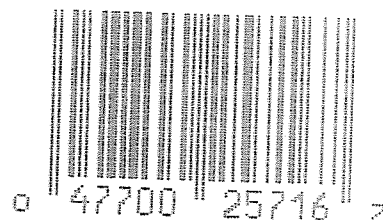


Small
M
AT 7 3 4 2 0 2 8

FORM

UPC



06665754

MODEL 700 TM M24

ORDER NO.

5716

BARREL LENGTH

CAPACITY*

Remington



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

MODEL 700TM M24

SERIAL NO.

C6665754

ORDER NO.

5716

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

20



5716 C6665754

ORDER 5716

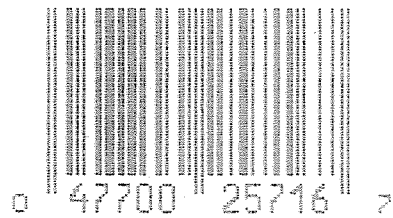
MODEL 700TM M24

UPC

ORDER 5716

MODEL 700TM M24

UPC



0 47700 25716 7



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6665754

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 26	9 1	RW
600	Proof	9 26	9 1	RW
607	Check Headspace	9 26	9 1	RW
610	Dis-assemble Gun	9 26	9 1	RW
612	Magnaflux Barrel Action		SEP 30 1991	KR
	Magnaflux Bolt		SEP 30 1991	KR
615	Rollmark Caliber		SEP 30 1991	GL
617	Drill and Tap Sight Holes		SEP 30 1991	LB
618	Polish Barrel		OCT 2 1991	WT
620	Apply Coatings (Barrel Action)		10-13-91	DA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/13/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/13/91	RW
	C) Inspect Ejector Hole for Chamfer		10/13/91	RW
	D) Oil Firing Pin Ass'y		10/13/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/16/91	SH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			10/16/91	SL
	G) Safety Off Force	3	3	3			10/16/91	SL
	H) Trigger Pull Test & Retainability						10/16/91	SL
	I) Firing Pin Indent	.020	.020	.020			10/16/91	SL
	J) Assemble Stock						10/18/91	RW
	K) Assemble Swivel Studs						10-22-91	SL
	L) Attach Front and Rear Sight Assemblies						10/18/91	RW
	M) Iron Sight Alignment						10/18/91	RW
	N) Detach Front & Rear Sights & place in numbered container						10/18/91	RW
	O) Attach Scope to Rifle						10/18/91	RW
	P) Detach & Attach Scope 20 Times						10/18/91	RW
640	Gallery Target & Test						10-18-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						10-18-91	NF
655	Final Inspection							
	A) Headspace						10-22-91	SL
	B) Trigger Pull	264	269	273	271	260	10-21-91	SL
	C) Function						10-22-91	SL
660	Pack						12-17-91	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. C-6665754

DATE 10-16-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.33	2.26	2.35	264	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.23	2.23	2.32	269	
PULL #3	2.32	2.28	2.38	273	
PULL #4	2.24	2.49	2.44	271	
PULL #5	2.36	2.32	2.35	260	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.48	3.40		
PULL #2	3.44	3.46		
PULL #3	3.40	3.48		
PULL #4	3.34	3.47		
PULL #5	3.29	3.52		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.39	4.19		4.25
PULL #2	4.20	4.24		4.15
PULL #3	4.23	4.22		4.19
PULL #4	4.19	4.24		4.31
PULL #5	4.21	4.28		4.22
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665754
18 Oct 1991

CENTROIDAL DISTANCES

0 TO 1	.0332415
1 TO 2	.0968814
1 TO 3	.021095
1 TO 4	.188096
1 TO 5	.114978

5 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .011
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0634
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0643472
THE AMR FOR THIS RIFLE IS: .9786

18 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6685754

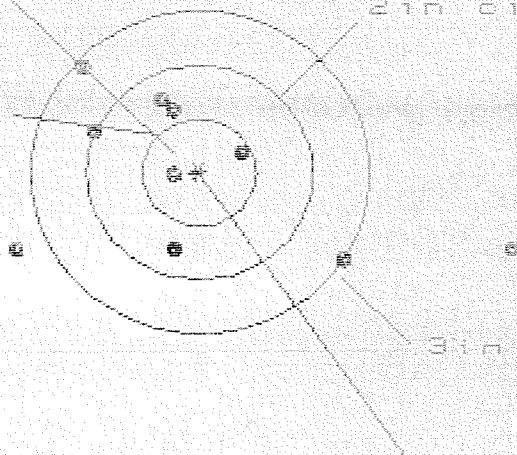
CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 7

HS= 4.431

VS= 1.782

GS= 4.431

CENTROID *

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.815	1.623	1.460
MINIMUM X	:	-1.616	-1.304	-.836
MAXIMUM Y	:	1.000	.926	.829
MINIMUM Y	:	-.782	-.856	-.953
CENTROID X	:	.031	-.281	-.118
CENTROID Y	:	.012	.086	.183
POA TO CENTROID in.	:	.034	.294	.218
MIN RADIUS	:	.216	.146	.213
MEAN RADIUS	:	1.142	.889	.798
MAX RADIUS	:	2.893	1.835	1.744
HORIZONTAL SPREAD	:	4.431	2.927	2.296
VERTICAL SPREAD	:	1.782	1.782	1.782

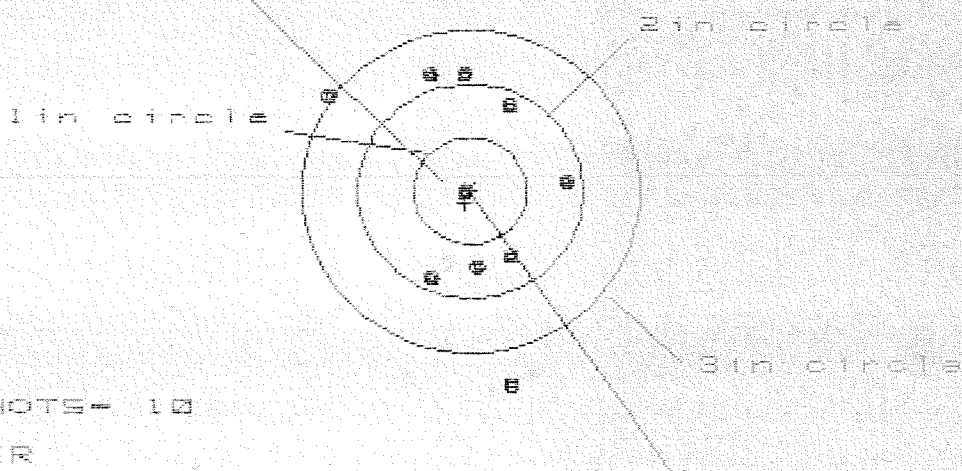
EXTREME SPREAD :	4.431	2.928	2.906
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

18 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8665754

CENTERFIRE PATTERNS # 2

POA



OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 4

HS = 2.041

VS = 2.916

GS = 3.110

CENTROID #

PATTERN #

2

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.833

.873

.727

MINIMUM X

-1.208

-1.168

-.494

MAXIMUM Y

1.082

.878

.960

MINIMUM Y

-1.834

-.965

-.884

CENTROID X

.050

.010

.156

CENTROID X	:	.107	.311	.230
POA TO CENTROID in.	:	.118	.311	.278
MIN RADIUS	:	.053	.197	.197
MEAN RADIUS	:	.957	.862	.782
MAX RADIUS	:	1.869	1.336	1.053
HORIZONTAL SPREAD	:	2.041	2.041	1.221
VERTICAL SPREAD	:	2.916	1.843	1.843
EXTREME SPREAD	:	3.110	2.179	1.875
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

18 Oct 1991

FILE: /PATTERNING/CENTERFIRE_PATT/C88683754

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 3

2in = 4

3in = 8

HS= 2.499

VS= 2.586

GS= 3.013

PATTERN #

3

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.332

.696

.664

MINIMUM X

-1.167

-1.019

-1.051

MINIMUM Y	: -1.996	-1.833	-1.614
CENTROID X	: .052	-.096	-.064
CENTROID Y	: .014	-.149	-.368
POA TO CENTROID in.	: .054	.177	.373
MIN RADIUS	: .269	.414	.261
MEAN RADIUS	: .959	.830	.684
MAX RADIUS	: 1.979	1.771	1.070
HORIZONTAL SPREAD	: 2.499	1.715	1.715
VERTICAL SPREAD	: 2.586	2.586	1.219
EXTREME SPREAD	: 3.013	2.652	1.843
NUMBER IN ONE INCH CIRCLE	=	3	
NUMBER IN TWO INCH CIRCLE	=	4	
NUMBER IN THREE INCH CIRCLE	=	8	

18 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B65754

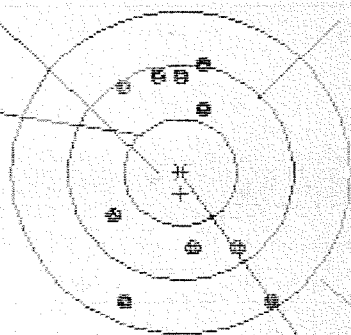
CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle



CENTROID #

OF SHOTS= 10

IN CIR

1in = 0

2in = 7

3in = 10

HS= 1.395

VS= 2.246

GS= 2.415

PATTERN #

4

MAXIMUM X	:	.832	.548	.499
MINIMUM X	:	-.563	-.471	-.520
MAXIMUM Y	:	1.015	.879	.708
MINIMUM Y	:	-1.231	-1.367	-1.029
CENTROID X	:	.003	-.089	-.040
CENTROID Y	:	.198	.334	.505
POA TO CENTROID in.	:	.198	.346	.507
MIN RADIUS	:	.658	.574	.405
MEAN RADIUS	:	.941	.858	.745
MAX RADIUS	:	1.478	1.423	1.083
HORIZONTAL SPREAD	:	1.395	1.019	1.019
VERTICAL SPREAD	:	2.246	2.246	1.737
EXTREME SPREAD	:	2.415	2.355	1.746
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

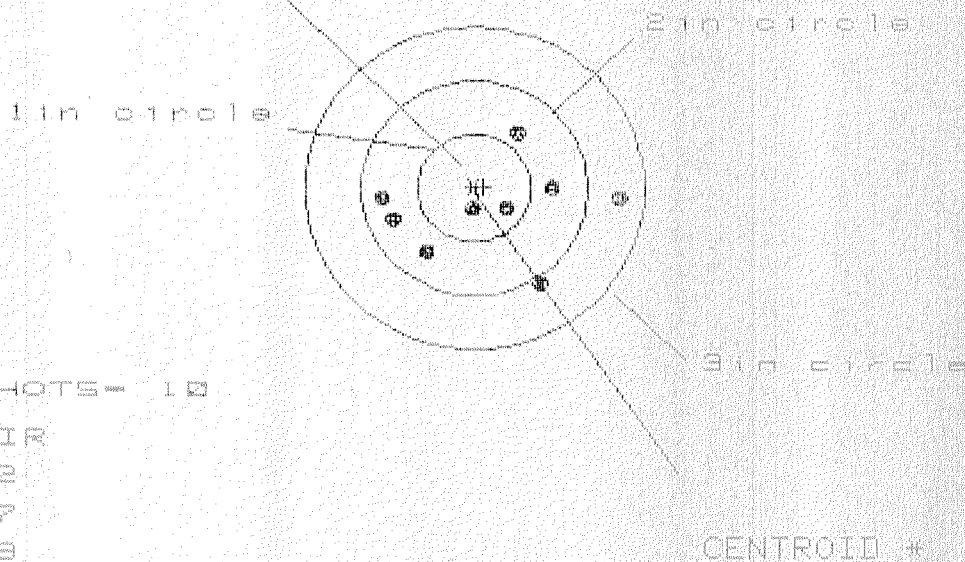
18 Oct 1991

FILE: /PATTERNING/CENTERFIRE_PATT/C6685754

CENTERFIRE PATTERNS

5

POA



OF SHOTS - 10

IN CIR

1in - 2

2in - 7

3in - 9

HS = 2.465

VS = 2.682

GS = 3.212

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.285	1.154	.697
MINIMUM X	:	-1.180	-.910	-.766
MAXIMUM Y	:	1.800	.760	.780
MINIMUM Y	:	-.882	-.682	-.662
CENTROID X	:	-.081	.050	-.094
CENTROID Y	:	-.014	-.214	-.234
POA TO CENTROID in.	:	.082	.220	.253
MIN RADIUS	:	.210	.137	.013
MEAN RADIUS	:	.876	.686	.612
MAX RADIUS	:	2.152	1.165	.893
HORIZONTAL SPREAD	:	2.465	2.064	1.463
VERTICAL SPREAD	:	2.682	1.442	1.442
EXTREME SPREAD	:	3.212	2.065	1.582
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	