

FORM

UPC



0 47700 25716 7

BARREL LENGTH

CAPACITY*

*INCLUDES 1 IN CHAMBER

06649193

MODEL 700 TM M24

ORDER NO.

5715

Remington



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

MODEL 700TM M24

SERIAL NO.

C6649193

ORDER NO.

5716

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

20



5716 C6649193

ORDER 5716

MODEL 700TM M24

UPC

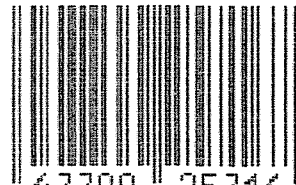
ORDER 5716

MODEL 700TM M24

UPC



0 47700 25716 7



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649193

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 1 n 1991	KR
	Magnaflux Bolt		OCT n 1991	KR
615	Rollmark Caliber		OCT 1 n 1991	GL
617	Drill and Tap Sight Holes		OCT 1 n 1991	LB
618	Polish Barrel		10/15/91	WB
620	Apply Coatings (Barrel Action)		11-2-91	TH
	Apply Coating (Bolt)			
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		12-7-91	TH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			12-9-91	JK
	G) Safety Off Force	3	3	3			12-9-91	JK
	H) Trigger Pull Test & Retainability						12-7-91	JK
	I) Firing Pin Indent	.022	.022	.022			12-9-91	JK
	J) Assemble Stock						12/9/91	RW
	K) Assemble Swivel Studs						12-13-91	JK
	L) Attach Front and Rear Sight Assemblies						12/9/91	RW
	M) Iron Sight Alignment						12/9/91	RW
	N) Detach Front & Rear Sights & place in numbered container						12/9/91	RW
	O) Attach Scope to Rifle						12/9/91	RW
	P) Detach & Attach Scope 20 Times						12/9/91	RW
640	Gallery Target & Test						12-10-91	JK
	A) Time						12-10-91	JK
	B) Malfunctions						12-10-91	JK
	C) Pierced Primers						12-10-91	JK
	D) Optical Clarity of Scope						12-10-91	JK
645	Inspect for Live Ammo						12-10-91	JK
655	Final Inspection							
	A) Headspace						12/13/91	JK
	B) Trigger Pull	2.50	2.45	2.56	2.50	2.52	12-11-91	JK
	C) Function						12-13-91	JK
660	Pack						12-17-91	NF

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6649193

DATE 12-7-91

TESTER YI

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.35	2.50	2.50	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.37	2.31	2.46	2.45	
PULL #3	2.38	2.34	2.44	2.56	
PULL #4	2.31	2.34	2.33	2.50	
PULL #5	2.37	2.39	2.38	2.52	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.35	3.44		
PULL #2	3.49	3.45		
PULL #3	3.51	3.49		
PULL #4	3.50	3.55		
PULL #5	3.38	3.59		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.35	4.31		4.32
PULL #2	4.38	4.26		4.34
PULL #3	4.36	4.32		4.37
PULL #4	4.33	4.35		4.16
PULL #5	4.38	4.20		4.47
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649193
10 Dec 1991

CENTROIDAL DISTANCES

0 TO	1	.470499
1 TO	2	.794123
1 TO	3	.464039
1 TO	4	.390082
1 TO	5	.437146

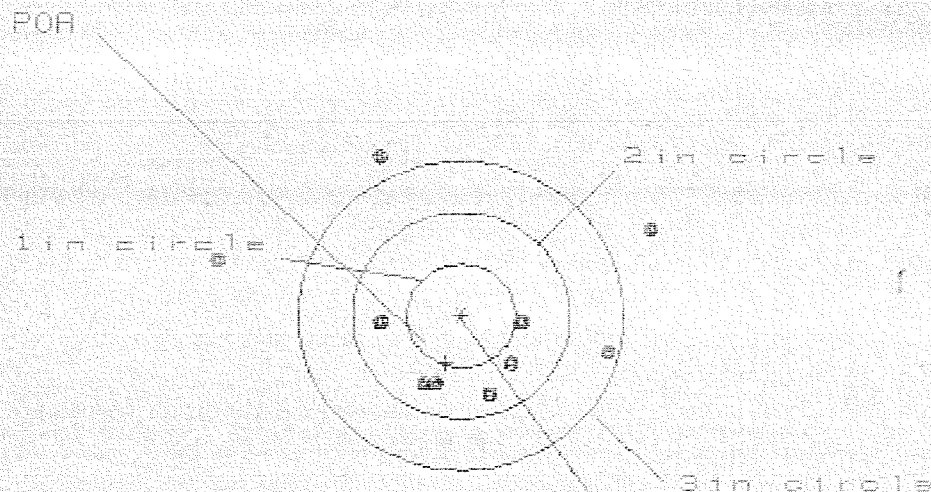
$\frac{1}{5}$ $\frac{2}{5}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1828
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .067
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .194692
THE AMR FOR THIS RIFLE IS: 1.015

18 Dec 1993

FILE:/PATTERNING/CENTERFIRE_PATT/C6649193

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 6

3 in = 7

HS= 4.027

VS= 2.323

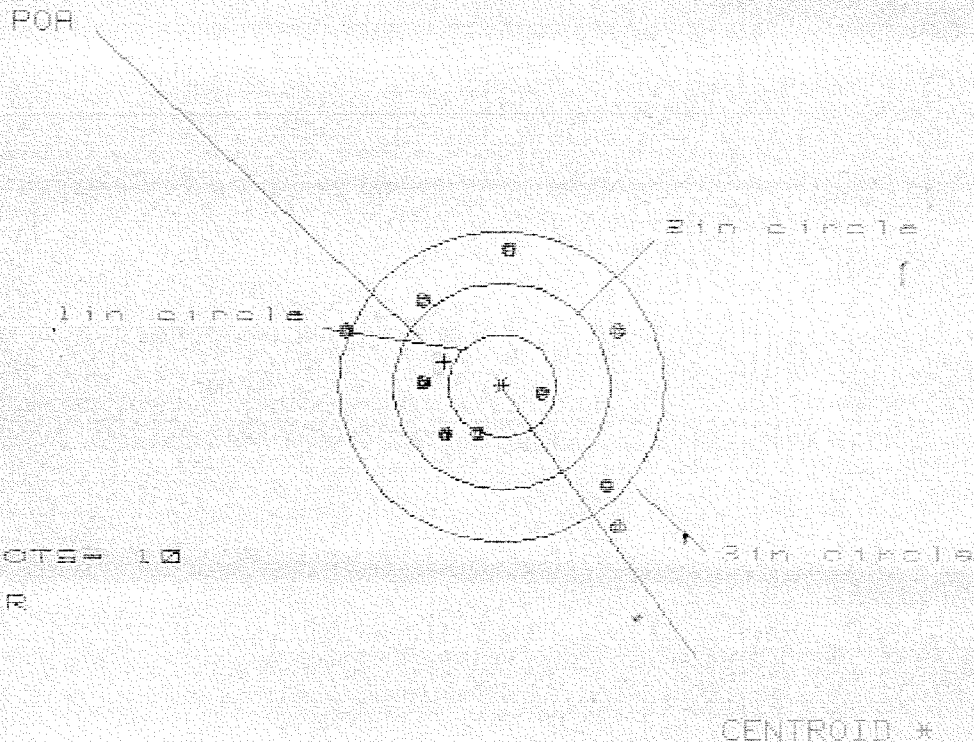
CS= 4.037

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.736	1.481	1.331
MINIMUM X	-2.291	-1.010	-0.825
MAXIMUM Y	1.541	1.607	1.725
MINIMUM Y	-0.782	-0.716	-0.598
CENTROID X	.145	.400	.215
CENTROID Y	.456	.390	.272
POA TO CENTROID in.	.478	.558	.346
MIN RADIUS	.535	.273	.460
MEAN RADIUS	1.158	.979	.845
MAX RADIUS	2.367	1.898	1.912
HORIZONTAL SPREAD	4.027	2.491	2.156
VERTICAL SPREAD	2.323	2.323	2.323
EXTREME SPREAD	4.037	2.884	2.884
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	7		

10 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649193

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS= 2.567

VS= 2.620

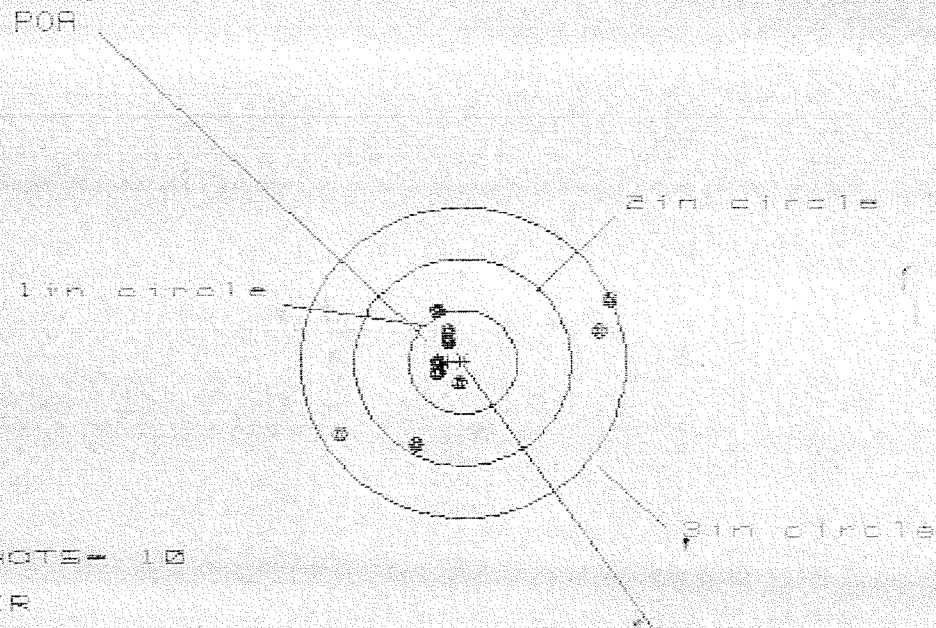
GS= 3.153

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.111	1.175	1.009
MINIMUM X	:	-1.456	-1.333	-1.755
MAXIMUM Y	:	1.383	1.156	1.202
MINIMUM Y	:	-1.317	-1.155	-1.109
CENTROID X	:	.531	.408	.574
CENTROID Y	:	-.238	-.091	-.137
POA TO CENTROID in.	:	.582	.418	.590
MIN RADIUS	:	.416	.570	.398
MEAN RADIUS	:	1.070	.988	.934
MAX RADIUS	:	1.723	1.613	1.467
HORIZONTAL SPREAD	:	2.567	2.508	1.764
VERTICAL SPREAD	:	2.620	2.311	2.311
EXTREME SPREAD	:	3.153	2.891	2.523
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			4	
NUMBER IN THREE INCH CIRCLE =			8	

10 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C06045193

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 5

2in = 7

3in = 10

HS = 2.494

VS = 1.336

GS = 2.772

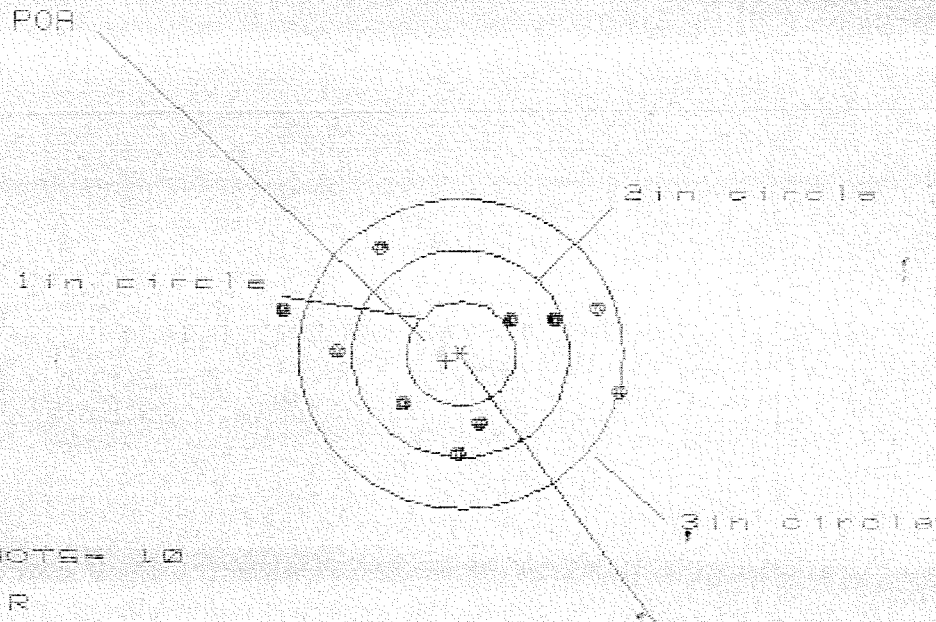
CENTROID *

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.354	1.367	1.243
MINIMUM X	-1.140	-1.989	-1.372
MAXIMUM Y	.569	.524	.452
MINIMUM Y	-.767	-.704	-.777
CENTROID X	.139	-.012	.112
CENTROID Y	-.008	-.071	.002
POA TO CENTROID in.	.139	.072	.112
MIN RADIUS	.232	.085	.207
MEAN RADIUS	.675	.543	.487
MAX RADIUS	1.469	1.405	1.268
HORIZONTAL SPREAD	2.494	2.356	1.615
VERTICAL SPREAD	1.336	1.228	1.228
EXTREME SPREAD	2.772	2.523	1.914
NUMBER IN ONE INCH CIRCLE =	5		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

10 Dec 1991

FILE: PATTERNING/CENTERFIRE_PATT/C6649193

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 10

2 in = 5

3 in = 9

HS= 3.103

VS= 1.933

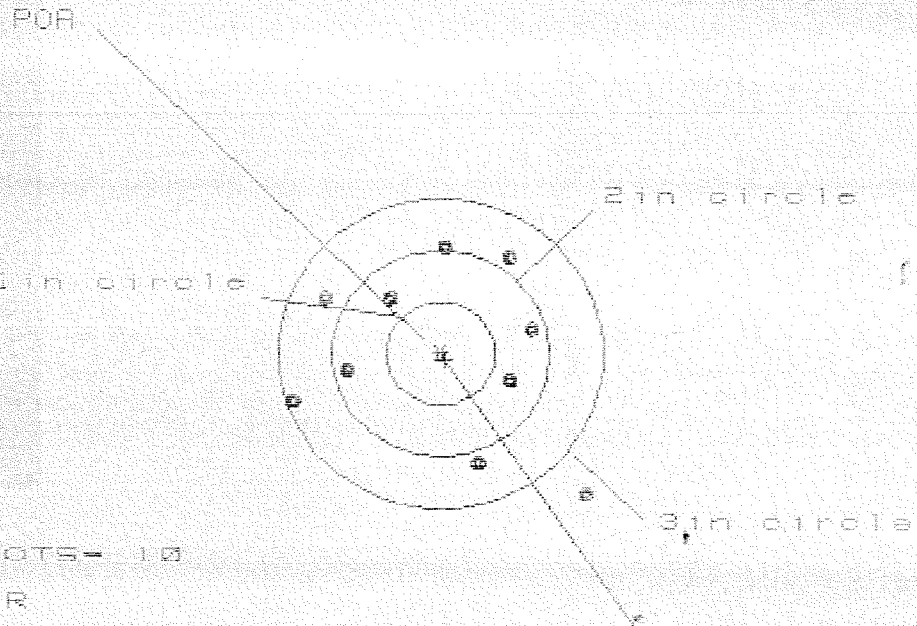
GS= 3.212

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.433	1.247	1.190
MINIMUM X	:	-1.670	-1.353	-1.197
MAXIMUM Y	:	1.010	1.057	1.011
MINIMUM Y	:	-.923	-.976	-.922
CENTROID X	:	.137	.323	.167
CENTROID Y	:	.066	.019	.065
POA TO CENTROID in.	:	.152	.323	.179
MIN RADIUS	:	.536	.427	.511
MEAN RADIUS	:	1.064	.966	.928
MAX RADIUS	:	1.722	1.406	1.271
HORIZONTAL SPREAD	:	3.103	2.600	2.387
VERTICAL SPREAD	:	1.933	1.933	1.933
EXTREME SPREAD	:	3.212	2.634	2.421
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

18 Dec 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 0

2in = 4

3in = 9

HS= 2.748

VS= 2.365

GS= 3.102

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.346	1.095	.848
MINIMUM X	:	-1.402	-1.252	-1.118
MAXIMUM Y	:	1.001	.850	.778
MINIMUM Y	:	-1.364	-1.205	-1.277
CENTROID X	:	-.038	-.188	-.031
CENTROID Y	:	.059	.210	.282
POA TO CENTROID IN.	:	.070	.282	.283
MIN RADIUS	:	.659	.523	.576
MEAN RADIUS	:	1.106	.991	.926
MAX RADIUS	:	1.916	1.377	1.326
HORIZONTAL SPREAD	:	2.748	2.257	1.966
VERTICAL SPREAD	:	2.365	2.055	2.055
EXTREME SPREAD	:	3.102	2.453	2.165
NUMBER IN ONE INCH CIRCLE =			0	
NUMBER IN TWO INCH CIRCLE =			4	
NUMBER IN THREE INCH CIRCLE =			9	