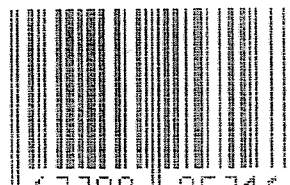


FORM

UPC



0 47700 25716 7

06665966

*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 700 TM M24

SERIAL NO.

C6665966

ORDER NO.

5716

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

20



5716 C6665966

ORDER 5716

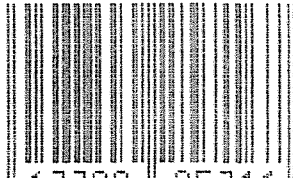
MODEL 700 TM M24

UPC

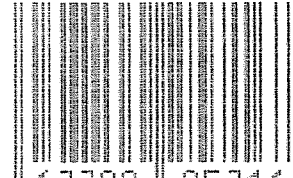
ORDER 5716

MODEL 700 TM M24

UPC



0 47700 25716 7



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6665966

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		9/24/91	KL
600	Proof		9/24/91	KL
607	Check Headspace		9/24/91	KL
610	Dis-assemble Gun		9/24/91	KL
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	KL
	Apply Coating (Bolt)		10-14/91	KL
625	Final Assembly A) Clean inside of Bolt Assembly		10/18/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/18/91	KL
	C) Inspect Ejector Hole for Chamfer		10/18/91	KL
	D) Oil Firing Pin Ass'y		10/18/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		10/22/91	KL

op. #	BARBER - M24 0104567 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			10-22-91	DH
	G) Safety Off Force	3	2 1/4	2 1/4			10-22-91	DH
	H) Trigger Pull Test & Retainability						10/22/91	JH
	I) Firing Pin Indent	.023	.020	.023			10-22-91	DH
	J) Assemble Stock						10/23/91	YH
	K) Assemble Swivel Studs						10-30-91	AC
	L) Attach Front and Rear Sight Assemblies						10/23/91	YH
	M) Iron Sight Alignment						10/23/91	YH
	N) Detach Front & Rear Sights & place in numbered container						10/23/91	YH
	O) Attach Scope to Rifle						10/23/91	YH
	P) Detach & Attach Scope 20 Times						10/23/91	YH
640	Gallery Target & Test						10-24-91	AC
	A) Time						10-24-91	AC
	B) Malfunctions						10-24-91	AC
	C) Pierced Primers						10-24-91	AC
	D) Optical Clarity of Scope						10-24-91	AC
645	Inspect for Live Ammo						10-24-91	AC
655	Final Inspection							
	A) Headspace						10-30-91	AC
	B) Trigger Pull	2.56	2.61	2.61	2.64	2.53	10-28-91	DH
	C) Function						10-30-91	AC
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.6665966DATE 10/22/91TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.55	2.58	2.52	256	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.59	2.48	2.50	261	
PULL #3	2.61	2.50	2.46	261	
PULL #4	2.59	2.46	2.44	264	
PULL #5	2.60	2.49	2.55	253	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.42	3.41		
PULL #2	3.41	3.50		
PULL #3	3.48	3.37		
PULL #4	3.42	3.43		
PULL #5	3.37	3.45		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.50	4.54		4.54
PULL #2	4.57	4.37		4.60
PULL #3	4.47	4.55		4.54
PULL #4	4.50	4.30		4.59
PULL #5	4.51	4.53		4.60
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C5665966
24 Oct 1991

CENTROIDAL DISTANCES

0 TO	1	.277276
1 TO	2	.0877268
1 TO	3	.661925
1 TO	4	.298965
1 TO	5	.627407

3 42 <----POA
5

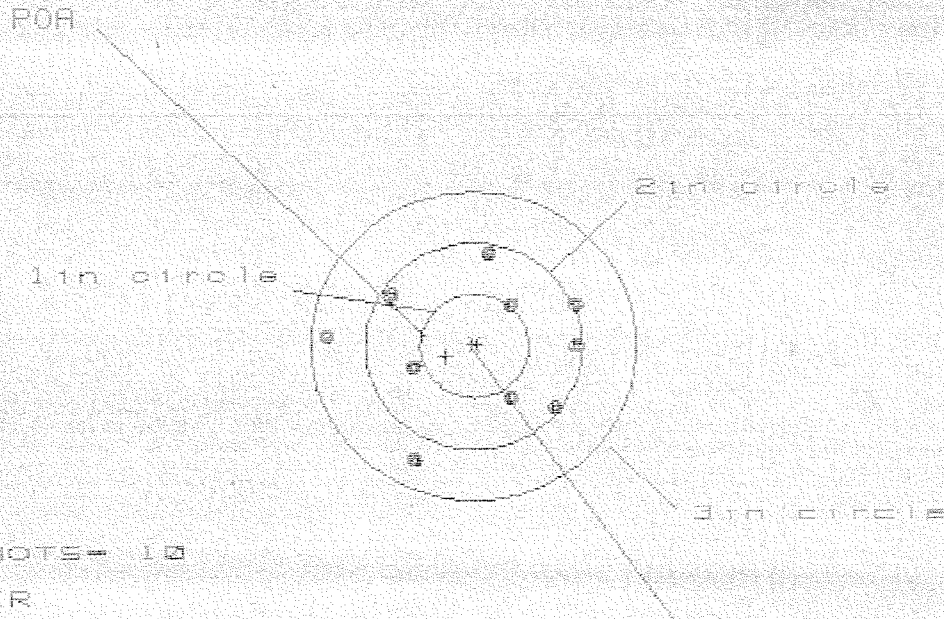
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0486
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0744
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0888669
THE AMR FOR THIS RIFLE IS: .9284

24 Oct 1991

FILE: PATTERNING/CENTERFIRE_PATT/C6B65986

CENTERFIRE PATTERNS

1



OF SHOTS= 10

IN CIR

1in = 0

2in = 7

3in = 10

HS= 2.349

VS= 1.972

GS= 2.351

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.947	.791	.696
MINIMUM X	-1.402	-.948	-1.044
MAXIMUM Y	.909	.916	.784
MINIMUM Y	-1.063	-1.056	-1.716
CENTROID X	.259	.415	.511
CENTROID Y	.099	.032	.224
POA TO CENTROID in.	.278	.425	.558
MIN RADIUS	.504	.433	.279
MEAN RADIUS	.903	.825	.740
MAX RADIUS	1.404	1.304	1.096
HORIZONTAL SPREAD	2.349	1.739	1.739
VERTICAL SPREAD	1.972	1.972	1.500
EXTREME SPREAD	2.351	2.112	1.863
NUMBER IN ONE INCH CIRCLE	= 0		
NUMBER IN TWO INCH CIRCLE	= 7		
NUMBER IN THREE INCH CIRCLE	= 10		

24 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8865966

CENTERFIRE PATTERNS

2

POB

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS = 2.009

VS = 4.415

GS = 4.509

CENTROID +

PATTERN #

2

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.348

1.309

1.375

MINIMUM X

-1.661

-1.700

-1.634

MAXIMUM Y

1.651

1.344

1.225

MINIMUM Y

-2.764

-1.272

-1.104

CENTROID X

.179

.218

.152

CENTROID Y

.135

.442

.274

POB TO CENTROID in.

.224

.493

.314

MIN RADIUS

.197

.244

.199

MEAN RADIUS

1.196

.996

.923

MAX RADIUS

2.787

1.446

1.386

HORIZONTAL SPREAD

2.009

2.009

2.009

VERTICAL SPREAD

4.415

2.616

2.329

EXTREME SPREAD

4.509

2.889

2.456

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

4

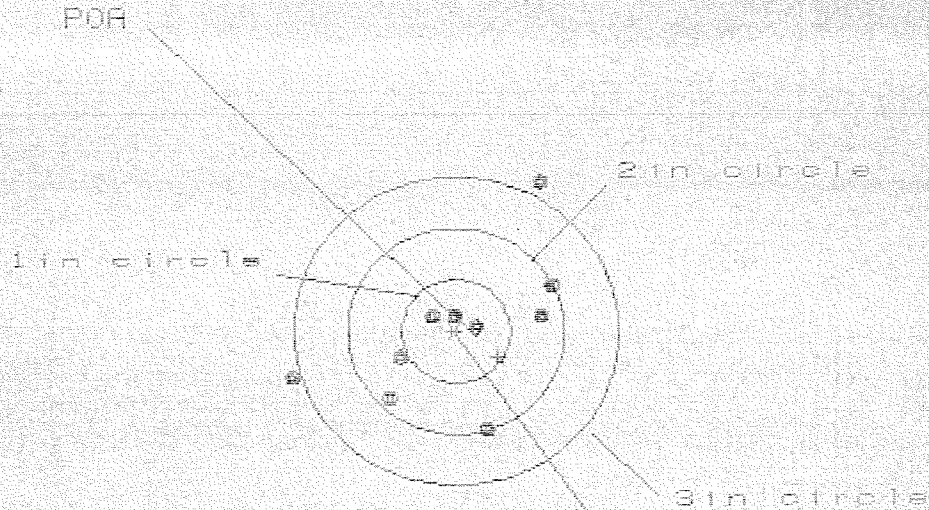
NUMBER IN THREE INCH CIRCLE =

8

24 Oct 1991

FILE: \PATTERNING\CENTERFIRE_PATT\06685966

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 8

HS= 2.405

VS= 2.364

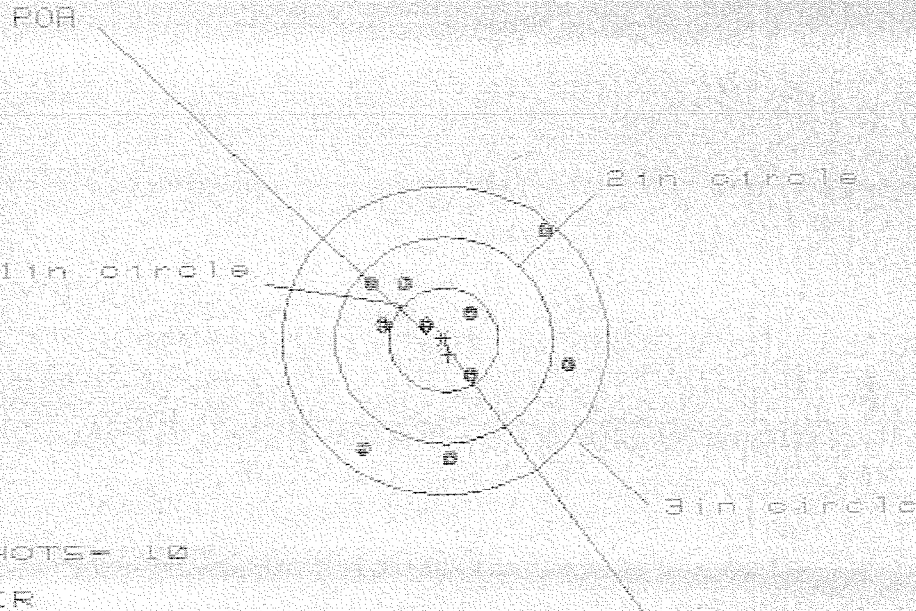
GS= 2.961

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	.850
MINIMUM X	-1.355
MAXIMUM Y	1.400
MINIMUM Y	-.964
CENTROID X	-.385
CENTROID Y	.252
POA TO CENTROID in.	.460
MIN RADIUS	.159
MEAN RADIUS	.810
MAX RADIUS	1.611
HORIZONTAL SPREAD	2.405
VERTICAL SPREAD	2.364
EXTREME SPREAD	2.961
NUMBER IN ONE INCH CIRCLE	3
NUMBER IN TWO INCH CIRCLE	7
NUMBER IN THREE INCH CIRCLE	8

24 Oct 1997

FILE: PATTERNING/CENTERFIRE_PATT/C6665966

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 6

3 in = 10

HS= 1.917

VS= 2.162

GS= 2.676

CENTROID *

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.162	1.264	1.182
MINIMUM X	-.755	-.653	-.632
MAXIMUM Y	1.065	.709	.595
MINIMUM Y	-1.097	-.978	-1.092
CENTROID X	-.037	-.139	-.057
CENTROID Y	.141	.022	.136
POA TO CENTROID in.	.145	.141	.147
MIN RADIUS	.244	.264	.238
MEAN RADIUS	.815	.749	.683
MAX RADIUS	1.403	1.274	1.214
HORIZONTAL SPREAD	1.917	1.917	1.814
VERTICAL SPREAD	2.162	1.687	1.687
EXTREME SPREAD	2.676	2.058	2.004
NUMBER IN ONE INCH CIRCLE	=	3	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	10	

24 Oct 1991

FILE: \PATTERNING\CENTERFIRE_PATT\08065966

CENTERFIRE PATTERNS # 5

POA

1 in circle =

2 in circle

3 in circle

CENTROID #

OF SHOTS= 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS= 2.627

VS= 2.389

GS= 2.728

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.128	.961	.995
MINIMUM X	-1.499	-1.207	-1.173
MAXIMUM Y	.795	.716	.507
MINIMUM Y	-1.594	-1.673	-1.782
CENTROID X	-.259	-.092	-.126
CENTROID Y	-.255	-.178	.033
POA TO CENTROID in.	.364	.199	.130
MIN RADIUS	.231	.210	.308
MEAN RADIUS	.918	.798	.634
MAX RADIUS	1.659	1.694	1.410
HORIZONTAL SPREAD	2.627	2.168	2.168
VERTICAL SPREAD	2.389	2.389	1.289
EXTREME SPREAD	2.728	2.436	2.238
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	