

FORM

UPC



0 47700 25716 7

06649001

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.
C6649001

20

ORDER NO.
5716

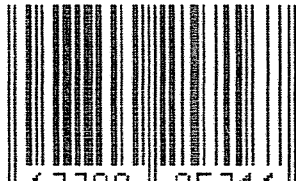
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.



5716 C6649001

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 # C6649001

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	9 26	91	RW
612	Magnaflux Barrel Action	OCT	3 1991	KCR
	Magnaflux Bolt	OCT	3 1991	KCR
615	Rollmark Caliber	OCT	3 1991	GS
617	Drill and Tap Sight Holes	OCT	4 1991	LB
618	Polish Barrel	OCT	4 1991	WB
620	Apply Coatings (Barrel Action)		9-13-91	DA
	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		11-20-91	JH

op. #	BARBER - M24 0030495	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			11/25/91	WB
	G) Safety Off Force	3	3	3			11/25/91	WB
	H) Trigger Pull Test & Retainability						11-20-91	JL
	I) Firing Pin Indent	.020	.020	.020			11/25/91	WB
	J) Assemble Stock						11/25/91	RW
	K) Assemble Swivel Studs						11-27-91	D/H
	L) Attach Front and Rear Sight Assemblies						11/25/91	RW
	M) Iron Sight Alignment						11/25/91	RW
	N) Detach Front & Rear Sights & place in numbered container						11/25/91	RW
	O) Attach Scope to Rifle						11/25/91	RW
	P) Detach & Attach Scope 20 Times						11/25/91	RW
640	Gallery Target & Test						11-25-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						11-25-91	AF
655	Final Inspection							
	A) Headspace						11-27-91	D/H
	B) Trigger Pull	218	205	203	209	210	11-26-91	DH
	C) Function						11-27-91	D/H
660	Pack						12-19-91	AF

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

SERIAL NO. 06649001DATE 11-20-91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.22	2.45	2.38	2.18	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.24	2.44	2.48	2.05	
PULL #3	2.39	2.44	2.44	2.03	
PULL #4	2.33	2.36	2.39	2.09	
PULL #5	2.38	2.29	2.41	2.10	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.45	3.34		
PULL #2	3.66	3.36		
PULL #3	3.25	3.45		
PULL #4	3.29	3.46		
PULL #5	3.33	3.42		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.58		4.49
PULL #2	4.28	4.49		4.48
PULL #3	4.20	4.46		4.44
PULL #4	4.43	4.52		4.51
PULL #5	4.33	4.42		4.40
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649001
25 Nov 1991

CENTROIDAL DISTANCES

0 TO	1	.2314
1 TO	2	.305262
1 TO	3	.207692
1 TO	4	.274029
1 TO	5	.0764853

-----FOR

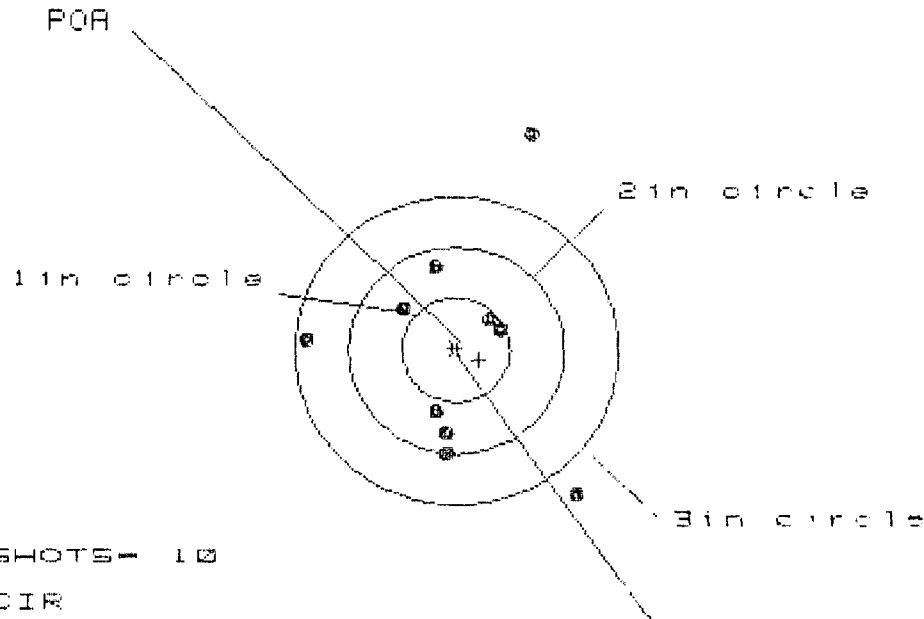
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1326
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0162
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .140537

THE AMR FOR THIS RIFLE IS: 1.016

25 Nov 1931

FILE: PATTERNING/CENTERFIRE_PATT/C6649001

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.543

VS= 3.510

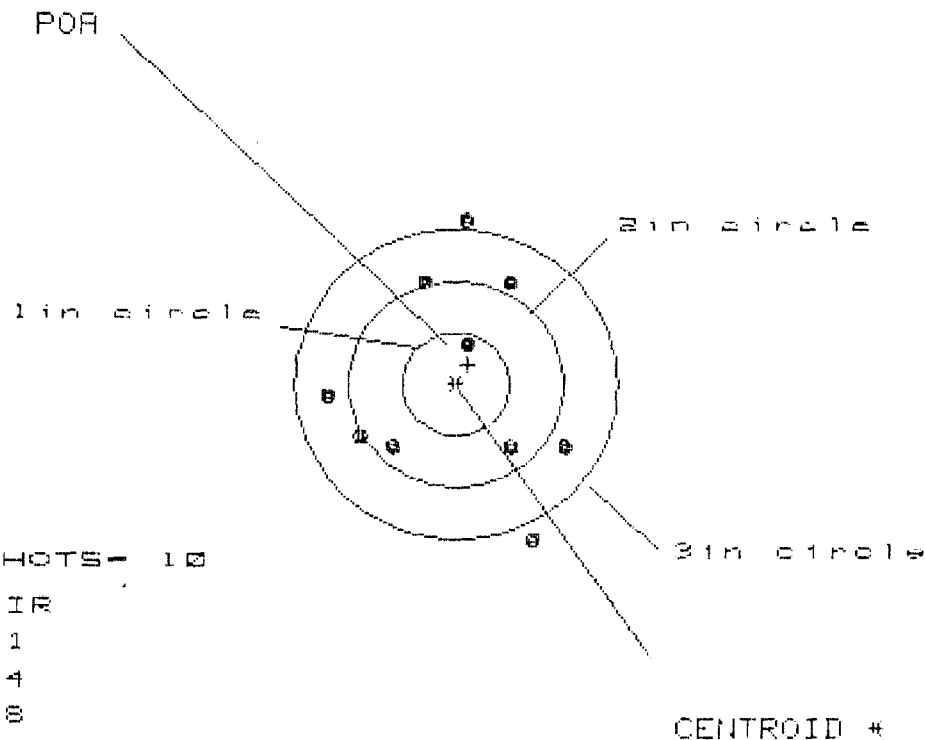
GS= 3.534

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.113	1.190	.661
MINIMUM X	-1.430	-1.353	-1.204
MAXIMUM Y	2.090	1.086	.938
MINIMUM Y	-1.420	-1.188	-.938
CENTROID X	-.211	-.288	-.437
CENTROID Y	.095	-.137	.011
POA TO CENTROID in.	.231	.319	.437
MIN RADIUS	.437	.419	.555
MEAN RADIUS	1.039	.894	.791
MAX RADIUS	2.204	1.682	1.215
HORIZONTAL SPREAD	2.543	2.543	1.865
VERTICAL SPREAD	3.510	2.274	1.876
EXTREME SPREAD	3.534	2.954	1.878
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

25 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CG649001

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS= 2.170

VS= 3.106

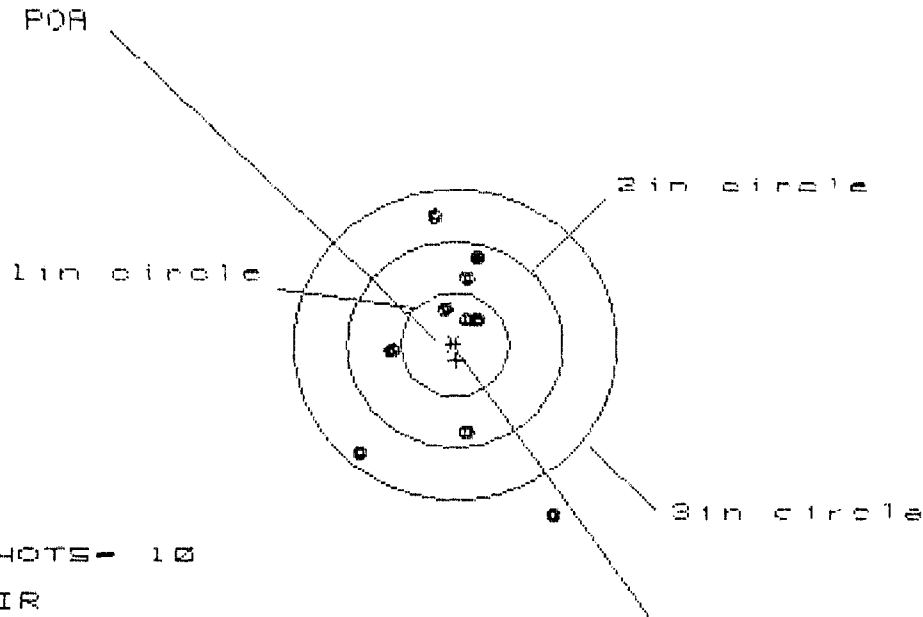
GS= 3.177

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.957	1.041	1.062
MINIMUM X	:	-1.213	-1.129	-1.108
MAXIMUM Y	:	1.612	1.446	.998
MINIMUM Y	:	-1.494	-.798	-.617
CENTROID X	:	-.107	-.191	-.212
CENTROID Y	:	-.192	-.026	-.207
POA TO CENTROID in.	:	.220	.193	.297
MIN RADIUS	:	.390	.303	.453
MEAN RADIUS	:	1.085	1.004	.943
MAX RADIUS	:	1.674	1.456	1.229
HORIZONTAL SPREAD	:	2.170	2.170	2.170
VERTICAL SPREAD	:	3.106	2.244	1.615
EXTREME SPREAD	:	3.177	2.406	2.239
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	8		

25 Nov 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 9

HG= 1.797

VS= 2.973

GS= 3.145

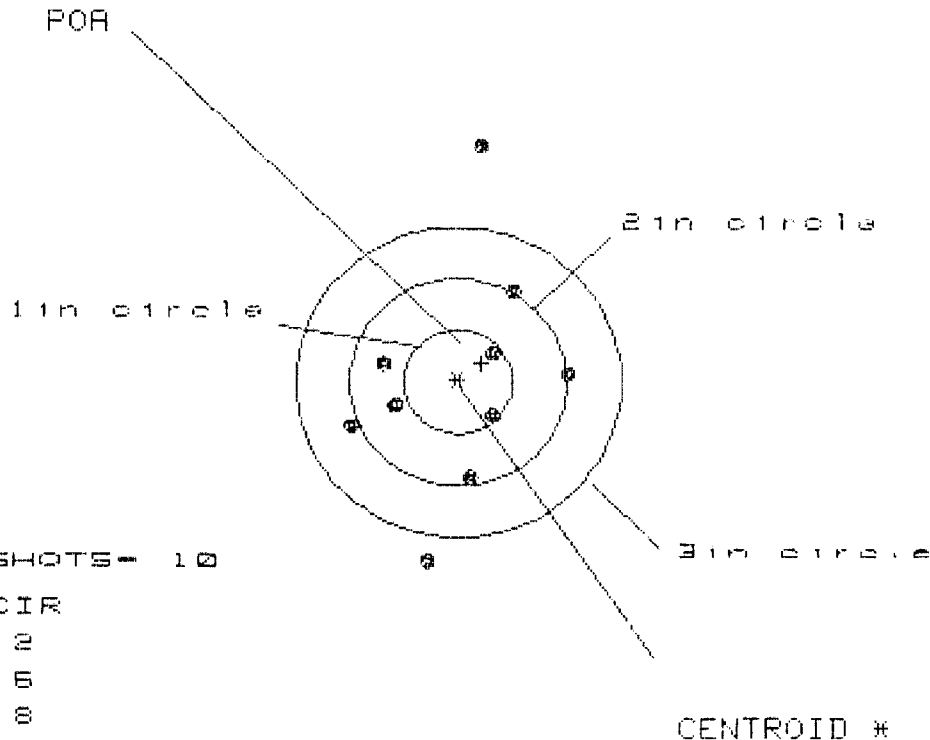
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.880	.353	.251
MINIMUM X	:	-.917	-.819	-.595
MAXIMUM Y	:	1.285	1.098	.948
MINIMUM Y	:	-1.688	-1.199	-1.213
CENTROID X	:	-.011	-.109	-.007
CENTROID Y	:	.151	.338	.488
POA TO CENTROID in.	:	.151	.356	.488
MIN RADIUS	:	.215	.176	.069
MEAN RADIUS	:	.856	.689	.540
MAX RADIUS	:	1.904	1.452	1.222
HORIZONTAL SPREAD	:	1.797	1.172	.846
VERTICAL SPREAD	:	2.973	2.297	2.161
EXTREME SPREAD	:	3.145	2.423	2.181
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

25 Nov 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS= 2.039

VS= 4.002

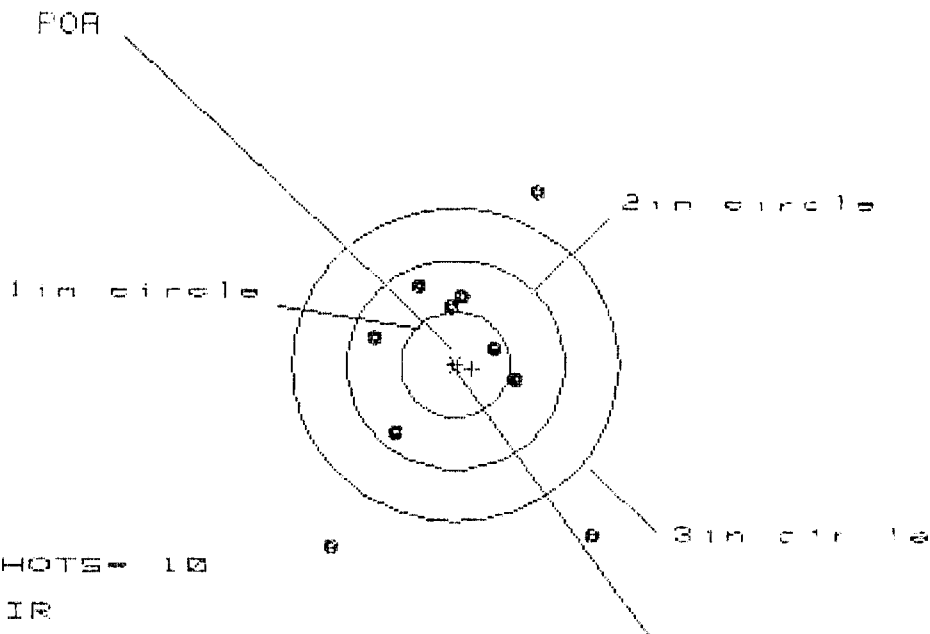
GS= 4.036

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.047	1.071	1.037
MINIMUM X	:	-0.992	-0.968	-1.002
MAXIMUM Y	:	2.294	1.111	.929
MINIMUM Y	:	-1.708	-1.453	-.812
CENTROID X	:	-.215	-.239	-.205
CENTROID Y	:	-.179	-.434	-.252
POA TO CENTROID in.	:	.280	.496	.325
MIN RADIUS	:	.393	.343	.389
MEAN RADIUS	:	1.020	.855	.765
MAX RADIUS	:	2.305	1.479	1.065
HORIZONTAL SPREAD	:	2.039	2.039	2.039
VERTICAL SPREAD	:	4.002	2.564	1.741
EXTREME SPREAD	:	4.036	2.686	2.095
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

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FILE: /PATTERNING/CENTERFIRE_PATT/06649001

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 1

2in = 7

3in = 7

HS= 2.430

VS= 3.439

GS= 3.954

CENTROID +

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.247
MINIMUM X	-1.183
MAXIMUM Y	1.682
MINIMUM Y	-1.757
CENTROID X	-0.154
CENTROID Y	.044
POA TO CENTROID in.	.160
MIN RADIUS	.413
MEAN RADIUS	1.082
MAX RADIUS	2.119
HORIZONTAL SPREAD	2.430
VERTICAL SPREAD	3.439
EXTREME SPREAD	3.954
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	7
NUMBER IN THREE INCH CIRCLE =	7