

FORM

UPC



0 47700 25716 7

C6665965

*INCLUDES 1 IN CHAMBER

CAPACITY*

MODEL 700 TM M24

ORDER NO. 5716

BARREL LENGTH

Remington		 REG. U.S. PAT. & TM. OFF.	VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700TM M24		SERIAL NO. C6665965	
		ORDER NO. 5716	
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		20	



5716 C6665965

ORDER 5716
MODEL 700TM M24
UPC



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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6665965

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	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	LS
618	Polish Barrel		10/14/91	WB
620	Apply Coatings (Barrel Action)		11-51	LS
	Apply Coating (Bolt)			LS
625	Final Assembly A) Clean inside of Bolt Assembly		11/26/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/26/91	KL
	C) Inspect Ejector Hole for Chamfer		11/26/91	KL
	D) Oil Firing Pin Ass'y		11/26/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		12-2-91	KL

op. #	BARBER - M24 0104555 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			12-29-91	JK
	G) Safety Off Force	3	3	3			12-29-91	JK
	H) Trigger Pull Test & Retainability						12-29-91	JK
	I) Firing Pin Indent	10205	10205	10205			12-29-91	JK
	J) Assemble Stock						12-29-91	JK
	K) Assemble Swivel Studs						12-29-91	AC
	L) Attach Front and Rear Sight Assemblies						12-29-91	JK
	M) Iron Sight Alignment						12-29-91	JK
	N) Detach Front & Rear Sights & place in numbered container						12-29-91	JK
	O) Attach Scope to Rifle						12-29-91	JK
	P) Detach & Attach Scope 20 Times						12-29-91	JK
640	Gallery Target & Test						12-3-91	N
	A) Time						"	N
	B) Malfunctions						"	N
	C) Pierced Primers						"	N
	D) Optical Clarity of Scope						"	N
645	Inspect for Live Ammo						12-3-91	N
655	Final Inspection							
	A) Headspace						12-7-91	AC
	B) Trigger Pull	2.80	2.78	2.77	2.80	2.73	12-5-91	AC
	C) Function						12-7-91	AC
660	Pack						12-19-91	N

ETAQ

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 06665965DATE 12-2-91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.22	2.36	2.40	2.80	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.39	2.44	2.78	
PULL #3	2.33	2.34	2.39	2.77	
PULL #4	2.36	2.37	2.30	2.80	
PULL #5	2.36	2.38	2.48	2.73	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.30	3.52		
PULL #2	3.28	3.32		
PULL #3	3.38	3.53		
PULL #4	3.51	3.57		
PULL #5	3.34	3.51		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.28	4.42		4.40
PULL #2	4.44	4.42		4.37
PULL #3	4.43	4.32		4.37
PULL #4	4.33	4.29		4.31
PULL #5	4.42	4.44		4.44
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
 FOR RIFLE # 06665965
 3 Dec 1991

CENTROIDAL DISTANCES

0 TO	1	.543007
1 TO	2	.0601664
1 TO	3	.305792
1 TO	4	.482296
1 TO	5	.553507

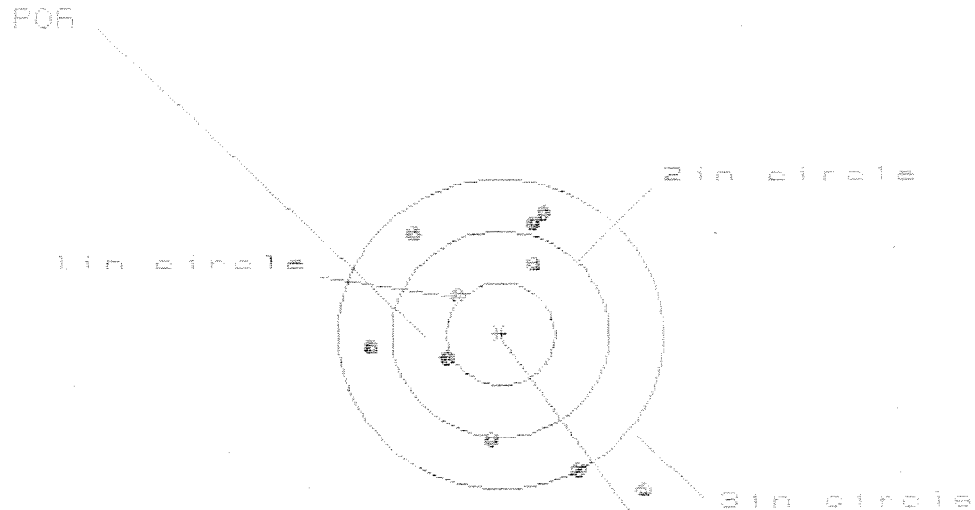
532
 # <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2654
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1688
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .14500
 THE AVE FOR THIS RIFLE IS: .9854

Date: 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8685965

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 0

3 in = 0

HS = 2.554

VS = 2.789

GS = 3.268

CENTROID #

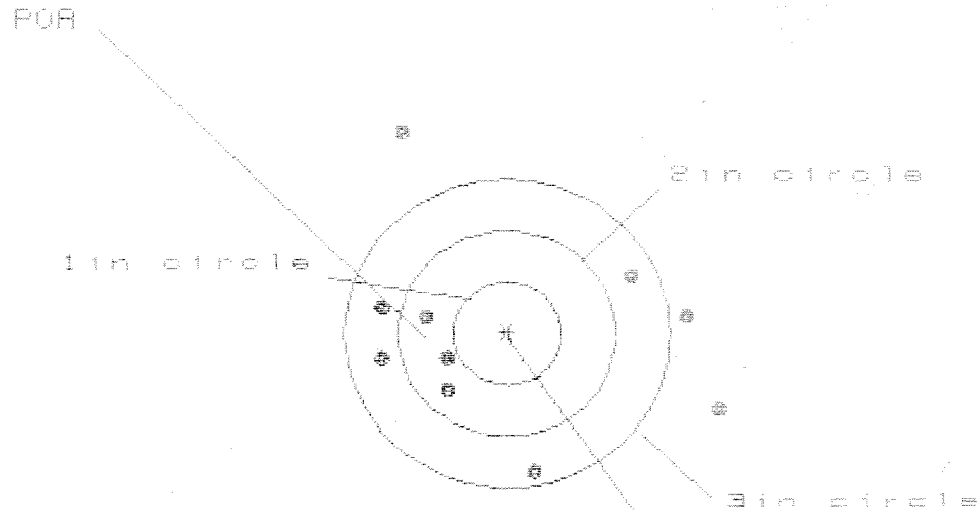
PATTERN #

	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.349	.848	.666
MINIMUM X	-1.205	-1.055	-.950
MAXIMUM Y	1.222	1.048	.866
MINIMUM Y	1.567	-1.453	-1.349
CENTROID X	.496	.346	.241
CENTROID Y	.221	.395	.577
POB TO CENTROID (in)	.540	.526	.625
1 in radius	.552	.325	.156
2 in radius	1.115	.957	.824
3 in radius	2.068	1.682	1.354
1 in SPREAD	2.554	1.903	1.616
2 in SPREAD	2.789	2.501	2.215
3 in SPREAD	3.268	2.647	2.282
POB TO ONE INCH CIRCLE =		6	
POB TO TWO INCH CIRCLE =		2	
POB TO THREE INCH CIRCLE =		9	

3 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8665965

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 0

2in = 3

3in = 7

HS= 3.162

VS= 3.254

GS= 3.996

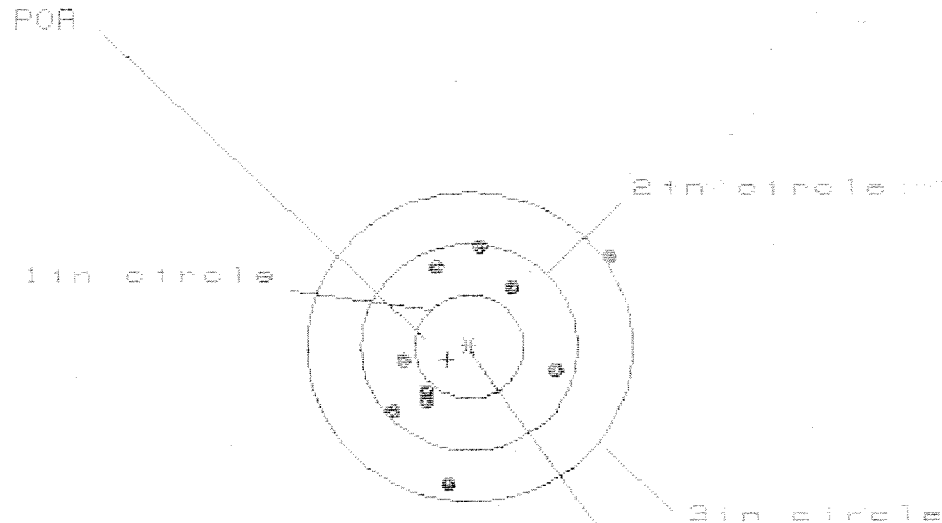
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.983	1.875	1.807
MINIMUM X	:	-1.179	-1.287	-1.053
MAXIMUM Y	:	1.948	.786	.720
MINIMUM Y	:	-1.306	-1.089	-1.155
CENTROID X	:	.554	.652	.428
CENTROID Y	:	.237	.020	.086
POR TO CENTROID in.	:	.603	.663	.437
MIN RADIUS	:	.601	.657	.432
MEAN RADIUS	:	1.305	1.206	1.039
MAX RADIUS	:	2.177	1.947	1.830
HORIZONTAL SPREAD	:	3.162	3.162	2.868
VERTICAL SPREAD	:	3.254	1.875	1.875
EXTREME SPREAD	:	3.996	3.319	2.863
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		7	

3 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06665965

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 0

2in = 8

3in = 9

HS= 2.045

VS= 2.241

GS= 2.636

CENTROID #

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.301
MINIMUM X	-1.744
MAXIMUM Y	.956
MINIMUM Y	-1.285
CENTROID X	.206
CENTROID Y	.124
POR TO CENTROID in.	.241
MIN RADIUS	.574
MEAN RADIUS	.904
MAX RADIUS	1.559
HORIZONTAL SPREAD	2.045
VERTICAL SPREAD	2.241
EXTREME SPREAD	2.636
NUMBER IN ONE INCH CIRCLE	0
NUMBER IN TWO INCH CIRCLE	8
NUMBER IN THREE INCH CIRCLE	9

3 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08665985

CENTERFIRE PATTERNS # 4

POR

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 3

2in = 7

3in = 10

HS = 1.455

VS = 2.420

GS = 2.475

CENTROID #

PATTERN #

4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.845	.778	.770
MINIMUM X	-.611	-.638	-.646
MAXIMUM Y	1.054	.902	.714
MINIMUM Y	-1.366	-1.504	-.695
CENTROID X	.116	.183	.191
CENTROID Y	-.076	.076	.264
POR TO CENTROID in.	.138	.199	.326
MIN RADIOS	.119	.151	.199
MEAN RADIUS	.788	.686	.571
MAX RADIOS	1.497	1.505	.963
HORIZONTAL SPREAD	1.456	1.416	1.416
VERTICAL SPREAD	2.420	2.406	1.409
EXTREME SPREAD	2.475	2.475	1.691
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

13 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8685965

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

CENTROID #

HS = 2.254

VS = 2.252

GS = 2.620

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.146

.763

.640

MINIMUM X

-1.108

-.980

-.712

MAXIMUM Y

1.226

.949

.952

MINIMUM Y

-1.026

-.890

-.887

CENTROID X

-.045

-.173

-.050

CENTROID Y

.038

.202

.139

POA TO CENTROID in.

.341

.266

.205

MIN RADIUS

.223

.220

.135

MEAN RADIUS

.815

.705

.651

MAX RADIUS

1.678

1.023

1.077

HORIZONTAL SPREAD

2.254

1.743

1.352

VERTICAL SPREAD

2.252

1.839

1.839

EXTREME SPREAD

2.620

1.916

1.916

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

7

NUMBER IN THREE INCH CIRCLE =

9