

FORM

UPC



0 47700 25716 7

06649177

MODEL 700 TM M24

ORDER NO. 5716

BARREL LENGTH

CAPACITY*

*INCLUDES 1 IN CHAMBER

Remington



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

MODEL 700 TM M24

SERIAL NO.

C6649177

ORDER NO.

5716

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

20



5716 C6649177

ORDER 5716

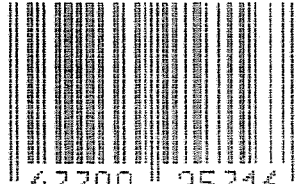
MODEL 700 TM M24

UPC

ORDER 5716

MODEL 700 TM M24

UPC



0 47700 25716 7



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649177

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10 1	51	Ru
600	Proof	10 1	91	Ru
607	Check Headspace	10 1	91	Ru
610	Dis-assemble Gun	10 1	91	Ru
612	Magnaflux Barrel Action		OCT 10 1991	KR
	Magnaflux Bolt		OCT 10 1991	KR
615	Rollmark Caliber		OCT 10 1991	GL
617	Drill and Tap Sight Holes		OCT 10 1991	LB
618	Polish Barrel		10/15/91	WB
620	Apply Coatings (Barrel Action)		11/7-91	PA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		12/3/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/3/91	KS
	C) Inspect Ejector Hole for Chamfer		12/3/91	KS
	D) Oil Firing Pin Ass'y		12/3/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		12-6-91	GH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			12-6-91	QU
	G) Safety Off Force	3	3	3			12-6-91	QU
	H) Trigger Pull Test & Retainability						12-6-91	QU
	I) Firing Pin Indent	.020	.020	.020			12-6-91	QU
	J) Assemble Stock						12/4/91	QU
	K) Assemble Swivel Studs						12-13-91	QU
	L) Attach Front and Rear Sight Assemblies						12/4/91	QU
	M) Iron Sight Alignment						12/4/91	QU
	N) Detach Front & Rear Sights & place in numbered container						12/4/91	QU
	O) Attach Scope to Rifle						12/4/91	QU
	P) Detach & Attach Scope 20 Times						12/4/91	QU
640	Gallery Target & Test						12-9-91	QU
	A) Time						12-9-91	QU
	B) Malfunctions						12-9-91	QU
	C) Pierced Primers						12-9-91	QU
	D) Optical Clarity of Scope						12-9-91	QU
645	Inspect for Live Ammo						12-9-91	QU
655	Final Inspection						12-13-91	QU
	A) Headspace							
	B) Trigger Pull	2.63	2.54	2.60	2.55	2.68	12-10-91	QU
	C) Function						12-13-91	QU
660	Pack						12-17-91	QU

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C-6649177
DATE 12-6-91
TESTER [Signature]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.42	2.38	2.63	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.49	2.39	2.44	2.54	
PULL #3	2.41	2.42	2.41	2.60	
PULL #4	2.44	2.37	2.31	2.53	
PULL #5	2.44	2.30	2.36	2.68	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.43	3.35		
PULL #2	3.44	3.33		
PULL #3	3.41	3.29		
PULL #4	3.45	3.37		
PULL #5	3.48	3.41		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.59	4.47		4.46
PULL #2	4.40	4.40		4.33
PULL #3	4.26	4.38		4.40
PULL #4	4.46	4.39		4.47
PULL #5	4.50	4.48		4.37
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649177
9 Dec 1991

CENTROIDAL DISTANCES

0 TO 1	.269429
1 TO 2	.474693
1 TO 3	.482084
1 TO 4	.48056
1 TO 5	.740438

5
54
54 <----POA

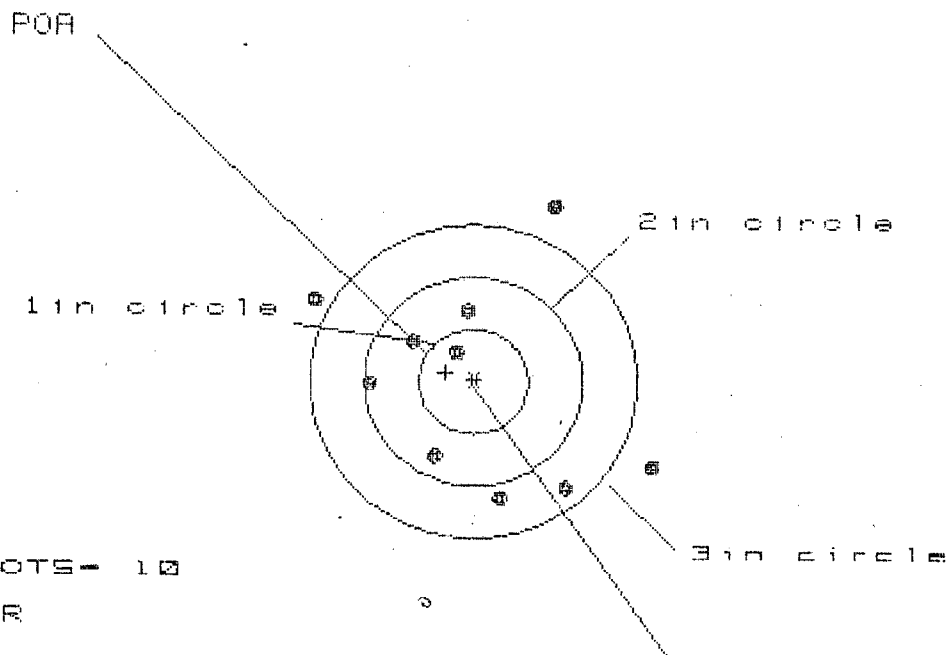
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0476
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1986
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .204225
THE AMR FOR THIS RIFLE IS: 1.05

9 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649177

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 7

HS= 3.136

VS= 2.834

GS= 3.527

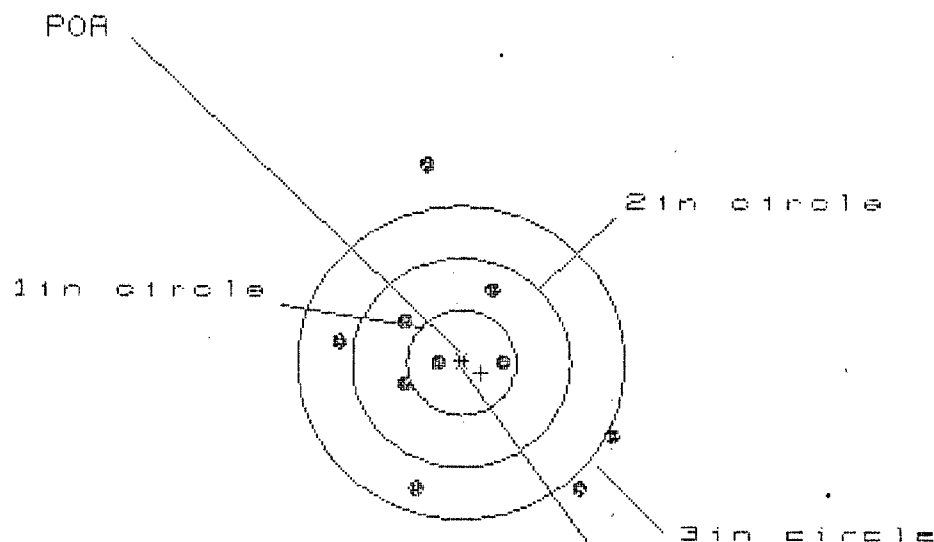
CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.661	1.743	1.193
MINIMUM X	-1.475	-1.393	-1.175
MAXIMUM Y	1.709	.999	.923
MINIMUM Y	-1.125	-.935	-1.011
CENTROID X	.256	.174	-.044
CENTROID Y	-.084	-.274	-.198
POA TO CENTROID in.	.270	.325	.202
MIN RADIUS	.299	.445	.383
MEAN RADIUS	1.131	1.042	.900
MAX RADIUS	1.862	1.848	1.501
HORIZONTAL SPREAD	3.136	3.136	2.368
VERTICAL SPREAD	2.834	1.934	1.934
EXTREME SPREAD	3.527	3.527	2.995
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

9 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B49177

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 7

HS= 2.527

VS= 3.168

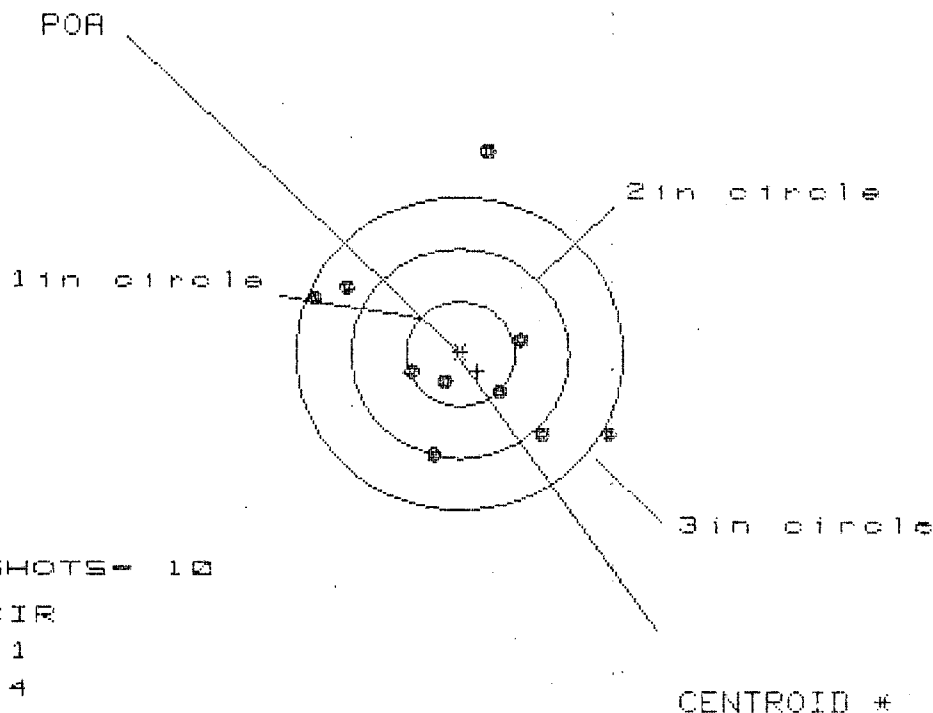
GS= 3.409

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.375	1.344	1.472
MINIMUM X	:	-1.152	-1.183	-1.055
MAXIMUM Y	:	1.949	.942	.820
MINIMUM Y	:	-1.219	-1.002	-1.124
CENTROID X	:	-.182	-.151	-.279
CENTROID Y	:	.099	-.118	.004
POA TO CENTROID in.	:	.207	.192	.279
MIN RADIUS	:	.196	.314	.138
MEAN RADIUS	:	1.018	.924	.815
MAX RADIUS	:	1.968	1.425	1.588
HORIZONTAL SPREAD	:	2.527	2.527	2.527
VERTICAL SPREAD	:	3.168	1.944	1.944
EXTREME SPREAD	:	3.409	2.691	2.691
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			7	

5 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649177

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 8

HS= 2.644

VS= 2.929

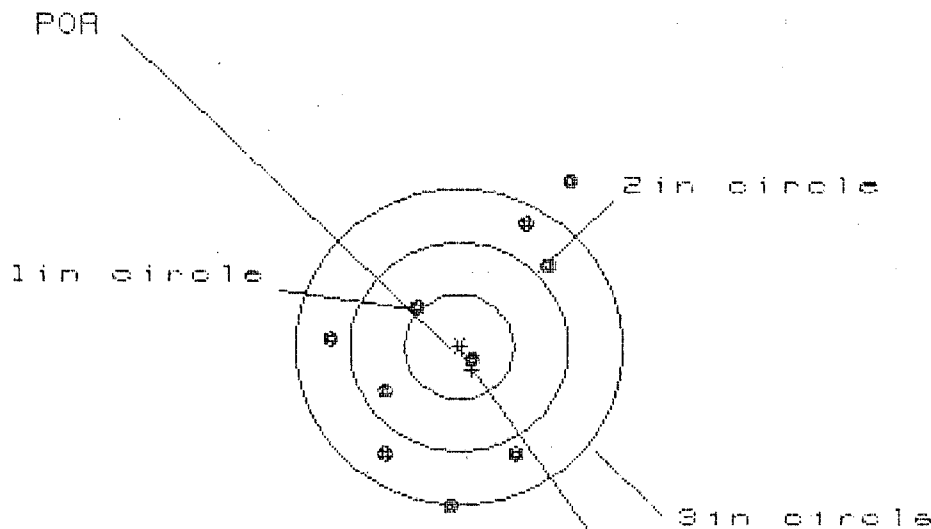
GS= 2.965

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.337	1.363	.923
MINIMUM X	-1.387	-1.281	-1.111
MAXIMUM Y	1.940	.878	.813
MINIMUM Y	-.989	-.773	-.838
CENTROID X	-.158	-.184	-.354
CENTROID Y	.163	-.053	.012
POA TO CENTROID in.	.227	.191	.354
MIN RADIUS	.282	.116	.112
MEAN RADIUS	1.014	.862	.787
MAX RADIUS	1.954	1.477	1.298
HORIZONTAL SPREAD	2.644	2.644	2.034
VERTICAL SPREAD	2.929	1.651	1.651
EXTREME SPREAD	2.965	2.927	2.416
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

9 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6849177

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 8

HS= 2.190

VS= 3.054

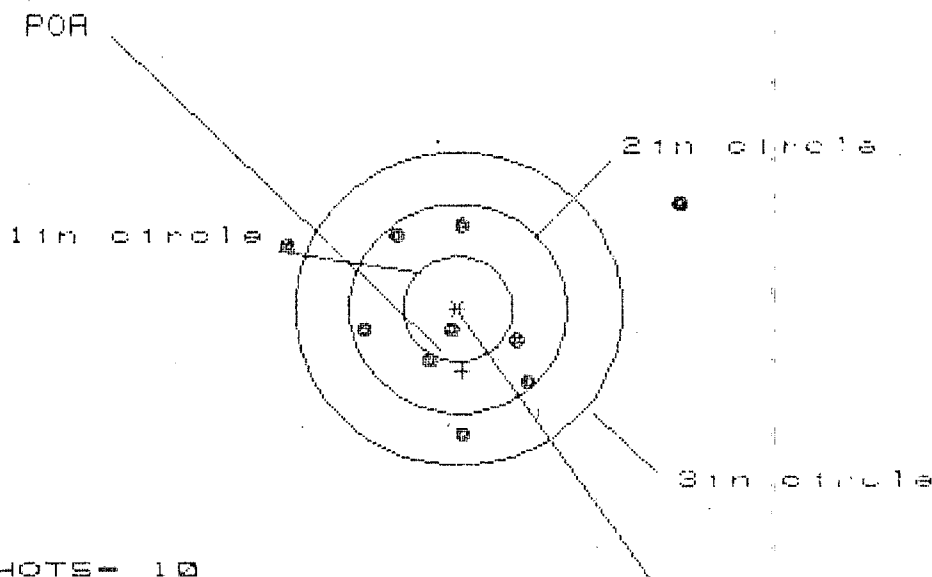
GS= 3.260

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.050	.901	.904
MINIMUM X	-1.140	-1.023	-1.020
MAXIMUM Y	1.548	1.365	1.198
MINIMUM Y	-1.506	-1.334	-1.014
CENTROID X	-.117	-.234	-.237
CENTROID Y	.219	.047	.214
POA TO CENTROID in.	.249	.239	.320
MIN RADIUS	.138	.241	.242
MEAN RADIUS	1.086	.983	.928
MAX RADIUS	1.871	1.527	1.382
HORIZONTAL SPREAD	2.190	1.924	1.924
VERTICAL SPREAD	3.054	2.699	2.212
EXTREME SPREAD	3.260	2.779	2.555
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	8		

9 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CS649177

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 8

HS= 3.577

VS= 2.170

GS= 3.594

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.063	.816	.656
MINIMUM X	:	-1.514	-1.285	-1.762
MAXIMUM Y	:	.974	.901	.993
MINIMUM Y	:	-1.196	-1.088	-1.996
CENTROID X	:	-.037	-.266	-.106
CENTROID Y	:	.596	.488	.396
POA TO CENTROID in.	:	.597	.556	.410
MIN RADIUS	:	.198	.137	.050
MEAN RADIUS	:	.999	.819	.708
MAX RADIUS	:	2.281	1.479	1.019
HORIZONTAL SPREAD	:	3.577	2.101	1.418
VERTICAL SPREAD	:	2.170	1.989	1.989
EXTREME SPREAD	:	3.594	2.465	1.990
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			8	