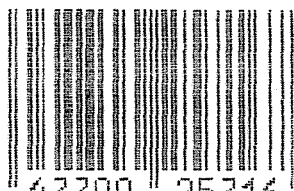


FORM

UPC



0 47700 25716 7

06636214

*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 TM M24

SERIAL NO.
C6636214

20

ORDER NO.
5716

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

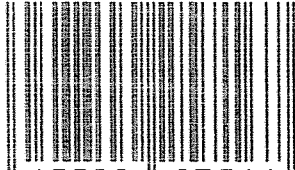


5716 C6636214

ORDER **5716**

MODEL 700 TM M24

UPC

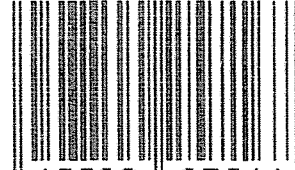


0 47700 25716 7

ORDER **5716**

MODEL 700 TM M24

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636214

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 30	91	RW
600	Proof	4 30	91	RW
607	Check Headspace	4 30	91	RW
610	Dis-assemble Gun	4 30	91	RW
612	Magnaflux Barrel Action	5 6	91	KCR
	Magnaflux Bolt	5 6	91	KCR
615	Rollmark Caliber	5 6	91	GB
617	Drill and Tap Sight Holes	5 10	91	WB
618	Polish Barrel	5 10	91	WB
620	Apply Coatings (Barrel Action)		5-30-91	PA
	Apply Coating (Bolt)			PA
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	YJ

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			10/16/91	JS
	G) Safety Off Force	3	3	3			10/16/91	JS
	H) Trigger Pull Test & Retainability						10/16/91	JS
	I) Firing Pin Indent	.021	.022	.022			10/16/91	JS
	J) Assemble Stock						10/16/91	RW
	K) Assemble Swivel Studs						10-22-91	Ac
	L) Attach Front and Rear Sight Assemblies						10/16/91	RW
	M) Iron Sight Alignment						10/16/91	RW
	N) Detach Front & Rear Sights & place in numbered container						10/16/91	RW
	O) Attach Scope to Rifle						10/16/91	RW
	P) Detach & Attach Scope 20 Times						10/16/91	RW
640	Gallery Target & Test						10-17-91	AC
	A) Time						10-17-91	AC
	B) Malfunctions						10-17-91	AC
	C) Pierced Primers						10-17-91	AC
	D) Optical Clarity of Scope						10-17-91	AC
645	Inspect for Live Ammo						10-17-91	AC
655	Final Inspection							
	A) Headspace						10-22-91	AC
	B) Trigger Pull	259	270	261	259	266	10-17-91	D/H
	C) Function						10-22-91	Ac
660	Pack						12-17-91	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-6636214

DATE 10/16/91

TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.35	2.36	2.44	259	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.25	2.30	2.39	270	
PULL #3	2.36	2.38	2.40	261	
PULL #4	2.34	2.44	2.40	259	
PULL #5	2.31	2.40	2.43	266	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.32	3.48		
PULL #2	3.34	3.43		
PULL #3	3.36	3.39		
PULL #4	3.18	3.25		
PULL #5	3.45	3.21		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.23	4.59		4.43
PULL #2	4.34	4.39		4.35
PULL #3	4.18	4.55		4.56
PULL #4	4.25	4.44		4.45
PULL #5	4.42	4.56		4.48
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636214
17 Oct 1991

CENTROIDAL DISTANCES

0 TO 1	.246457
1 TO 2	.505479
1 TO 3	.127413
1 TO 4	.344449
1 TO 5	.366896

246 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0332
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0234
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .040617

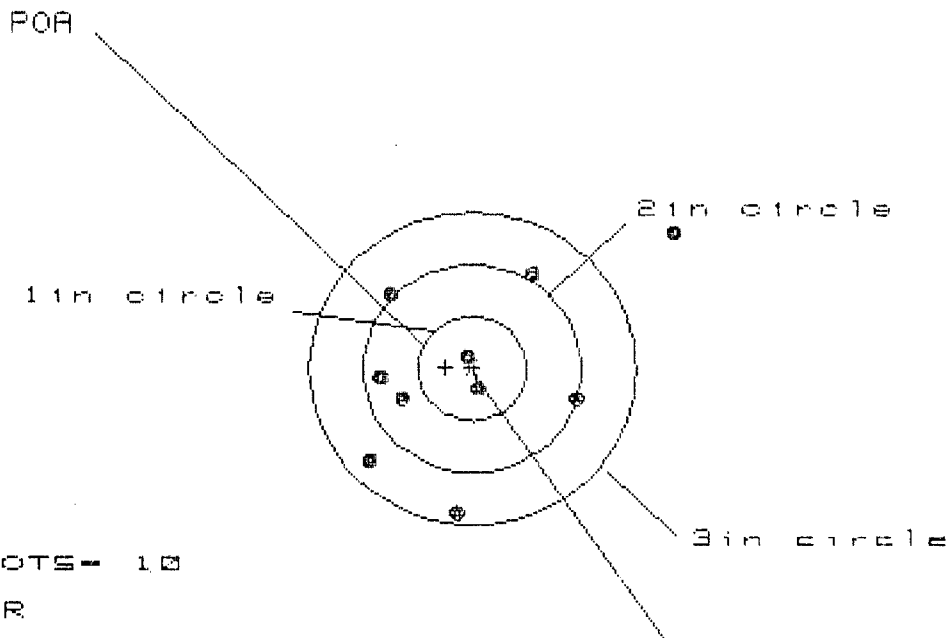
THE AMR FOR THIS RIFLE IS: .8162



17 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636214

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 2.749

VS= 2.735

GS= 3.568

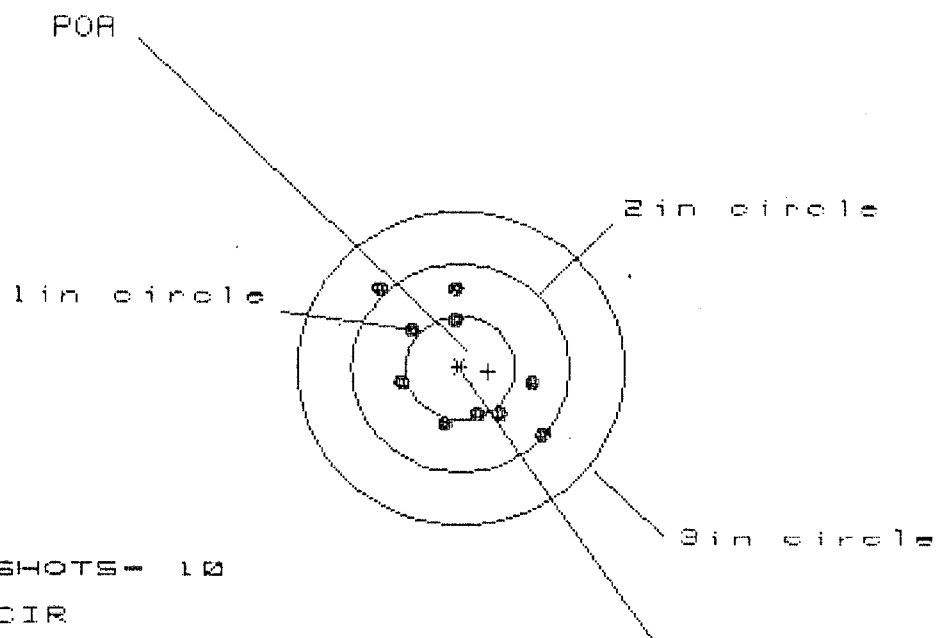
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.824	1.142	1.151
MINIMUM X	:	-.925	-.722	-.713
MAXIMUM Y	:	1.359	1.048	.894
MINIMUM Y	:	-1.376	-1.225	-.919
CENTROID X	:	.246	.043	.034
CENTROID Y	:	-.015	-.166	-.012
POA TO CENTROID in.	:	.246	.171	.036
MIN RADIUS	:	.099	.270	.218
MEAN RADIUS	:	1.000	.839	.780
MAX RADIUS	:	2.274	1.311	1.198
HORIZONTAL SPREAD	:	2.749	1.864	1.864
VERTICAL SPREAD	:	2.735	2.273	1.813
EXTREME SPREAD	:	3.568	2.383	2.359
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

17 Oct 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 9

3in = 10

HS = 1.485

VS = 1.424

GS = 2.057

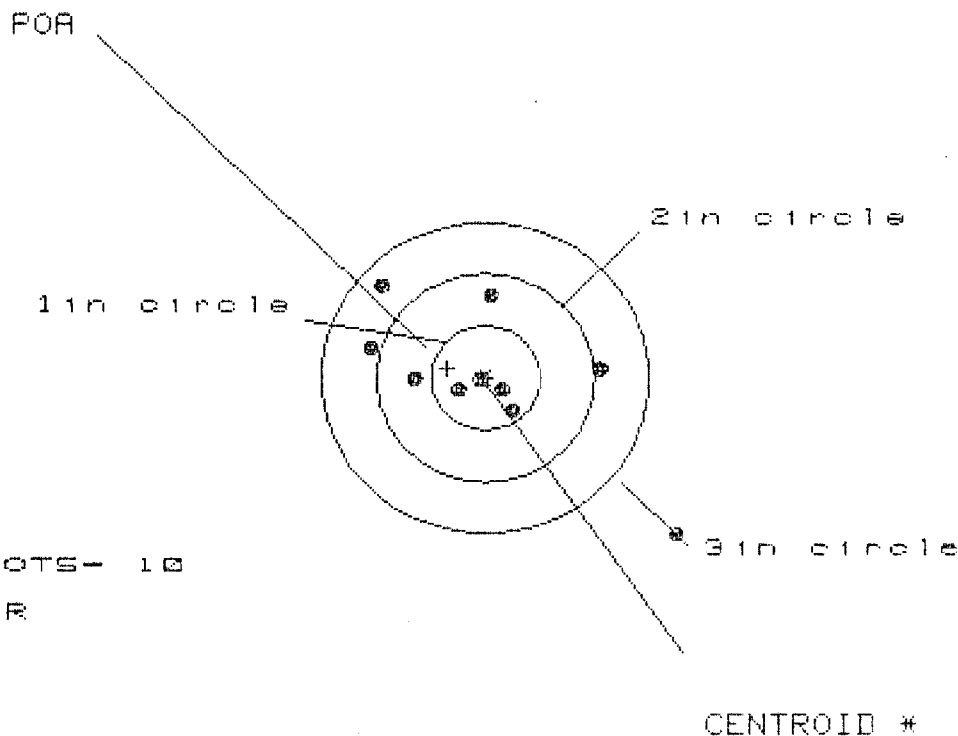
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.724	.640	.699
MINIMUM X	:	-.761	-.583	-.504
MAXIMUM Y	:	.745	.814	.739
MINIMUM Y	:	-.679	-.596	-.481
CENTROID X	:	-.257	-.173	-.253
CENTROID Y	:	.035	-.048	.027
POA TO CENTROID in.	:	.259	.179	.254
MIN RADIUS	:	.485	.388	.476
MEAN RADIUS	:	.671	.616	.581
MAX RADIUS	:	1.065	.874	.741
HORIZONTAL SPREAD	:	1.485	1.223	1.202
VERTICAL SPREAD	:	1.424	1.410	1.220
EXTREME SPREAD	:	2.057	1.610	1.276
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

17 Oct 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 4

2in = 6

3in = 9

HS= 2.790

VS= 2.372

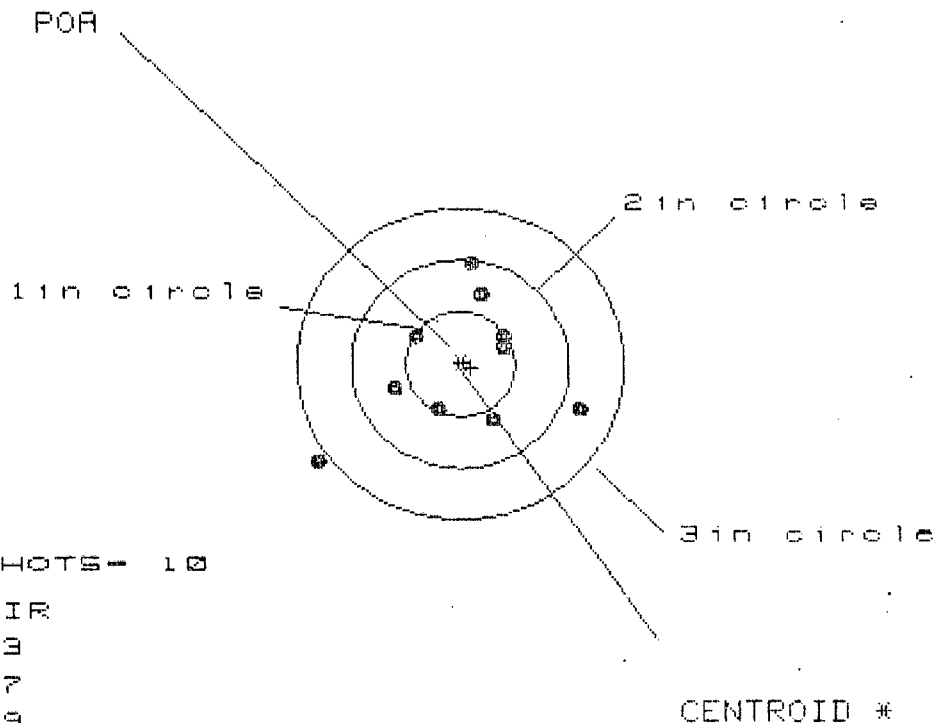
GS= 3.590

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.703	1.192	1.091
MINIMUM X	-1.087	-0.898	-0.999
MAXIMUM Y	.858	.690	.696
MINIMUM Y	-1.514	-0.431	-0.344
CENTROID X	.349	.159	.260
CENTROID Y	-0.090	.078	-0.008
POA TO CENTROID in.	.360	.177	.260
MIN RADIUS	.045	.208	.076
MEAN RADIUS	.793	.638	.551
MAX RADIUS	2.278	1.196	1.091
HORIZONTAL SPREAD	2.790	2.090	2.090
VERTICAL SPREAD	2.372	1.121	1.040
EXTREME SPREAD	3.590	2.148	2.098
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

17 Oct 1991

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CENTERFIRE PATTERNS # 4



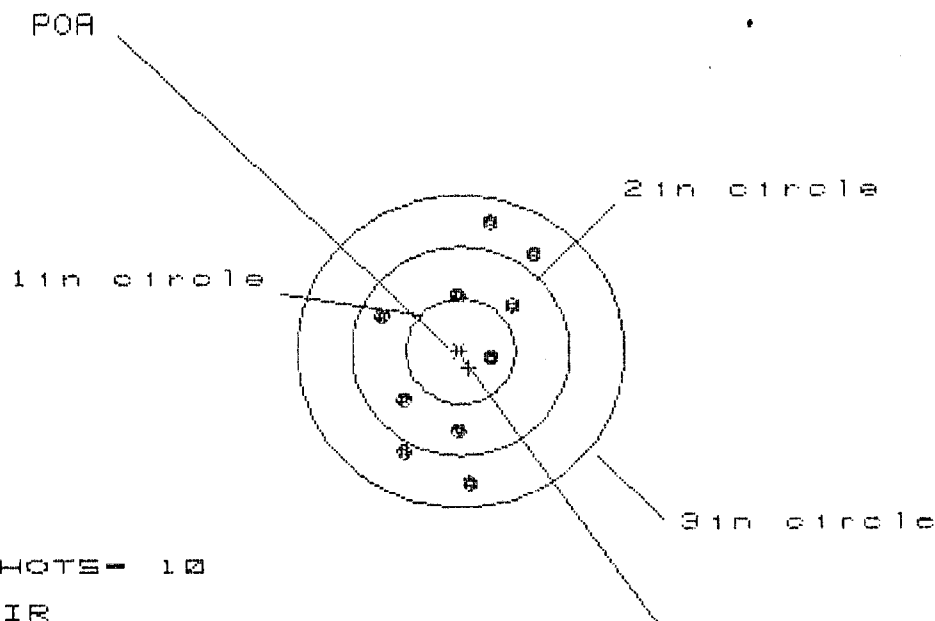
OF SHOTS- 10
IN CIR
1in = 3
2in = 7
3in = 9
HS= 2.372
VS= 1.969
GS= 2.431

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.048	.901	.373
MINIMUM X	-1.324	-.730	-.617
MAXIMUM Y	1.017	.911	.840
MINIMUM Y	-.952	-.599	-.670
CENTROID X	-.096	.051	-.062
CENTROID Y	.026	.132	.203
POA TO CENTROID in.	.100	.141	.212
MIN RADIUS	.424	.245	.340
MEAN RADIUS	.756	.633	.575
MAX RADIUS	1.631	1.065	.843
HORIZONTAL SPREAD	2.372	1.631	.990
VERTICAL SPREAD	1.969	1.510	1.510
EXTREME SPREAD	2.431	1.755	1.520
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

17 Oct 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1in = 1

2in = 6

3in = 10

HS = 1.479

VS = 2.567

GS = 2.576

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.718	.748	.759
MINIMUM X	:	-.761	-.731	-.720
MAXIMUM Y	:	1.285	1.077	.935
MINIMUM Y	:	-1.282	-1.139	-1.008
CENTROID X	:	-.076	-.106	-.117
CENTROID Y	:	.161	.018	.160
POA TO CENTROID in.	:	.178	.107	.199
MIN RADIUS	:	.247	.270	.286
MEAN RADIUS	:	.861	.803	.753
MAX RADIUS	:	1.313	1.311	1.204
HORIZONTAL SPREAD	:	1.479	1.479	1.479
VERTICAL SPREAD	:	2.567	2.216	1.943
EXTREME SPREAD	:	2.576	2.314	2.314
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	