

FORM

UPC



0 47700 25716 7

C6665987

*INCLUDES 1 IN CHAMBER

CAPACITY*

BARREL LENGTH

MODEL 700 TM M24

ORDER NO.

5716

Remington

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

MODEL 700™ M24

SERIAL NO.
C6665987

20

ORDER NO.
5716

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



5716 C6665987

ORDER 5716
MODEL 700™ M24

UPC

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ORDER 5716
MODEL 700™ M24

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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6665987

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10 1	91	RW
600	Proof	10 1	91	RW
607	Check Headspace	10 1	91	RW
610	Dis-assemble Gun	10 1	91	RW
612	Magnaflux Barrel Action	OCT	4 1991	KR
	Magnaflux Bolt	OCT	4 1991	KR
615	Rollmark Caliber	OCT	4 1991	GS.
617	Drill and Tap Sight Holes	OCT	4 1991	LB
618	Polish Barrel		10/8/91	LB
620	Apply Coatings (Barrel Action)		10-22-91	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/22/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/22/91	RW
	C) Inspect Ejector Hole for Chamfer		10/22/91	RW
	D) Oil Firing Pin Ass'y		10/22/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11-13-91	JL

op. #	BARBER - M24 0104815 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			11-14-91	GU
	G) Safety Off Force	3	3	3			11-14-91	GU
	H) Trigger Pull Test & Retainability						11-13-91	GU
	I) Firing Pin Indent	10205	1020	1020			11-14-91	GU
	J) Assemble Stock						11/13/91	RW
	K) Assemble Swivel Studs						11-27-91	A
	L) Attach Front and Rear Sight Assemblies						11/15/91	RW
	M) Iron Sight Alignment						11/15/91	RW
	N) Detach Front & Rear Sights & place in numbered container						11/15/91	RW
	O) Attach Scope to Rifle						11/13/91	RW
	P) Detach & Attach Scope 20 Times						11/15/91	RW
640	Gallery Target & Test						11-15-91	GU
	A) Time						11-15-91	DH
	B) Malfunctions						11-15-91	DH
	C) Pierced Primers						11-15-91	DH
	D) Optical Clarity of Scope						11-15-91	DH
645	Inspect for Live Ammo						11-15-91	DH
655	Final Inspection							
	A) Headspace						11-27-91	A
	B) Trigger Pull	260	246	241	252	259	11-15-91	DH
	C) Function						11-27-91	AC
660	Pack						12-19-91	NE

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO 2-6665987

DATE 11-13-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.61	2.47	2.55	260	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.51	2.57	2.59	246	
PULL #3	2.47	2.60	2.68	241	
PULL #4	2.44	2.56	2.54	252	
PULL #5	2.51	2.59	2.55	259	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.42	3.62		
PULL #2	3.47	3.15		
PULL #3	3.58	3.52		
PULL #4	3.55	3.38		
PULL #5	3.61	3.12		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.44	4.28		4.35
PULL #2	4.53	4.27		4.33
PULL #3	4.58	4.46		4.27
PULL #4	4.40	4.48		4.50
PULL #5	4.35	4.49		4.43
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06665987
18 Nov 1991

CENTROIDAL DISTANCES

0 TO 1	.367078
1 TO 2	.195533
1 TO 3	.459344
1 TO 4	.429907
1 TO 5	.179627

$\frac{1}{5}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1262
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1894
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .227593
THE AMP FOR THIS RIFLE IS: .938

18 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08665987

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS= 1.923

VS= 3.123

GS= 3.135

CENTROID *

PATTERN #

:

1

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

1.009

1.020

1.001

MINIMUM X

:

-.914

-.903

-.922

MAXIMUM Y

:

1.461

1.276

.914

MINIMUM Y

:

-1.662

-1.120

-.960

CENTROID X

:

-.039

-.050

-.031

CENTROID Y

:

.365

.550

.390

POA TO CENTROID in.

:

.367

.552

.392

MIN RADIUS

:

.167

.352

.192

MEAN RADIUS

:

.975

.909

.829

MAX RADIUS

:

1.665

1.515

1.387

HORIZONTAL SPREAD

:

1.923

1.923

1.923

VERTICAL SPREAD

:

3.123

2.396

1.874

EXTREME SPREAD

:

3.135

2.685

2.685

NUMBER IN ONE INCH CIRCLE =

2

5

NUMBER IN TWO INCH CIRCLE =

5

9

NUMBER IN THREE INCH CIRCLE =

9

9

18 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8685987

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 1.771

VS= 2.333

GS= 2.598

CENTROID *

PATTERN #

2

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.789	.711	.756
MINIMUM X	-.982	-1.060	-1.015
MAXIMUM Y	1.078	.938	.641
MINIMUM Y	-1.255	-.986	-.869
CENTROID X	.069	.147	.102
CENTROID Y	.202	.342	.225
POA TO CENTROID in.	.214	.372	.247
MIN RADIUS	.159	.033	.121
MEAN RADIUS	.802	.710	.672
MAX RADIUS	1.439	1.124	1.127
HORIZONTAL SPREAD	1.771	1.771	1.771
VERTICAL SPREAD	2.333	1.924	1.510
EXTREME SPREAD	2.598	1.933	1.838
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

(B Nov 1991)

FILE:/PATTERNING/CENTERFIRE_PATT/C8685387

CENTERFIRE PATTERNS # 3

POR

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 2.240

VS= 3.402

GS= 3.410

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.286	1.193	.932
MINIMUM X	:	-.954	-.811	-.662
MAXIMUM Y	:	1.489	1.276	.737
MINIMUM Y	:	-1.913	-1.021	-.861
CENTROID X	:	.160	.017	-.132
CENTROID Y	:	-.049	.164	.004
POR TO CENTROID in.	:	.167	.165	.132
MIN RADIUS	:	.446	.350	.412
MEAN RADIUS	:	1.050	.876	.743
MAX RADIUS	:	2.305	1.747	.947
HORIZONTAL SPREAD	:	2.240	2.004	1.594
VERTICAL SPREAD	:	3.402	2.297	1.598
EXTREME SPREAD	:	3.410	2.788	1.768
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

18 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66659B7

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 1

2in = 7

3in = 10

HS= 2.891

VS= 1.320

GS= 2.909

PATTERN #

4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.448	1.288	.966
MINIMUM X	-1.443	-1.113	-.952
MAXIMUM Y	.500	.612	.613
MINIMUM Y	-.740	-.708	-.708
CENTROID X	.355	.515	.354
CENTROID Y	.193	.161	.161
POA TO CENTROID in.	.404	.540	.389
MIN RADIUS	.199	.361	.262
MEAN RADIUS	.873	.887	.726
MAX RADIUS	1.473	1.288	1.123
HORIZONTAL SPREAD	2.891	2.401	1.918
VERTICAL SPREAD	1.320	1.320	1.320
EXTREME SPREAD	2.909	2.473	2.026
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

18 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66859B7

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 1.449

VS= 3.908

GS= 3.922

CENTROID *

PATTERN #

5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.584	.583	.444
MINIMUM X	-.865	-.946	-1.005
MAXIMUM Y	1.875	1.649	1.176
MINIMUM Y	-2.033	-1.097	-.891
CENTROID X	.086	.167	.226
CENTROID Y	.236	.462	.256
POA TO CENTROID in.	.251	.491	.341
MIN RADIUS	.317	.240	.294
MEAN RADIUS	.990	.832	.705
MAX RADIUS	2.158	1.717	1.343
HORIZONTAL SPREAD	1.449	1.449	1.449
VERTICAL SPREAD	3.908	2.746	2.067
EXTREME SPREAD	3.922	2.786	2.506
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	