

FORM

UPC



0 47700 25716 7

C6649107

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 700 TM M24

SERIAL NO.

C6649107

ORDER NO.

5716

20

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



5716 C6649107

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 # C6649107

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10 1	91	RW
600	Proof	10 1	91	RW
607	Check Headspace	10 1	91	RW
610	Dis-assemble Gun	10 1	91	RW
612	Magnaflux Barrel Action		OCT 10 1991	KR
	Magnaflux Bolt		OCT 10 1991	KR
615	Rollmark Caliber		OCT 10 1991	JS
617	Drill and Tap Sight Holes		OCT 10 1991	LB
618	Polish Barrel		10/13/91	WB
620	Apply Coatings (Barrel Action)		11/2/91	LB
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/11/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/11/91	RW
	C) Inspect Ejector Hole for Chamfer		11/11/91	RW
	D) Oil Firing Pin Ass'y		11/11/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		12-4-91	JS

op. #	BARBER MEM24 0064894	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5	5	5	12-4-91	RY
	G) Safety Off Force	2	2	2	2	2	12-4-91	RY
	H) Trigger Pull Test & Retainability						12-4-91	RY
	I) Firing Pin Indent	.0205	.0205	.0205	.0205	.0205	12-4-91	RY
	J) Assemble Stock						12/5/91	RW
	K) Assemble Swivel Studs						12-4-91	Ac
	L) Attach Front and Rear Sight Assemblies						12/5/91	RW
	M) Iron Sight Alignment						12/5/91	RW
	N) Detach Front & Rear Sights & place in numbered container						12/5/91	RW
	O) Attach Scope to Rifle						12/5/91	RW
	P) Detach & Attach Scope 20 Times						12/5/91	RW
640	Gallery Target & Test						12-5-91	AC
	A) Time						12-5-91	AC
	B) Malfunctions						12-5-91	AC
	C) Pierced Primers						12-5-91	AC
	D) Optical Clarity of Scope						12-5-91	AC
645	Inspect for Live Ammo						12-5-91	AC
655	Final Inspection							
	A) Headspace						12-7-91	AC
	B) Trigger Pull	2.51	2.45	2.23	2.20	2.58	12-7-91	D/H
	C) Function						12-7-91	AC
660	Pack						12-20-91	RV

SWS TRIGGER PULL TESTAVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6649107DATE 12-4-91TESTER SP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.56	2.55	2.51	2.51	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.52	2.38	2.39	2.45	
PULL #3	2.53	2.53	2.44	2.23	
PULL #4	2.59	2.34	2.53	2.20	
PULL #5	2.52	2.55	2.51	2.58	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.24	3.52		
PULL #2	3.49	3.46		
PULL #3	3.39	3.44		
PULL #4	3.49	3.52		
PULL #5	3.49	3.52		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.21	4.38		4.44
PULL #2	4.25	4.54		4.52
PULL #3	4.29	4.38		4.52
PULL #4	4.43	4.38		4.27
PULL #5	4.56	4.53		4.38
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
 FOR RIFLE # C6649107
 5 Dec 1991

CENTROIDAL DISTANCES

0 TO	1	.407039
1 TO	2	.635938
1 TO	3	.235136
1 TO	4	.004
1 TO	5	.362609

34 ³ <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.262
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0668
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .27038

THE AVERAGE FOR THIS RIFLE IS: 1.027

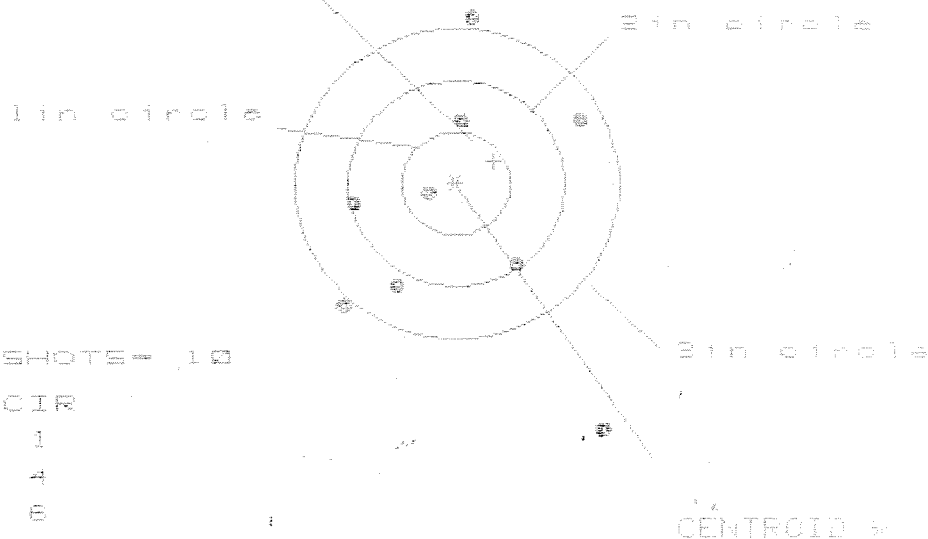
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FILE:/PATTERNING/CENTERFIRE_PATT/08649187

CENTERFIRE PATTERNS

1

FOR



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 6

HS= 2.428

VS= 5.318

GS= 5.615

CENTROID

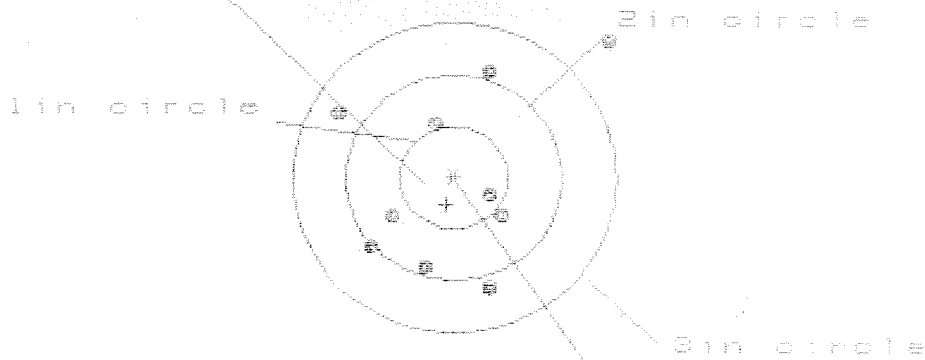
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.342	1.291	1.259
MINIMUM X	-1.088	-1.137	-1.975
MAXIMUM Y	2.892	1.897	1.634
MINIMUM Y	-2.426	-2.105	-1.170
CENTROID X	-0.345	-0.294	-0.456
CENTROID Y	-0.216	-0.537	-0.274
FOR TO CENTROID in.	.407	.612	.532
1 in RADIUS	.237	.358	.114
2 in RADIUS	1.414	1.238	1.034
3 in RADIUS	2.928	2.470	1.653
HORIZONTAL SPREAD	2.428	2.428	2.234
VERTICAL SPREAD	5.318	4.002	2.804
DIAG SPREAD	5.615	4.179	3.050
SHOTS IN ONE INCH CIRCLE	=	1	
SHOTS IN TWO INCH CIRCLE	=	4	
SHOTS IN THREE INCH CIRCLE	=	6	

Oct 1991

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CENTERFIRE PATTERNS # 2

POA



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 2.427

VS= 2.412

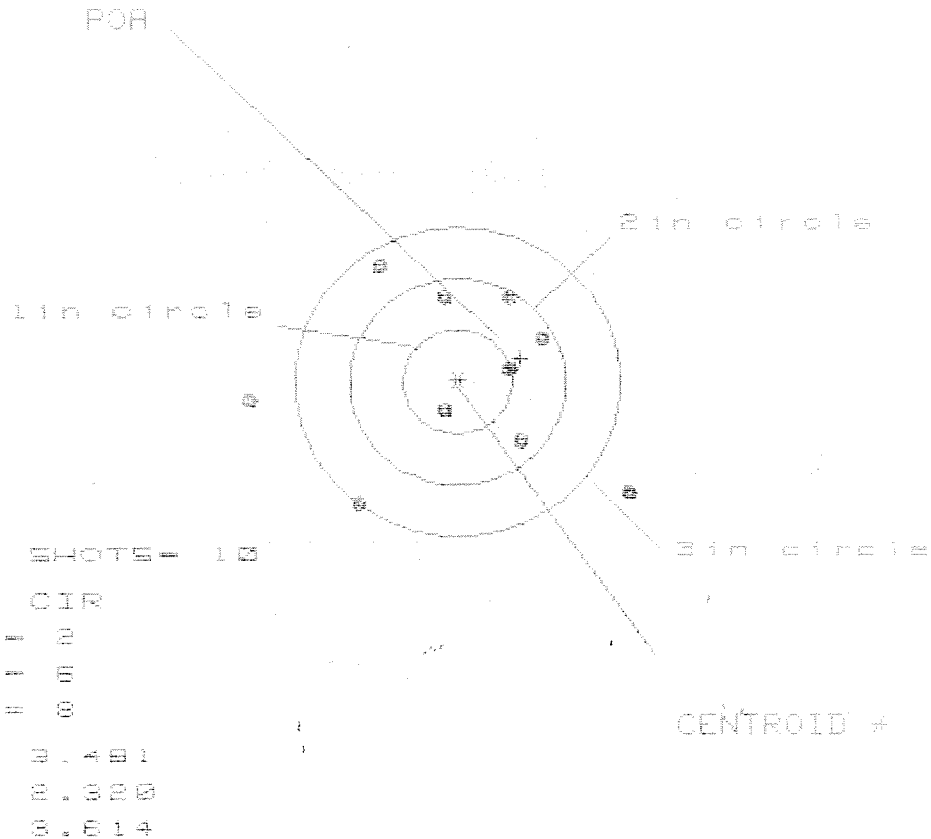
GS= 2.937

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.399	.631	.522
MINIMUM X	-1.028	-.872	-.597
MAXIMUM Y	1.369	1.137	1.235
MINIMUM Y	-1.043	-.891	-.793
CENTROID X	.071	-.085	.025
CENTROID Y	.265	.113	.015
POA TO CENTROID in.	.274	.141	.029
MIN RADIUS	.373	.467	.364
MEAN RADIUS	.948	.799	.731
VAR RADIUS	1.957	1.233	1.288
HORIZONTAL SPREAD	2.427	1.503	1.218
VERTICAL SPREAD	2.412	2.029	2.028
EXTREME SPREAD	2.937	2.134	2.028
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

5 Dec 1991

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CENTERFIRE PATTERNS # 3

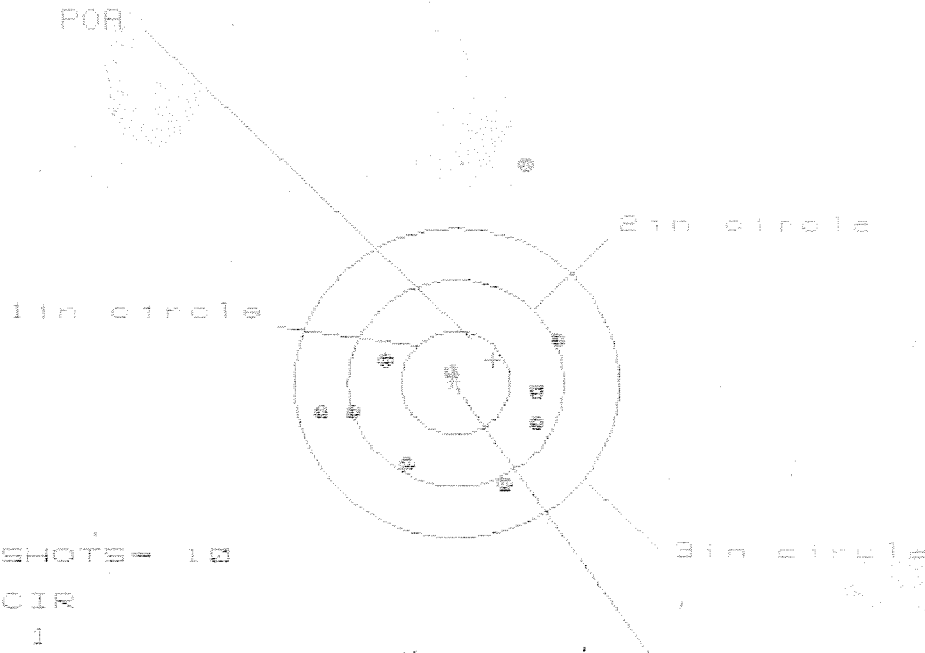


PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.537
MINIMUM X	-1.944
MAXIMUM Y	1.155
MINIMUM Y	-1.165
CENTROID X	-0.580
CENTROID Y	-0.224
POA TO CENTROID in.	0.622
MIN RADIUS	0.345
MEAN RADIUS	1.097
MAX RADIUS	1.949
HORIZONTAL SPREAD	3.481
VERTICAL SPREAD	2.320
EXTREME SPREAD	3.614
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	8

5 Dec 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 1

2in = 7

3in = 9

HS= 2.175

VS= 3.033

GS= 3.066

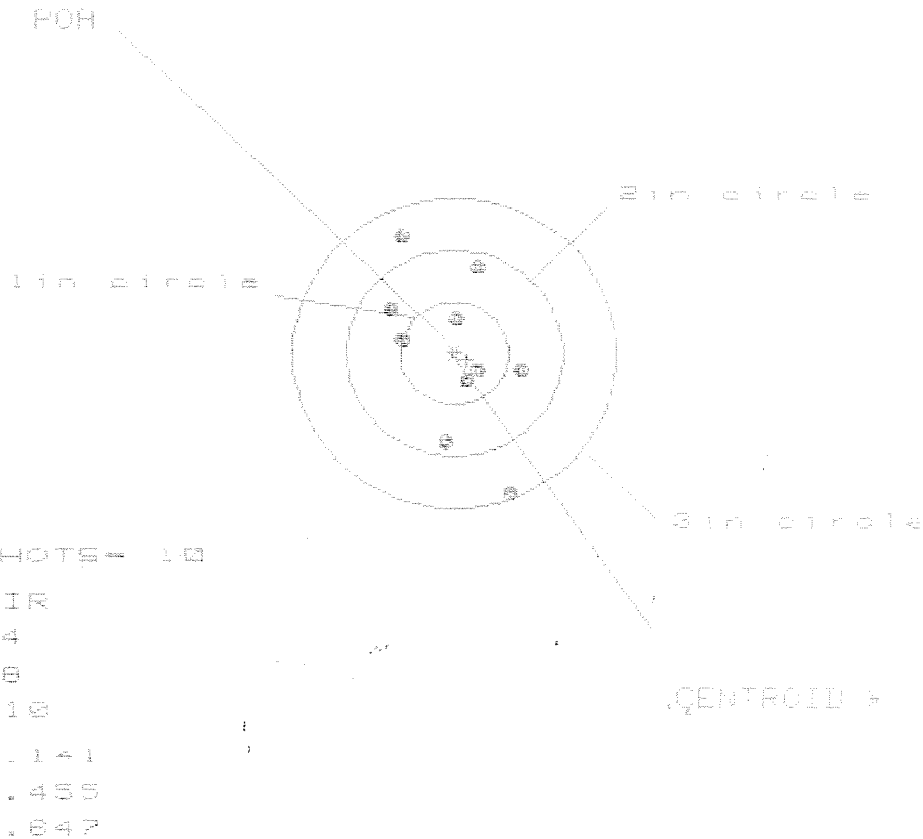
CENTROID +

PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	.898
MINIMUM X	-1.277
MAXIMUM Y	2.085
MINIMUM Y	-.948
CENTROID X	-.345
CENTROID Y	-.220
POB TO CENTROID in.	.489
MIN RADIUS	.097
MEAN RADIUS	.976
MAX RADIUS	2.172
HORIZONTAL SPREAD	2.175
VERTICAL SPREAD	3.033
EXTREME SPREAD	3.066
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	7
NUMBER IN THREE INCH CIRCLE =	9

5 Oct 1991

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CENTERFIRE PATTERNS # 5



PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.592	.648	.553
MINIMUM X	-.549	-.493	-.548
MAXIMUM Y	1.097	.947	.777
MINIMUM Y	-1.358	-1.025	-1.407
CENTROID X	-.111	-.167	-.211
CENTROID Y	.061	.211	.097
POH TO CENTROID in.	.127	.269	.176
MIN RADIUS	.265	.242	.227
MEAN RADIUS	.706	.617	.557
MAX RADIUS	1.446	1.042	.916
HORIZONTAL SPREAD	1.141	1.141	1.141
VERTICAL SPREAD	2.455	1.972	1.972
EXTREME SPREAD	2.647	2.005	2.005
CUMBER IN ONE INCH CIRCLE	=	4	
CUMBER IN TWO INCH CIRCLE	=	6	
CUMBER IN THREE INCH CIRCLE	=	10	