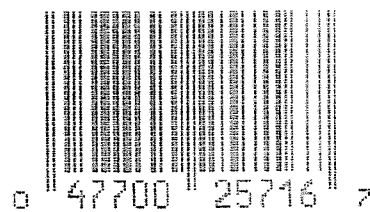


FOREN

UPC



06665707

*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 700 TM M24

SERIAL NO.

C6665707

ORDER NO.

5716

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

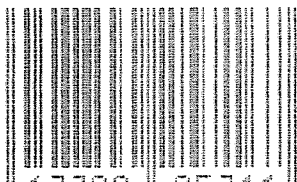


5716 C6665707

ORDER 5716

MODEL 700 TM M24

UPC

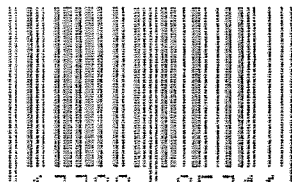


0 47700 25716 7

ORDER 5716

MODEL 700 TM M24

UPC



0 47700 25716 7

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF	Repaired 10/29/91 Adjusted Bolt Stop Release	RW
TEST ✓		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

MOD. _____ GA. CAL. _____ GUN # 5707

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
RW	1st	bolt Release stick	AT
	2nd		
	3rd		
	4th		

FUNCTION RD 6654 Rev 1

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6665707

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	4 1991	KR
	Magnaflux Bolt	OCT	4 1991	KR
615	Rollmark Caliber	OCT	4 1991	LS
617	Drill and Tap Sight Holes	OCT	4 1991	LB
618	Polish Barrel		10/8/91	WB
620	Apply Coatings (Barrel Action)		10-22-91	DA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/22/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/22/91	RW
	C) Inspect Ejector Hole for Chamfer		10/22/91	RW
	D) Oil Firing Pin Ass'y		10/22/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/25/91	JS

op. #	BARBER - M24 0101573	READINGS					DATE	INIT
	OP. NAME							
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2			10/28/91	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			10/28/91	WB
	H) Trigger Pull Test & Retainability						10/25/91	JH
	I) Firing Pin Indent	.021	.020	.0205			10/28/91	WB
	J) Assemble Stock						10/28/91	RW
	K) Assemble Swivel Studs						10-30-91	K
	L) Attach Front and Rear Sight Assemblies						10/28/91	RW
	M) Iron Sight Alignment						10/28/91	RW
	N) Detach Front & Rear Sights & place in numbered container						10/28/91	RW
	O) Attach Scope to Rifle						10/28/91	RW
		P) Detach & Attach Scope 20 Times						10/28/91
640	Gallery Target & Test						10/28/91	K- T
	A) Time							4T
	B) Malfunctions							1CT
	C) Pierced Primers							1CT
	D) Optical Clarity of Scope							1CT
645	Inspect for Live Ammo						10/28/91	1CT
655	Final Inspection							
	A) Headspace						10-30-91	K
	B) Trigger Pull	2.47	2.52	2.28	2.52	2.28	10-30-91	JH
	C) Function						10-30-91	K
660	Pack						12-18-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO C-6665707

DATE 10/26/91

TESTER [Signature]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.20	2.33	2.40	2.47	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.28	2.25	2.38	2.52	
PULL #3	2.35	2.36	2.25	2.28	
PULL #4	2.36	2.42	2.42	2.52	
PULL #5	2.42	2.38	2.44	2.28	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.42		
PULL #2	3.36	3.26		
PULL #3	3.22	3.55		
PULL #4	3.43	3.49		
PULL #5	3.48	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	4.25	4.56		4.55
PULL #2	4.55	4.48		4.53
PULL #3	4.56	4.53		4.53
PULL #4	4.47	4.60		4.50
PULL #5	4.58	4.59		4.55
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665707
29 Oct 1991

CENTROIDAL DISTANCES

0 TO	1	.356001
1 TO	2	.196825
1 TO	3	.403094
1 TO	4	.379415
1 TO	5	.285491

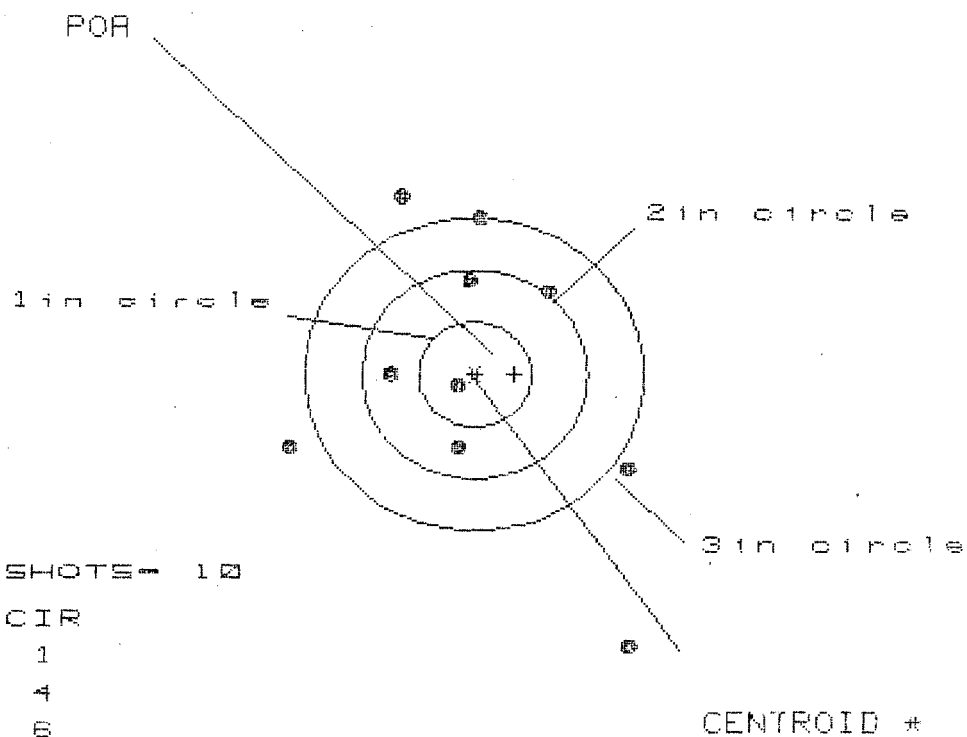
124 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1138
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.032
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .118214
THE AMR FOR THIS RIFLE IS: 1.083

29 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665707

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 6

HS= 3.004

VS= 4.238

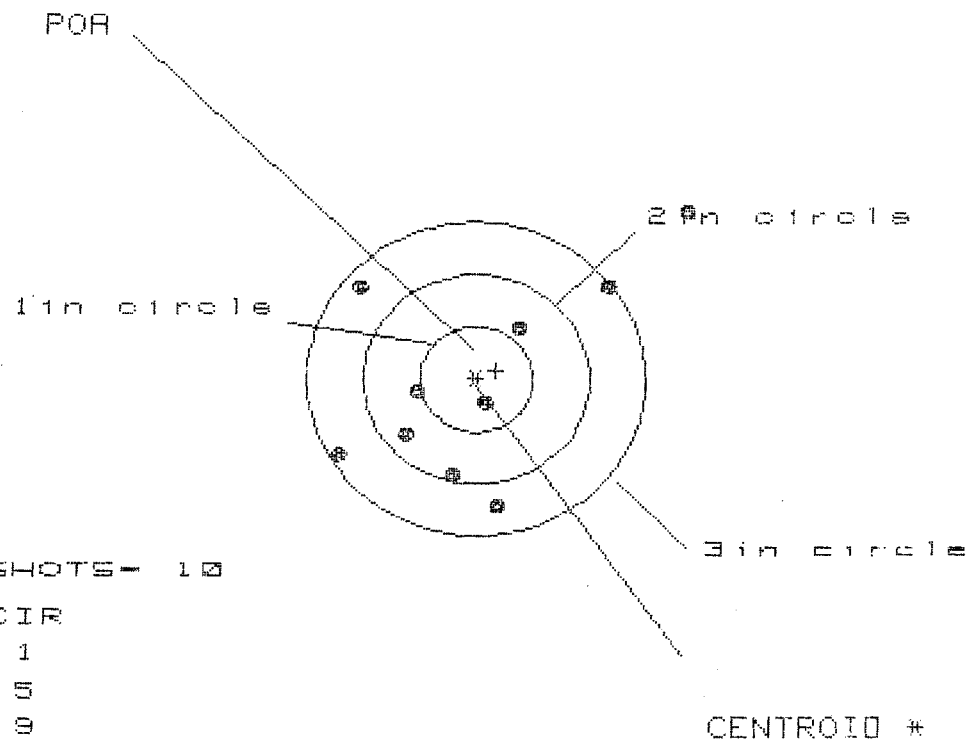
GS= 4.668

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.348	1.497	1.308
MINIMUM X	-1.656	-1.507	-1.802
MAXIMUM Y	1.677	1.392	1.265
MINIMUM Y	-2.561	-1.137	-1.264
CENTROID X	-.356	-.505	-.316
CENTROID Y	-.001	.284	.410
POA TO CENTROID in.	.356	.579	.518
MIN RADIUS	.214	.379	.485
MEAN RADIUS	1.320	1.112	1.015
MAX RADIUS	2.889	1.880	1.819
HORIZONTAL SPREAD	3.004	3.004	2.110
VERTICAL SPREAD	4.238	2.529	2.529
EXTREME SPREAD	4.669	3.207	3.207
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	6		

29 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08665707

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 3.015

VS= 2.752

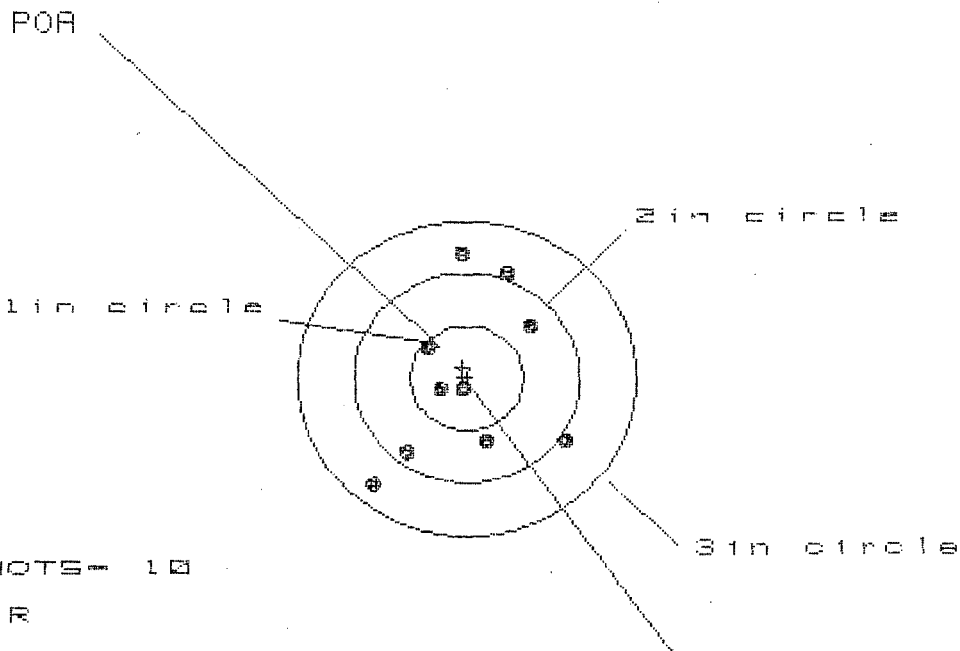
GS= 3.795

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.837	1.383	.740
MINIMUM X	:	-1.178	-.974	-.801
MAXIMUM Y	:	1.552	1.054	1.183
MINIMUM Y	:	-1.200	-1.027	-.898
CENTROID X	:	-.178	-.382	-.555
CENTROID Y	:	-.085	-.258	-.387
POA TO CENTROID in.	:	.197	.461	.677
MIN RADIUS	:	.249	.324	.221
MEAN RADIUS	:	1.099	.898	.755
MAX RADIUS	:	2.405	1.728	1.359
HORIZONTAL SPREAD	:	3.015	2.357	1.541
VERTICAL SPREAD	:	2.752	2.081	2.081
EXTREME SPREAD	:	3.795	2.857	2.394
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

29 Oct 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 10

HS= 1.657

VS= 2.227

GS= 2.371

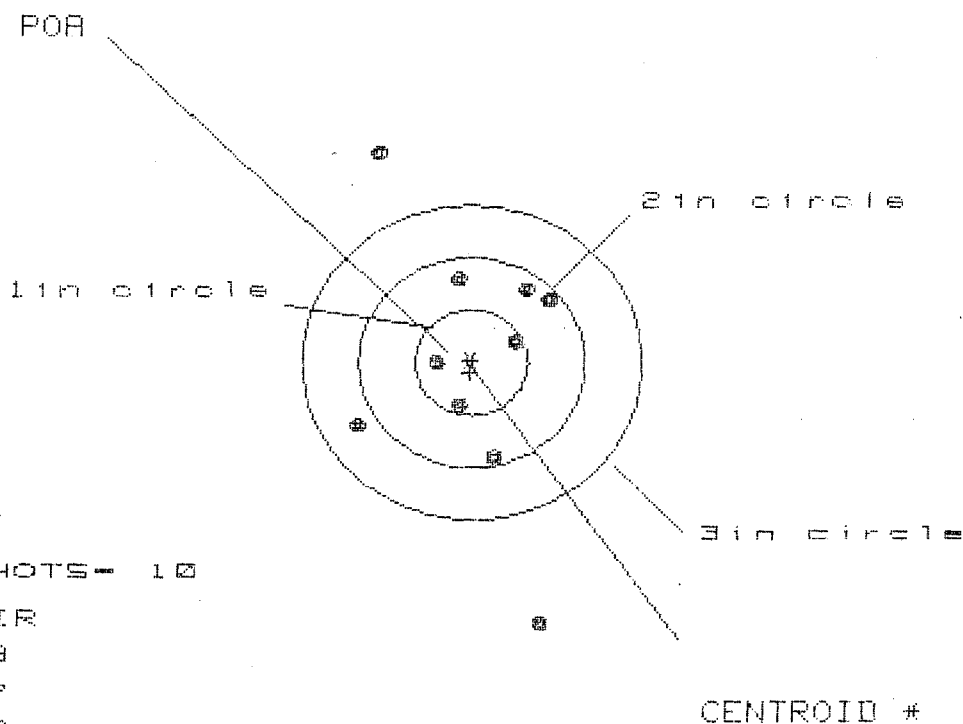
CENTROID #

PATTERN #	3	3	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.836	.745	.733
MINIMUM X	-.821	-.648	-.660
MAXIMUM Y	1.245	1.136	1.069
MINIMUM Y	-.982	-.820	-.678
CENTROID X	.035	.126	.138
CENTROID Y	-.099	.010	-.132
POA TO CENTROID in.	.105	.126	.191
MIN RADIUS	.105	.244	.155
MEAN RADIUS	.767	.726	.652
MAX RADIUS	1.280	1.140	1.109
HORIZONTAL SPREAD	1.657	1.393	1.393
VERTICAL SPREAD	2.227	1.956	1.748
EXTREME SPREAD	2.371	2.032	1.991
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

29 Oct 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1in = 3

2in = 7

3in = 8

HS = 1.633

VS = 4.446

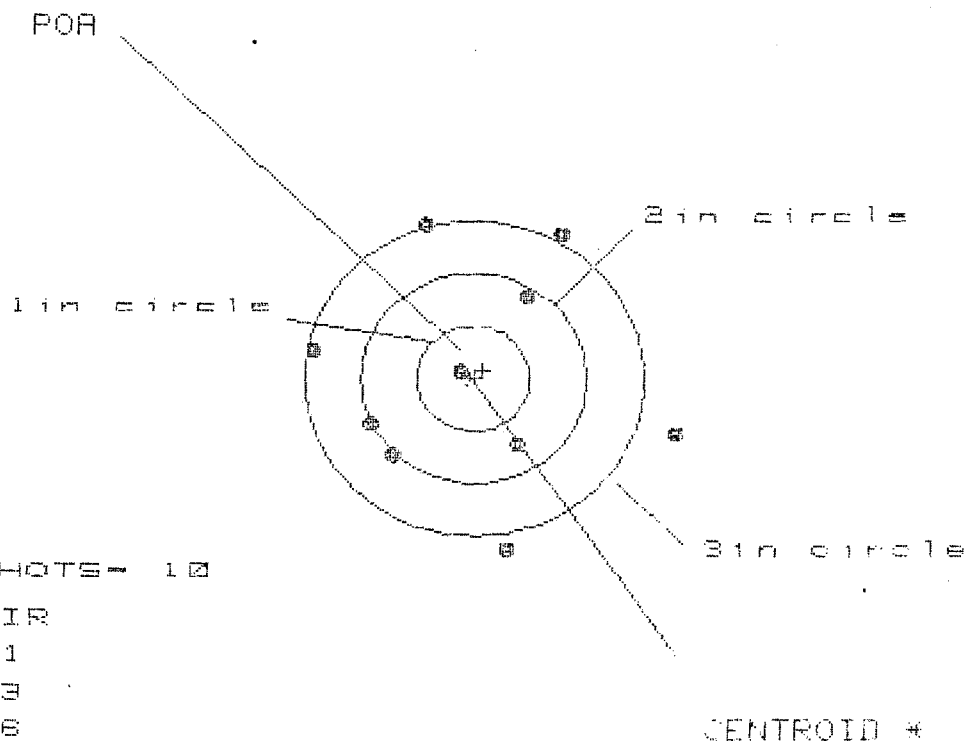
GS = 4.656

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.653	.719	.629
MINIMUM X	:	-.980	-.914	-1.004
MAXIMUM Y	:	1.973	1.698	.783
MINIMUM Y	:	-2.473	-1.185	-.972
CENTROID X	:	.010	-.056	.034
CENTROID Y	:	.099	.374	.161
POA TO CENTROID in.	:	.099	.378	.165
MIN RADIUS	:	.320	.367	.348
MEAN RADIUS	:	1.048	.872	.723
MAX RADIUS	:	2.544	1.845	1.222
HORIZONTAL SPREAD	:	1.633	1.633	1.633
VERTICAL SPREAD	:	4.446	2.883	1.755
EXTREME SPREAD	:	4.656	3.037	2.046
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

29 Oct 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 6

HS= 3.175

VS= 3.138

GS= 3.282

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.756	.983	1.041
MINIMUM X	-1.419	-1.224	-1.166
MAXIMUM Y	1.509	1.452	1.241
MINIMUM Y	-1.629	-1.686	1.026
CENTROID X	-.080	-.275	-.333
CENTROID Y	-.074	-.017	.194
POA TO CENTROID in.	.109	.276	.385
MIN RADIUS	.097	.100	.281
MEAN RADIUS	1.183	1.098	1.030
MAX RADIUS	1.830	1.749	1.515
HORIZONTAL SPREAD	3.175	2.207	2.207
VERTICAL SPREAD	3.138	3.138	2.267
EXTREME SPREAD	3.282	3.209	2.611
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	6		