

FORM

UPC



0 47700 25716 7

C6549206

INCLUDES 1 IN CHAMBER

MODEL 700 TM M24

ORDER NO. 5716

BARREL LENGTH

CAPACITY*

Remington



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

MODEL 700 TM M24

SERIAL NO.

C6649206

ORDER NO.

5716

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

20



5716 C6649206

ORDER 5716

MODEL 700 TM M24

UPC



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ORDER 5716

MODEL 700 TM M24

UPC



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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649206

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	GL
617	Drill and Tap Sight Holes		OCT 10 1991	FB
618	Polish Barrel		10/15/91	WB
620	Apply Coatings (Barrel Action)		11/2/91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		12/5/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/5/91	KA
	C) Inspect Ejector Hole for Chamfer		12/5/91	KA
	D) Oil Firing Pin Ass'y		12/5/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		12-6-91	JM

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			12-6-91	JH
	G) Safety Off Force	3	3	3			12-6-91	JH
	H) Trigger Pull Test & Retainability						12-6-91	JH
	I) Firing Pin Indent	.020	.020	.0205			12-6-91	JH
	J) Assemble Stock						12/6/91	KH
	K) Assemble Swivel Studs						12-11-91	K
	L) Attach Front and Rear Sight Assemblies						12/4/91	KH
	M) Iron Sight Alignment						12/6/91	KH
	N) Detach Front & Rear Sights & place in numbered container						12/6/91	KH
	O) Attach Scope to Rifle						12/6/91	KH
	P) Detach & Attach Scope 20 Times						12/6/91	KH
640	Gallery Target & Test						12/9/91	KJ
	A) Time						01	12/9
	B) Malfunctions						01	12/9
	C) Pierced Primers						01	12/9
	D) Optical Clarity of Scope						01	12/9
645	Inspect for Live Ammo						12/9/91	14
655	Final Inspection							
	A) Headspace						12-11-91	K
	B) Trigger Pull	2.27	2.29	2.28	2.24	2.27	12-11-91	JH
	C) Function						12-11-91	K
660	Pack							

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6649206

DATE 12-6-81

TESTER 981

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.64	2.57	2.60	2.27	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.48	2.66	2.58	2.29	
PULL #3	2.60	2.63	2.44	2.28	
PULL #4	2.65	2.64	2.61	2.24	
PULL #5	2.59	2.64	2.65	2.27	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.33	3.40		
PULL #2	3.33	3.40		
PULL #3	3.35	3.41		
PULL #4	3.41	3.38		
PULL #5	3.35	3.44		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.44	4.45		4.39
PULL #2	4.31	4.31		4.37
PULL #3	4.45	4.33		4.41
PULL #4	4.35	4.44		4.45
PULL #5	4.33	4.39		4.34
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649206
9 Dec 1991

CENTROIDAL DISTANCES

0 TO 1	.188905
1 TO 2	.162432
1 TO 3	.0320156
1 TO 4	.157258
1 TO 5	.13369

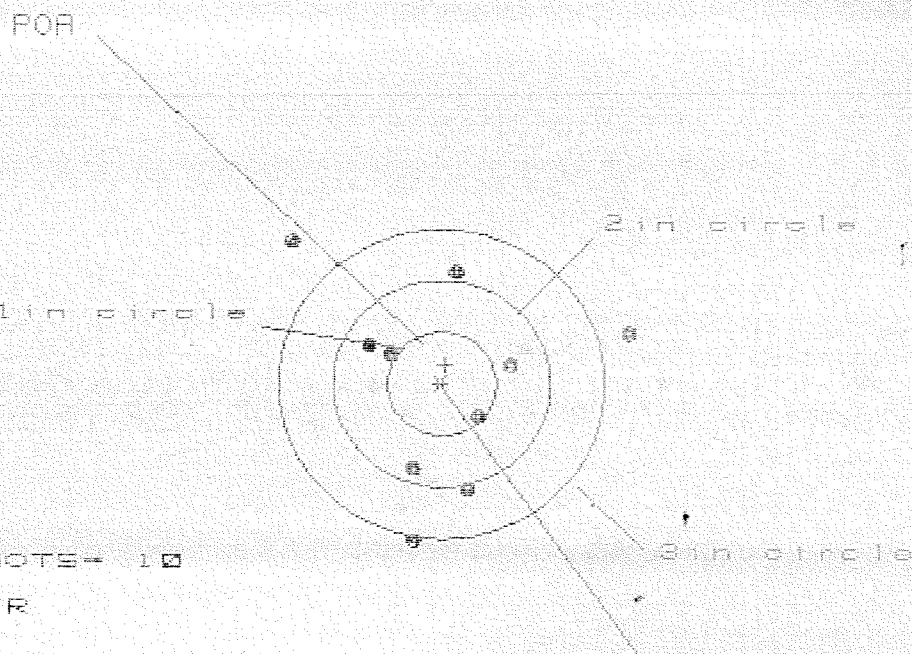
4P X----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0604
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2014
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .210262
THE AMR FOR THIS RIFLE IS: .9766

9 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B49206

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 5

3 in = 7

HS= 3.073

VS= 2.936

GS= 3.203

CENTROID *

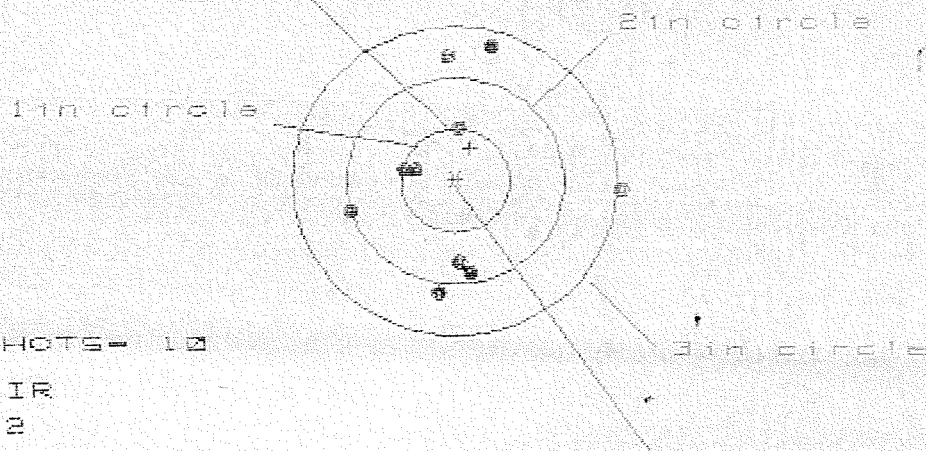
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.688	1.534	.676
MINIMUM X	-1.385	-.799	-.608
MAXIMUM Y	1.375	1.207	1.285
MINIMUM Y	-1.560	-1.408	-1.330
CENTROID X	-.033	.121	-.070
CENTROID Y	-.186	-.338	-.416
POA TO CENTROID in.	.188	.359	.422
MIN RADIUS	.464	.247	.381
MEAN RADIUS	1.064	.944	.845
MAX RADIUS	1.952	1.656	1.355
HORIZONTAL SPREAD	3.073	2.333	1.284
VERTICAL SPREAD	2.936	2.615	2.615
EXTREME SPREAD	3.203	2.840	2.649
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\06649206

CENTERFIRE PATTERNS # 2

POA



* OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.543

VS= 2.382

GS= 2.546

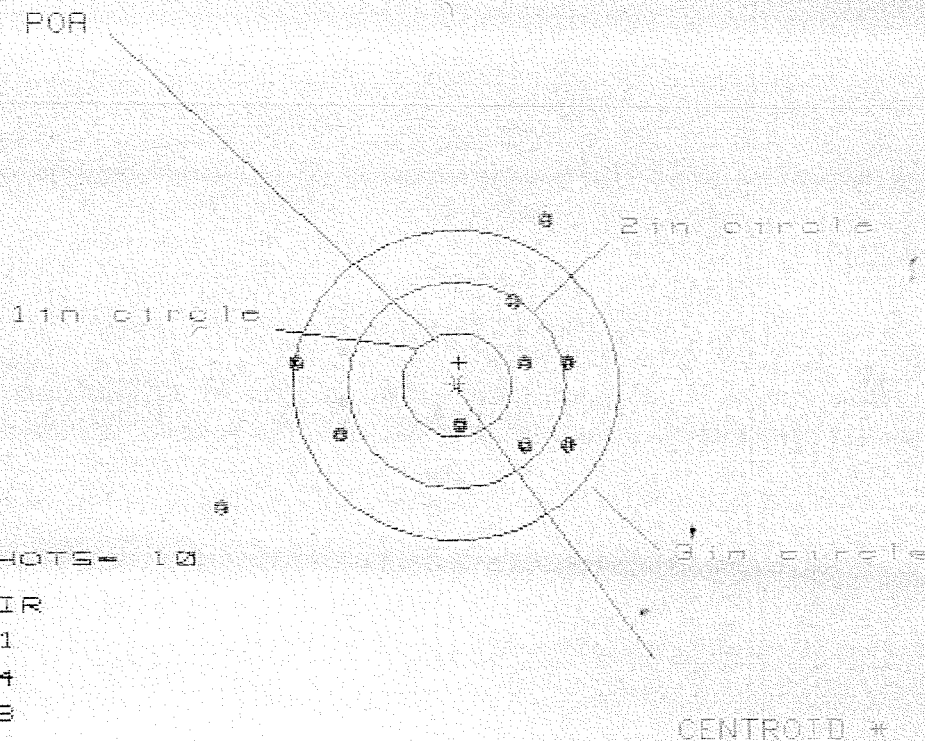
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.558	.462	.322
MINIMUM X	:	-.985	-.812	-.755
MAXIMUM Y	:	1.265	1.252	1.363
MINIMUM Y	:	-1.117	-1.130	-.973
CENTROID X	:	-.133	-.306	-.363
CENTROID Y	:	-.314	-.301	-.458
POA TO CENTROID in.	:	.341	.429	.584
MIN RADIUS	:	.410	.243	.294
MEAN RADIUS	:	.938	.828	.755
MAX RADIUS	:	1.562	1.335	1.371
HORIZONTAL SPREAD	:	2.543	1.274	1.077
VERTICAL SPREAD	:	2.382	2.382	2.336
EXTREME SPREAD	:	2.546	2.418	2.336
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			9	

8 Dec 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 8

HS= 3.206

VS= 2.771

GS= 4.041

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.065	.827	.898
MINIMUM X	:	-2.141	-1.721	-1.650
MAXIMUM Y	:	1.630	1.504	.922
MINIMUM Y	:	-1.141	-.676	-.489
CENTROID X	:	-.025	.213	.142
CENTROID Y	:	-.217	-.091	-.278
POA TO CENTROID in.	:	.219	.231	.313
MIN RADIUS	:	.364	.420	.345
MEAN RADIUS	:	1.211	1.025	.940
MAX RADIUS	:	2.426	1.722	1.669
HORIZONTAL SPREAD	:	3.206	2.548	2.548
VERTICAL SPREAD	:	2.771	2.180	1.411
EXTREME SPREAD	:	4.041	2.846	2.649
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

9 Dec 1991

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CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID +

OF SHOTS= 10

IN CIR

1 in = 1

2 in = 8

3 in = 9

HS= 2.655

VS= 1.949

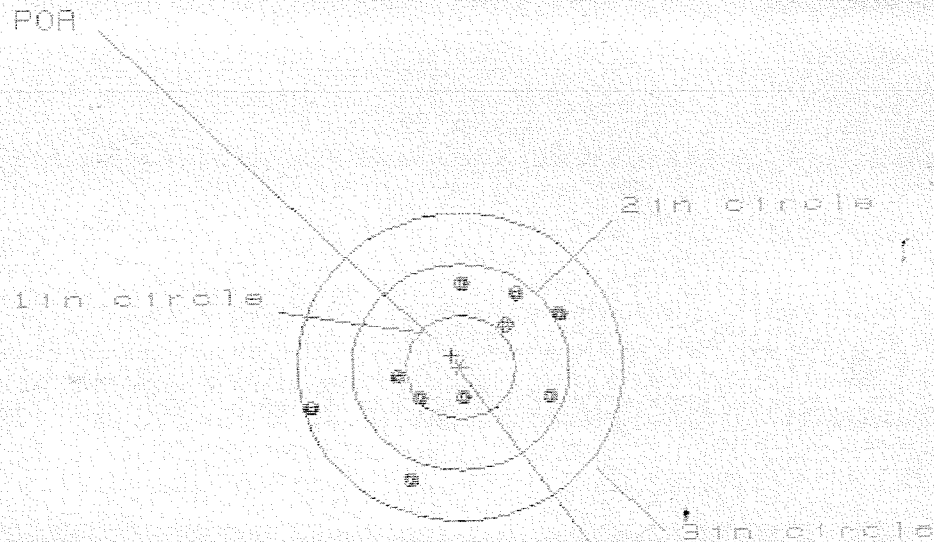
GS= 2.695

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.736	.974	.622
MINIMUM X	:	-.919	-.726	-.684
MAXIMUM Y	:	1.064	1.108	.757
MINIMUM Y	:	-.885	-.841	-.702
CENTROID X	:	-.190	-.383	-.505
CENTROID Y	:	-.177	-.221	-.368
POA TO CENTROID in.	:	.260	.443	.620
MIN RADIUS	:	.325	.307	.288
MEAN RADIUS	:	.853	.699	.552
MAX RADIUS	:	1.782	1.476	.988
HORIZONTAL SPREAD	:	2.655	1.700	1.226
VERTICAL SPREAD	:	1.949	1.949	1.459
EXTREME SPREAD	:	2.695	2.143	1.517
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

9 Dec 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 2.268

VS= 1.930

CS= 2.435

CENTROID #

PATTERN #

5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.918	.768	.686
MINIMUM X	-1.358	-.689	-.771
MAXIMUM Y	.853	.807	.667
MINIMUM Y	-1.077	-1.123	-.504
CENTROID X	.079	.229	.311
CENTROID Y	-.113	-.067	.073
POA TO CENTROID in.	.138	.239	.319
MIN RADIUS	.319	.387	.242
MEAN RADIUS	.817	.741	.651
MAX RADIUS	1.412	1.299	.803
HORIZONTAL SPREAD	2.268	1.457	1.457
VERTICAL SPREAD	1.930	1.930	1.171
EXTREME SPREAD	2.435	2.104	1.544
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		