

FORM

UPC



0 47700 25716 7

C6649206

*INCLUDES 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 700TM M24**SERIAL NO.****C6649206****ORDER NO.****5716**

20

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



5716 C6649206

ORDER 5716MODEL 700TM M24**UPC**

0 47700 25716 7

ORDER 5716MODEL 700TM M24**UPC**

0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649206

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	LS
617	Drill and Tap Sight Holes		OCT 10 1991	LB
618	Polish Barrel		10/15/91	WB
620	Apply Coatings (Barrel Action)		11/2/91	DA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		12/5/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/5/91	KA
	C) Inspect Ejector Hole for Chamfer		12/5/91	KA
	D) Oil Firing Pin Ass'y		12/5/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		12-6-91	JH

Op. #	DESCRIPTION	READINGS					DATE	INITIALS
625 cont.	F) Safety On Force	4	4	4			12-6-91	JK
	G) Safety Off Force	3	3	3			12-6-91	JK
	H) Trigger Pull Test & Retainability						12-6-91	JK
	I) Firing Pin Indent	.020	.020	.0205			12-6-91	JK
	J) Assemble Stock						12/6/91	JK
	K) Assemble Swivel Studs						12-11-91	K
	L) Attach Front and Rear Sight Assemblies						12/6/91	JK
	M) Iron Sight Alignment						12/6/91	JK
	N) Detach Front & Rear Sights & place in numbered container						12/6/91	JK
	O) Attach Scope to Rifle						12/6/91	JK
	P) Detach & Attach Scope 20 Times						12/6/91	JK
640	Gallery Target & Test						12/9/91	JK
	A) Time						12/9/91	JK
	B) Malfunctions						12/9/91	JK
	C) Pierced Primers						12/9/91	JK
	D) Optical Clarity of Scope						12/9/91	JK
645	Inspect for Live Ammo						12/9/91	JK
655	Final Inspection							
	A) Headspace						12-11-91	K
	B) Trigger Pull	2.27	2.29	2.28	2.24	2.27	12-11-91	JK
	C) Function						12-11-91	K
660	Pack							

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6649206

DATE 12-6-91

TESTER JD

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.64	2.57	2.60	2.27	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.48	2.66	2.58	2.29	
PULL #3	2.60	2.63	2.44	2.28	
PULL #4	2.65	2.64	2.61	2.24	
PULL #5	2.59	2.64	2.65	2.27	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.33	3.40		
PULL #2	3.33	3.40		
PULL #3	3.35	3.41		
PULL #4	3.41	3.38		
PULL #5	3.35	3.44		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.44	4.45		4.39
PULL #2	4.31	4.31		4.37
PULL #3	4.45	4.33		4.41
PULL #4	4.35	4.44		4.45
PULL #5	4.33	4.39		4.34
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649206
9 Dec 1991

CENTROIDAL DISTANCES

0 TO 1	.188905
1 TO 2	.162432
1 TO 3	.0320156
1 TO 4	.157258
1 TO 5	.13369

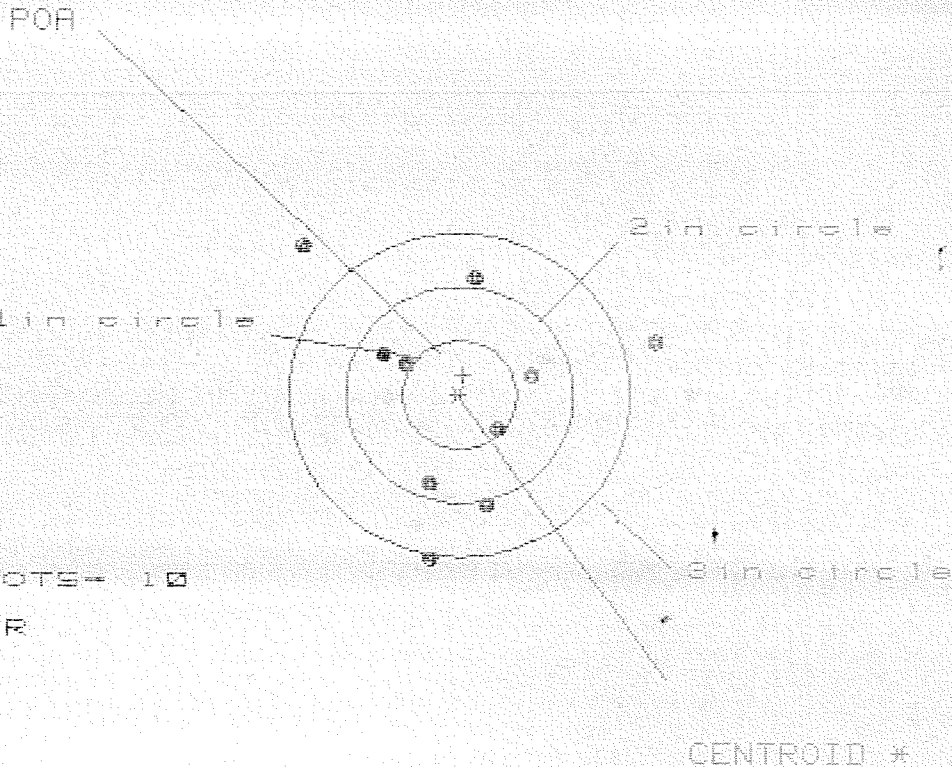
←----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0604
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2014
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .210262
THE AMP FOR THIS RIFLE IS: .9766

9 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8B49206

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 7

HS= 3.073

VS= 2.936

GS= 3.203

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.688	1.534	.676
MINIMUM X	-1.385	-.799	-.608
MAXIMUM Y	1.375	1.207	1.285
MINIMUM Y	-1.560	-1.408	-1.330
CENTROID X	-.033	.121	-.070
CENTROID Y	-.186	-.338	-.416
POA TO CENTROID in.	.188	.359	.422
MIN RADIUS	.464	.247	.381
MEAN RADIUS	1.064	.944	.845
MAX RADIUS	1.952	1.656	1.355
HORIZONTAL SPREAD	3.073	2.333	1.284
VERTICAL SPREAD	2.936	2.615	2.615
EXTREME SPREAD	3.203	2.840	2.649
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

9 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08849206

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.543

VS= 2.382

GS= 2.546

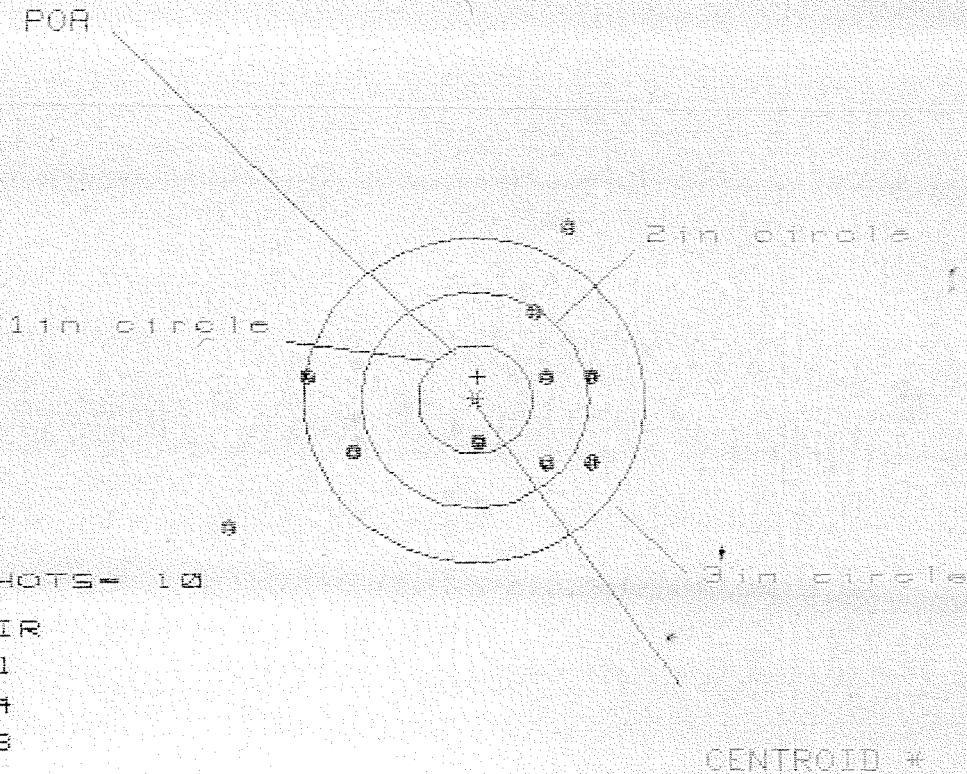
CENTROID #

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.558	.462	.322
MINIMUM X	-.985	-.812	-.755
MAXIMUM Y	1.265	1.252	1.363
MINIMUM Y	-1.117	-1.130	-.973
CENTROID X	-.133	-.306	-.363
CENTROID Y	-.314	-.301	-.458
POA TO CENTROID in.	.341	.429	.584
MIN RADIUS	.410	.243	.294
MEAN RADIUS	.938	.828	.755
MAX RADIUS	1.562	1.335	1.371
HORIZONTAL SPREAD	2.543	1.274	1.077
VERTICAL SPREAD	2.382	2.382	2.336
EXTREME SPREAD	2.546	2.418	2.336
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	5	
NUMBER IN THREE INCH CIRCLE	=	9	

5 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08643206

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 1

2in = 4

3in = 8

HS = 3.206

VS = 2.771

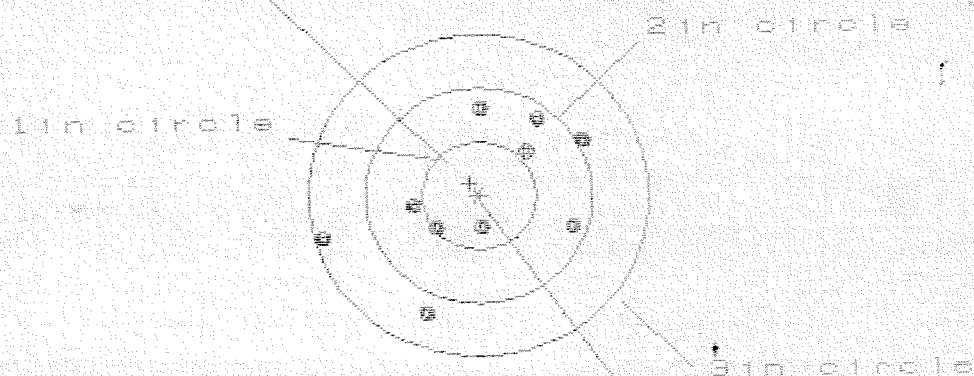
GS = 4.041

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.065
MINIMUM X	-2.141
MAXIMUM Y	1.630
MINIMUM Y	-1.141
CENTROID X	-.025
CENTROID Y	-.217
POR TO CENTROID in.	.219
MIN RADIUS	.364
MEAN RADIUS	1.211
MAX RADIUS	2.426
HORIZONTAL SPREAD	3.206
VERTICAL SPREAD	2.771
EXTREME SPREAD	4.041
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	8

FILE:/PATTERNING/CENTERFIRE PATT/06649206

CENTERFIRE PATTERNS # 5

DE
C
P



OF SHOTS = 10

INDEX

23-00000-5

015-12

45-269

$$V_E = 1.335$$

03 2.435

CENTROID #

PAPER

5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.918	.768	.686
MINIMUM X	-1.350	-.689	-.771
MAXIMUM Y	.853	.807	.667
MINIMUM Y	-1.077	-1.123	-.504
CENTROID X	.079	.229	.311
CENTROID Y	-.113	-.067	.073
POA TO CENTROID in.	.138	.239	.319
MIN RADIUS	.319	.387	.242
MEAN RADIUS	.817	.741	.651
MAX RADIUS	1.412	1.299	.803
HORIZONTAL SPREAD	2.268	1.457	1.457
VERTICAL SPREAD	1.930	1.930	1.171
EXTREME SPREAD	2.435	2.104	1.544
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	7	
NUMBER IN THREE INCH CIRCLE	=	10	