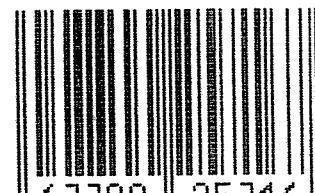


FORM

UPC



0 47700 25716 7

C6665781

INCLUDED 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.
C6665781

ORDER NO.
5716

20

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



5716 C6665781

ORDER **5716**

MODEL 700 TM M24

UPC



0 47700 25716 7

ORDER **5716**

MODEL 700 TM M24

UPC



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6665781

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/1/91	KH
600	Proof		10/1/91	KH
607	Check Headspace		10/1/91	KH
610	Dis-assemble Gun		10/1/91	KH
612	Magnaflux Barrel Action		OCT 8 1991	KR
	Magnaflux Bolt		OCT 8 1991	KR
615	Rollmark Caliber		OCT 8 1991	JS
617	Drill and Tap Sight Holes		OCT 8 1991	FB
618	Polish Barrel		10/14/91	WB
620	Apply Coatings (Barrel Action)		11-1-91	JA
	Apply Coating (Bolt)		11-1-91	JA
625	Final Assembly A) Clean inside of Bolt Assembly		11/26/91	KH
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/26/91	KH
	C) Inspect Ejector Hole for Chamfer		11/26/91	KH
	D) Oil Firing Pin Ass'y		11/26/91	KH
	E) Adjust Trigger Pull to Min Setting and Stake		12-2-91	JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			12-2-91	HL
	G) Safety Off Force	3	3	3			12-2-91	JH
	H) Trigger Pull Test & Retainability						12-2-91	HL
	I) Firing Pin Indent	.0205	.0205	.0205			12-2-91	JH
	J) Assemble Stock						12/2/91	JH
	K) Assemble Swivel Studs						12-7-91	Ac
	L) Attach Front and Rear Sight Assemblies						12/2/91	JH
	M) Iron Sight Alignment						12/2/91	JH
	N) Detach Front & Rear Sights & place in numbered container						12/2/91	JH
	O) Attach Scope to Rifle						12/3/91	JH
	P) Detach & Attach Scope 20 Times						12/2/91	JH
640	Gallery Target & Test						12-3-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						12-3-91	NF
655	Final Inspection							
	A) Headspace						12-4-91	Ac
	B) Trigger Pull	2.68	2.49	2.49	2.42	2.19	12-4-91	D/H
	C) Function						12-7-91	Ac
660	Pack						12-19-91	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-6665781

DATE 12-2-91

TESTER [Signature]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.29	2.38	2.44	2.68	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.28	2.38	2.32	2.49	
PULL #3	2.37	2.42	2.39	2.49	
PULL #4	2.37	2.37	2.40	2.42	
PULL #5	2.46	2.33	2.44	2.19	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.43	3.41		
PULL #2	3.42	3.45		
PULL #3	3.47	3.48		
PULL #4	3.47	3.40		
PULL #5	3.35	3.48		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.69	4.38		4.39
PULL #2	4.14	4.42		4.20
PULL #3	4.36	4.39		4.35
PULL #4	4.20	4.45		4.43
PULL #5	4.47	4.41		4.38
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665781
3 Dec 1991

CENTROIDAL DISTANCES

0 TO	1	.605486
1 TO	2	.991561
1 TO	3	.528366
1 TO	4	.146349
1 TO	5	.40078

2 to 4 <----POA

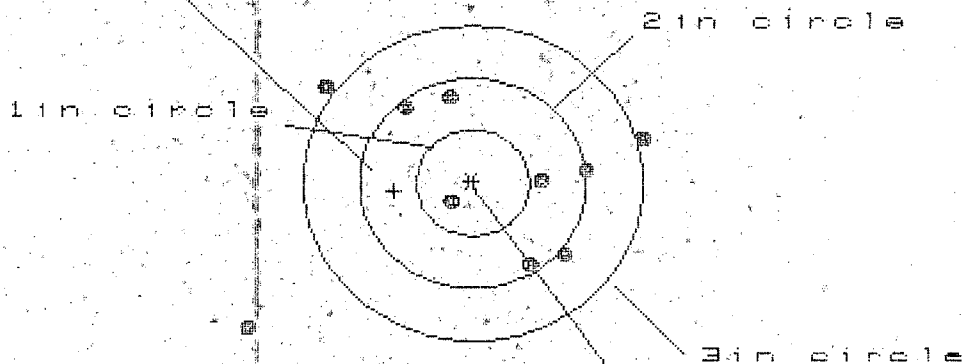
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2278
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0828
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .242381
THE AMR FOR THIS RIFLE IS: 1.07

3 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66657B1

CENTERFIRE PATTERNS # 4

POA



OF SHOTS = 10

IN CIRC

1 in = 1

2 in = 6

3 in = 7

HS = 0.0007

VS = 0.0004

GS = 0.0009

CENTROID *

PATTERN #

4

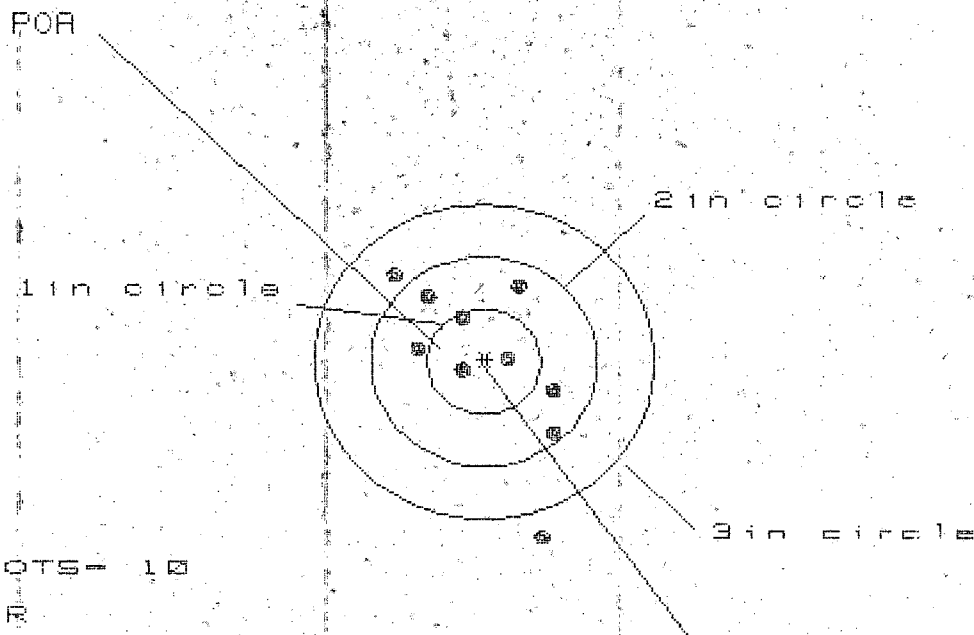
SHOTS (BEST OF)

		10	9	8
MAXIMUM	X	1.547	1.329	1.134
MINIMUM	X	-1.960	-1.558	-1.027
MAXIMUM	Y	.907	.754	.737
MINIMUM	Y	-1.377	-.916	-.821
CENTROID	X	.695	.913	1.108
CENTROID	Y	.074	.227	.132
POA TO CENTROID	in.	.699	.941	1.116
MIN RADIUS		.284	.368	.156
MEAN RADIUS		1.119	.949	.809
MAX RADIUS		2.395	1.731	1.216
HORIZONTAL	SPREAD	3.507	2.887	2.161
VERTICAL	SPREAD	2.284	1.670	1.558
EXTREME	SPREAD	3.959	2.922	2.175
NUMBER IN ONE	INCH CIRCLE	= 1		
NUMBER IN TWO	INCH CIRCLE	= 6		
NUMBER IN THREE	INCH CIRCLE	= 7		

3 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6865781

CENTERFIRE PATTERNS # 5



OF SHOTS = 10
 # IN CIRC
 1in = 3
 2in = 8
 3in = 9
 HS = 1.471
 VS = 2.514
 GS = 2.851

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.651	.710	.614
MINIMUM X	:	-.820	-.761	-.590
MAXIMUM Y	:	.834	.648	.573
MINIMUM Y	:	-1.680	-.833	-.752
CENTROID X	:	.191	.132	.228
CENTROID Y	:	.079	.265	.184
POA TO CENTROID in.	:	.206	.297	.293
MIN RADIUS	:	.218	.305	.208
MEAN RADIUS	:	.752	.617	.566
MAX RADIUS	:	1.760	1.049	.927
HORIZONTAL SPREAD	:	1.471	1.471	1.204
VERTICAL SPREAD	:	2.514	1.481	1.325
EXTREME SPREAD	:	2.851	2.037	1.642
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

3 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66657B1

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS- 10

IN CIR

1 in = 9

2 in = 7

3 in = 9

HS = 2.556

VS = 1.750

GS = 2.056

PATTERN #

3

SHOTS (BEST OF)

10

9

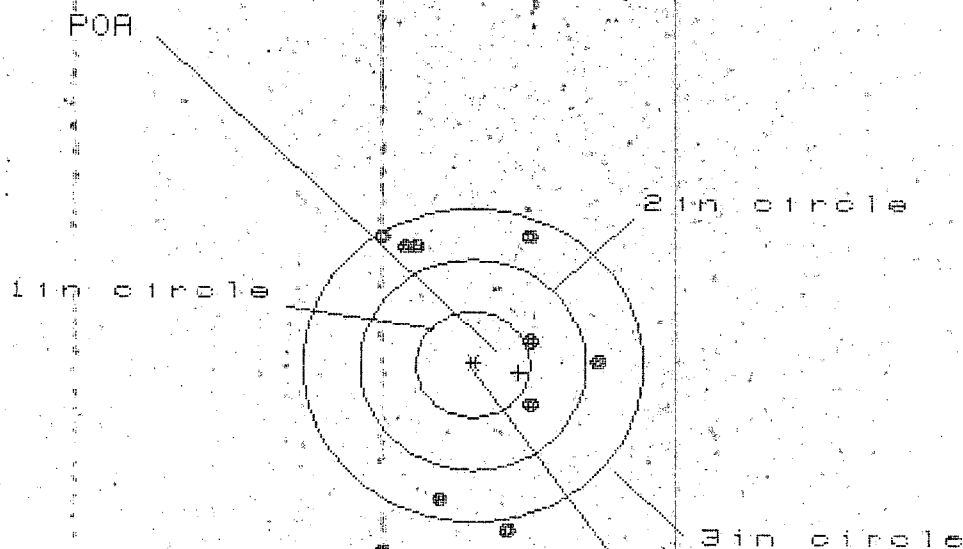
8

MAXIMUM X	1.249	1.092	.539
MINIMUM X	-1.417	-.935	-.798
MAXIMUM Y	.758	.817	.762
MINIMUM Y	-.992	-.933	-.988
CENTROID X	.076	.233	.097
CENTROID Y	.022	-.037	.019
POA TO CENTROID in.	.079	.236	.098
MIN RADIUS	.249	.240	.261
MEAN RADIUS	.795	.717	.638
MAX RADIUS	1.511	1.178	.999
HORIZONTAL SPREAD	2.666	2.027	1.338
VERTICAL SPREAD	1.750	1.750	1.750
EXTREME SPREAD	2.856	2.038	1.770
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

3 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66657B1

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in 1

2 in 2

3 in 7

10 in 1.0002

VS in 3.0039

GS in 3.314

CENTROID #

PATTERN #

2

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.138

1.051

1.077

MINIMUM X

-0.824

-0.911

-0.885

MAXIMUM Y

1.268

1.071

0.851

MINIMUM Y

-1.771

-1.756

-1.666

CENTROID X

-0.405

-0.318

-0.344

CENTROID Y

0.072

0.269

0.489

POA TO CENTROID in.

0.411

0.417

0.598

MIN RADIUS

0.552

0.417

0.481

MEAN RADIUS

1.238

1.127

1.024

MAX RADIUS

1.934

1.768

1.697

HORIZONTAL SPREAD

1.962

1.962

1.962

VERTICAL SPREAD

3.009

2.827

2.517

EXTREME SPREAD

3.314

3.021

2.644

NUMBER IN ONE INCH CIRCLE =

0

NUMBER IN TWO INCH CIRCLE =

2

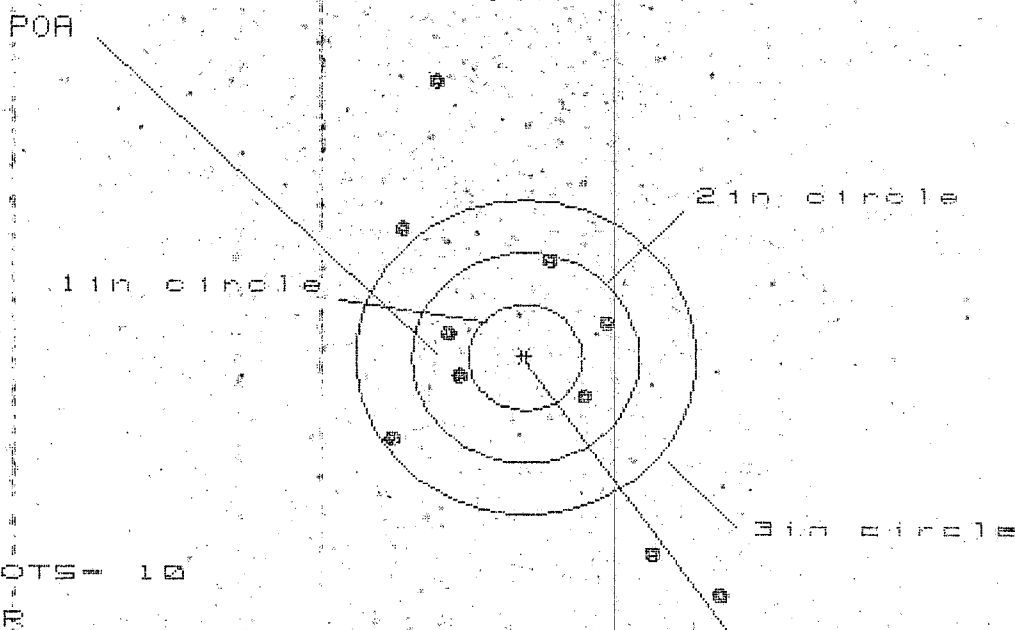
NUMBER IN THREE INCH CIRCLE =

8

3 Dec 1991

FILE: PATTERNING/CENTERFIRE_PATT/C66657B1

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 0

2in = 5

3in = 6

HS= 2.960

VS= 4.927

GS= 5.540

CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.764	1.286	1.215
MINIMUM X	:	-1.196	-1.000	-1.071
MAXIMUM Y	:	2.671	2.421	1.242
MINIMUM Y	:	-2.256	-2.067	-1.765
CENTROID X	:	.582	.386	.457
CENTROID Y	:	.167	.417	.115
POA TO CENTROID in.	:	.605	.568	.471
MIN RADIUS	:	.584	.470	.526
MEAN RADIUS	:	1.447	1.260	1.094
MAX RADIUS	:	2.864	2.487	2.142
HORIZONTAL SPREAD	:	2.960	2.286	2.286
VERTICAL SPREAD	:	4.927	4.488	3.007
EXTREME SPREAD	:	5.540	4.857	3.694
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		6	