

FORM

UPC



0 47700 25716 7

06665981

CAPACITY
INCLUDES 1 IN CHAMBER

MODEL 700 TM M24

ORDER NO.

5716

BARREL LENGTH

Remington

VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700 TM M24

SERIAL NO.

C6665981

ORDER NO.

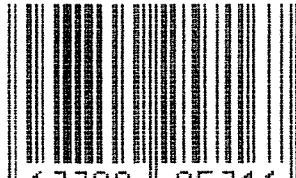
5716

20

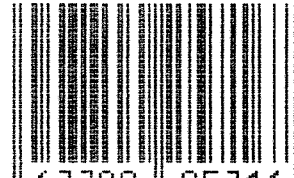
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.



5716 C6665981

ORDER 5716MODEL 700 TM M24**UPC****ORDER 5716**MODEL 700 TM M24**UPC**

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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6665981

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		9/25/91	KH
600	Proof		9/25/91	KH
607	Check Headspace		9/25/91	KH
610	Dis-assemble Gun		9/25/91	KH
612	Magnaflux Barrel Action		OCT 2 1991	KR
	Magnaflux Bolt		OCT 2 1991	KR
615	Rollmark Caliber		OCT 2 1991	LS
617	Drill and Tap Sight Holes		OCT 2 1991	CB
618	Polish Barrel		OCT 4 1991	WB
620	Apply Coatings (Barrel Action)		10-14-91	JA
	Apply Coating (Bolt)		10-14-91	JA
625	Final Assembly A) Clean inside of Bolt Assembly		10/16/91	KH
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/16/91	KH
	C) Inspect Ejector Hole for Chamfer		10/16/91	KH
	D) Oil Firing Pin Ass'y		10/16/91	KH
	E) Adjust Trigger Pull to Min Setting and Stake		10/17/91	SH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6 1/4			10-18-91	DH
	G) Safety Off Force	2	2 1/4	2 1/2			10-18-91	DH
	H) Trigger Pull Test & Retainability						10/17/91	JL
	I) Firing Pin Indent	1020	1022	1020			10-18-91	DH
	J) Assemble Stock						10/18/91	KL
	K) Assemble Swivel Studs						10-22-91	AC
	L) Attach Front and Rear Sight Assemblies						10/18/91	KL
	M) Iron Sight Alignment						10/18/91	KL
	N) Detach Front & Rear Sights & place in numbered container						10/18/91	KL
	O) Attach Scope to Rifle						10/18/91	KL
	P) Detach & Attach Scope 20 Times						10/18/91	KL
640	Gallery Target & Test						10/21/91	Kf
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	KT
645	Inspect for Live Ammo						10/21/91	KT
655	Final Inspection							
	A) Headspace						10-22-91	AC
	B) Trigger Pull	272	277	278	277	280	10-22-91	DH
	C) Function						10-22-91	AC
660	Pack						12-17-91	NF

SWS TRIGGER PULL TEST

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

SERIAL NO C-6665981DATE 10-17-91TESTER JM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.26	2.49	253	277	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.58	2.60	244	277	
PULL #3	2.51	2.59	258	278	
PULL #4	2.28	2.58	266	277	
PULL #5	2.57	2.55	250	280	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.24	3.54		
PULL #2	3.29	3.25		
PULL #3	3.32	3.48		
PULL #4	3.50	3.32		
PULL #5	3.60	3.31		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.36	4.45		4.37
PULL #2	4.40	4.54		4.49
PULL #3	4.58	4.54		4.49
PULL #4	4.56	4.64		4.41
PULL #5	4.53	4.54		4.55
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06665981
22 Oct 1991

CENTROIDAL DISTANCES

0 TO	1	.0980459
1 TO	2	.501028
1 TO	3	.209612
1 TO	4	.267798
1 TO	5	.371442

34
15
4
X----FOR

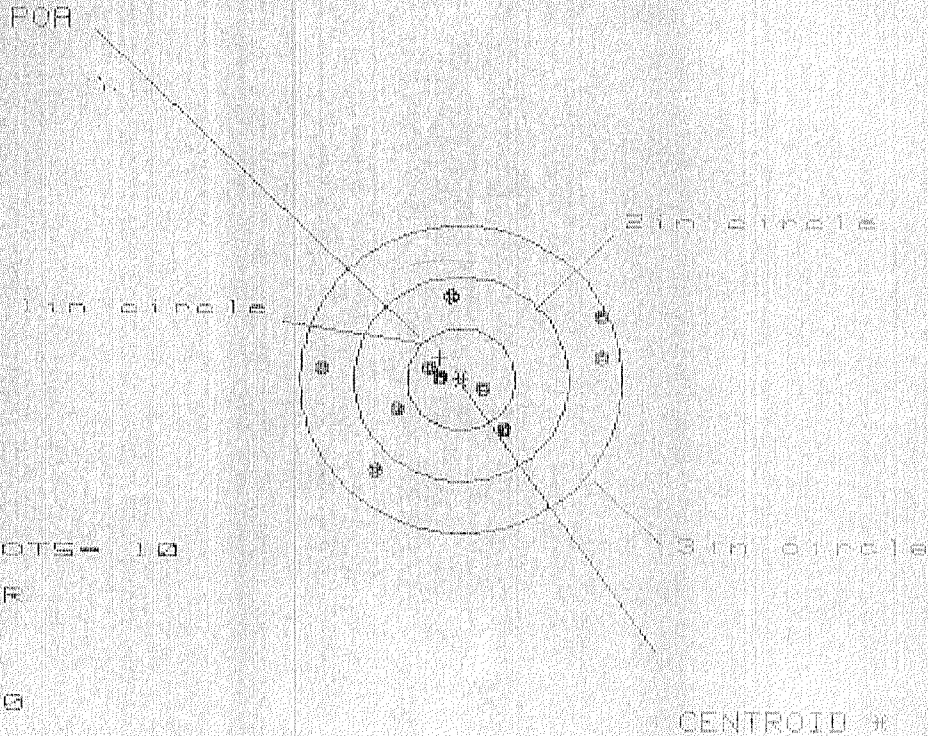
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0228
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2208
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .221974

THE AMP FOR THIS RIFLE IS: .9386

21 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C666598J

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 6

3 in = 10

HS = 2.609

VS = 1.702

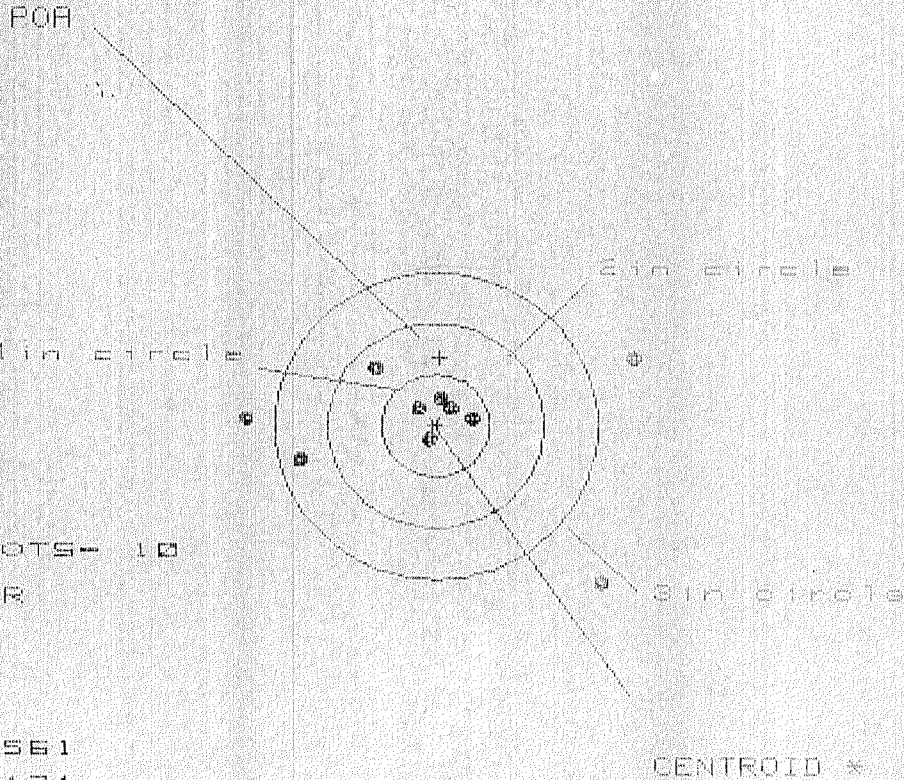
GS = 2.609

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.342	1.482	.776
MINIMUM X	-1.267	-1.127	-.942
MAXIMUM Y	.776	.840	.863
MINIMUM Y	-.926	-.862	-.833
CENTROID X	.197	.057	-.128
CENTROID Y	-.215	-.279	-.308
POA TO CENTROID in.	.292	.285	.334
MIN RADIUS	.195	.083	.145
MEAN RADIUS	.807	.720	.619
MAX RADIUS	1.388	1.500	.967
HORIZONTAL SPREAD	2.609	2.609	1.718
VERTICAL SPREAD	1.702	1.702	1.702
EXTREME SPREAD	2.609	2.609	1.835
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

21 Oct 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 5

2 in = 6

3 in = 7

HS= 3.561

VS= 2.171

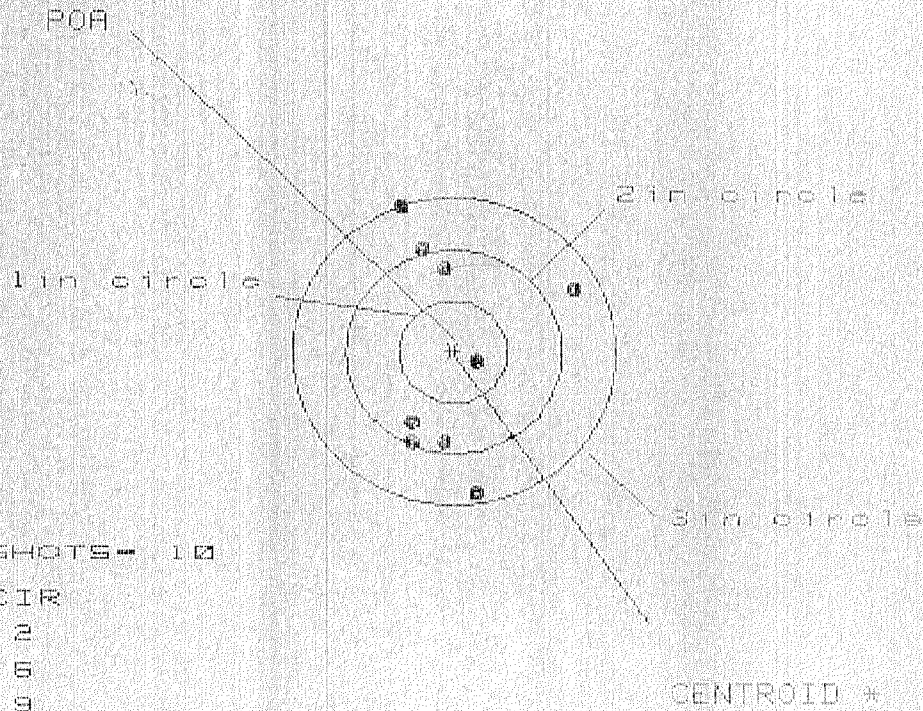
GS= 3.665

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.805	1.974	.715
MINIMUM X	-1.756	-1.587	-1.340
MAXIMUM Y	.650	.482	.435
MINIMUM Y	-1.520	-.509	-.449
CENTROID X	-.038	-.207	-.454
CENTROID Y	-.669	-.501	-.561
POA TO CENTROID in.	.671	.542	.721
MIN RADIUS	.193	.017	.271
MEAN RADIUS	.909	.740	.641
MAX RADIUS	2.153	2.032	1.340
HORIZONTAL SPREAD	3.561	3.561	2.055
VERTICAL SPREAD	2.171	.991	.884
EXTREME SPREAD	3.665	3.601	2.055
NUMBER IN ONE INCH CIRCLE =		5	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		7	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS= 1.575

VS= 2.888

GS= 2.971

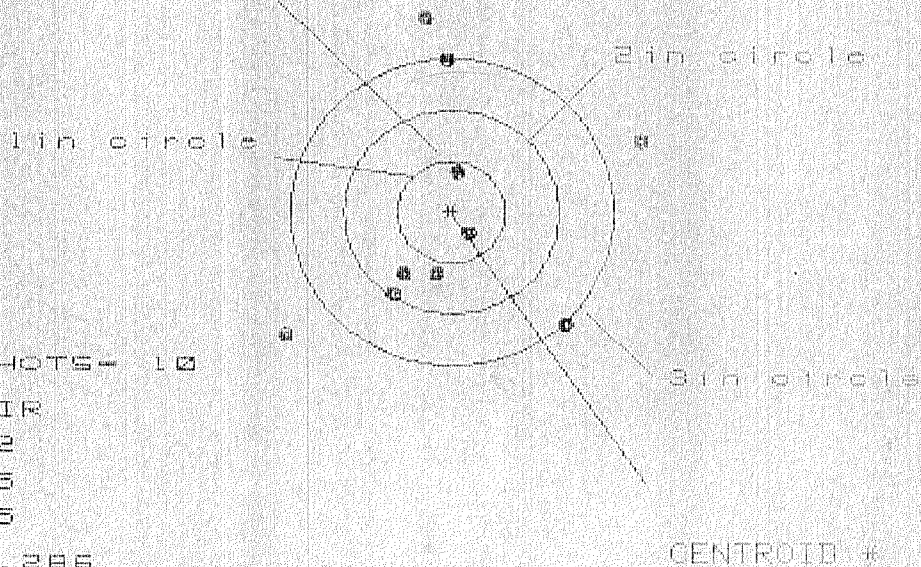
PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.063	1.006	1.022
MINIMUM X	-1.512	-1.432	-1.416
MAXIMUM Y	1.465	1.225	1.068
MINIMUM Y	-1.423	-1.260	-1.861
CENTROID X	-1.212	-1.155	-1.171
CENTROID Y	.082	-.081	.076
POA TO CENTROID in.	.227	.175	.187
MIN RADIUS	.234	.184	.194
MEAN RADIUS	.917	.817	.766
MAX RADIUS	1.552	1.278	1.261
HORIZONTAL SPREAD	1.575	1.438	1.438
VERTICAL SPREAD	2.888	2.485	1.929
EXTREME SPREAD	2.971	2.532	2.061
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS # 2

POA



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 5

3 in = 5

HS= 3.286

VS= 3.120

GS= 3.824

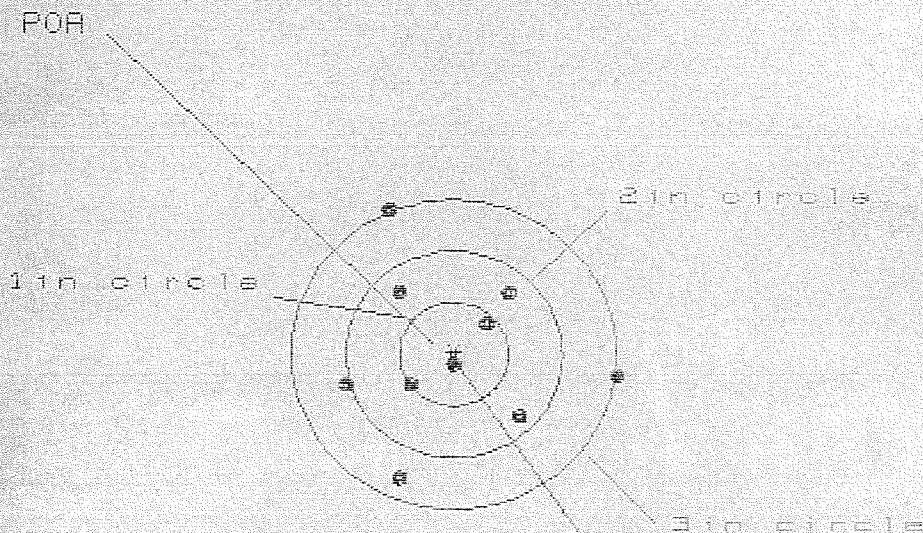
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.763	1.594	1.538
MINIMUM X	:	-1.523	-.679	-.735
MAXIMUM Y	:	1.908	1.773	1.605
MINIMUM Y	:	-1.212	-1.185	-.963
CENTROID X	:	-.058	.111	.167
CENTROID Y	:	-.400	-.265	-.487
POA TO CENTROID in.	:	.404	.288	.515
MIN RADIUS	:	.239	.264	.171
MEAN RADIUS	:	1.178	1.113	.985
MAX RADIUS	:	1.946	1.828	1.748
HORIZONTAL SPREAD	:	3.286	2.273	2.273
VERTICAL SPREAD	:	3.120	2.958	2.568
EXTREME SPREAD	:	3.824	3.255	2.814
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		5	

MAX RADIUS :	1.490	1.409	1.125
HORIZONTAL SPREAD :	2.505	1.649	1.649
VERTICAL SPREAD :	2.566	2.566	1.780
EXTREME SPREAD :	2.597	2.568	2.035
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

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CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 10

HS= 2.505

VS= 2.566

GS= 2.597

CENTROID *

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.477	.785	.731
MINIMUM X	:	-1.028	-.864	-.910
MAXIMUM Y	:	1.361	1.340	.721
MINIMUM Y	:	-1.205	-1.226	-1.059
CENTROID X	:	-.003	-.167	-.113
CENTROID Y	:	.098	.119	-.048
POA TO CENTROID in.	:	.098	.206	.122
MIN RADIUS	:	.134	.229	.114
MEAN RADIUS	:	.882	.815	.719