

FORM

UPC



0 47700 25716 7

C6665854

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™ M24**SERIAL NO.****C6665854****ORDER NO.****5716****20**

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



5716 C6665854

ORDER 5716

MODEL 700™ M24

UPC

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ORDER 5716

MODEL 700™ M24

UPC

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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6665854

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		9/24/91	KL
600	Proof		9/24/91	KL
607	Check Headspace		9/24/91	KL
610	Dis-assemble Gun		9/24/91	KL
612	Magnaflux Barrel Action	OCT 2 1991		KR
	Magnaflux Bolt	OCT 2 1991		KR
615	Rollmark Caliber	OCT 2 1991		KL
617	Drill and Tap Sight Holes	OCT 2 1991		KL
618	Polish Barrel	OCT 4 1991		KL
620	Apply Coatings (Barrel Action)		10-14-91	KL
	Apply Coating (Bolt)			KL
625	Final Assembly A) Clean inside of Bolt Assembly		10/28/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/28/91	KL
	C) Inspect Ejector Hole for Chamfer		10/28/91	KL
	D) Oil Firing Pin Ass'y		10/28/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		10/29/91	KL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			10/29/91	JY
	G) Safety Off Force	3	3	3			10/29/91	JY
	H) Trigger Pull Test & Retainability						10/29/91	JY
	I) Firing Pin Indent	0215	0215	0215			10/29/91	JY
	J) Assemble Stock						10/30/91	JY
	K) Assemble Swivel Studs						11-12-91	AK
	L) Attach Front and Rear Sight Assemblies						10/30/91	JY
	M) Iron Sight Alignment						10/30/91	JY
	N) Detach Front & Rear Sights & place in numbered container						10/30/91	JY
	O) Attach Scope to Rifle						10/30/91	JY
	P) Detach & Attach Scope 20 Times						10/30/91	JY
640	Gallery Target & Test						10-31-91	DH
	A) Time						10-31-91	DH
	B) Malfunctions						10-31-91	DH
	C) Pierced Primers						10-31-91	DH
	D) Optical Clarity of Scope						10-31-91	DH
645	Inspect for Live Ammo						10-31-91	DH
655	Final Inspection							
	A) Headspace						11-12-91	AK
	B) Trigger Pull	265	276	271	282	279	11-6-91	DH
	C) Function						11-12-91	AC
660	Pack						12-18-91	V

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6665854DATE 10/29/91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.49	2.50	2.50	265	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.48	2.44	2.55	276	
PULL #3	2.52	2.62	2.60	271	
PULL #4	2.57	2.49	2.62	282	
PULL #5	2.54	2.57	2.51	279	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.29	3.55		
PULL #2	3.57	3.62		
PULL #3	3.59	3.61		
PULL #4	3.58	3.63		
PULL #5	3.63	3.60		
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	4.19		4.46
PULL #2	4.25	4.29		4.41
PULL #3	4.36	4.22		4.43
PULL #4	4.34	4.33		4.20
PULL #5	4.37	4.43		4.35
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665854
31 Oct 1991

CENTROIDAL DISTANCES

0 TO	1	.116619
1 TO	2	.459753
1 TO	3	.231918
1 TO	4	.257109
1 TO	5	.535706

2
4
5

<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1862
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0556
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .194324

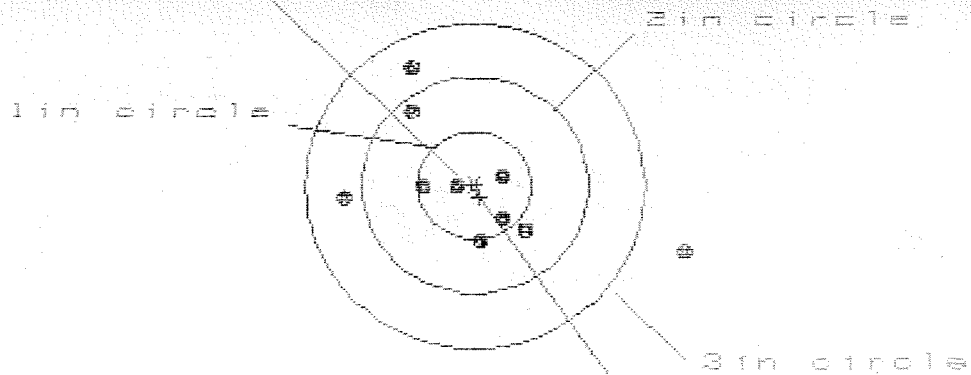
THE AMR FOR THIS RIFLE IS: .9512

31 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8665854

CENTERFIRE PATTERNS # 1

POR



OF SHOTS = 10

IN CIR

1 in = 4

2 in = 7

3 in = 9

HS = 3.025

VS = 1.651

GS = 3.063

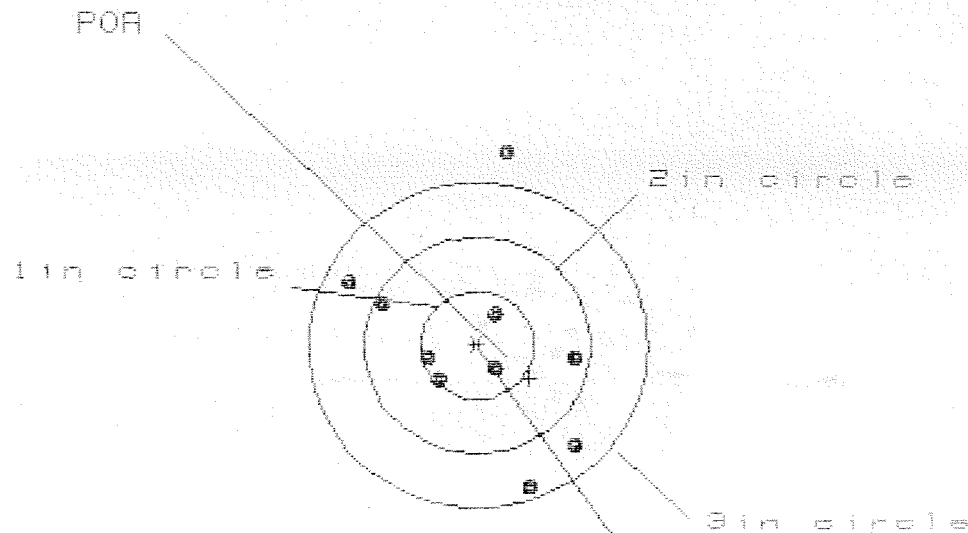
CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.827	.675	.634
MINIMUM X	:	-1.198	-.995	-1.036
MAXIMUM Y	:	1.090	1.028	.745
MINIMUM Y	:	-.561	-.572	-.444
CENTROID X	:	-.044	-.247	-.206
CENTROID Y	:	.108	.170	.042
POR TO CENTROID in.	:	.116	.300	.211
MIN RADIUS	:	.190	.063	.072
MEAN RADIUS	:	.765	.625	.553
MAX RADIUS	:	1.911	1.078	1.036
HORIZONTAL SPREAD	:	3.025	1.670	1.570
VERTICAL SPREAD	:	1.651	1.600	1.188
EXTREME SPREAD	:	3.063	1.822	1.706
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 4

2 in = 5

3 in = 9

HS= 2.003

VS= 3.159

GS= 3.166

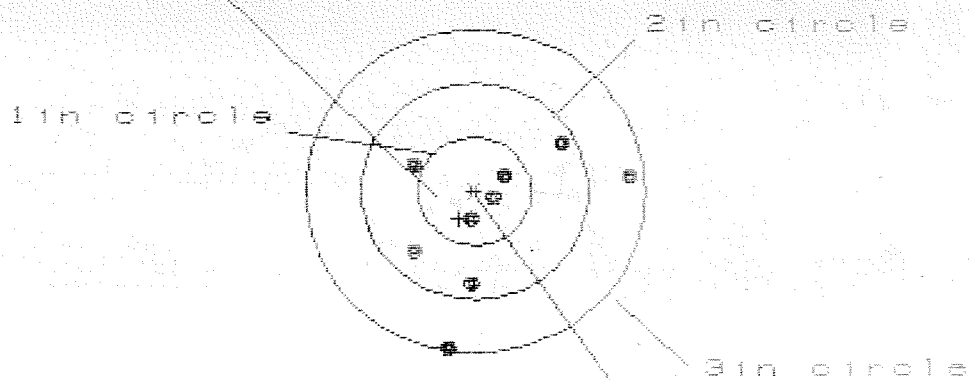
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.885	.910	.968
MINIMUM X	:	-1.118	-1.093	-1.034
MAXIMUM Y	:	1.824	.747	.605
MINIMUM Y	:	-1.335	-1.132	-.857
CENTROID X	:	-.457	-.482	-.540
CENTROID Y	:	.310	.107	.248
POA TO CENTROID in.	:	.552	.494	.595
MIN RADIUS	:	.291	.215	.316
MEAN RADIUS	:	.904	.783	.717
MAX RADIUS	:	1.838	1.324	1.294
HORIZONTAL SPREAD	:	2.003	2.003	2.003
VERTICAL SPREAD	:	3.159	1.879	1.463
EXTREME SPREAD	:	3.166	2.480	2.480
NUMBER IN ONE INCH CIRCLE =			4	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			9	

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CENTERFIRE PATTERNS # 3

POR



OF SHOTS = 10

IN CIR

1in = 3

2in = 7

3in = 9

HS = 2.513

VS = 3.657

GS = 3.769

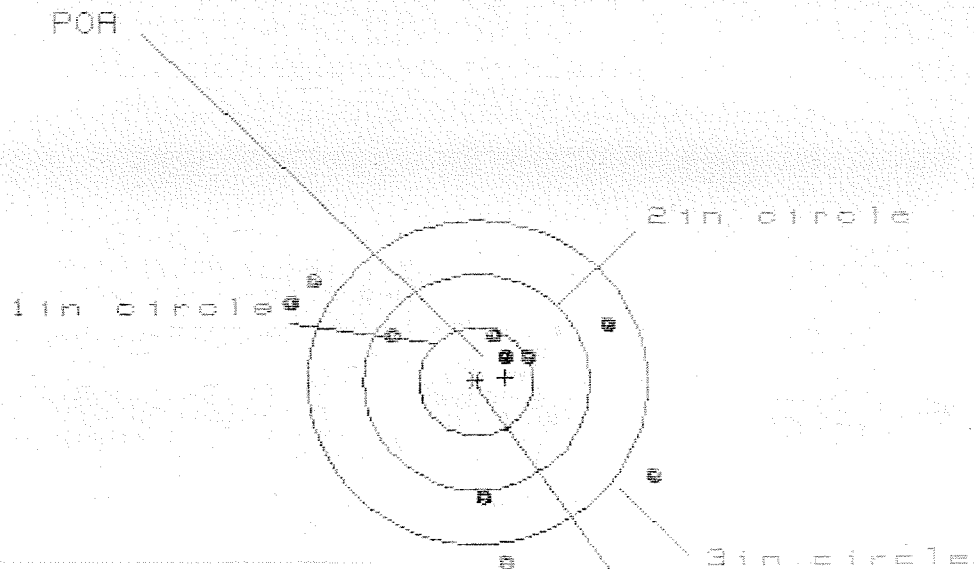
CENTROID *

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.399	1.275	1.234
MINIMUM X	:	-1.114	-1.687	-1.728
MAXIMUM Y	:	2.178	.692	.538
MINIMUM Y	:	-1.479	-1.238	-1.782
CENTROID X	:	.137	.261	.302
CENTROID Y	:	.253	.012	.166
POR TO CENTROID in.	:	.288	.261	.345
MIN RADIUS	:	.128	.200	.070
MEAN RADIUS	:	.914	.734	.639
MAX RADIUS	:	2.446	1.319	1.248
HORIZONTAL SPREAD	:	2.513	1.962	1.962
VERTICAL SPREAD	:	3.657	1.930	1.320
EXTREME SPREAD	:	3.769	2.247	2.059
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 6

HS= 3.189

VS= 2.619

GS= 3.561

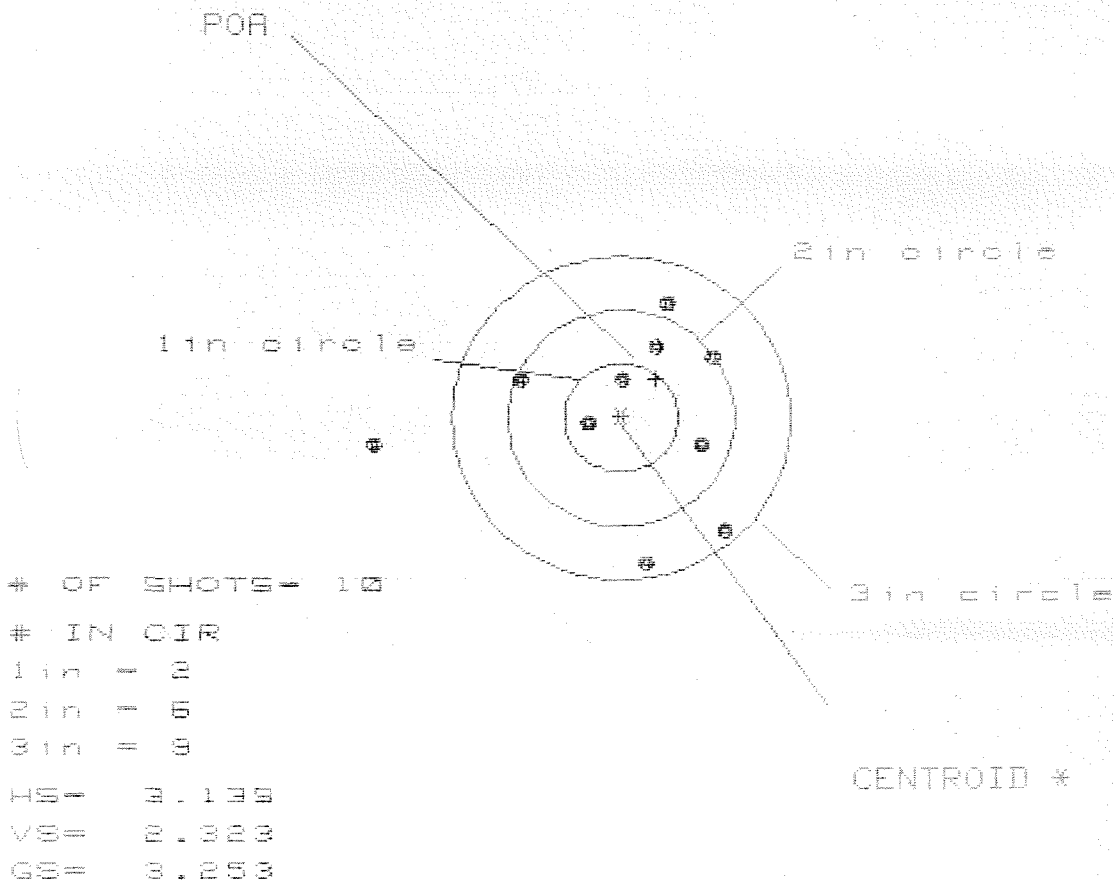
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.577	1.316	1.136
MINIMUM X	:	-1.612	-1.437	-1.458
MAXIMUM Y	:	.984	.887	.963
MINIMUM Y	:	-1.635	-1.732	-1.656
CENTROID X	:	-.257	-.432	-.252
CENTROID Y	:	-.036	.061	-.015
POA TO CENTROID in.	:	.259	.436	.253
MIN RADIUS	:	.297	.484	.279
MEAN RADIUS	:	1.151	1.079	.989
MAX RADIUS	:	1.804	1.778	1.747
HORIZONTAL SPREAD	:	3.189	2.753	2.594
VERTICAL SPREAD	:	2.619	2.619	2.619
EXTREME SPREAD	:	3.561	3.113	3.113
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	

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CENTERFIRE PATTERNS # 5



PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.904	.655	.685
MINIMUM X	:	-2.235	-1.123	-1.041
MAXIMUM Y	:	1.015	.992	.856
MINIMUM Y	:	-1.308	-1.331	-1.457
CENTROID X	:	-.310	-.061	-.143
CENTROID Y	:	-.357	-.334	-.198
POA TO CENTROID in.	:	.473	.339	.244
MIN RADIUS	:	.336	.440	.283
MEAN RADIUS	:	1.022	.864	.780
MAX RADIUS	:	2.245	1.331	1.470
HORIZONTAL SPREAD	:	3.139	1.778	1.726
VERTICAL SPREAD	:	2.323	2.323	2.323
EXTREME SPREAD	:	3.253	2.330	2.330
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	