

FORM

UPC



0 47700 25716 7

C6666119

BARREL LENGTH
CAPACITY*
*INCLUDES 1 IN CHAMBER

MODEL 700 TM M24

ORDER NO.

5716

Remington



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

MODEL 700 TM M24

SERIAL NO.

C6666119

ORDER NO.

5716

20

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



5716 C6666119

ORDER 5716

MODEL 700 TM M24

UPC

ORDER 5716

MODEL 700 TM M24

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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

26666119

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/1/91	KA
600	Proof		10/1/91	KA
607	Check Headspace		10/1/91	KA
610	Dis-assemble Gun		10/1/91	KA
612	Magnaflux Barrel Action		OCT 8 1991	KR
	Magnaflux Bolt		OCT 8 1991	KR
615	Rollmark Caliber		OCT 8 1991	28.
617	Drill and Tap Sight Holes		OCT 8 1991	LB
618	Polish Barrel		10/14/91	WB
620	Apply Coatings (Barrel Action)		11/1/91	AB
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/5/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/5/91	KA
	C) Inspect Ejector Hole for Chamfer		11/5/91	KA
	D) Oil Firing Pin Ass'y		11/5/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		11-6-91	JH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			11-6-91	SH
	G) Safety Off Force	3	3	3			11-6-91	SH
	H) Trigger Pull Test & Retainability						11-6-91	SH
	I) Firing Pin Indent	.020	.020	.020			11-6-91	SH
	J) Assemble Stock						11-6-91	SH
	K) Assemble Swivel Studs						11-14-91	SH
	L) Attach Front and Rear Sight Assemblies						11-6-91	SH
	M) Iron Sight Alignment						11-6-91	SH
	N) Detach Front & Rear Sights & place in numbered container						11-6-91	SH
	O) Attach Scope to Rifle						11-6-91	SH
	P) Detach & Attach Scope 20 Times						11-6-91	SH
640	Gallery Target & Test						11-11-91	SH
	A) Time						11	SH
	B) Malfunctions						11	SH
	C) Pierced Primers						11	SH
	D) Optical Clarity of Scope						11	SH
645	Inspect for Live Ammo						11-11-91	SH
655	Final Inspection							
	A) Headspace						12-14-91	SH
	B) Trigger Pull	2.56	2.54	2.62	2.70	2.76	11-13-91	Ac
	C) Function						12-14-91	SH
660	Pack						12-17-91	DH

SWS TRIGGER PULL TESTAVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO 2-6666119DATE 11-6-91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.60	2.58	2.47	2.56	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.63	2.57	2.44	2.54	
PULL #3	2.59	2.46	2.54	2.62	
PULL #4	2.62	2.62	2.58	2.70	
PULL #5	2.60	2.57	2.51	2.76	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.52	3.34		
PULL #2	3.51	3.30		
PULL #3	3.52	3.49		
PULL #4	3.53	3.27		
PULL #5	3.35	3.36		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.45	4.32		4.20
PULL #2	4.25	4.30		4.29
PULL #3	4.21	4.35		4.37
PULL #4	4.33	4.31		4.44
PULL #5	4.52	4.38		4.23
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6666119
11 Nov 1991

CENTROIDAL DISTANCES

0	TO	1	.0616117
1	TO	2	.0830963
1	TO	3	.344246
1	TO	4	.15948
1	TO	5	.044911

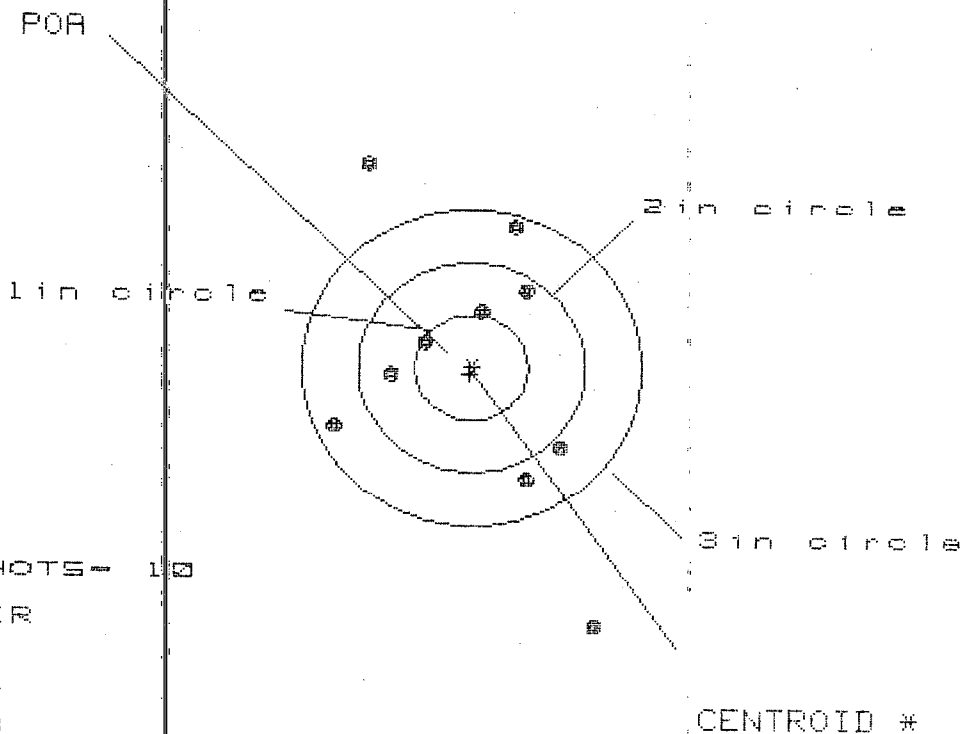
 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0086
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0352
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0362353
THE AMR FOR THIS RIFLE IS: .9928

11 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8686119

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 1

2in = 4

3in = 8

HS = 2.311

VS = 4.338

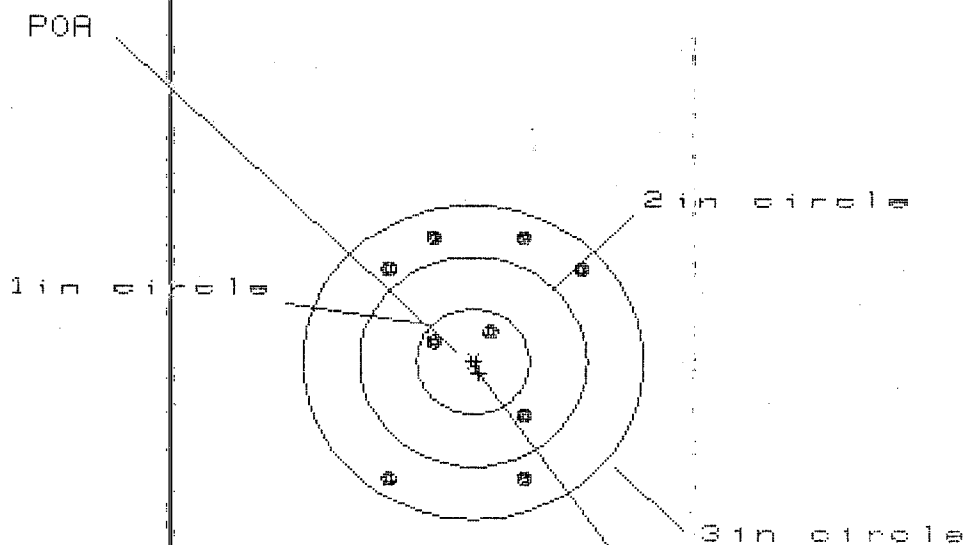
GS = 4.785

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.057	.934	.828
MINIMUM X	:	-1.254	-1.136	-1.242
MAXIMUM Y	:	1.910	1.640	1.246
MINIMUM Y	:	-2.428	-1.317	-1.111
CENTROID X	:	.014	-.104	.002
CENTROID Y	:	.060	.330	.125
POA TO CENTROID in.	:	.061	.346	.125
MIN RADIUS	:	.477	.297	.437
MEAN RADIUS	:	1.245	1.035	.947
MAX RADIUS	:	2.648	1.845	1.377
HORIZONTAL SPREAD	:	2.311	2.070	2.070
VERTICAL SPREAD	:	4.338	2.957	2.357
EXTREME SPREAD	:	4.785	3.308	2.484
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			4	
NUMBER IN THREE INCH CIRCLE =			8	

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 3

3in = 9

HS= 1.695

VS= 3.090

GS= 3.142

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.956	.938	.847
MINIMUM X	-.739	-.757	-.848
MAXIMUM Y	1.217	1.009	.841
MINIMUM Y	-1.873	-1.350	-1.456
CENTROID X	-.050	-.032	.059
CENTROID Y	.113	.321	.489
POA TO CENTROID in.	.123	.322	.493
MIN RADIUS	.299	.114	.099
MEAN RADIUS	1.071	.943	.854
MAX RADIUS	1.880	1.534	1.502
HORIZONTAL SPREAD	1.695	1.695	1.695
VERTICAL SPREAD	3.090	2.359	2.296
EXTREME SPREAD	3.142	2.653	2.390
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS - 10

IN CIR

1in = 2

2in = 7

3in = 8

HS = 1.540

VS = 3.419

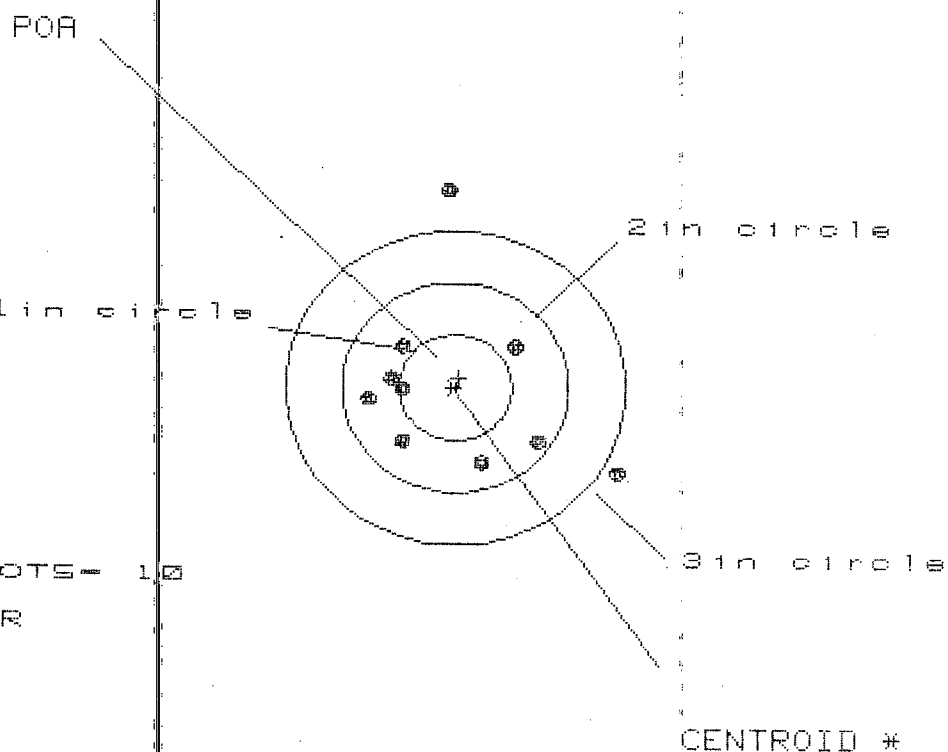
GS = 3.430

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.853	.801	.769
MINIMUM X	-.686	-.739	-.770
MAXIMUM Y	1.635	1.437	1.186
MINIMUM Y	-1.784	-1.169	-.989
CENTROID X	.105	.157	.189
CENTROID Y	-.272	-.074	-.254
POA TO CENTROID in.	.292	.174	.316
MIN RADIUS	.184	.303	.130
MEAN RADIUS	.926	.840	.719
MAX RADIUS	1.846	1.459	1.205
HORIZONTAL SPREAD	1.540	1.540	1.540
VERTICAL SPREAD	3.419	2.606	2.175
EXTREME SPREAD	3.430	2.612	2.199
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	

11 May 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in = 0

2 in = 8

3 in = 8

HS = 2.197

VS = 2.686

GS = 3.089

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.431	1.421	.902
MINIMUM X	:	-.766	-.776	-.599
MAXIMUM Y	:	1.852	.627	.549
MINIMUM Y	:	-.834	-.629	-.604
CENTROID X	:	-.031	-.021	-.199
CENTROID Y	:	-.093	-.298	-.220
POA TO CENTROID in.	:	.098	.299	.296
MIN RADIUS	:	.502	.562	.368
MEAN RADIUS	:	.905	.787	.643
MAX RADIUS	:	1.854	1.554	.984
HORIZONTAL SPREAD	:	2.197	2.197	1.501
VERTICAL SPREAD	:	2.686	1.256	1.153
EXTREME SPREAD	:	3.089	2.303	1.548
NUMBER IN ONE INCH CIRCLE =			0	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			8	

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 2.001

VS= 1.813

GS= 2.256

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.212	1.314	.675
MINIMUM X	-.789	-.687	-.523
MAXIMUM Y	1.036	.951	1.009
MINIMUM Y	-.777	-.662	-.604
CENTROID X	.005	-.097	-.261
CENTROID Y	.016	-.099	-.157
POA TO CENTROID in.	.017	.139	.304
MIN RADIUS	.024	.176	.129
MEAN RADIUS	.817	.730	.617
MAX RADIUS	1.383	1.392	1.136
HORIZONTAL SPREAD	2.001	2.001	1.198
VERTICAL SPREAD	1.813	1.613	1.613
EXTREME SPREAD	2.256	2.060	1.930
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	