

FORM

UPC



0 47700 25716 7

C6648943

CAPACITY*
*INCLUDES 1 IN CHAMBER

MODEL 700 TM M24

ORDER NO. 5716

BARREL LENGTH

Remington



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

MODEL 700™ M24

SERIAL NO.
C6648943

ORDER NO.
5716

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

20



5716 C6648943

ORDER 5716

MODEL 700™ M24

UPC



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ORDER 5716

MODEL 700™ M24

UPC



0 47700 25716 7

(5)

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6648943

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	OCT	8 1991	KCD
	Magnaflux Bolt	OCT	3 1991	KCD
615	Rollmark Caliber	OCT	3 1991	CS
617	Drill and Tap Sight Holes	OCT	4 1991	LB
618	Polish Barrel	OCT	4 1991	WB
620	Apply Coatings (Barrel Action)		10-13-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/18/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/18/91	RW
	C) Inspect Ejector Hole for Chamfer		10/18/91	RW
	D) Oil Firing Pin Ass'y		10/18/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11-20-91	JU

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			11/28/91	SC
	G) Safety Off Force	2	2	2			11/20/91	SC
	H) Trigger Pull Test & Retainability						11-20-91	SC
	I) Firing Pin Indent	.0205	.0205	.020			11-20/91	SC
	J) Assemble Stock						12/3/91	SC
	K) Assemble Swivel Studs						12-7-91	SC
	L) Attach Front and Rear Sight Assemblies						12/3/91	SC
	M) Iron Sight Alignment						12/3/91	SC
	N) Detach Front & Rear Sights & place in numbered container						12/3/91	SC
	O) Attach Scope to Rifle						12/3/91	SC
	P) Detach & Attach Scope 20 Times						12/3/91	SC
640	Gallery Target & Test						12-4-91	AC
	A) Time						12-4-91	AC
	B) Malfunctions						12-4-91	AC
	C) Pierced Primers						12-4-91	AC
	D) Optical Clarity of Scope						12-4-91	AC
645	Inspect for Live Ammo						12-4-91	AC
655	Final Inspection							
	A) Headspace						12-7-91	AC
	B) Trigger Pull	238	246	247	245	234	12-5-91	DH
	C) Function						12-7-91	AC
660	Pack						12-7-91	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO C-6648943

DATE 11-20-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.26	2.40	238	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.38	2.66	2.48	246	
PULL #3	2.38	2.45	2.55	247	
PULL #4	2.34	2.46	2.61	245	
PULL #5	2.38	2.42	2.50	234	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.65	3.41		
PULL #2	3.59	3.44		
PULL #3	3.49	3.54		
PULL #4	3.44	3.61		
PULL #5	3.41	3.40		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.30	4.49		4.24
PULL #2	4.32	4.31		4.20
PULL #3	4.26	4.29		4.21
PULL #4	4.31	4.23		4.23
PULL #5	4.19	4.24		4.20
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6648943
4 Dec 1991

CENTROIDAL DISTANCES

0 TO	1	.171814
1 TO	2	.325572
1 TO	3	.362763
1 TO	4	.225282
1 TO	5	.131034

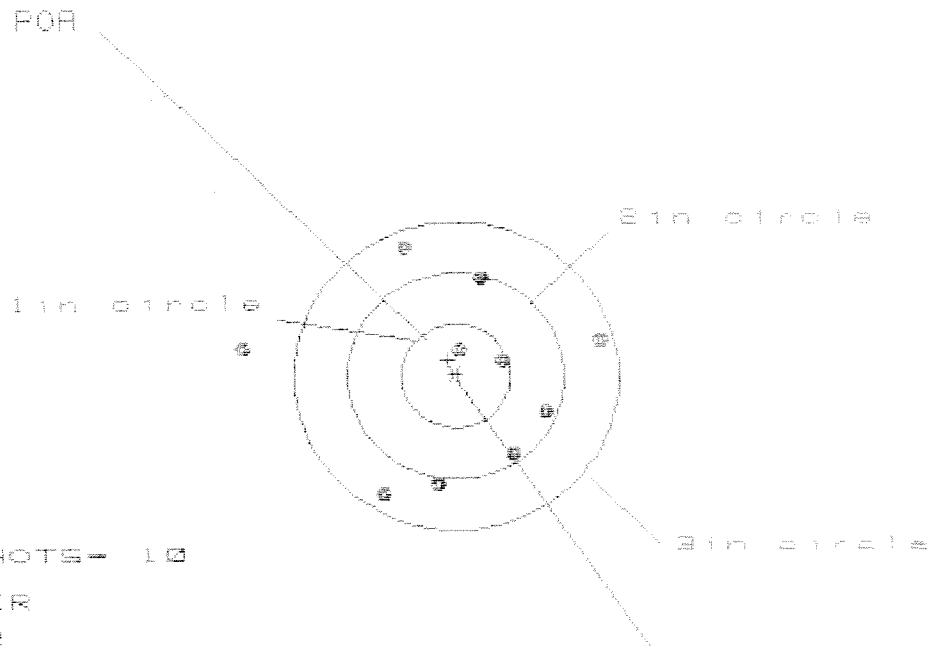
$\frac{3}{34}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0162
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.069
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .070876
THE AMR FOR THIS RIFLE IS: .8774

4 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6646943

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 9

HS= 3.225

VS= 2.400

GS= 2.228

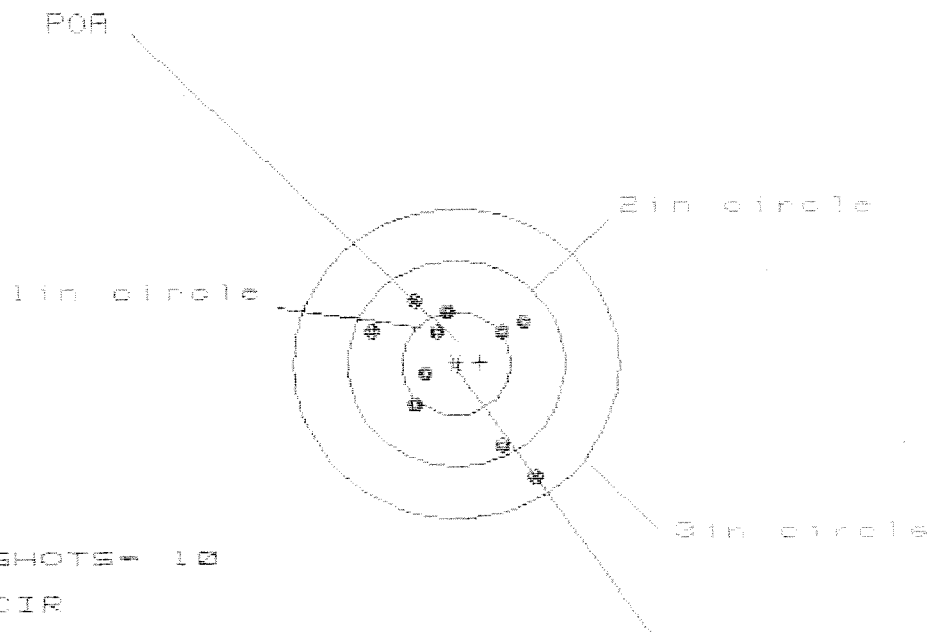
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.285	1.070	.978
MINIMUM X	-1.940	-.861	-.953
MAXIMUM Y	1.295	1.319	1.186
MINIMUM Y	-1.105	-1.081	-.916
CENTROID X	.072	.287	.379
CENTROID Y	-.156	-.180	-.345
POB TO CENTROID in.	.172	.339	.512
MIN RADIUS	.298	.223	.319
MEAN RADIUS	1.056	.912	.828
MAX RADIUS	1.952	1.507	1.322
HORIZONTAL SPREAD	3.225	1.931	1.931
VERTICAL SPREAD	2.400	2.400	2.102
EXTREME SPREAD	3.228	2.420	2.420
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	9		

4 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C864B943

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 4

2in = 9

3in = 10

HS = 1.527

VS = 1.708

GS = 2.093

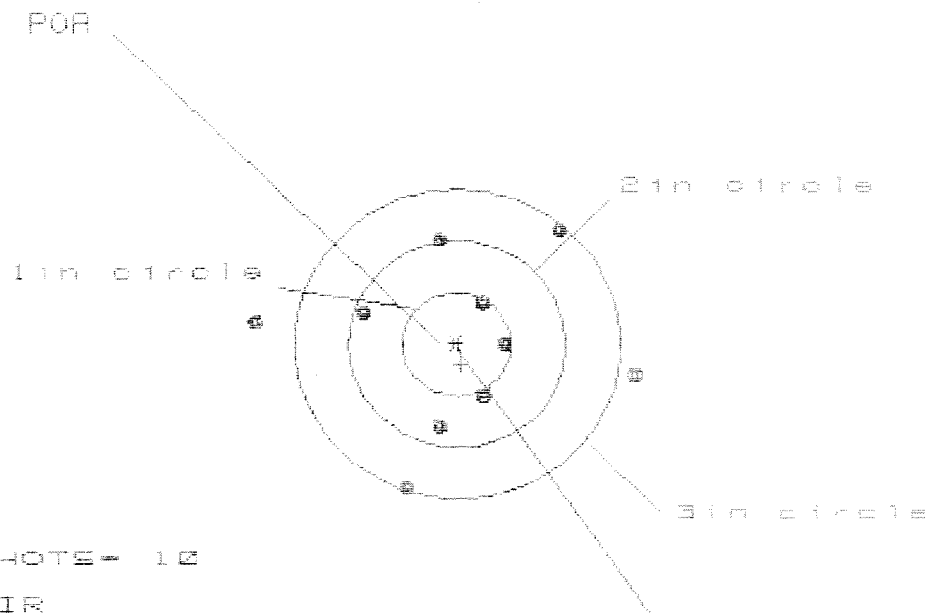
CENTROID #

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.697	.741	.647
MINIMUM X	-.830	-.753	-.441
MAXIMUM Y	.574	.448	.470
MINIMUM Y	-1.134	-.881	-.859
CENTROID X	-.219	-.296	-.282
CENTROID Y	-.010	.116	.094
POA TO CENTROID in.	.219	.318	.223
MIN RADIUS	.314	.169	.242
MEAN RADIUS	.673	.563	.545
MAX RADIUS	1.331	1.009	.947
HORIZONTAL SPREAD	1.527	1.494	1.088
VERTICAL SPREAD	1.708	1.329	1.329
EXTREME SPREAD	2.093	1.631	1.557
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	9		
NUMBER IN THREE INCH CIRCLE =	10		

4 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6646343

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 8

HS = 3.455

VS = 2.448

GS = 3.499

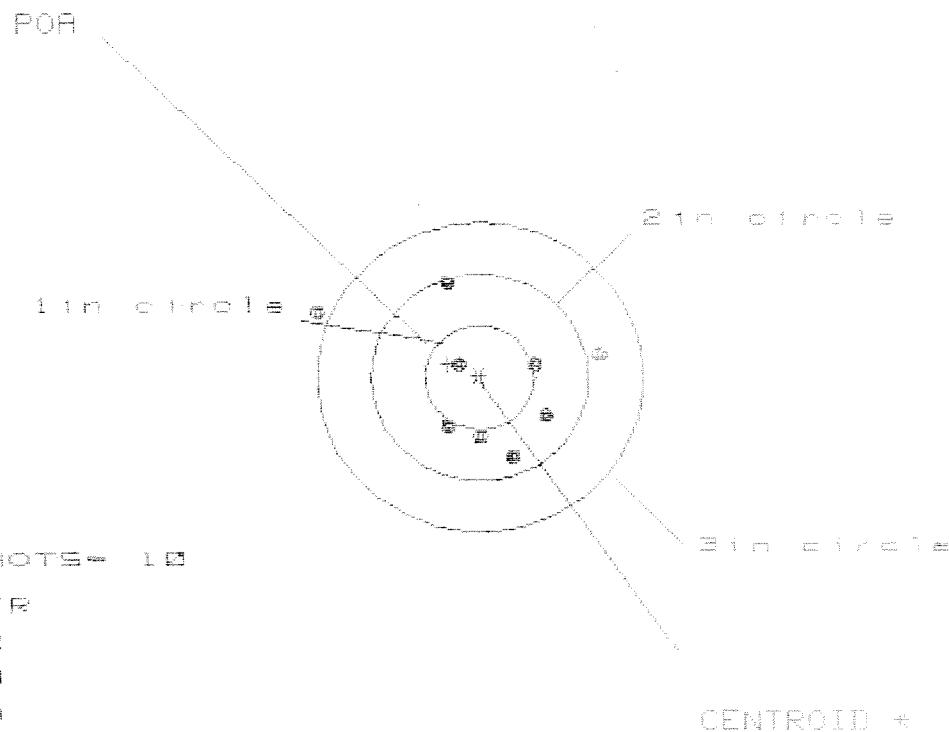
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.633	1.438	.877
MINIMUM X	:	-1.822	-1.832	-.853
MAXIMUM Y	:	1.091	1.116	1.077
MINIMUM Y	:	-1.357	-1.332	-1.371
CENTROID X	:	-.037	.166	-.013
CENTROID Y	:	.190	.165	.204
POR TO CENTROID in.	:	.194	.234	.204
MIN RADIUS	:	.387	.186	.363
MEAN RADIUS	:	1.050	.933	.871
MAX RADIUS	:	1.836	1.492	1.457
HORIZONTAL SPREAD	:	3.455	2.462	1.730
VERTICAL SPREAD	:	2.448	2.448	2.448
EXTREME SPREAD	:	3.499	2.805	2.805
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

4 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8648943

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 2

2in = 8

3in = 9

HS= 2.638

VS= 1.688

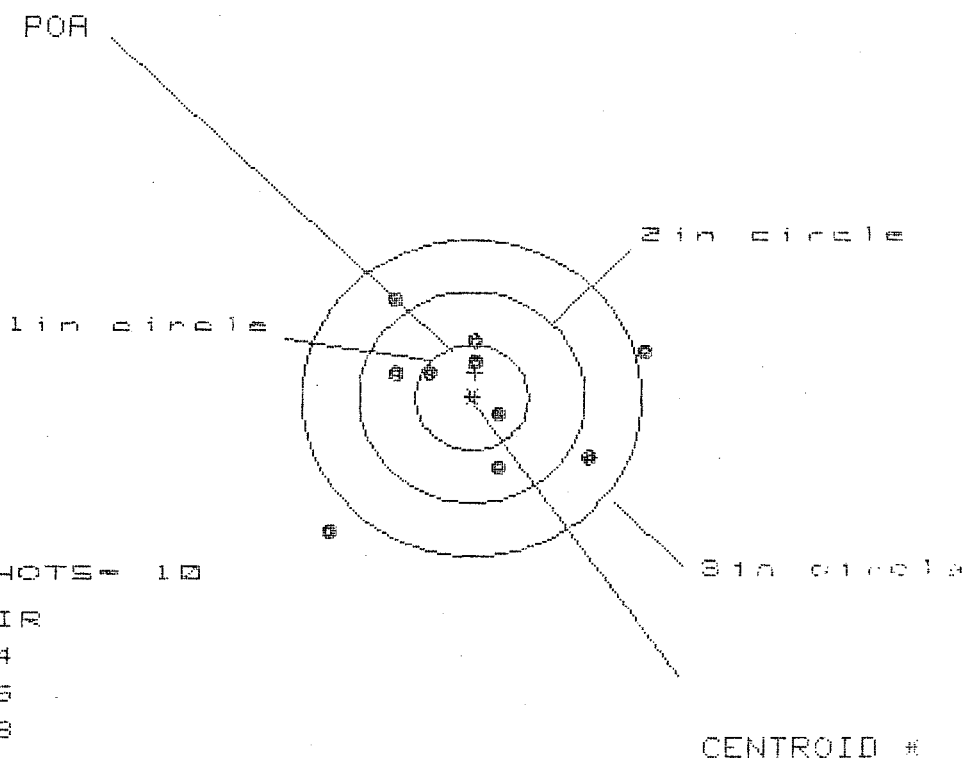
CS= 2.674

PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	1.129
MINIMUM X	-1.509
MAXIMUM Y	.889
MINIMUM Y	-.791
CENTROID X	.296
CENTROID Y	-.132
POR TO CENTROID in.	.324
MIN RADIUS	.293
MEAN RADIUS	.741
MAX RADIUS	1.654
HORIZONTAL SPREAD	2.638
VERTICAL SPREAD	1.688
EXTREME SPREAD	2.674
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	8
NUMBER IN THREE INCH CIRCLE =	9

4 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6646343

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 4

2 in = 6

3 in = 8

HS = 2.807

VS = 2.236

GS = 3.266

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.494	1.348	1.013
MINIMUM X	:	-1.313	-.864	-.696
MAXIMUM Y	:	.965	.824	.856
MINIMUM Y	:	-1.271	-.776	-.744
CENTROID X	:	-.031	.115	-.053
CENTROID Y	:	-.237	-.096	-.128
POA TO CENTROID in.	:	.239	.150	.139
MIN RADIUS	:	.315	.269	.281
MEAN RADIUS	:	.867	.748	.643
MAX RADIUS	:	1.827	1.372	1.235
HORIZONTAL SPREAD	:	2.807	2.212	1.789
VERTICAL SPREAD	:	2.236	1.600	1.600
EXTREME SPREAD	:	3.266	2.315	2.315
NUMBER IN ONE INCH CIRCLE =			4	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			8	