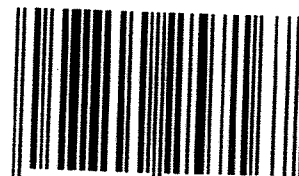


FORM

UPC



0 47700 25716 7

C6665978

*INCLUDES 1 IN CHAMBER

CAPACITY*

MODEL 700TM M24

ORDER NO.

5716

BARREL LENGTH

BARBER - M24 0104697

Remington



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

MODEL 700 TM M24

SERIAL NO.

C6665978

ORDER NO.

5716

20

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



5716 C6665978

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 #

C6665978

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		9/25/91	YK
600	Proof		9/25/91	YK
607	Check Headspace		9/25/91	YK
610	Dis-assemble Gun		9/25/91	YK
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	FB
618	Polish Barrel		OCT 4 1991	WB
620	Apply Coatings (Barrel Action)		10/4/91	YK
	Apply Coating (Bolt)			YK
625	Final Assembly A) Clean inside of Bolt Assembly		10/18/91	YK
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/18/91	YK
	C) Inspect Ejector Hole for Chamfer		10/18/91	YK
	D) Oil Firing Pin Ass'y		10/18/91	YK
	E) Adjust Trigger Pull to Min Setting and Stake		10/22/91	YK

op. #	BARBER - M24 0104699	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			10-22-91	DH
	G) Safety Off Force	3 1/2	4	4			10-22-91	DH
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent	.020	.020	.020			10-22-91	DH
	J) Assemble Stock						10/23/91	TS
	K) Assemble Swivel Studs						10-30-91	A
	L) Attach Front and Rear Sight Assemblies						10/23/91	TS
	M) Iron Sight Alignment						10/23/91	TS
	N) Detach Front & Rear Sights & place in numbered container						10/23/91	TS
	O) Attach Scope to Rifle						10/23/91	TS
	P) Detach & Attach Scope 20 Times						10/23/91	TS
640	Gallery Target & Test						10-24-91	DH
	A) Time						10-24-91	DH
	B) Malfunctions						10-24-91	DH
	C) Pierced Primers						10-24-91	DH
	D) Optical Clarity of Scope						10-24-91	DH
645	Inspect for Live Ammo						10-24-91	DH
655	Final Inspection							
	A) Headspace						10-30-91	A
	B) Trigger Pull	270	272	274	278	277	10-30-91	DH
	C) Function						10-30-91	A
660	Pack						12-11-91	TS

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6665978

DATE 10/22/91

TESTER JPL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.56	2.60	2.50	2.70	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.39	2.32	2.51	2.72	
PULL #3	2.48	2.28	2.55	2.74	
PULL #4	2.59	2.56	2.48	2.78	
PULL #5	2.57	2.54	2.53	2.77	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.53	3.47		
PULL #2	3.47	3.40		
PULL #3	3.51	3.39		
PULL #4	3.28	3.49		
PULL #5	3.46	3.42		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.33	4.36		4.35
PULL #2	4.28	4.31		4.28
PULL #3	4.26	4.33		4.17
PULL #4	4.28	4.21		4.34
PULL #5	4.33	4.16		4.30
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6663978
24 OCT 1991

CENTROIDAL DISTANCES

0 TO	1	.217007
1 TO	2	.32062
1 TO	3	.255906
1 TO	4	.492687
1 TO	5	.179644

$d_{1/2}$ (----) FOR

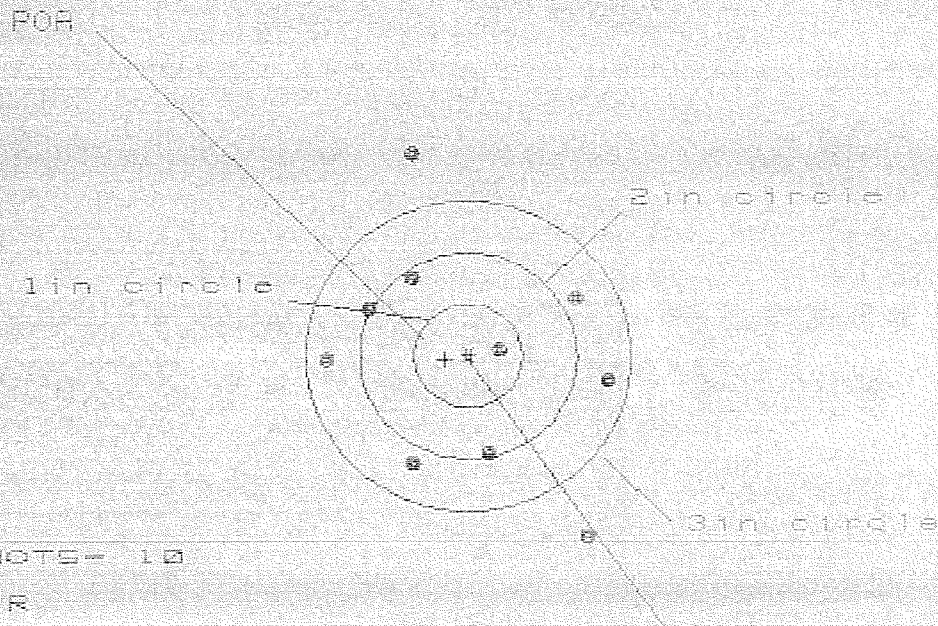
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0874
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0536
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .102527

THE AMR FOR THIS RIFLE IS: 1.06

24 Oct 1991

FILE: \PATTERNING\CENTERFIRE_PATT\EG665978

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 3

3 in = 8

HS= 2.515

VS= 3.759

GS= 4.090

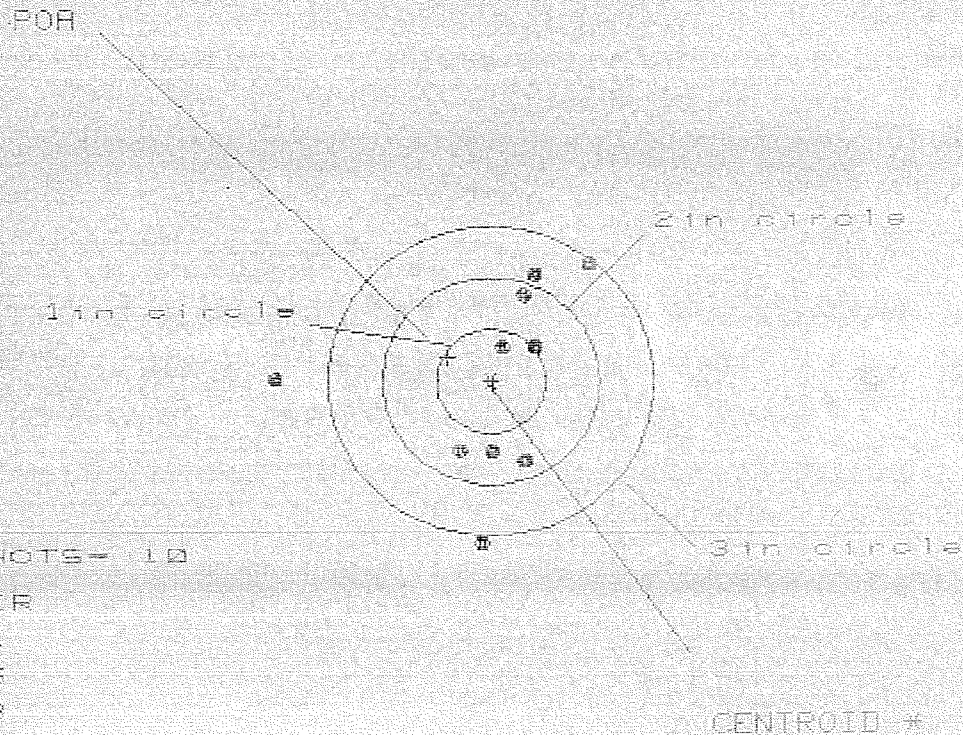
CENTROID *

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.250	1.373	1.325
MINIMUM X	-1.265	-1.142	-1.190
MAXIMUM Y	1.990	1.794	.828
MINIMUM Y	-1.769	-1.189	-1.965
CENTROID X	.214	.091	.139
CENTROID Y	.036	.232	.008
POA TO CENTROID in.	.217	.249	.139
MIN RADIUS	.279	.426	.358
MEAN RADIUS	1.210	1.106	.997
MAX RADIUS	2.087	1.834	1.340
HORIZONTAL SPREAD	2.515	2.515	2.515
VERTICAL SPREAD	3.759	2.983	1.793
EXTREME SPREAD	4.090	2.983	2.528
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	8		

24 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CBB65070

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 8

HS = 2.925

VS = 2.665

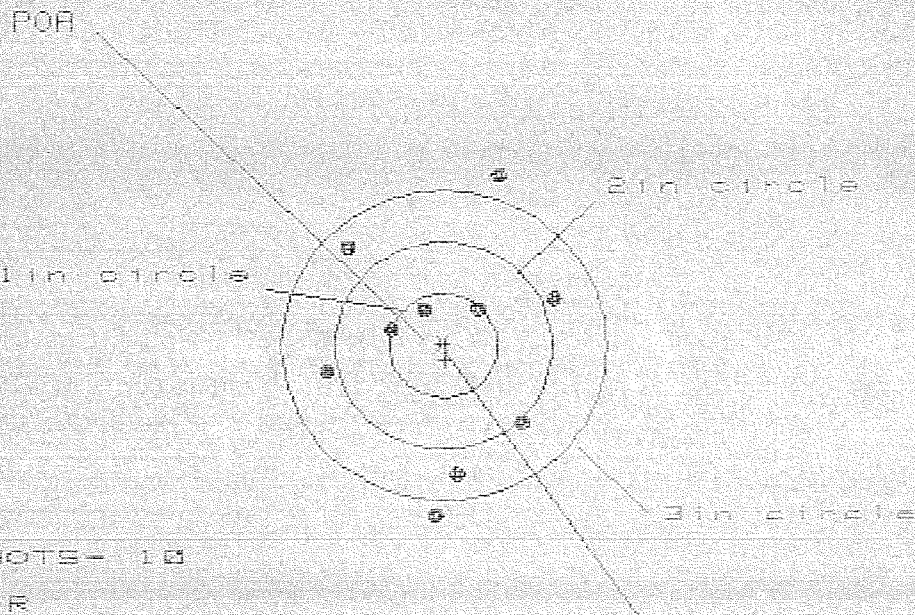
GS = 3.127

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.898	.673	.627
MINIMUM X	:	-2.027	-.549	-.595
MAXIMUM Y	:	1.090	1.089	.892
MINIMUM Y	:	-1.575	-1.576	-.035
CENTROID X	:	.393	.618	.664
CENTROID Y	:	-.230	-.229	-.032
POA TO CENTROID IN.	:	.456	.659	.664
MIN RADIUS	:	.364	.366	.190
MEAN RADIUS	:	1.009	.867	.730
MAX RADIUS	:	2.027	1.617	1.090
HORIZONTAL SPREAD	:	2.925	1.222	1.222
VERTICAL SPREAD	:	2.665	2.665	1.827
EXTREME SPREAD	:	3.127	2.859	2.102
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

24 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08685978

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 3

3in = 8

HS= 2.092

VS= 3.324

GS= 3.380

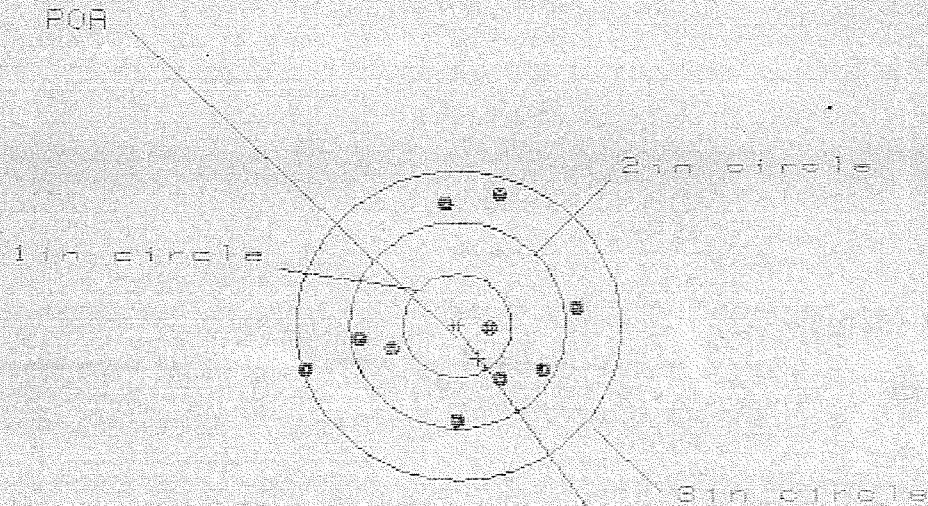
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.989	1.048	1.046
MINIMUM X	:	-1.103	-1.044	-1.046
MAXIMUM Y	:	1.631	1.146	.957
MINIMUM Y	:	-1.692	-1.511	-1.221
CENTROID X	:	-.013	-.077	-.075
CENTROID Y	:	.144	-.038	.151
POA TO CENTROID in.	:	.145	.086	.169
MIN RADIUS	:	.407	.515	.383
MEAN RADIUS	:	1.058	.994	.892
MAX RADIUS	:	1.717	1.511	1.292
HORIZONTAL SPREAD	:	2.092	2.092	2.092
VERTICAL SPREAD	:	3.324	2.657	2.170
EXTREME SPREAD	:	3.380	2.790	2.424
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

24 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08665978

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 10

HS= 2.491

VS= 2.175

GS= 2.563

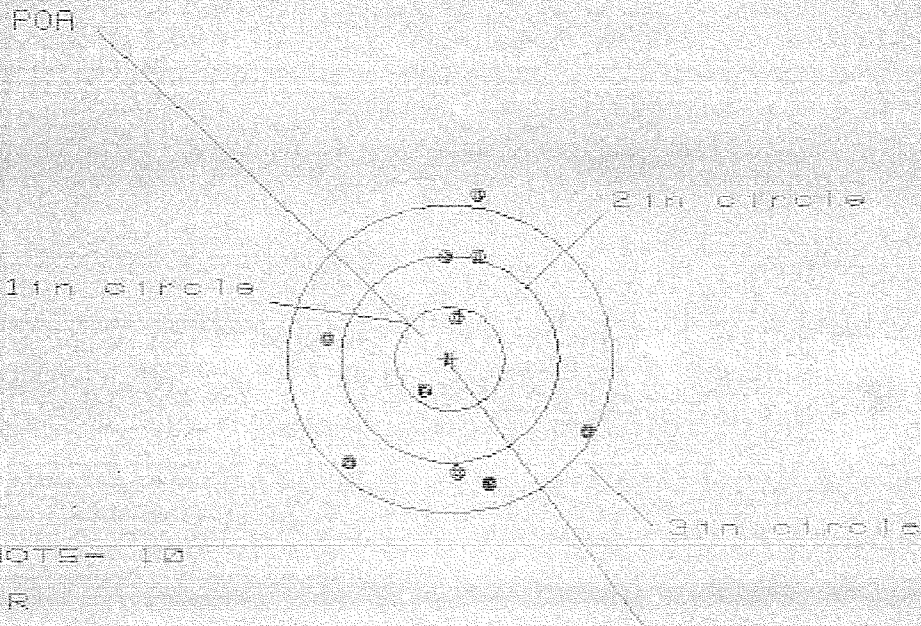
CENTROID #

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.087	.931	.965
MINIMUM X	-1.404	-1.052	-1.018
MAXIMUM Y	1.247	1.201	1.291
MINIMUM Y	-.928	-.974	-.824
CENTROID X	-.190	-.034	-.068
CENTROID Y	.318	.364	.214
POA TO CENTROID in.	.371	.366	.225
MIN RADIUS	.326	.170	.241
MEAN RADIUS	.945	.867	.801
MAX RADIUS	1.464	1.230	1.310
HORIZONTAL SPREAD	2.491	1.983	1.993
VERTICAL SPREAD	2.175	2.175	2.115
EXTREME SPREAD	2.563	2.219	2.117
NUMBER IN ONE INCH CIRCLE	=	1	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	10	

24 Oct 1991

FILE: PATTERNING/CENTERFIRE_PATT/03665378

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 2

2in = 3

3in = 9

HS= 2.347

VS= 2.884

GS= 2.945

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.251
MINIMUM X	-1.096
MAXIMUM Y	1.649
MINIMUM Y	-1.235
CENTROID X	.038
CENTROID Y	-.000
POA TO CENTROID in.	.038
MIN RADIUS	.345
MEAN RADIUS	1.080
MAX RADIUS	1.672
HORIZONTAL SPREAD	2.347
VERTICAL SPREAD	2.884
EXTREME SPREAD	2.945
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	3
NUMBER IN THREE INCH CIRCLE =	9