

FORM

UPC



0 47700 25716 7

CAPACITY*
*INCLUDES 1 IN CHAMBER

C6648994

MODEL 700 TM M24

ORDER NO.

5716

BARREL LENGTH

BARBER - M24 0030418

Remington



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

MODEL 700 TM M24

SERIAL NO.

C6648994

20

ORDER NO.

5716

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



5716 C6648994

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 # C6648994

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 26 91		RW
600	Proof	9 26 91		RW
607	Check Headspace	9 26 91		RW
610	Dis-assemble Gun			RW
612	Magnaflux Barrel Action	OCT	3 1991	KCR
	Magnaflux Bolt	OCT	3 1991	KCR
615	Rollmark Caliber	OCT	3 1991	ES
617	Drill and Tap Sight Holes	OCT	4 1991	LB
618	Polish Barrel	OCT	4 1991	WB
620	Apply Coatings (Barrel Action)		10-18-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/18/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/18/91	RW
	C) Inspect Ejector Hole for Chamfer		10/18/91	RW
	D) Oil Firing Pin Ass'y		10/18/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		12/3/91	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2			12/3/91	WB
	G) Safety Off Force	3	3	3			12/3/91	WB
	H) Trigger Pull Test & Retainability						12/3/91	WB
	I) Firing Pin Indent	.0205	.020	.020			12/3/91	WB
	J) Assemble Stock						12/4/91	RW
	K) Assemble Swivel Studs						12-7-91	AC
	L) Attach Front and Rear Sight Assemblies						12/4/91	RW
	M) Iron Sight Alignment						12/4/91	RW
	N) Detach Front & Rear Sights & place in numbered container						12/4/91	RW
	O) Attach Scope to Rifle						12/4/91	RW
	P) Detach & Attach Scope 20 Times						12/4/91	RW
640	Gallery Target & Test						12-4-91	AC
	A) Time						12-4-91	AC
	B) Malfunctions						12-4-91	AC
	C) Pierced Primers						12-4-91	AC
	D) Optical Clarity of Scope						12-4-91	AC
645	Inspect for Live Ammo						12-4-91	AC
655	Final Inspection							
	A) Headspace						12-7-91	AC
	B) Trigger Pull	232	207	210	201	204	12-5-91	DH
	C) Function						12-7-91	AC
660	Pack						12-14-91	VF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6648994

DATE 12/3/91

TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.52	2.38	2.32	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.26	2.30	2.20	2.07	
PULL #3	2.39	2.30	2.38	2.10	
PULL #4	2.32	2.29	2.15	2.01	
PULL #5	2.33	2.26	2.36	2.04	
TOTAL	11.76	11.67	11.47		
AVG.	2.35	2.33	2.29		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.20	3.20		
PULL #2	3.23	3.09		
PULL #3	3.12	3.41		
PULL #4	3.30	3.14		
PULL #5	3.24	3.18		
TOTAL	16.19	16.02		
AVG.	3.24	3.20		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.21	4.22		4.26
PULL #2	4.01	4.27		4.08
PULL #3	4.00	4.33		4.07
PULL #4	4.07	4.35		4.24
PULL #5	4.15	4.08		3.95
TOTAL	20.44	21.28		20.60
AVG.	4.09	4.25		4.12

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6648994
4 Dec 1991

CENTROIDAL DISTANCES

0 TO	1	.5989
1 TO	2	.24907
1 TO	3	.62418
1 TO	4	.686313
1 TO	5	.869501

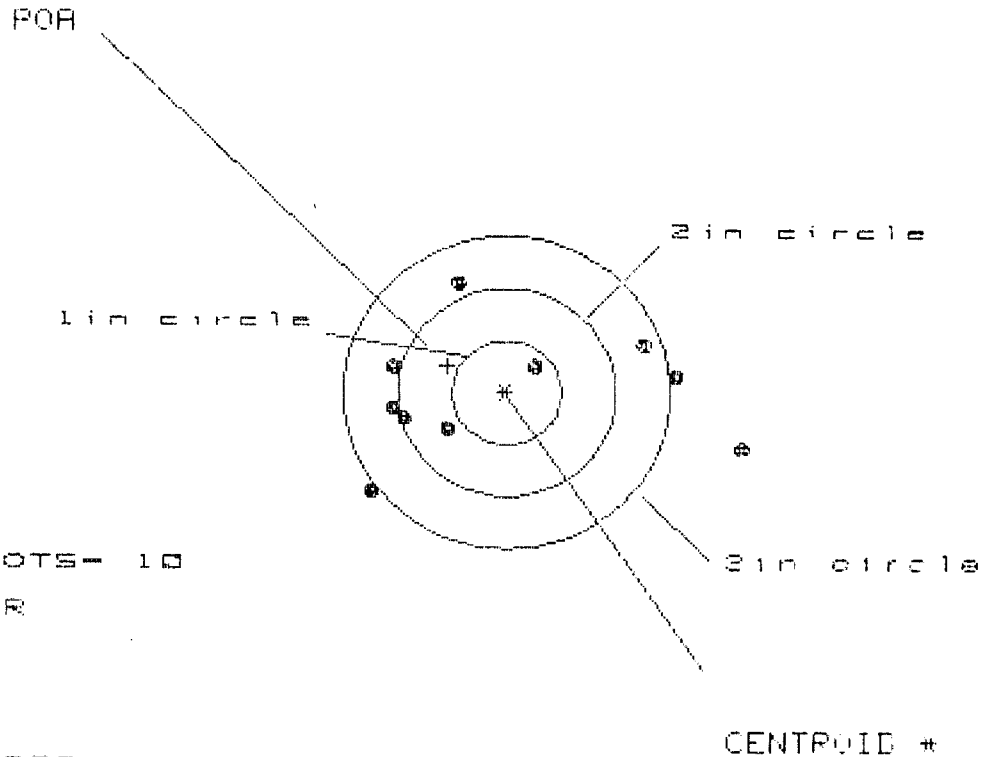
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THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1262
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.009
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .126521
THE AMR FOR THIS RIFLE IS: 1.029

4 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C664B394

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 7

HS= 3.335

VS= 1.998

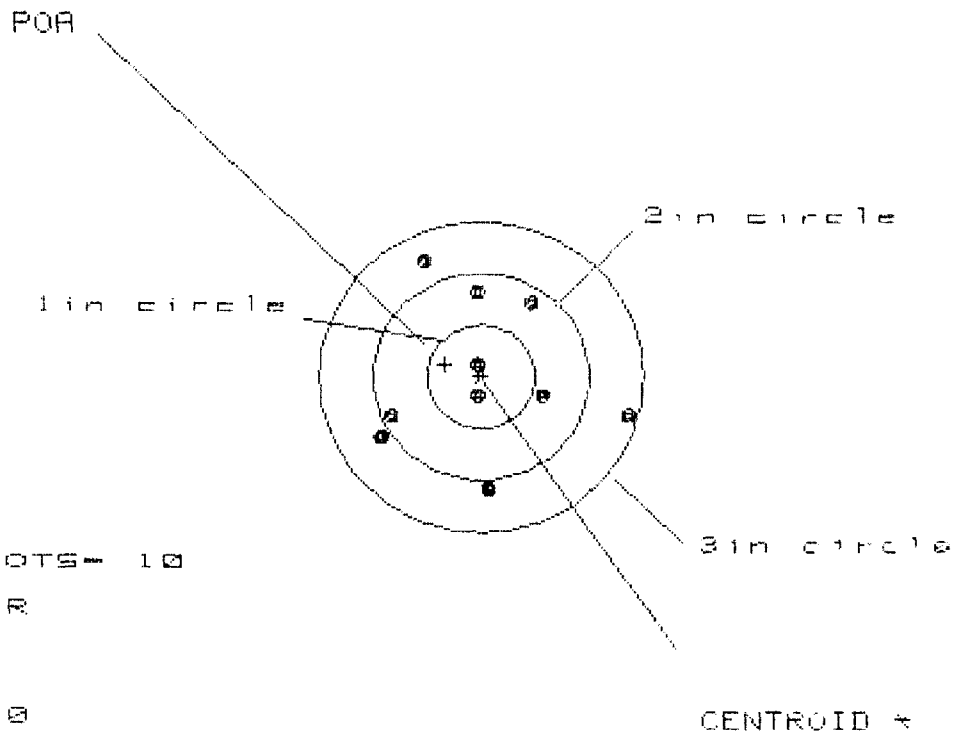
GS= 3.351

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.130	1.754	1.762
MINIMUM X	-1.205	-0.969	-0.750
MAXIMUM Y	1.084	1.019	1.027
MINIMUM Y	-0.914	-0.979	-0.971
CENTROID X	.540	.304	.085
CENTROID Y	-.259	-.194	-.202
POA TO CENTROID in.	.599	.360	.219
MIN RADIUS	.376	.525	.446
MEAN RADIUS	1.187	1.021	.871
MAX RADIUS	2.208	1.755	1.803
HORIZONTAL SPREAD	3.335	2.723	2.511
VERTICAL SPREAD	1.998	1.998	1.998
EXTREME SPREAD	3.351	2.916	2.854
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

4 Dec 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 10

HS= 2.328

VS= 2.165

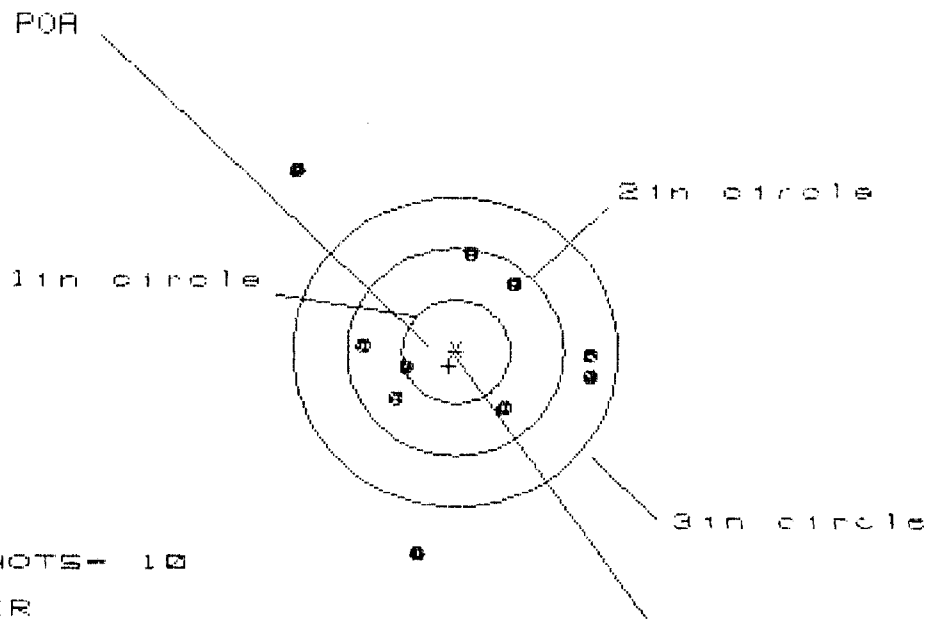
GS= 2.383

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.351	.760	.712
MINIMUM X	-.977	-.827	-.875
MAXIMUM Y	1.094	1.054	.915
MINIMUM Y	-1.071	-1.111	-.979
CENTROID X	.334	.184	.232
CENTROID Y	-.119	-.079	-.211
POA TO CENTROID in.	.354	.200	.314
MIN RADIUS	.100	.089	.108
MEAN RADIUS	.836	.769	.710
MAX RADIUS	1.397	1.138	1.004
HORIZONTAL SPREAD	2.328	1.587	1.587
VERTICAL SPREAD	2.165	2.165	1.894
EXTREME SPREAD	2.383	2.256	1.947
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

4 Dec 1931

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 6

3 in = 4

HS = 2.707

VS = 3.677

GS = 3.852

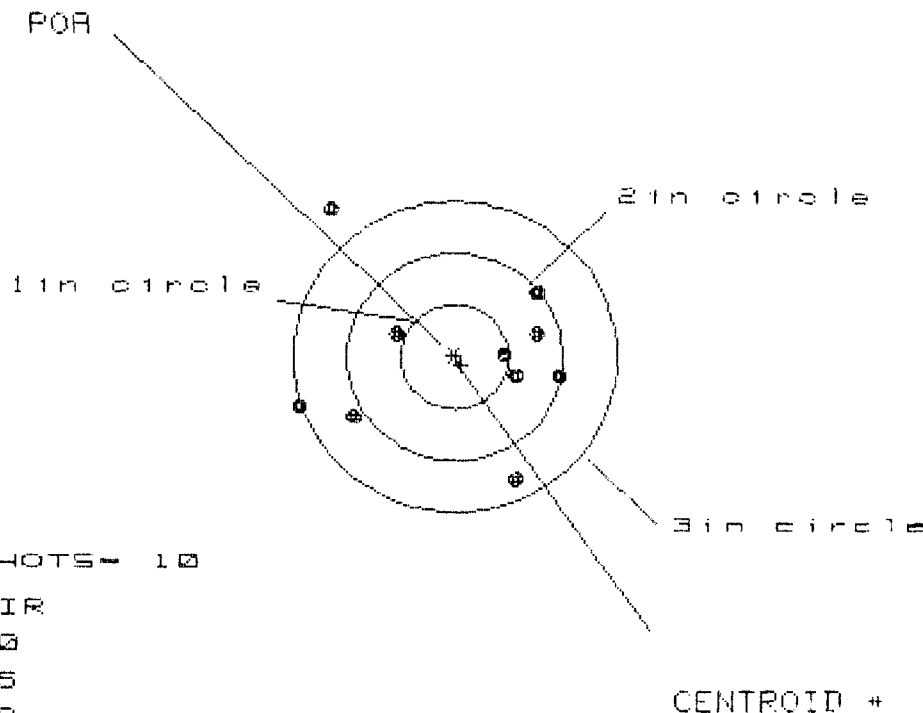
CENTROID #

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.224
MINIMUM X	-1.484
MAXIMUM Y	1.738
MINIMUM Y	-1.939
CENTROID X	.060
CENTROID Y	.140
POR TO CENTROID in.	.152
MIN RADIUS	.501
MEAN RADIUS	1.129
MAX RADIUS	2.285
HORIZONTAL SPREAD	2.707
VERTICAL SPREAD	3.677
EXTREME SPREAD	3.852
NUMBER IN ONE INCH CIRCLE =	0
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	4

4 Oct 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 5

3 in = 8

HS = 2.435

VS = 2.529

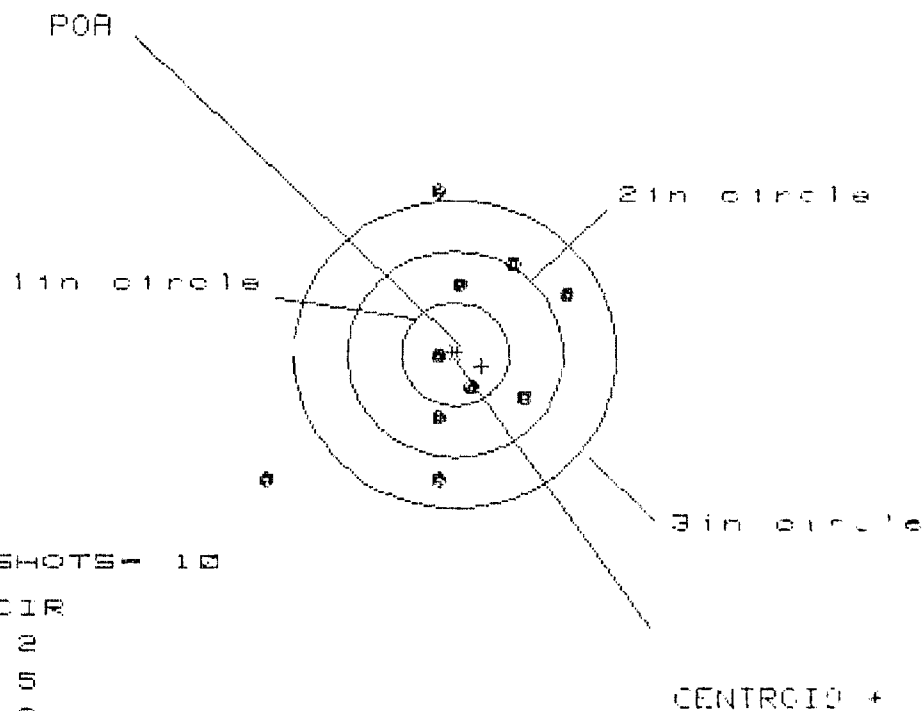
GS = 3.006

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.986	.864	.668
MINIMUM X	-1.449	-1.571	-1.306
MAXIMUM Y	1.391	.788	.752
MINIMUM Y	-1.138	-.983	-1.019
CENTROID X	-.059	.063	.259
CENTROID Y	.076	-.079	-.043
POA TO CENTROID in.	.096	.101	.263
MIN RADIUS	.500	.392	.203
MEAN RADIUS	1.007	.893	.737
MAX RADIUS	1.772	1.597	1.385
HORIZONTAL SPREAD	2.435	2.435	1.974
VERTICAL SPREAD	2.529	1.771	1.771
EXTREME SPREAD	3.006	2.450	2.104
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		8	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.822

VS= 2.794

GS= 3.341

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.067	.872	.822
MINIMUM X	:	-1.755	-.394	-.407
MAXIMUM Y	:	1.604	1.472	.947
MINIMUM Y	:	-1.190	-1.322	-1.138
CENTROID X	:	-.244	-.049	.001
CENTROID Y	:	.117	.249	.065
POA TO CENTROID in.	:	.271	.253	.065
MIN RADIUS	:	.168	.397	.285
MEAN RADIUS	:	.987	.859	.745
MAX RADIUS	:	2.117	1.524	1.207
HORIZONTAL SPREAD	:	2.822	1.266	1.230
VERTICAL SPREAD	:	2.794	2.794	2.085
EXTREME SPREAD	:	3.341	2.794	2.191
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	