

FIRE

UPC



0 47700 25716 7

06666105

*INCLUDES 1 IN CHAMBER

CAPACITY*

BARREL LENGTH

MODEL 700 TM M24

ORDER NO. 5716

Remington



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

MODEL 700 TM M24

SERIAL NO.

C6666105

ORDER NO.

5716

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

20



5716 C6666105

ORDER 5716
MODEL 700 TM M24
UPC

ORDER 5716
MODEL 700 TM M24
UPC



0 47700 25716 7



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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6666105

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		9/25/91	KA
600	Proof		9/25/91	KA
607	Check Headspace		9/25/91	KA
610	Dis-assemble Gun		9/25/91	KA
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	LB
618	Polish Barrel		OCT 4 1991	WB
620	Apply Coatings (Barrel Action)		10-14/91	TH
	Apply Coating (Bolt)		10-14/91	TH
625	Final Assembly A) Clean inside of Bolt Assembly		10/16/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/16/91	KA
	C) Inspect Ejector Hole for Chamfer		10/16/91	KA
	D) Oil Firing Pin Ass'y		10/16/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		10/17/91	TH

op. #	OP NAME	READINGS			DATE	INIT		
	BARBER - M24 0105126							
625 cont.	F) Safety On Force	5	5 $\frac{1}{4}$	5 $\frac{3}{4}$	10-17-91	DH		
	G) Safety Off Force	3	3	3	10-17-91	DH		
	H) Trigger Pull Test & Retainability				10/17/91	JL		
	I) Firing Pin Indent	.021	.021	.020	10-17-91	DH		
	J) Assemble Stock				10/17/91	KL		
	K) Assemble Swivel Studs				10-22-91	E		
	L) Attach Front and Rear Sight Assemblies				10/17/91	KL		
	M) Iron Sight Alignment				10/17/91	KL		
	N) Detach Front & Rear Sights & place in numbered container				10/17/91	KL		
	O) Attach Scope to Rifle				10/17/91	KL		
	P) Detach & Attach Scope 20 Times				10/17/91	KL		
640	Gallery Target & Test				10-21-91	DH		
	A) Time				10-21-91	DH		
	B) Malfunctions				10-21-91	DH		
	C) Pierced Primers				10-21-91	DH		
	D) Optical Clarity of Scope				10-21-91	DH		
645	Inspect for Live Ammo				10-21-91	DH		
655	Final Inspection							
	A) Headspace				10-22-91	E		
	B) Trigger Pull	255	257	257	258	259	10-22-91	DH
	C) Function						10-22-91	K
660	Pack						12-18-91	N

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6666105

DATE 10/17/81

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.64	2.55	2.55	2.55	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.52	2.50	2.50	2.57	
PULL #3	2.56	2.52	2.62	2.57	
PULL #4	2.55	2.61	2.50	2.58	
PULL #5	2.57	2.60	2.54	2.59	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.45	3.24		
PULL #2	3.38	3.26		
PULL #3	3.28	3.25		
PULL #4	3.30	3.29		
PULL #5	3.33	3.29		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.41	4.41		4.41
PULL #2	4.43	4.42		4.37
PULL #3	4.42	4.42		4.33
PULL #4	4.31	4.42		4.42
PULL #5	4.40	4.43		4.39
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6666105
21 Oct 1991

CENTROIDAL DISTANCES

0	TO	1	.40093
1	TO	2	.215745
1	TO	3	.244598
1	TO	4	.384003
1	TO	5	.586147

5th <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1206
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0984
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .15565
THE AMR FOR THIS RIFLE IS: .9086

21 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6666185

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS - 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 1.310

VS= 2.603

GS= 2.718

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.789	.868	.305
MINIMUM X	-.520	-.442	-.334
MAXIMUM Y	1.215	1.061	1.189
MINIMUM Y	-1.388	-1.036	-.908
CENTROID X	.283	.205	.097
CENTROID Y	-.284	-.130	-.258
POA TO CENTROID in.	.401	.243	.275
MIN RADIUS	.312	.355	.188
MEAN RADIUS	.866	.793	.688
MAX RADIUS	1.556	1.341	1.194
HORIZONTAL SPREAD	1.310	1.310	.639
VERTICAL SPREAD	2.603	2.097	2.097
EXTREME SPREAD	2.718	2.440	2.143
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

21 Oct 1991

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CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 3

2 in = 5

3 in = 8

HS= 1.679

VS= 3.240

GS= 3.296

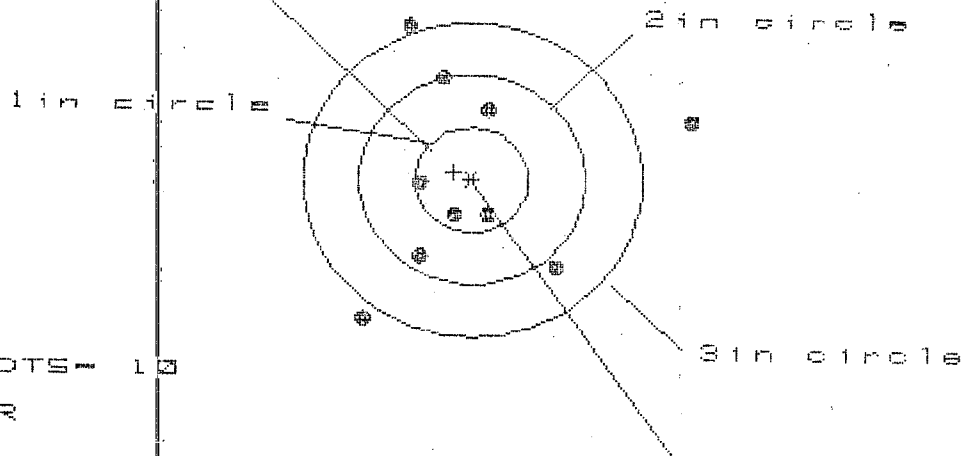
PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.793	.762	.568
MINIMUM X	-.886	-.917	-.822
MAXIMUM Y	1.067	.825	.897
MINIMUM Y	-2.173	-.719	-.647
CENTROID X	.238	.269	.174
CENTROID Y	-.073	.169	.097
POA TO CENTROID in.	.249	.318	.199
MIN RADIUS	.363	.223	.341
MEAN RADIUS	.852	.656	.630
MAX RADIUS	2.192	1.165	1.046
HORIZONTAL SPREAD	1.679	1.679	1.390
VERTICAL SPREAD	3.240	1.544	1.544
EXTREME SPREAD	3.296	2.119	1.960
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS # 3

POA



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 6

3 in = 7

HS = 2.928

VS = 2.814

GS = 3.482

CENTROID *

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.957	.978	.884
MINIMUM X	-.971	-.754	-.481
MAXIMUM Y	1.474	1.534	1.374
MINIMUM Y	-1.340	-1.280	-.880
CENTROID X	.161	-.056	.038
CENTROID Y	-.072	-.132	.028
POA TO CENTROID in.	.176	.144	.047
MIN RADIUS	.343	.292	.400
MEAN RADIUS	1.016	.874	.806
MAX RADIUS	2.031	1.582	1.456
HORIZONTAL SPREAD	2.928	1.732	1.365
VERTICAL SPREAD	2.814	2.814	2.254
EXTREME SPREAD	3.482	2.838	2.635
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	7		

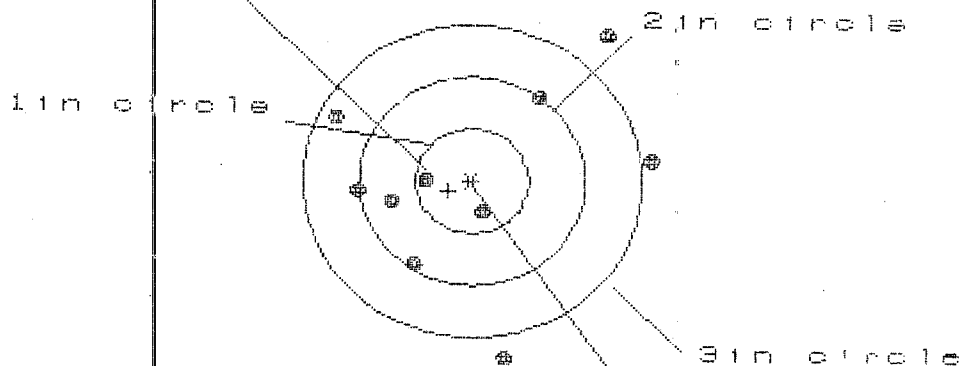
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CENTERFIRE PATTERNS

4

POA



OF SHOTS- 12

IN CIR

1in = 2

2in = 5

3in = 7

HS= 2.859

VS= 3.064

GS= 3.179

CENTROID #

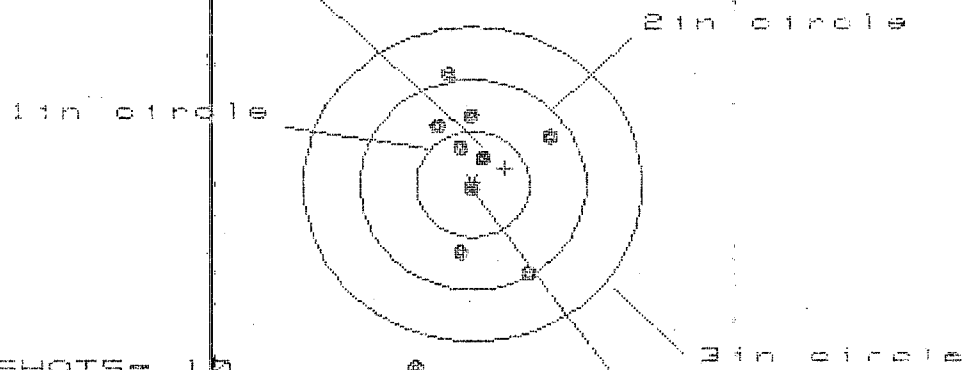
PATTERN #	4	10	9	8
SHOTS (BEST OF)	10	9	8	
MAXIMUM X	1.625	1.755	1.812	
MINIMUM X	-1.234	-1.104	-1.047	
MAXIMUM Y	1.364	.953	.760	
MINIMUM Y	-1.700	-1.549	-.804	
CENTROID X	.210	.080	.023	
CENTROID Y	.093	-.058	.135	
POA TO CENTROID in.	.229	.099	.137	
MIN RADIUS	.287	.262	.270	
MEAN RADIUS	1.091	.968	.880	
MAX RADIUS	1.798	1.793	1.820	
HORIZONTAL SPREAD	2.859	2.859	2.859	
VERTICAL SPREAD	3.064	2.502	1.564	
EXTREME SPREAD	3.179	2.887	2.887	
NUMBER IN ONE INCH CIRCLE =		2		
NUMBER IN TWO INCH CIRCLE =		5		
NUMBER IN THREE INCH CIRCLE =		7		

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FILE:/PATTERNING/CENTERFIRE_PATT/C6688185

CENTERFIRE PATTERNS # 5

POR



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 8

3 in = 9

HS= 1.143

VS= 2.759

GS= 2.771

CENTROID #

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.673	.621	.588
MINIMUM X	-.470	-.407	-.440
MAXIMUM Y	1.062	.873	.532
MINIMUM Y	-1.697	-1.009	-.900
CENTROID X	-.289	-.237	-.204
CENTROID Y	-.156	.033	-.076
POR TO CENTROID in.	.328	.239	.218
MIN RADIUS	.076	.036	.146
MEAN RADIUS	.718	.557	.529
MAX RADIUS	1.761	1.113	1.000
HORIZONTAL SPREAD	1.143	1.028	1.028
VERTICAL SPREAD	2.759	1.882	1.432
EXTREME SPREAD	2.771	2.018	1.614
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		9	