

FORM

BARREL LENGTH

CAPACITY*

*INCLUDES 1 IN CHAMBER

C6649078

UPC



0 47700 25716 7

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.

C6649078

ORDER NO.

5716

20

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



5716 C6649078

ORDER 5716

MODEL 700™ M24

UPC

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MODEL 700™ M24

UPC



0 47700 25716 7



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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649078

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 10 1991	KR
	Magnaflux Bolt		OCT 10 1991	KR
615	Rollmark Caliber		OCT 10 1991	LS
617	Drill and Tap Sight Holes		OCT 10 1991	LB
618	Polish Barrel		10/15/91	WB
620	Apply Coatings (Barrel Action)		11/2/91	LB
	Apply Coating (Bolt)			LB
625	Final Assembly A) Clean inside of Bolt Assembly		11/11/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/11/91	RW
	C) Inspect Ejector Hole for Chamfer		11/11/91	RW
	D) Oil Firing Pin Ass'y		11/11/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		12-5-91	RM

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	6	8			12-5-91	JU
	G) Safety Off Force	3	3	3			12-5-91	JU
	H) Trigger Pull Test & Retainability						12-5-91	JU
	I) Firing Pin Indent	.0205	.0205	.0205			12-5-91	JU
	J) Assemble Stock						12/6/91	RW
	K) Assemble Swivel Studs						12-7-91	AC
	L) Attach Front and Rear Sight Assemblies						12/6/91	RW
	M) Iron Sight Alignment						12/6/91	RW
	N) Detach Front & Rear Sights & place in numbered container						12/6/91	RW
	O) Attach Scope to Rifle						12/6/91	RW
	P) Detach & Attach Scope 20 Times						12/6/91	RW
640	Gallery Target & Test						12-6-91	DH
	A) Time						12-6-91	DH
	B) Malfunctions						12-6-91	DH
	C) Pierced Primers						12-6-91	DH
	D) Optical Clarity of Scope						12-6-91	DH
645	Inspect for Live Ammo						12-6-91	DH
655	Final Inspection							
	A) Headspace						12-7-91	AC
	B) Trigger Pull	254	255	251	255	2.50	12-6-91	DH
	C) Function						12-7-91	AC
660	Pack						12-19-91	VF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6649078

DATE 12-5-91

TESTER JK

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.31	2.41	2.49	2.54	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.55	2.49	2.44	2.55	
PULL #3	2.48	2.48	2.40	2.51	
PULL #4	2.29	2.50	2.58	2.55	
PULL #5	2.52	2.50	2.55	2.50	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.60	3.29		
PULL #2	3.60	3.29		
PULL #3	3.43	3.27		
PULL #4	3.37	3.26		
PULL #5	3.30	3.25		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.45	4.33		4.35
PULL #2	4.31	4.36		4.35
PULL #3	4.39	4.35		4.42
PULL #4	4.42	4.36		4.40
PULL #5	4.27	4.37		4.33
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649078
5 Dec 1991

CENTROIDAL DISTANCES

0 TO	1	.12744
1 TO	2	.526927
1 TO	3	.375899
1 TO	4	.0566127
1 TO	5	.363824

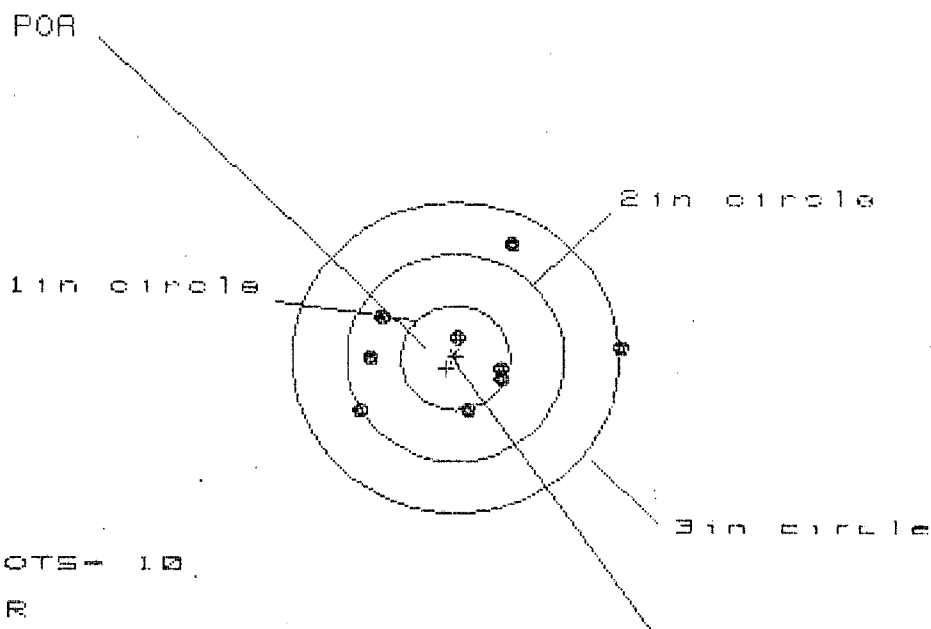
$\frac{a^2 + 5}{2}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0536
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.048
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0719511
THE AMR FOR THIS RIFLE IS: .944

6 Dec 1931

FILE:/PATTERNING/CENTERFIRE_PATT/C6649078

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 5

3 in = 2

HS= 2.444

VS= 1.598

GS= 2.504

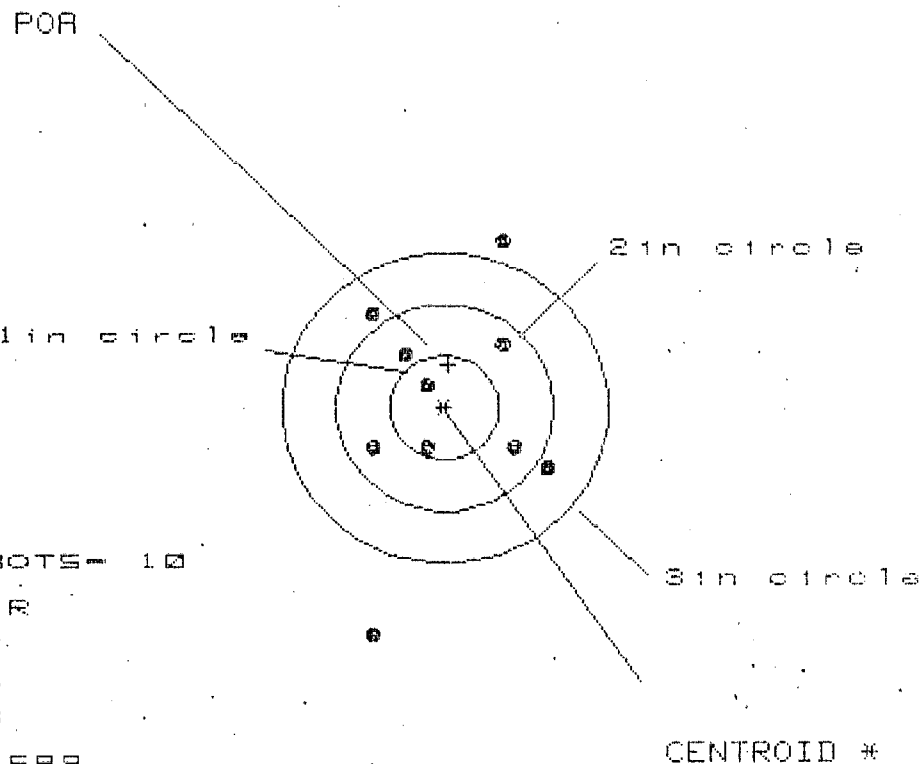
CENTROID #

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.550	.732	.705
MINIMUM X	:	-.894	-.722	-.631
MAXIMUM Y	:	1.084	1.091	.559
MINIMUM Y	:	-.514	-.507	-.370
CENTROID X	:	.079	-.093	-.184
CENTROID Y	:	.100	.093	-.044
POA TO CENTROID in.	:	.127	.131	.189
MIN RADIUS	:	.200	.278	.441
MEAN RADIUS	:	.793	.705	.623
MAX RADIUS	:	1.551	1.314	.717
HORIZONTAL SPREAD	:	2.444	1.454	1.336
VERTICAL SPREAD	:	1.598	1.598	.929
EXTREME SPREAD	:	2.504	2.142	1.392
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

6 Dec 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 1.688

VS= 3.735

GS= 3.934

PATTERN #

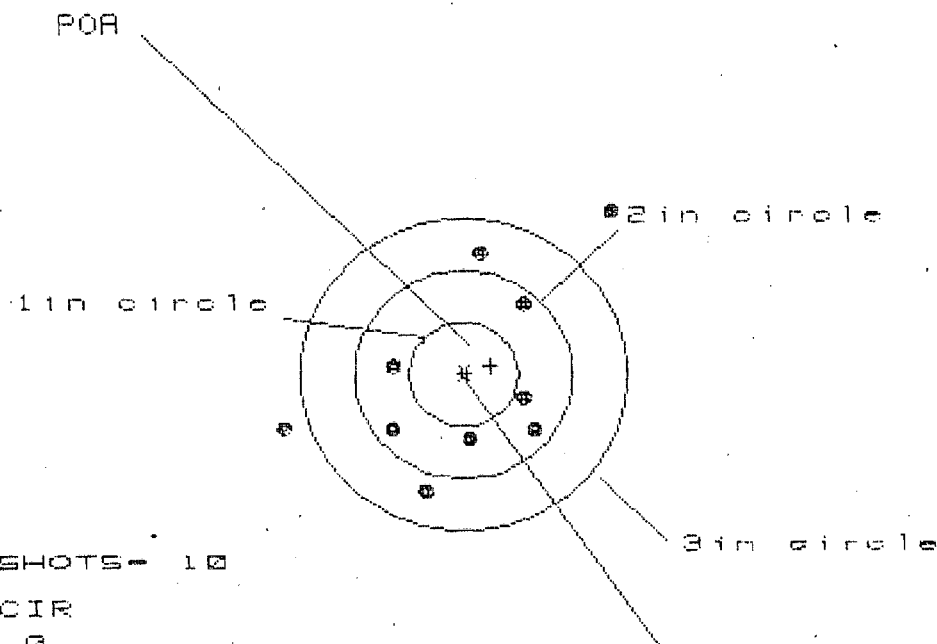
2

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.979	.901	.956
MINIMUM X	-.710	-.762	-.707
MAXIMUM Y	1.574	1.334	.852
MINIMUM Y	-2.161	-.796	-.630
CENTROID X	-.037	.041	-.014
CENTROID Y	-.414	-.174	-.340
POA TO CENTROID in.	.415	.179	.341
MIN RADIUS	.243	.202	.199
MEAN RADIUS	.984	.827	.735
MAX RADIUS	2.275	1.407	1.145
HORIZONTAL SPREAD	1.689	1.663	1.663
VERTICAL SPREAD	3.735	2.130	1.482
EXTREME SPREAD	3.934	2.254	2.228
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

6 Dec 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in - 0

2in - 5

3in - 5

HS = 3.025

VS = 2.609

GS = 3.642

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.347	.822	.631
MINIMUM X	:	-1.678	-1.529	-.657
MAXIMUM Y	:	1.537	1.395	1.355
MINIMUM Y	:	-1.072	-.902	-.942
CENTROID X	:	-.251	-.400	-.209
CENTROID Y	:	-.080	-.250	-.210
POA TO CENTROID in.	:	.263	.472	.297
MIN RADIUS	:	.582	.502	.493
MEAN RADIUS	:	1.054	.911	.817
MAX RADIUS	:	2.043	1.562	1.358
HORIZONTAL SPREAD	:	3.025	2.351	1.288
VERTICAL SPREAD	:	2.609	2.297	2.297
EXTREME SPREAD	:	3.642	2.529	2.352
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

6 Dec 1991

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CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 2

2in = 4

3in = 8

HS = 2.245

VS = 2.634

GS = 3.391

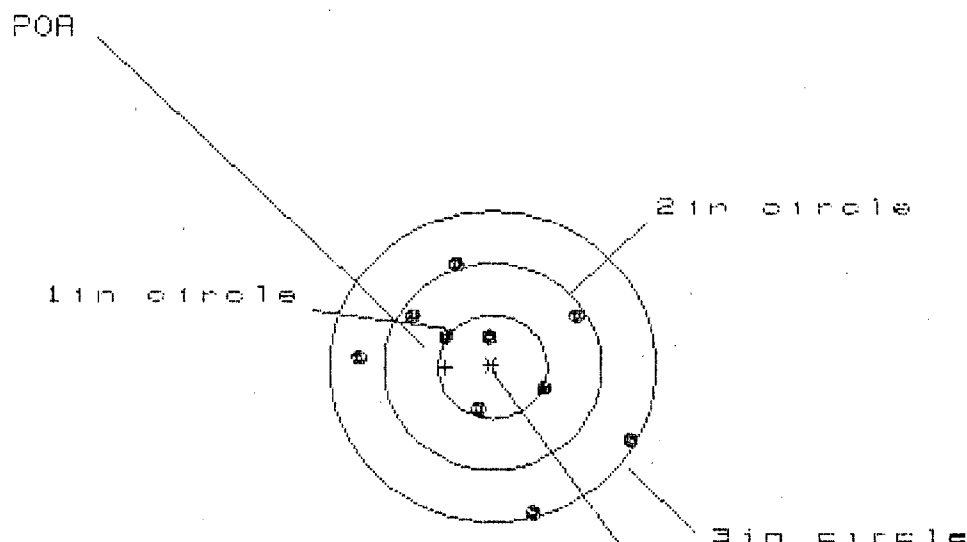
CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.184	.880	.777
MINIMUM X	-1.061	-.929	-1.032
MAXIMUM Y	1.359	1.217	.952
MINIMUM Y	-1.275	-.975	-.822
CENTROID X	.046	-.086	.017
CENTROID Y	.146	.288	.135
POA TO CENTROID in.	.153	.300	.136
MIN RADIUS	.322	.138	.317
MEAN RADIUS	1.019	.925	.849
MAX RADIUS	1.740	1.467	1.132
HORIZONTAL SPREAD	2.245	1.809	1.809
VERTICAL SPREAD	2.634	2.192	1.774
EXTREME SPREAD	3.391	2.773	2.150
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		8	

5 Dec 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 10

HS= 2.446

VS= 2.431

GS= 2.580

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.254
MINIMUM X	-1.192
MAXIMUM Y	.982
MINIMUM Y	-1.449
CENTROID X	.431
CENTROID Y	.008
POA TO CENTROID in.	.432
MIN RADIUS	.330
MEAN RADIUS	.870
MAX RADIUS	1.486
HORIZONTAL SPREAD	2.446
VERTICAL SPREAD	2.431
EXTREME SPREAD	2.580
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	10