

FROM

UPC



0 47700 25716 7

06648979

BARREL LENGTH
CAPACITY*
*INCLUDES 1 IN CHAMBER

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.
C6648979

20

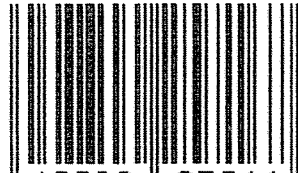
ORDER NO.
5716

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



5716 C6648979

ORDER 5716
MODEL 700 TM M24
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ORDER 5716
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CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6648979

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 2	9 1	RW
600	Proof	7 2	9 1	RW
607	Check Headspace	7 2	9 1	RW
610	Dis-assemble Gun			RW
612	Magnaflux Barrel Action		JUL 22 1991	JS
	Magnaflux Bolt		JUL 22 1991	JS
615	Rollmark Caliber		JUL 22 1991	JS
617	Drill and Tap Sight Holes		JUL 22 1991	FB
618	Polish Barrel		7/22/91	WB
620	Apply Coatings (Barrel Action)		8-22-91	JS
	Apply Coating (Bolt)			JS
625	Final Assembly A) Clean inside of Bolt Assembly		8/30/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/30/91	RW
	C) Inspect Ejector Hole for Chamfer		8/30/91	RW
	D) Oil Firing Pin Ass'y		8/30/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9/4/91	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			7-9-91	DH
	G) Safety Off Force	2	2 1/2	2			7-9-91	DH
	H) Trigger Pull Test & Retainability						9/9/91	JH
	I) Firing Pin Indent	.022	.022	.022			7-9-91	DH
	J) Assemble Stock						10/7/91	RW
	K) Assemble Swivel Studs						10/14/91	JH
	L) Attach Front and Rear Sight Assemblies						10/7/91	RW
	M) Iron Sight Alignment						10/7/91	RW
	N) Detach Front & Rear Sights & place in numbered container						10/7/91	RW
	O) Attach Scope to Rifle						10/7/91	RW
	P) Detach & Attach Scope 20 Times						10/7/91	RW
640	Gallery Target & Test						10/10/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						10/10/91	KT
655	Final Inspection							
	A) Headspace						10/14/91	JH
	B) Trigger Pull	2.35	2.42	2.37	2.40	2.36	10/14/91	JH
	C) Function						10/14/91	JH
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. 06648979

DATE 9-9-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.35	2.36	2.50	2.35	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.25	2.35	2.40	2.42	
PULL #3	2.21	2.40	2.58	2.37	
PULL #4	2.22	2.59	2.43	2.40	
PULL #5	2.36	2.59	2.44	2.36	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.47	3.38		
PULL #2	3.67	3.49		
PULL #3	3.25	3.22		
PULL #4	3.50	3.60		
PULL #5	3.62	3.48		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.48	4.32		4.21
PULL #2	4.29	4.28		4.30
PULL #3	4.27	4.27		4.27
PULL #4	4.31	4.28		4.27
PULL #5	4.31	4.25		4.29
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6648979
10 Oct 1991

CENTROIDAL DISTANCES

0 TO	1	.25633
1 TO	2	.138091
1 TO	3	.511837
1 TO	4	.372308
1 TO	5	.856512

5 ³⁴/₁₆ <----POA

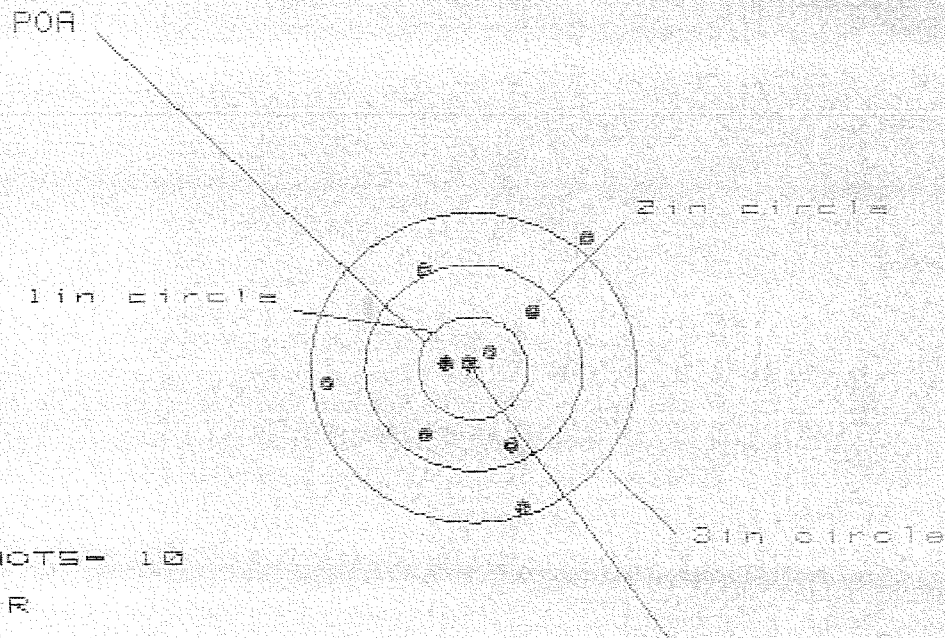
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0116
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1482
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .148653

THE HMR FOR THIS RIFLE IS: .8444

10 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8646979

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 3

2in = 6

3in = 9

HS= 2.377

VS= 2.601

GS= 2.751

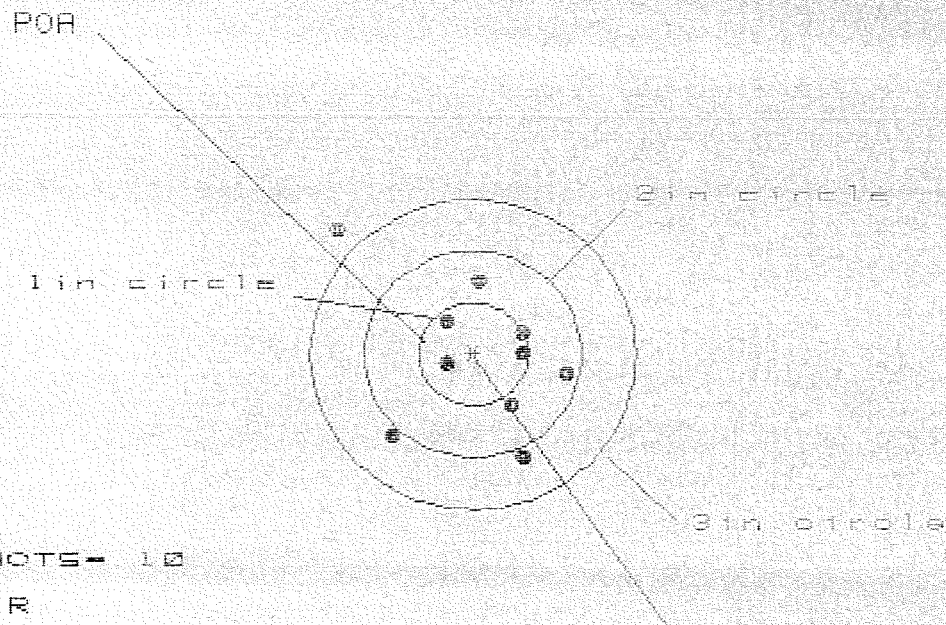
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.036	.640	.713
MINIMUM X	:	-1.341	-1.226	-1.153
MAXIMUM Y	:	1.205	1.082	.924
MINIMUM Y	:	-1.395	-1.261	-.756
CENTROID X	:	.251	.136	.063
CENTROID Y	:	-.052	-.186	-.028
POA TO CENTROID in.	:	.256	.230	.069
MIN RADIUS	:	.064	.211	.055
MEAN RADIUS	:	.826	.754	.646
MAX RADIUS	:	1.590	1.389	1.171
HORIZONTAL SPREAD	:	2.377	1.866	1.866
VERTICAL SPREAD	:	2.601	2.343	1.680
EXTREME SPREAD	:	2.751	2.506	1.995
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

18 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6646379

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 2.105

VS= 2.181

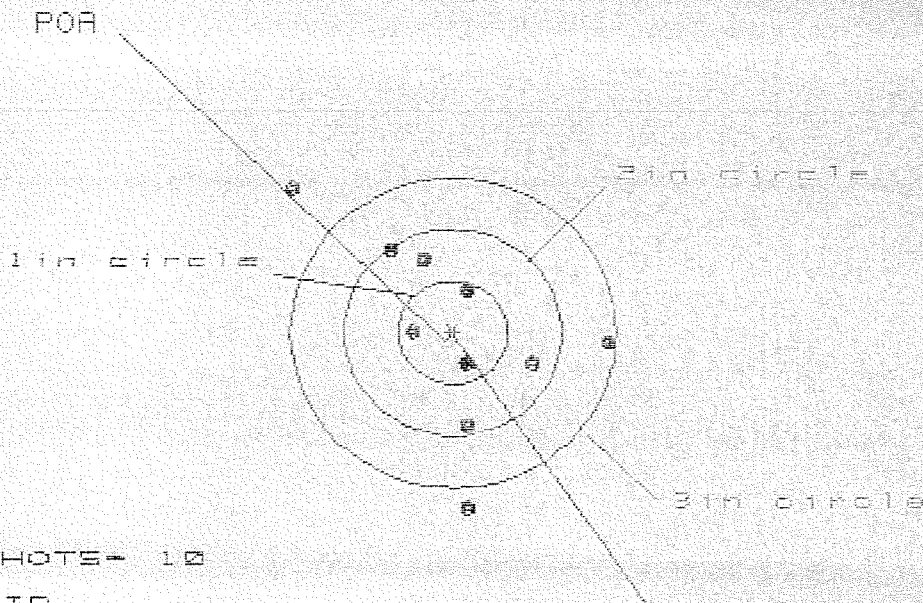
GS= 2.767

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.843	.703	.586
MINIMUM X	-1.262	-.932	-.545
MAXIMUM Y	1.210	.836	.752
MINIMUM Y	-.971	-.837	-.921
CENTROID X	.246	.386	.503
CENTROID Y	.086	-.048	.036
POA TO CENTROID in.	.281	.389	.504
MIN RADIUS	.266	.370	.229
MEAN RADIUS	.777	.650	.561
MAX RADIUS	1.748	1.148	.939
HORIZONTAL SPREAD	2.105	1.635	1.131
VERTICAL SPREAD	2.181	1.673	1.673
EXTREME SPREAD	2.767	1.764	1.721
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

18 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B48979

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 7

3 in = 8

HS= 2.967

VS= 3.160

GS= 3.563

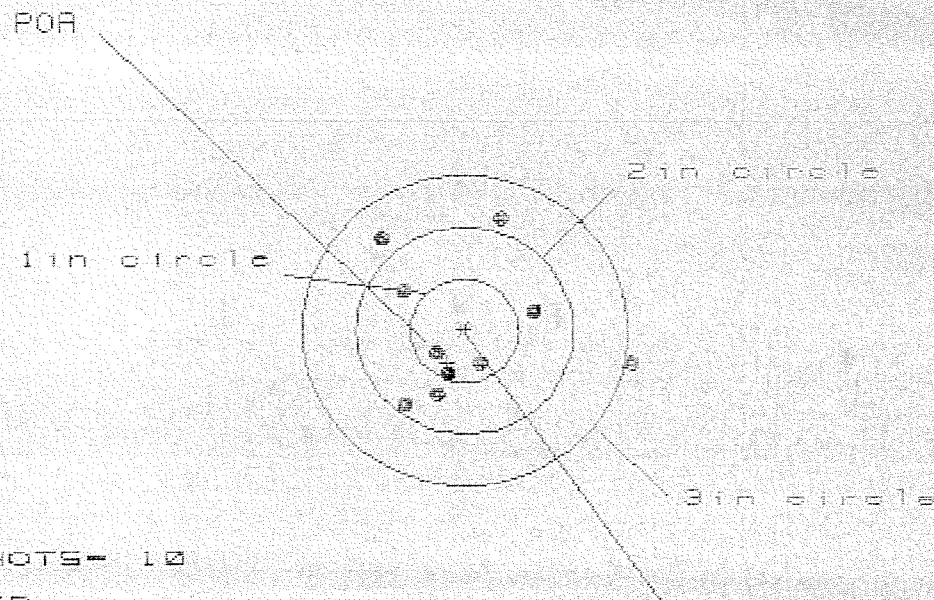
CENTROID #

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.462	1.295	1.291
MINIMUM X	-1.505	-.693	-.697
MAXIMUM Y	1.451	.999	.806
MINIMUM Y	-1.709	-1.548	-.953
CENTROID X	-.128	.039	.043
CENTROID Y	.292	.131	.324
POA TO CENTROID in.	.319	.137	.327
MIN RADIUS	.341	.158	.350
MEAN RADIUS	.983	.847	.751
MAX RADIUS	2.091	1.548	1.297
HORIZONTAL SPREAD	2.967	1.988	1.988
VERTICAL SPREAD	3.160	2.547	1.759
EXTREME SPREAD	3.563	2.633	2.191
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	

18 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6646373

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 2.224

VS= 1.847

GS= 2.530

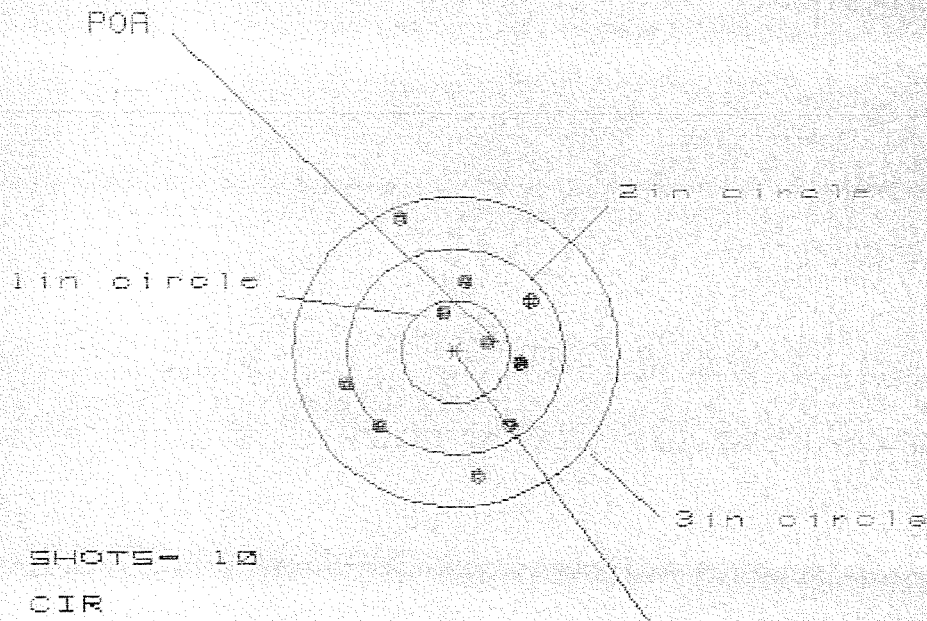
CENTROID #

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.503	.826	.895
MINIMUM X	-.721	-.554	-.495
MAXIMUM Y	1.130	1.096	1.000
MINIMUM Y	-.717	-.751	-.614
CENTROID X	.164	-.003	-.062
CENTROID Y	.310	.344	.207
POA TO CENTROID in.	.350	.344	.216
MIN RADIUS	.327	.243	.096
MEAN RADIUS	.794	.694	.587
MAX RADIUS	1.535	1.192	1.116
HORIZONTAL SPREAD	2.224	1.380	1.380
VERTICAL SPREAD	1.847	1.847	1.614
EXTREME SPREAD	2.530	2.054	1.619
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 10

HS= 1.627

VS= 2.570

GS= 2.670

CENTROID #

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.644	.589	.611
MINIMUM X	-.983	-1.038	-1.016
MAXIMUM Y	1.322	.793	.655
MINIMUM Y	-1.248	-1.101	-.671
CENTROID X	-.591	-.536	-.558
CENTROID Y	.105	-.042	.096
POA TO CENTROID in.	.600	.538	.566
MIN RADIUS	.322	.361	.295
MEAN RADIUS	.842	.779	.714
MAX RADIUS	1.412	1.115	1.063
HORIZONTAL SPREAD	1.627	1.627	1.627
VERTICAL SPREAD	2.570	1.894	1.326
EXTREME SPREAD	2.670	1.900	1.832
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		