

FORM

UPC



0 47700 25716 7

C6666012

CAPACITY
INCLUDES 1 IN CHAMBER

5716

ORDER NO.

BARREL LENGTH

MODEL 700 TM M24

Remington

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

MODEL 700™ M24

SERIAL NO.
C6666012

20

ORDER NO.
5716

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



5716 C6666012

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 #

C6666012

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		9/30/91	KL
600	Proof		9/30/91	KL
607	Check Headspace		9/30/91	KL
610	Dis-assemble Gun		9/30/91	KL
612	Magnaflux Barrel Action		OCT 8 1991	KR
	Magnaflux Bolt		OCT 8 1991	KR
615	Rollmark Caliber		OCT 8 1991	GS
617	Drill and Tap Sight Holes		OCT 8 1991	LB
618	Polish Barrel		9/14/91	WB
620	Apply Coatings (Barrel Action)		11/1/91	KL
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/7/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/7/91	KL
	C) Inspect Ejector Hole for Chamfer		11/7/91	KL
	D) Oil Firing Pin Ass'y		11/7/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		11-8-91	KL

op. #	BARBER - M24 0105010 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			11-8-91	JK
	G) Safety Off Force	2	2	2			11-8-91	JK
	H) Trigger Pull Test & Retainability						11-8-91	JK
	I) Firing Pin Indent	021	021	021			11-8-91	JK
	J) Assemble Stock						11-8-91	JK
	K) Assemble Swivel Studs						11-27-91	JK
	L) Attach Front and Rear Sight Assemblies						11-8-91	JK
	M) Iron Sight Alignment						11-8-91	JK
	N) Detach Front & Rear Sights & place in numbered container						11-8-91	JK
	O) Attach Scope to Rifle						11-8-91	JK
	P) Detach & Attach Scope 20 Times						11-8-91	JK
640	Gallery Target & Test						11-11-91	JK
	A) Time						11	JK
	B) Malfunctions						11	JK
	C) Pierced Primers						11	JK
	D) Optical Clarity of Scope						11	JK
645	Inspect for Live Ammo						11-11-91	JK
655	Final Inspection							
	A) Headspace						11-27-91	AC
	B) Trigger Pull	2.40	2.42	2.47	2.43	2.40	11-13-91	AC
	C) Function						11-27-91	AC
660	Pack							

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# + 50#
3.00# + 75#
4.00# + 100#

SERIAL NO. C-6666012
DATE 11-8-91
TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.30	2.30	2.44	2.40	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.25	2.32	2.36	2.42	
PULL #3	2.29	2.29	2.28	2.47	
PULL #4	2.32	2.33	2.38	2.43	
PULL #5	2.30	2.30	2.40	2.40	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.25	3.38		
PULL #2	3.33	3.46		
PULL #3	3.39	3.37		
PULL #4	3.37	3.41		
PULL #5	3.39	3.46		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.43	4.37		4.24
PULL #2	4.23	4.24		4.29
PULL #3	4.32	4.37		4.34
PULL #4	4.32	4.24		4.46
PULL #5	4.34	4.34		4.33
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6666012
11 Nov 1991

CENTROIDAL DISTANCES

0 TO	1	.207714
1 TO	2	.278196
1 TO	3	.168238
1 TO	4	.253622
1 TO	5	.158218

←----POI

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0038
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0584
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0585235
THE AMR FOR THIS RIFLE IS: .7916

11 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8686012

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 4

2in = 7

3in = 10

HS= 1.901

VS= 1.569

GS= 2.140

CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.698	.564	.423
MINIMUM X	:	-1.203	-1.132	-.350
MAXIMUM Y	:	.539	.593	.486
MINIMUM Y	:	-1.030	-.976	-.901
CENTROID X	:	.136	.270	.411
CENTROID Y	:	-.157	-.211	-.286
POA TO CENTROID in.	:	.269	.343	.501
MIN RADIUS	:	.225	.179	.223
MEAN RADIUS	:	.678	.573	.475
MAX RADIUS	:	1.299	1.278	.902
HORIZONTAL SPREAD	:	1.901	1.696	.773
VERTICAL SPREAD	:	1.569	1.569	1.387
EXTREME SPREAD	:	2.140	2.039	1.387
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

11 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6666012

CENTERFIRE PATTERNS # 2

POR

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.711

VS= 1.415

GS= 2.031

CENTROID *

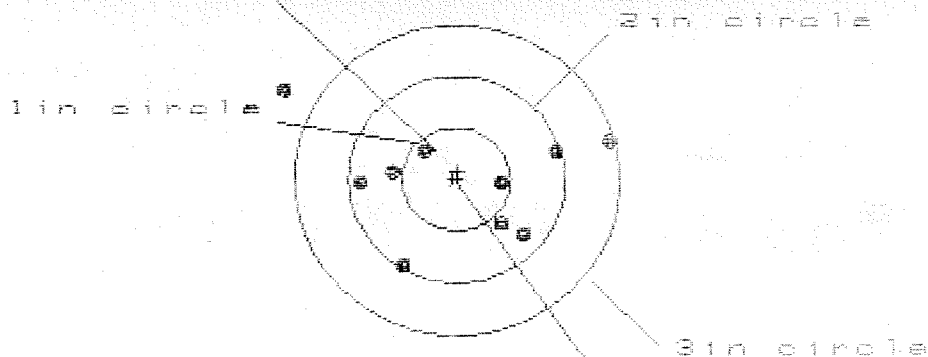
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.874	.781	.625
MINIMUM X	:	-.837	-.820	-.722
MAXIMUM Y	:	.610	.521	.449
MINIMUM Y	:	-.805	-.598	-.670
CENTROID X	:	-.097	-.084	-.102
CENTROID Y	:	-.005	.084	.156
POR TO CENTROID in.	:	.097	.084	.186
MIN RADIUS	:	.278	.242	.129
MEAN RADIUS	:	.688	.617	.552
MAX RADIUS	:	1.161	.971	.835
HORIZONTAL SPREAD	:	1.711	1.601	1.347
VERTICAL SPREAD	:	1.415	1.119	1.119
EXTREME SPREAD	:	2.031	1.986	1.604
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

11 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08666012

CENTERFIRE PATTERNS # 3

POR



OF SHOTS = 10

IN CIR

1in = 2

2in = 8

3in = 8

HS = 3.011

VS = 1.688

GS = 3.045

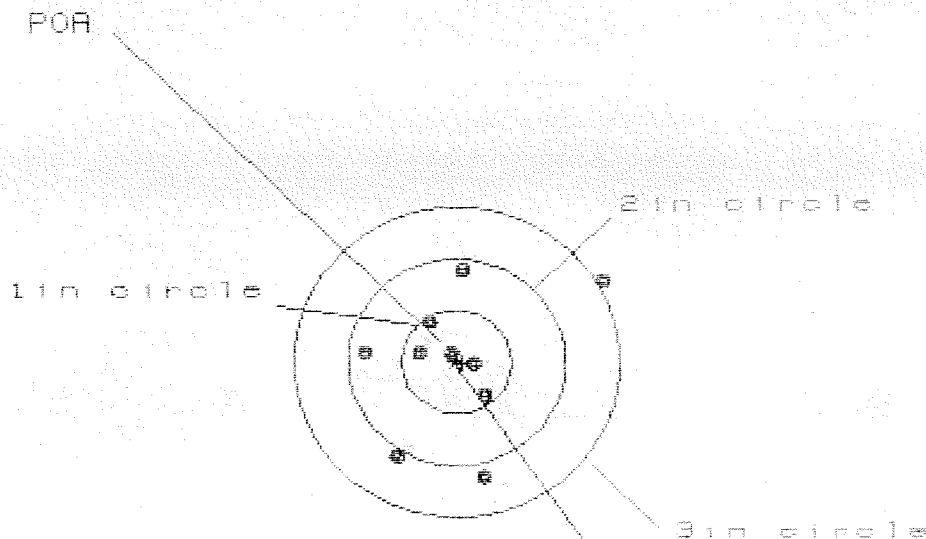
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.449	1.276	.939
MINIMUM X	:	-1.562	-1.061	-.902
MAXIMUM Y	:	.848	.491	.461
MINIMUM Y	:	-.848	-.746	-.685
CENTROID X	:	-.012	.161	.002
CENTROID Y	:	-.077	-.171	-.232
POR TO CENTROID in.	:	.078	.235	.232
MIN RADIUS	:	.402	.243	.414
MEAN RADIUS	:	.890	.766	.691
MAX RADIUS	:	1.777	1.367	1.019
HORIZONTAL SPREAD	:	3.011	2.337	1.841
VERTICAL SPREAD	:	1.688	1.237	1.146
EXTREME SPREAD	:	3.045	2.382	1.066
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		8	

11 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C866B012

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 5

2in = 7

3in = 9

HS = 2.216

VS = 2.061

GS = 2.633

CENTROID *

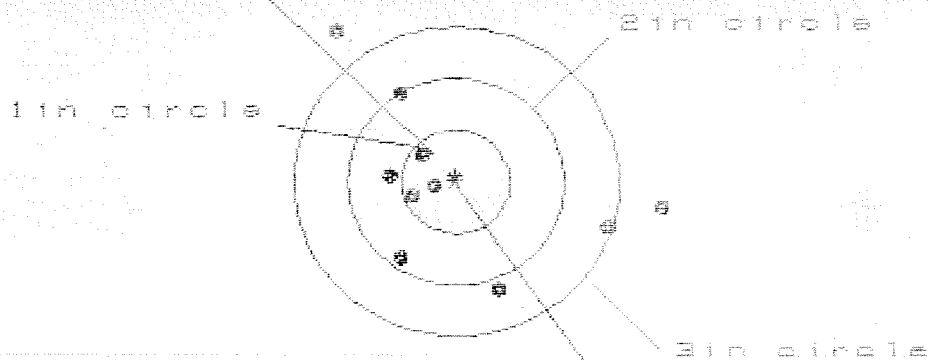
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.387	.411	.460
MINIMUM X	:	-.829	-.675	-.626
MAXIMUM Y	:	.922	1.012	.881
MINIMUM Y	:	-1.139	-1.049	-.979
CENTROID X	:	-.054	-.208	-.257
CENTROID Y	:	.011	-.079	.052
POA TO CENTROID in.	:	.055	.223	.262
MIN RADIUS	:	.074	.161	.142
MEAN RADIUS	:	.709	.614	.524
MAX RADIUS	:	1.605	1.119	1.051
HORIZONTAL SPREAD	:	2.216	1.086	1.086
VERTICAL SPREAD	:	2.061	2.061	1.860
EXTREME SPREAD	:	2.633	2.070	1.962
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

11 Nov 1991

FILE:/PATTERNING/CENTERFIRE PATT/09686012

CENTERFIRE PATTERNS # 5

POR



OF SHOTS = 10

IN CIR

1in = 3

2in = 5

3in = 8

HS = 3.047

VS = 2.489

GS = 3.494

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.911
MINIMUM X	-1.136
MAXIMUM Y	1.469
MINIMUM Y	-1.020
CENTROID X	.088
CENTROID Y	-.064
POR TO CENTROID in.	.065
MIN RADIUS	.193
MEAN RADIUS	.993
MAX RADIUS	1.926
HORIZONTAL SPREAD	3.047
VERTICAL SPREAD	2.489
EXTREME SPREAD	3.494
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	8