

FORM

UPC



0 47700 25716 7

C66666026

*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 700TM M24

SERIAL NO.

C6666026

ORDER NO.

5716

20

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



5716 C6666026

ORDER 5716

MODEL 700TM M24

UPC

ORDER 5716

MODEL 700TM M24

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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6666026

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		9/30/91	KA
600	Proof		9/30/91	KA
607	Check Headspace		9/30/91	KA
610	Dis-assemble Gun		9/30/91	KA
612	Magnaflux Barrel Action		OCT 8 1991	KR
	Magnaflux Bolt		OCT 8 1991	KR
615	Rollmark Caliber		OCT 8 1991	SL
617	Drill and Tap Sight Holes		OCT 8 1991	LB
618	Polish Barrel		10/4/91	WB
620	Apply Coatings (Barrel Action)		11-1-91	KA
	Apply Coating (Bolt)			KA
625	Final Assembly A) Clean inside of Bolt Assembly		11/1/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/1/91	KA
	C) Inspect Ejector Hole for Chamfer		11/1/91	KA
	D) Oil Firing Pin Ass'y		11/1/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		11-4-91	KA

op. #	BARBER - M24 0105090 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			11-1-91	GU
	G) Safety Off Force	3	3	3			11-1-91	GU
	H) Trigger Pull Test & Retainability						11-4-91	GU
	I) Firing Pin Indent	.021	.0215	.0215			11-4-91	GU
	J) Assemble Stock						11/4/91	GU
	K) Assemble Swivel Studs						11-12-91	AC
	L) Attach Front and Rear Sight Assemblies						11/4/91	GU
	M) Iron Sight Alignment						11/4/91	GU
	N) Detach Front & Rear Sights & place in numbered container						11/4/91	GU
	O) Attach Scope to Rifle						11/4/91	GU
	P) Detach & Attach Scope 20 Times						11/4/91	GU
640	Gallery Target & Test						11-5-91	AC
	A) Time						11-5-91	AC
	B) Malfunctions						11-5-91	AC
	C) Pierced Primers						11-5-91	AC
	D) Optical Clarity of Scope						11-5-91	AC
645	Inspect for Live Ammo						11-5-91	AC
655	Final Inspection							
	A) Headspace						11-12-91	AC
	B) Trigger Pull	235	235	222	238	239	11-6-91	GU
	C) Function						11-12-91	AC
660	Pack						12-18-91	GU

ETA

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6666026DATE 11-4-91TESTER JM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.47	2.40	2.39	2.35	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.43	2.46	2.40	2.35	
PULL #3	2.20	2.41	2.48	2.22	
PULL #4	2.43	2.44	2.46	2.38	
PULL #5	2.51	2.37	2.40	2.39	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.60	3.69		
PULL #2	3.59	3.70		
PULL #3	3.57	3.49		
PULL #4	3.57	3.51		
PULL #5	3.53	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	4.36	4.58		4.57
PULL #2	4.57	4.49		4.60
PULL #3	4.51	4.58		4.56
PULL #4	4.47	4.50		4.61
PULL #5	4.56	4.68		4.64
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06666825
5 Nov 1991

CENTROIDAL DISTANCES

0	TO	1	.0559017
1	TO	2	.187128
1	TO	3	.562502
1	TO	4	.221822
1	TO	5	.241661

POI <----POI
3

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .041
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1686
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .173514

AND FOR THIS RIFLE IS: 1.125

Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6666026

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS - 10

IN CIR

1in = 2

2in = 3

3in = 7

HS= 2.062

VS= 2.836

GS= 3.460

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.171	1.111	1.015
MINIMUM X	-.891	-.761	-.825
MAXIMUM Y	1.427	1.270	1.422
MINIMUM Y	-1.409	-1.368	-1.216
CENTROID X	-.038	-.168	-.073
CENTROID Y	.041	.198	.046
POA TO CENTROID in.	.056	.259	.086
1IN RADIUS	.274	.311	.288
MEAN RADIUS	1.130	1.044	.977
MAX RADIUS	1.832	1.550	1.504
HORIZONTAL SPREAD	2.062	1.872	1.840
VERTICAL SPREAD	2.836	2.638	2.638
EXTREME SPREAD	3.460	2.836	2.740
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	7		

5 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6666026

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 8

HS= 2.561

VS= 2.956

GS= 3.038

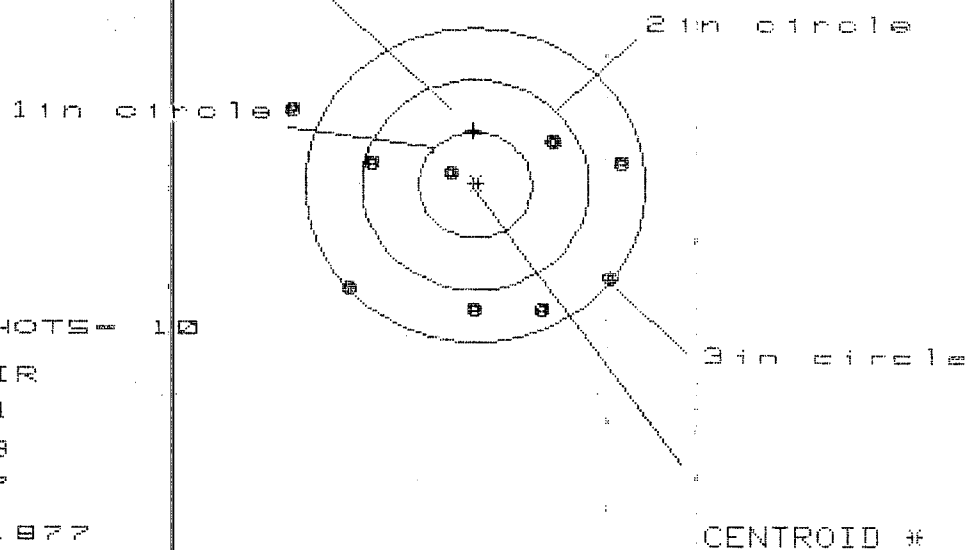
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.800	.605	.639
MINIMUM X	-1.761	-.934	-.859
MAXIMUM Y	1.479	1.527	.824
MINIMUM Y	-1.477	-1.429	-1.238
CENTROID X	.038	.233	.158
CENTROID Y	-.130	-.178	-.369
POA TO CENTROID in.	.135	.293	.401
MIN RADIUS	.365	.302	.474
MEAN RADIUS	.977	.849	.755
MAX RADIUS	1.812	1.642	1.238
HORIZONTAL SPREAD	2.561	1.539	1.497
VERTICAL SPREAD	2.956	2.956	2.062
EXTREME SPREAD	3.038	3.038	2.191
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		

5 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6566026

CENTERFIRE PATTERNS : # 3

POA



OF SHOTS = 10

IN CIR

1in = 1

2in = 3

3in = 7

HS = 2.977

VS = 3.703

GS = 3.729

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.309	1.324	1.130
MINIMUM X	-1.568	-1.553	-1.317
MAXIMUM Y	2.496	1.028	.838
MINIMUM Y	-1.207	-.930	-.801
CENTROID X	.015	-.000	.194
CENTROID Y	-.519	-.796	-.925
POA TO CENTROID in.	.519	.796	.945
MIN RADIUS	.261	.465	.676
MEAN RADIUS	1.308	1.162	1.060
MAX RADIUS	2.500	1.862	1.419
HORIZONTAL SPREAD	2.877	2.877	2.447
VERTICAL SPREAD	3.703	1.958	1.639
EXTREME SPREAD	3.729	3.228	2.688
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		7	

5 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8666026

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 2

2in = 4

3in = 8

HS = 2.482

VS = 3.408

GS = 3.451

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.237	1.211	1.052
MINIMUM X	-1.245	-1.271	-.528
MAXIMUM Y	1.278	1.042	.864
MINIMUM Y	-2.130	-1.475	-1.653
CENTROID X	.008	.034	.193
CENTROID Y	-.176	.061	.239
POA TO CENTROID in.	.176	.070	.307
MIN RADIUS	.352	.227	.339
MEAN RADIUS	1.135	.962	.809
MAX RADIUS	2.143	1.908	1.653
HORIZONTAL SPREAD	2.482	2.482	1.580
VERTICAL SPREAD	3.408	2.517	2.517
EXTREME SPREAD	3.451	2.963	2.518
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

5 NOV 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6666026

CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS - 10

IN CIR

1in = 2

2in = 3

3in = 9

HE = 2.749

VS = 2.333

GS = 3.046

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.188

1.014

.940

MINIMUM X

-1.561

-1.229

-1.303

MAXIMUM Y

1.370

1.451

1.126

MINIMUM Y

-.963

-.882

-.700

CENTROID X

.182

.356

.430

CENTROID Y

-.059

-.140

-.322

POA TO CENTROID in.

.192

.383

.537

MIN RADIUS

.324

.306

.285

MEAN RADIUS

1.073

.979

.884

MAX RADIUS

1.724

1.569

1.722

HORIZONTAL SPREAD

2.749

2.243

2.243

VERTICAL SPREAD

2.333

2.333

1.826

EXTREME SPREAD

3.046

2.710

2.710

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

3

NUMBER IN THREE INCH CIRCLE =

9