

FORM

UPC



0 47700 25716 7

C6665687

*INCLUDES 1 IN CHAMBER

MODEL 700 TM M24

5716

ORDER NO.

BARREL LENGTH

CAPACITY

Remington



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

MODEL 700TM M24

SERIAL NO.

C6665687

ORDER NO.

5716

20

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



5716 C6665687

ORDER 5716

MODEL 700TM M24

UPC



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ORDER 5716

MODEL 700TM M24

UPC



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # *C6665687*

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT 10 1 91	91	<i>RW</i>
600	Proof		91	<i>RW</i>
607	Check Headspace		91	<i>RW</i>
610	Dis-assemble Gun		91	<i>RW</i>
612	Magnaflux Barrel Action		OCT 4 1991	KR
	Magnaflux Bolt		OCT 4 1991	KR
615	Rollmark Caliber		OCT 4 1991	LL
617	Drill and Tap Sight Holes		OCT 4 1991	LB
618	Polish Barrel		10/8/91	WB
620	Apply Coatings (Barrel Action)		10-22-91	<i>AS</i>
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		10/22/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/22/91	RW
	C) Inspect Ejector Hole for Chamfer		10/22/91	RW
	D) Oil Firing Pin Ass'y		10/22/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/28/91	<i>SL</i>

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/4	4 1/4	4 1/4			10/28/91	WB
	G) Safety Off Force	2	2	2			10/28/91	WB
	H) Trigger Pull Test & Retainability						10/28/91	JL
	I) Firing Pin Indent	.0205	.020	.020			10/28/91	WB
	J) Assemble Stock						10/29/91	RW
	K) Assemble Swivel Studs						11-12-91	AC
	L) Attach Front and Rear Sight Assemblies						10/29/91	RW
	M) Iron Sight Alignment						10/29/91	RW
	N) Detach Front & Rear Sights & place in numbered container						10/29/91	RW
	O) Attach Scope to Rifle						10/29/91	RW
	P) Detach & Attach Scope 20 Times						10/29/91	RW
640	Gallery Target & Test						10/29/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						10/29/91	KT
655	Final Inspection							
	A) Headspace						11-12-91	AC
	B) Trigger Pull	239	240	240	235	240	10-30-91	D/H
	C) Function						11-12-91	AC
660	Pack						12-17-91	N

SWS TRIGGER PULL TEST

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

SERIAL NO 6665687
DATE 10/28/91
TESTER JY

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.33	2.28	2.19	2.39	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.35	2.27	2.22	2.40	
PULL #3	2.28	2.28	2.20	2.40	
PULL #4	2.32	2.30	2.29	2.35	
PULL #5	2.31	2.23	2.38	2.40	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.35	3.56		
PULL #2	3.32	3.40		
PULL #3	3.26	3.46		
PULL #4	3.28	3.60		
PULL #5	3.24	3.47		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.47	4.21		4.41
PULL #2	4.33	4.58		4.34
PULL #3	4.37	4.43		4.43
PULL #4	4.15	4.41		4.33
PULL #5	4.26	4.50		4.42
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06665687
29 Oct 1991

CENTROIDAL DISTANCES

0 TO	1	.179324
1 TO	2	.229819
1 TO	3	.155641
1 TO	4	.251748
1 TO	5	.729449

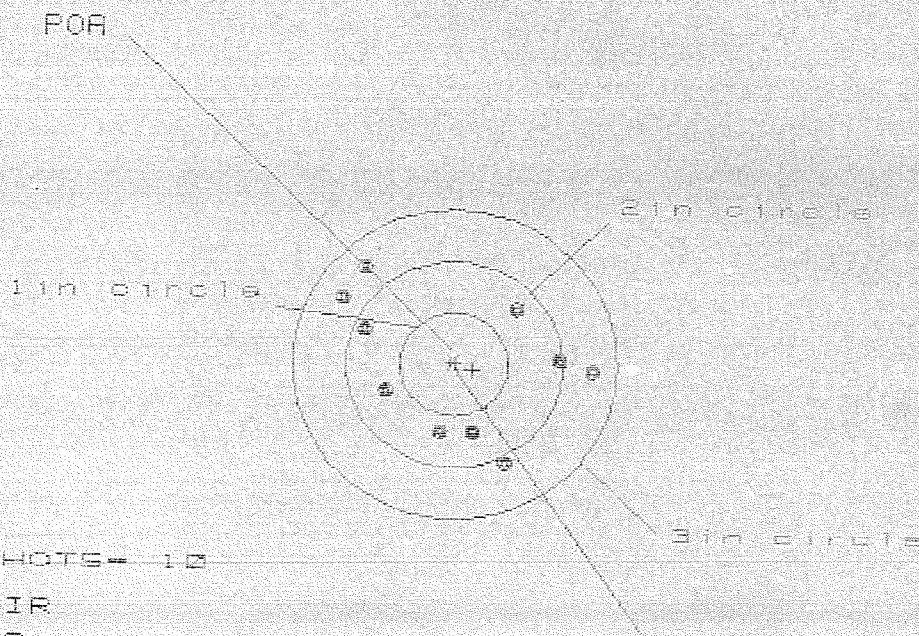
45 ← POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0634
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0124
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0646012
THE AMR FOR THIS RIFLE IS: .0578

29 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6565667

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 5

3 in = 10

HS = 2.348

VS = 1.835

GS = 2.452

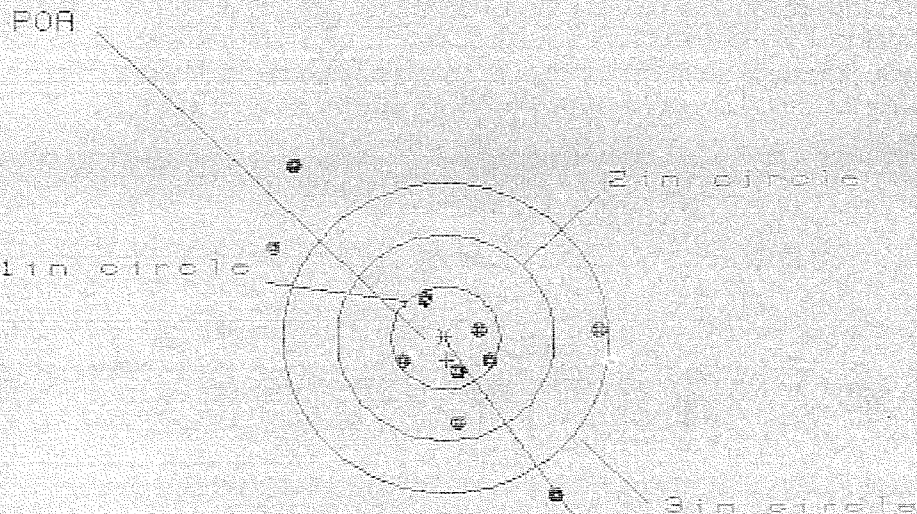
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.300	1.159	1.071
MINIMUM X	:	-1.043	-0.984	-0.992
MAXIMUM Y	:	.904	.894	.714
MINIMUM Y	:	-.930	-.941	-.829
CENTROID X	:	-.171	-.315	-.227
CENTROID Y	:	.054	.064	-.048
POA TO CENTROID in.	:	.179	.321	.232
MIN RADIUS	:	.665	.534	.572
MEAN RADIUS	:	.956	.905	.859
MAX RADIUS	:	1.303	1.162	1.223
HORIZONTAL SPREAD	:	2.348	2.063	2.063
VERTICAL SPREAD	:	1.835	1.835	1.543
EXTREME SPREAD	:	2.452	2.245	2.146
NUMBER IN ONE INCH CIRCLE =			0	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			10	

25 Oct 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 5

2in = 6

3in = 7

HS = 2.994

VS = 3.168

GS = 3.941

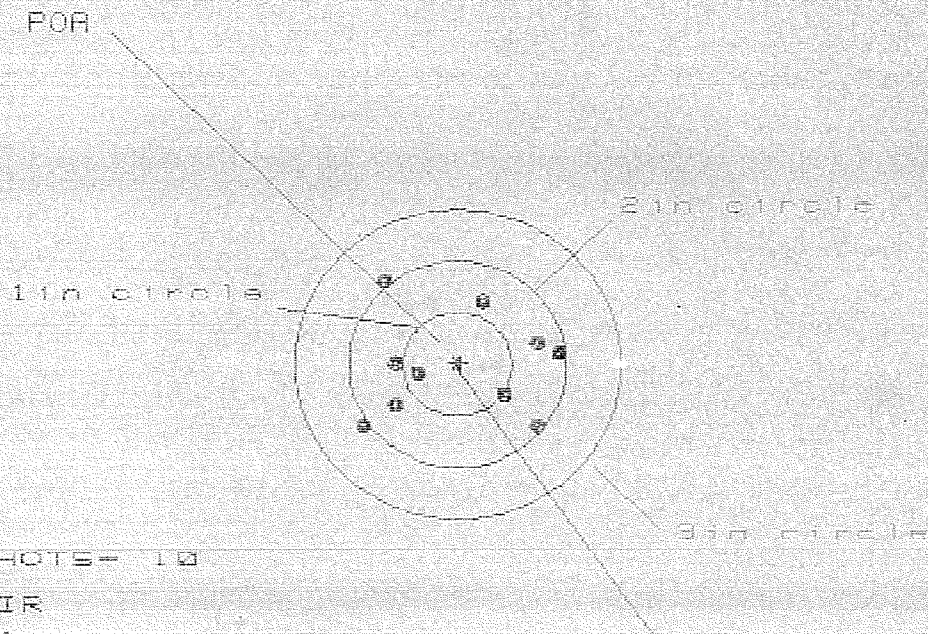
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.449	1.298	1.403
MINIMUM X	:	-1.545	-1.696	-1.591
MAXIMUM Y	:	1.676	1.061	.898
MINIMUM Y	:	-1.492	-1.306	-.816
CENTROID X	:	-.010	.141	.036
CENTROID Y	:	.218	.032	.195
POB TO CENTROID in.	:	.218	.144	.198
MIN RADIUS	:	.312	.109	.225
MEAN RADIUS	:	.997	.818	.743
MAX RADIUS	:	2.155	2.000	1.826
HORIZONTAL SPREAD	:	2.994	2.994	2.994
VERTICAL SPREAD	:	3.168	2.367	1.714
EXTREME SPREAD	:	3.941	3.469	3.087
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

29 Oct 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 1

2in = 8

3in = 10

HS= 1.810

VS= 1.449

GS= 1.992

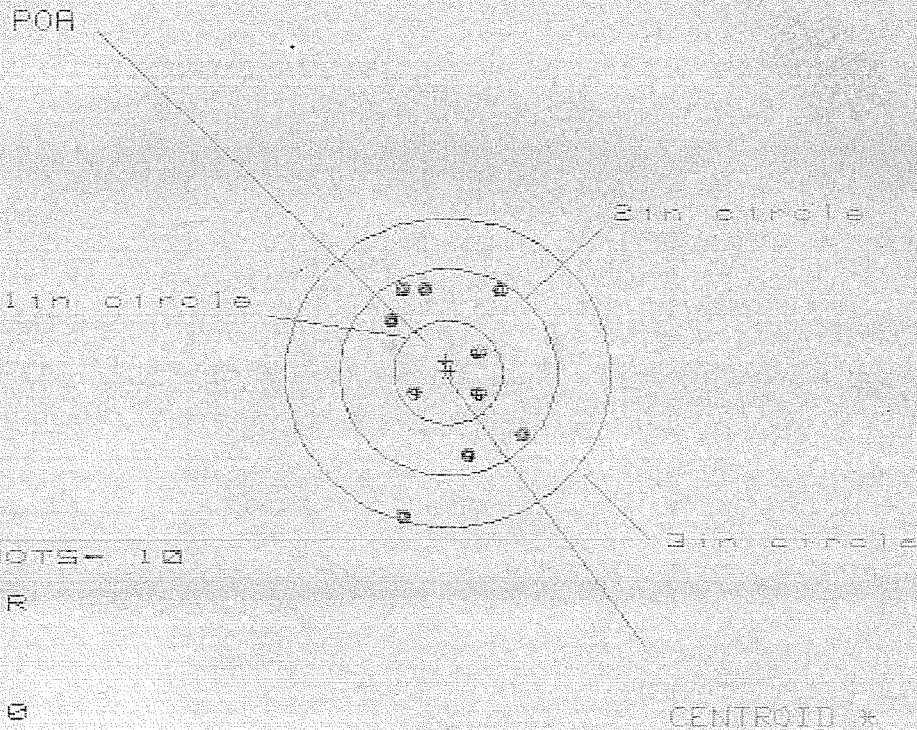
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.962	.887	.771
MINIMUM X	:	-.848	-.923	-.734
MAXIMUM Y	:	.814	.738	.675
MINIMUM Y	:	-.635	-.545	-.608
CENTROID X	:	-.031	.044	.160
CENTROID Y	:	-.014	-.104	-.042
POA TO CENTROID in.	:	.034	.113	.165
MIN RADIUS	:	.423	.393	.330
MEAN RADIUS	:	.755	.716	.665
MAX RADIUS	:	1.059	1.051	.788
HORIZONTAL SPREAD	:	1.810	1.810	1.505
VERTICAL SPREAD	:	1.449	1.283	1.283
EXTREME SPREAD	:	1.992	1.950	1.562
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

29 Oct 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 3

2in = 9

3in = 10

HS= 1.133

VS= 2.263

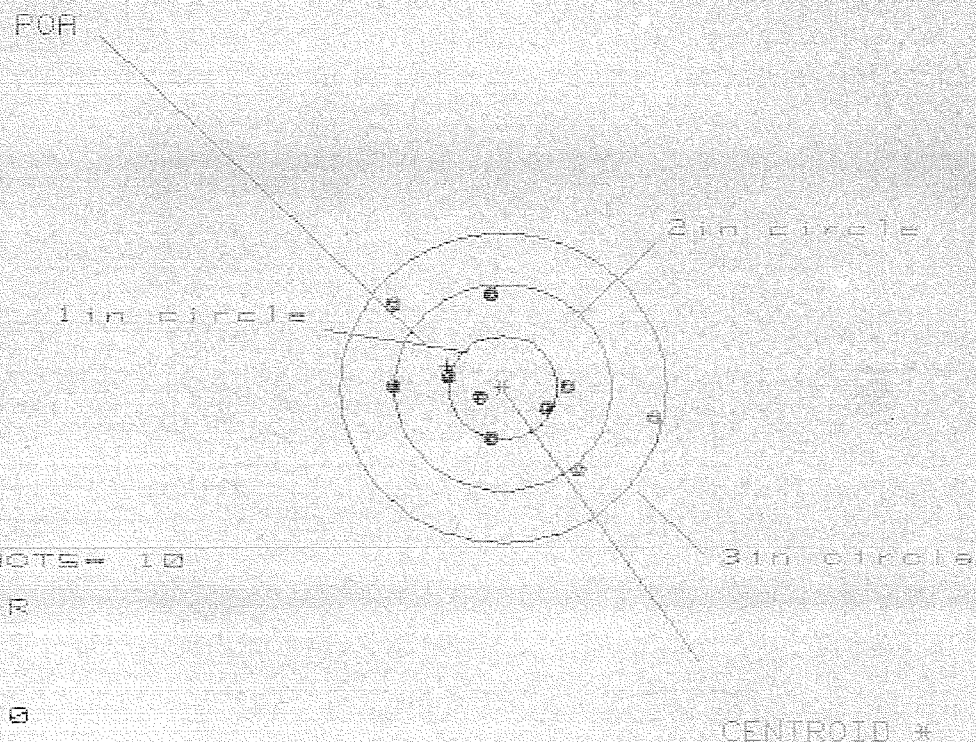
GS= 2.444

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.641	.594	.651
MINIMUM X	:	-.492	-.539	-.482
MAXIMUM Y	:	.927	.668	.740
MINIMUM Y	:	-1.436	-.920	-.837
CENTROID X	:	.020	.067	.010
CENTROID Y	:	-.110	.049	-.024
FOR TO CENTROID in.	:	.112	.083	.036
MIN RADIUS	:	.362	.288	.372
MEAN RADIUS	:	.774	.677	.657
MAX RADIUS	:	1.497	.989	.961
HORIZONTAL SPREAD	:	1.133	1.133	1.133
VERTICAL SPREAD	:	2.263	1.598	1.577
EXTREME SPREAD	:	2.444	1.792	1.792
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

29 Oct 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 6

3 in = 10

HS= 2.414

VS= 1.738

GS= 2.594

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.350	.962	.761
MINIMUM X	:	-1.054	-.903	-1.004
MAXIMUM Y	:	.926	.891	.990
MINIMUM Y	:	-.812	-.847	-.748
CENTROID X	:	.509	.358	.459
CENTROID Y	:	-.210	-.175	-.274
FOR TO CENTROID in.	:	.551	.398	.535
MIN RADIUS	:	.255	.170	.185
MEAN RADIUS	:	.807	.727	.663
MAX RADIUS	:	1.398	1.209	1.067
HORIZONTAL SPREAD	:	2.414	1.765	1.765
VERTICAL SPREAD	:	1.738	1.738	1.738
EXTREME SPREAD	:	2.594	2.346	1.961
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	