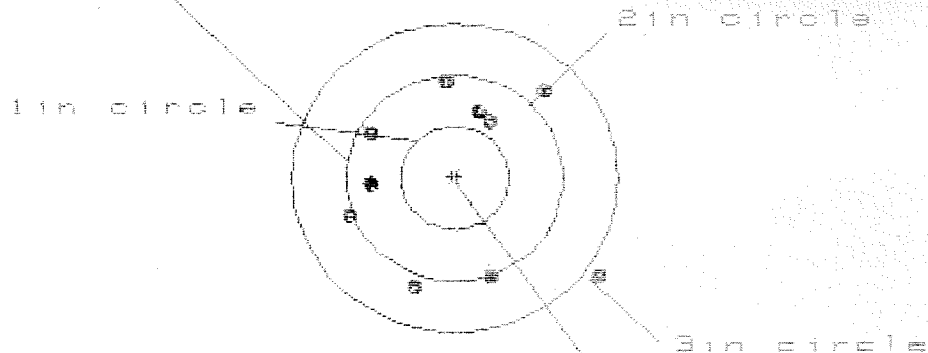
PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.527	.467	.444
MINIMUM X	-.738	-.568	-.591
MAXIMUM Y	1.442	1.554	1.350
MINIMUM Y	-1.751	-1.639	-.832
CENTROID X	.211	.041	.064
CENTROID Y	.076	-.036	.168
POA TO CENTROID in.	.224	.055	.188
MIN RADIUS	.161	.043	.176
MEAN RADIUS	.799	.647	.546
MAX RADIUS	1.832	1.648	1.352
HORIZONTAL SPREAD	2.265	1.035	1.035
VERTICAL SPREAD	3.193	3.193	2.182
EXTREME SPREAD	3.341	3.195	2.244
NUMBER IN ONE INCH CIRCLE =		5	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	

15 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8885947

CENTERFIRE PATTERNS # 5

POR



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 2.215

VS= 2.012

GS= 2.441

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.290	.981	.572
MINIMUM X	-.924	-.781	-.658
MAXIMUM Y	.934	.832	.930
MINIMUM Y	-1.078	-1.100	-1.082
CENTROID X	.774	.631	.508
CENTROID Y	.054	.156	.057
POR TO CENTROID in.	.776	.650	.512
MIN RADIUS	.577	.585	.530
MEAN RADIUS	.983	.896	.831
MAX RADIUS	1.584	1.260	1.131
HORIZONTAL SPREAD	2.215	1.762	1.230
VERTICAL SPREAD	2.012	2.012	2.012
EXTREME SPREAD	2.441	2.316	2.038
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	