

FORM

UPC



0 47700 25716 2

C6666013

*INCLUDES 1 IN CHAMBER

CAPACITY*

5716

ORDER NO.

BARREL LENGTH

MODEL 700 TM M24

Remington

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

MODEL 700TM M24**SERIAL NO.**

C6666013

ORDER NO.**5716**

20

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



5716 C6666013

ORDER 5716
MODEL 700TM M24

UPC

0 47700 25716 7

ORDER 5716
MODEL 700TM M24

UPC

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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

26666013

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/1/91	KL
600	Proof		10/1/91	KL
607	Check Headspace		10/1/91	KL
610	Dis-assemble Gun		10/1/91	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		10/4/91	WB
620	Apply Coatings (Barrel Action)		11-1-91	KL
	Apply Coating (Bolt)			KL
625	Final Assembly A) Clean inside of Bolt Assembly		11/1/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/1/91	KL
	C) Inspect Ejector Hole for Chamfer		11/1/91	KL
	D) Oil Firing Pin Ass'y		11/1/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		11-4-91	KL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			11-4-91	RL
	G) Safety Off Force	4	4	4			11-4-91	RL
	H) Trigger Pull Test & Retainability						11-4-91	RL
	I) Firing Pin Indent	.0215	.0215	.0215			11-4-91	RL
	J) Assemble Stock						11/5/91	RL
	K) Assemble Swivel Studs						11-27-91	AC
	L) Attach Front and Rear Sight Assemblies						11/5/91	RL
	M) Iron Sight Alignment						11/5/91	RL
	N) Detach Front & Rear Sights & place in numbered container						11/5/91	RL
	O) Attach Scope to Rifle						11/5/91	RL
	P) Detach & Attach Scope 20 Times						11/5/91	RL
640	Gallery Target & Test						11-6-91	DH
	A) Time						11-6-91	DH
	B) Malfunctions						11-6-91	DH
	C) Pierced Primers						11-6-91	DH
	D) Optical Clarity of Scope						11-6-91	DH
645	Inspect for Live Ammo						11-6-91	DH
655	Final Inspection						11-27-91	AC
	A) Headspace						11-6-91	DH
	B) Trigger Pull	276	268	277	277	281	11-6-91	DH
	C) Function						11-27-91	AC
660	Pack						12-18-91	NF

MOD.		GA. CAL.	GUN #	ASSEM. #
#	DATE	MALFUNCTION/DEFECT		
11-6-91	1st	weak mag spring		KS
11-7-91	2nd	New Mag SPG		KS
	3rd			
	4th			
		FUNCTION		RD 6654 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF	<i>Test OK</i> <i>11-26-91</i> <i>DH</i>	
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. C6666013

DATE 11-4-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.19	2.44	2.48	276	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.45	2.45	2.57	268	
PULL #3	2.45	2.41	2.41	277	
PULL #4	2.44	2.46	2.44	277	
PULL #5	2.48	2.44	2.40	281	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.54	3.60		
PULL #2	3.60	3.37		
PULL #3	3.32	3.51		
PULL #4	3.58	3.40		
PULL #5	3.59	3.63		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.31	4.24		4.39
PULL #2	4.25	4.40		4.37
PULL #3	4.46	4.25		4.38
PULL #4	4.38	4.40		4.41
PULL #5	4.34	4.37		4.28
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06666013
6 Nov 1991

CENTROIDAL DISTANCES

0 TO	1	.606842
1 TO	2	.531008
1 TO	3	.241868
1 TO	4	.0630079
1 TO	5	.47821

$\frac{5}{4}$ (----POA

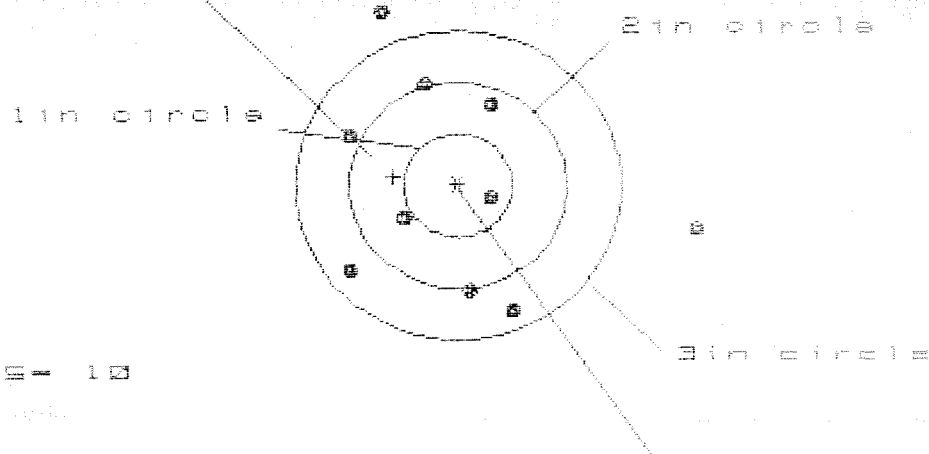
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .4762
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0462
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .476436
THE AMP FOR THIS RIFLE IS: .9298

6 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C656B0013

CENTERFIRE PATTERNS # 1

POR



OF SHOTS= 10

IN CIRCLES

1in = 1

2in = 4

3in = 8

HS= 3.223

VS= 2.895

GS= 3.593

CENTROID #

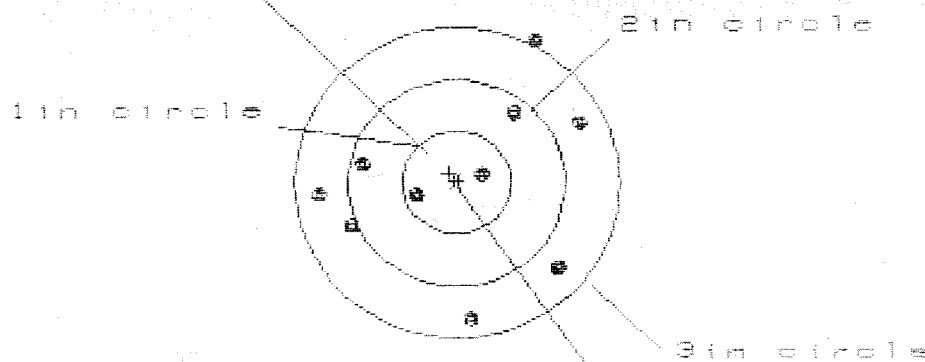
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.239	.721	.666
MINIMUM X	-.985	-.736	-.791
MAXIMUM Y	1.688	1.644	1.098
MINIMUM Y	-1.207	-1.251	-1.046
CENTROID X	.601	.352	.407
CENTROID Y	-.084	-.040	-.245
POR TO CENTROID in.	.606	.354	.475
MIN RADIUS	.372	.445	.360
MEAN RADIUS	1.160	1.016	.909
MAX RADIUS	2.273	1.701	1.240
HORIZONTAL SPREAD	3.223	1.457	1.457
VERTICAL SPREAD	2.895	2.895	2.144
EXTREME SPREAD	3.593	3.119	2.274
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =			8

6 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08688013

CENTERFIRE PATTERNS # 2

POR



OF SHOTS = 10

IN CIR

1in = 2

2in = 4

3in = 9

HE = 2.457

VS = 2.698

GS = 2.762

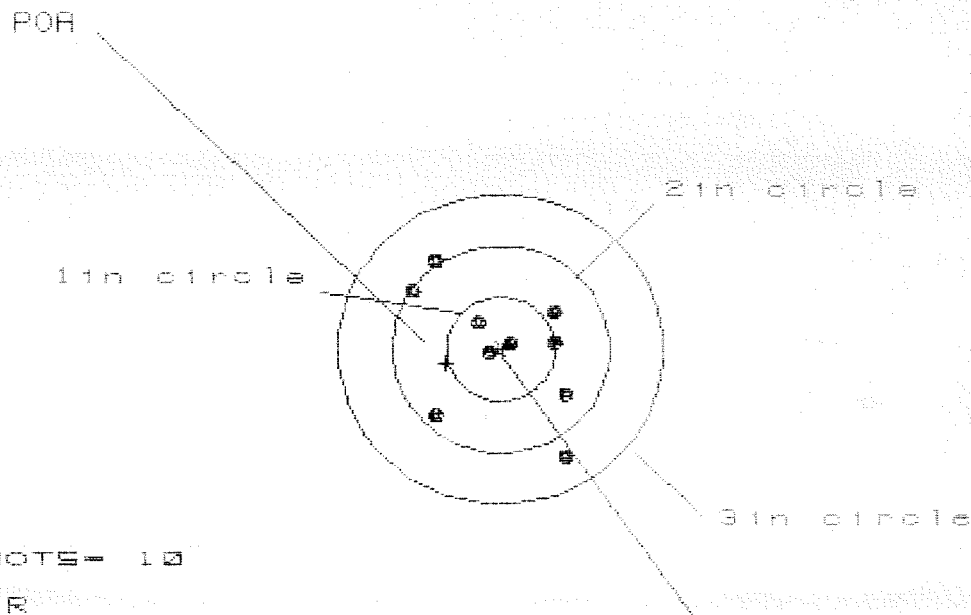
CENTROID #

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.138	1.214	1.059
MINIMUM X	-1.319	-1.243	-1.083
MAXIMUM Y	1.415	.796	.800
MINIMUM Y	-1.283	-1.126	-1.122
CENTROID X	.070	-.006	.149
CENTROID Y	-.081	-.238	-.242
POR TO CENTROID in.	.107	.238	.284
MIN RADIUS	.215	.334	.266
MEAN RADIUS	1.017	.950	.912
MAX RADIUS	1.574	1.402	1.272
HORIZONTAL SPREAD	2.457	2.457	2.142
VERTICAL SPREAD	2.698	1.922	1.922
EXTREME SPREAD	2.762	2.548	2.363
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		9	

6 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6566013

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 4

2in = 8

3in = 10

HS = 1.416

VS = 1.833

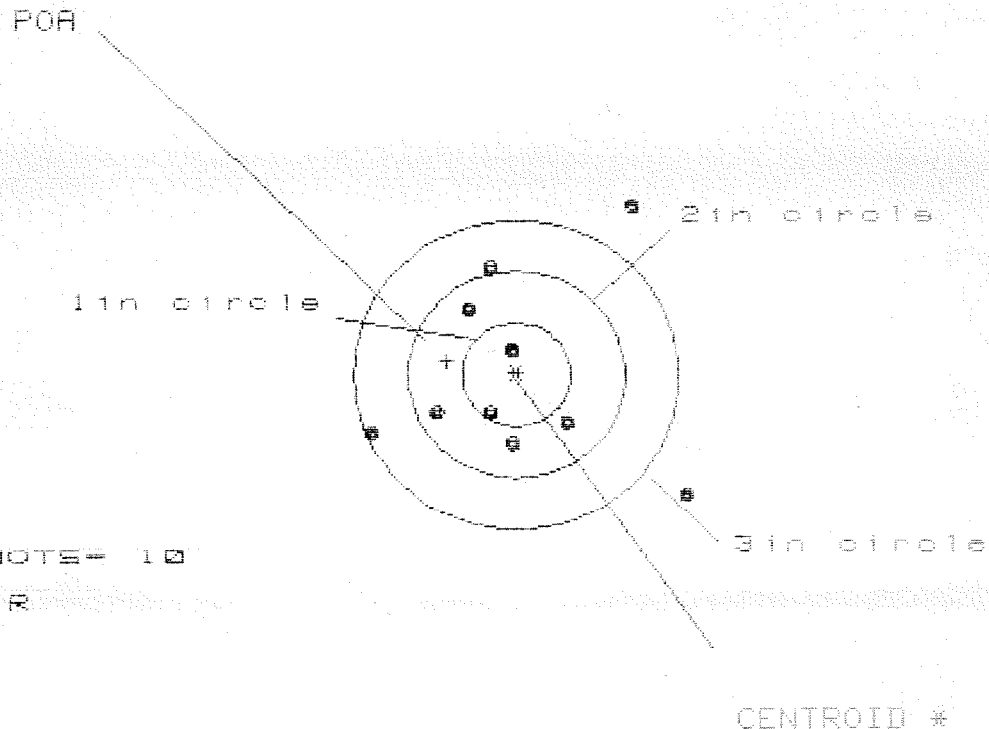
GS = 2.173

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.604	.632	.570
MINIMUM X	:	-.812	-.745	-.887
MAXIMUM Y	:	.825	.712	.554
MINIMUM Y	:	-1.008	-.792	-.703
CENTROID X	:	.505	.438	.500
CENTROID Y	:	.138	.250	.161
POA TO CENTROID in.	:	.523	.504	.525
MIN RADIUS	:	.063	.135	.071
MEAN RADIUS	:	.637	.574	.523
MAX RADIUS	:	1.175	.936	.979
HORIZONTAL SPREAD	:	1.416	1.377	1.377
VERTICAL SPREAD	:	1.833	1.504	1.257
EXTREME SPREAD	:	2.173	1.716	1.716
NUMBER IN ONE INCH CIRCLE =			4	
NUMBER IN TWO INCH CIRCLE =			9	
NUMBER IN THREE INCH CIRCLE =			10	

6 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8666013

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 2.888

VS= 2.833

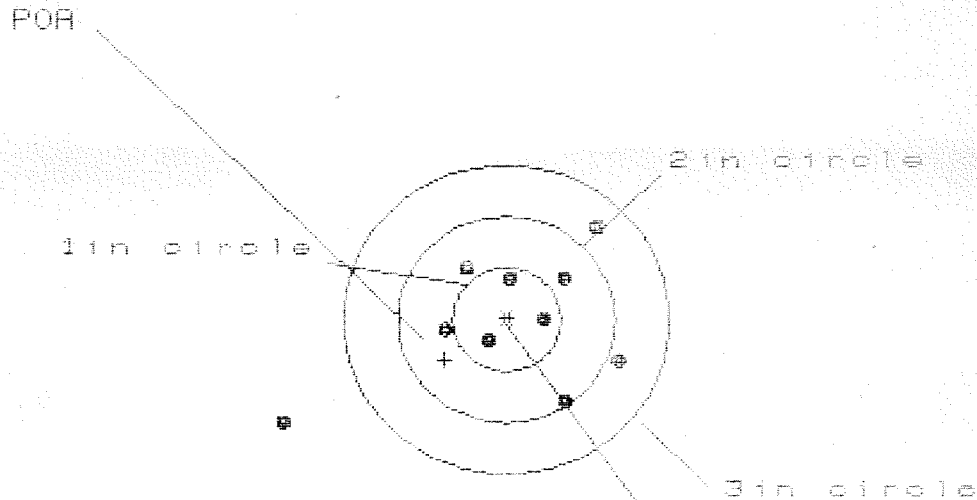
GS= 3.318

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.532	1.654	.795
MINIMUM X	:	-1.356	-1.234	-1.028
MAXIMUM Y	:	1.669	1.182	1.059
MINIMUM Y	:	-1.164	-.978	-.591
CENTROID X	:	.638	.516	.310
CENTROID Y	:	-.135	-.321	-.198
POA TO CENTROID in.	:	.652	.608	.368
MIN RADIUS	:	.273	.174	.289
MEAN RADIUS	:	.994	.846	.794
MAX RADIUS	:	1.997	1.921	1.145
HORIZONTAL SPREAD	:	2.888	2.888	1.823
VERTICAL SPREAD	:	2.833	2.160	1.650
EXTREME SPREAD	:	3.318	2.949	1.900
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			8	

8 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6666013

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 3.147

VS= 1.895

GS= 3.488

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.031	.796	.867
MINIMUM X	:	-2.116	-.889	-.738
MAXIMUM Y	:	.946	.840	.492
MINIMUM Y	:	-.950	-.868	-.763
CENTROID X	:	.567	.802	.731
CENTROID Y	:	.393	.499	.394
POA TO CENTROID in.	:	.690	.944	.830
MIN RADIUS	:	.237	.120	.161
MEAN RADIUS	:	.841	.644	.595
MAX RADIUS	:	2.319	1.014	.951
HORIZONTAL SPREAD	:	3.147	1.605	1.605
VERTICAL SPREAD	:	1.895	1.708	1.255
EXTREME SPREAD	:	3.488	1.731	1.642
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	