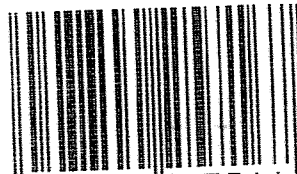


FORN

UPC



0 47700 25716 7

BARREL LENGTH

CAPACITY*

*INCLUDES 1 IN CHAMBER

C6648980

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.

C6648980

ORDER NO.

5716

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



5716 C6648980

ORDER 5716
MODEL 700 TM M24

UPC



0 47700 25716 7

ORDER 5716
MODEL 700 TM M24

UPC



0 47700 25716 7

INTERCHANGEABILITY

M-24

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6648980

1.252

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 26	91	RW
600	Proof	9 26	91	RW
607	Check Headspace	9 26	91	RW
610	Dis-assemble Gun	9 26	91	RW
612	Magnaflux Barrel Action	OCT	3 1991	KCR
	Magnaflux Bolt	OCT	3 1991	KCR
615	Rollmark Caliber	OCT	3 1991	CS.
617	Drill and Tap Sight Holes	OCT	4 1991	LB
618	Polish Barrel	OCT	4 1991	WB
620	Apply Coatings (Barrel Action)		10-18-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/18/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/18/91	RW
	C) Inspect Ejector Hole for Chamfer		10/18/91	RW
	D) Oil Firing Pin Ass'y		10/18/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11-20-91	JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			11/20/91	SL
	G) Safety Off Force	3	3	3			11/20/91	SL
	H) Trigger Pull Test & Retainability						11-20-90	SL
	I) Firing Pin Indent	.0215	.022	.022			11-20/91	SL
	J) Assemble Stock						11/25/91	RW
	K) Assemble Swivel Studs						11-27-91	D/H
	L) Attach Front and Rear Sight Assemblies						11/25/91	RW
	M) Iron Sight Alignment						11/25/91	RW
	N) Detach Front & Rear Sights & place in numbered container						11/25/91	RW
	O) Attach Scope to Rifle						11/25/91	RW
	P) Detach & Attach Scope 20 Times						11/25/91	RW
640	Gallery Target & Test						11/25/91	KJ
	A) Time						"	1CT
	B) Malfunctions						"	1CT
	C) Pierced Primers						"	1CT
	D) Optical Clarity of Scope						"	1CT
645	Inspect for Live Ammo						11/25/91	KE
655	Final Inspection							
	A) Headspace						11-27-91	D/H
	B) Trigger Pull	222	213	208	215	217	11-26-91	D/H
	C) Function						11-27-91	D/H
660	Pack						12-18-91	NF

Rebut 12/13 NF

SWS TRIGGER PULL TEST

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

SERIAL NO C-6648980
DATE 11-20-91
TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.33	2.40	2.22	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.24	2.22	2.28	2.13	
PULL #3	2.46	2.37	2.44	2.08	
PULL #4	2.41	2.38	2.39	2.15	
PULL #5	2.42	2.26	2.40	2.17	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.39	3.46		
PULL #2	3.20	3.37		
PULL #3	3.49	3.40		
PULL #4	3.46	3.36		
PULL #5	3.53	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	4.24	4.22		4.21
PULL #2	4.21	4.23		4.30
PULL #3	4.30	4.22		4.21
PULL #4	4.42	4.32		4.28
PULL #5	4.29	4.29		4.32
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6648980
25 Nov 1991

CENTROIDAL DISTANCES

0 TO	1	.48434
1 TO	2	.570022
1 TO	3	.56657
1 TO	4	.559904
1 TO	5	.441989

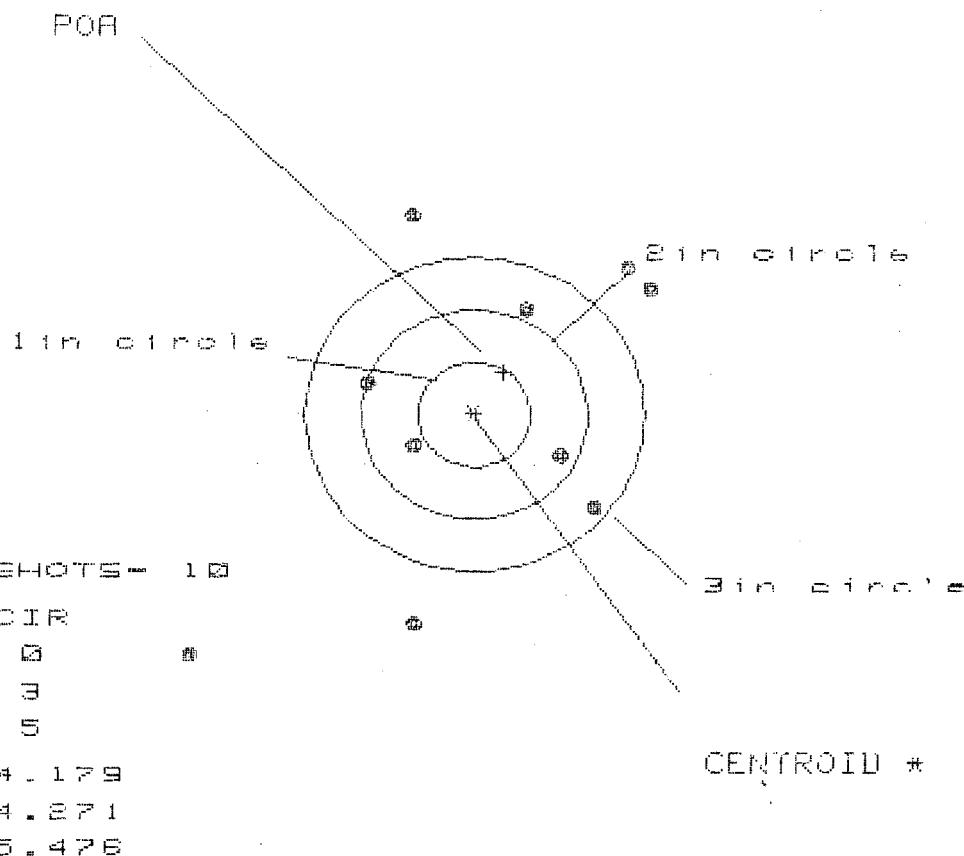
92 (----POA
1

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0532
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0486
THE RESULTING AVERAGE POI RADII'S FOR THIS RIFLE IS: .0720569
THE AMR FOR THIS RIFLE IS: 1.252

25 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66489B0

CENTERFIRE PATTERNS # 1

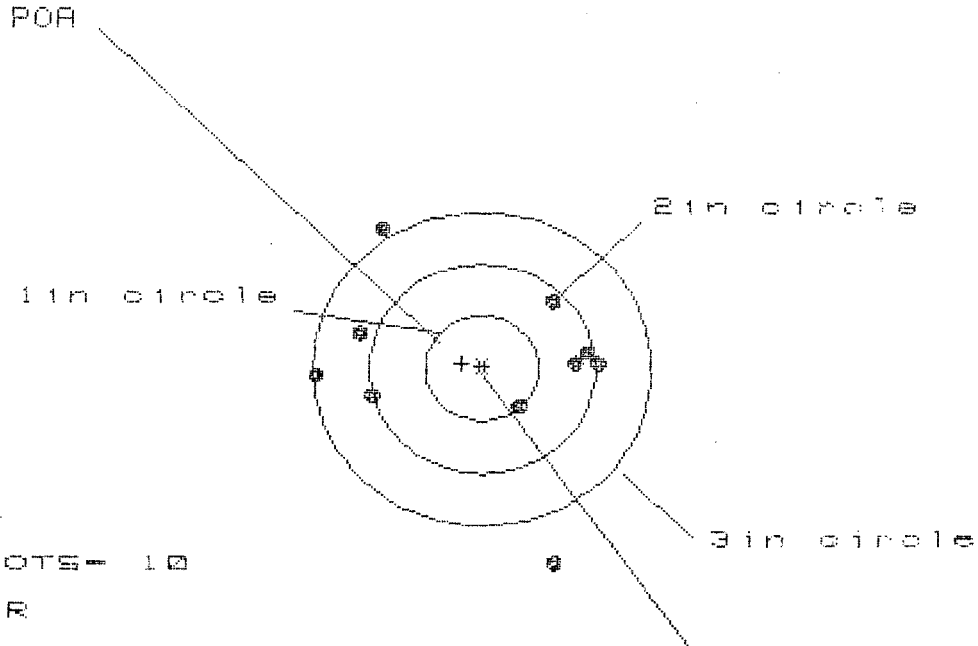


PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.593	1.306	1.201
MINIMUM X	:	-2.586	-1.231	-1.336
MAXIMUM Y	:	1.942	1.683	1.404
MINIMUM Y	:	-2.329	-2.230	-1.435
CENTROID X	:	-.261	.027	.132
CENTROID Y	:	-.408	-.149	.130
POA TO CENTROID in.	:	.484	.151	.185
MIN RADIUS	:	.594	.722	.429
MEAN RADIUS	:	1.632	1.388	1.235
MAX RADIUS	:	3.480	2.383	1.683
HORIZONTAL SPREAD	:	4.179	2.537	2.537
VERTICAL SPREAD	:	4.271	3.913	2.839
EXTREME SPREAD	:	5.476	3.913	3.250
NUMBER IN ONE INCH CIRCLE	=	0	0	0
NUMBER IN TWO INCH CIRCLE	=	0	3	3
NUMBER IN THREE INCH CIRCLE	=	0	5	5

25 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6846380

CENTERFIRE PATTERNS # 2



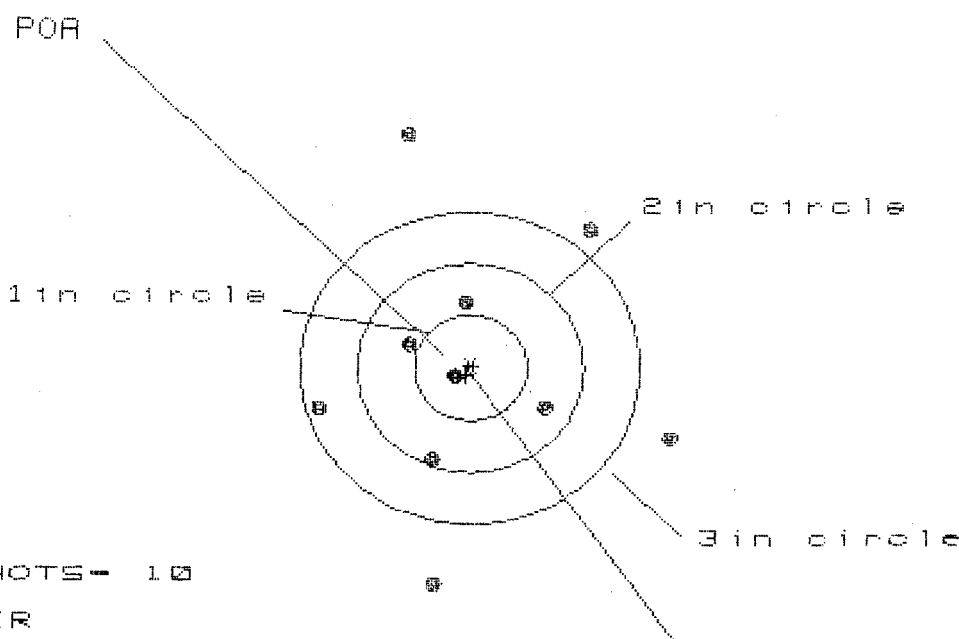
OF SHOTS- 10
IN CIR
1 in = 1
2 in = 4
3 in = 8
HS= 2.537
VS= 3.256
GS= 3.579

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.065	1.134	1.034
MINIMUM X	-1.472	-1.403	-1.503
MAXIMUM Y	1.386	1.179	.553
MINIMUM Y	-1.870	-.585	-.438
CENTROID X	.176	.107	.207
CENTROID Y	-.042	.165	.018
POA TO CENTROID in.	.191	.197	.208
MIN RADIUS	.491	.699	.521
MEAN RADIUS	1.145	1.054	.976
MAX RADIUS	1.969	1.424	1.505
HORIZONTAL SPREAD	2.537	2.537	2.537
VERTICAL SPREAD	3.256	1.764	.991
EXTREME SPREAD	3.579	2.537	2.537
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

25 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06648360

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 6

HS= 3.105

VS= 4.373

GS= 4.378

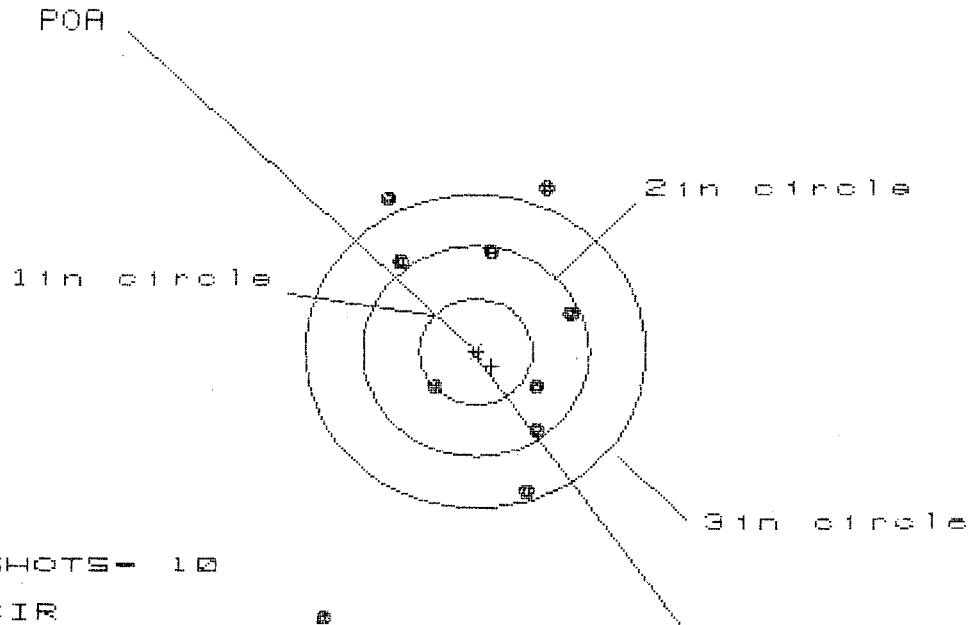
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.723	1.660	1.609
MINIMUM X	:	-1.382	-1.445	-1.496
MAXIMUM Y	:	2.273	1.563	1.332
MINIMUM Y	:	-2.100	-1.847	-.844
CENTROID X	:	.040	.103	.154
CENTROID Y	:	.072	-.181	.050
POA TO CENTROID in.	:	.082	.208	.162
MIN RADIUS	:	.188	.245	.276
MEAN RADIUS	:	1.261	1.138	1.031
MAX RADIUS	:	2.342	1.892	1.721
HORIZONTAL SPREAD	:	3.105	3.105	3.105
VERTICAL SPREAD	:	4.373	3.410	2.176
EXTREME SPREAD	:	4.378	3.684	3.119
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		6	

25 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C664B9B0

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 7

HS= 2.188

VS= 4.043

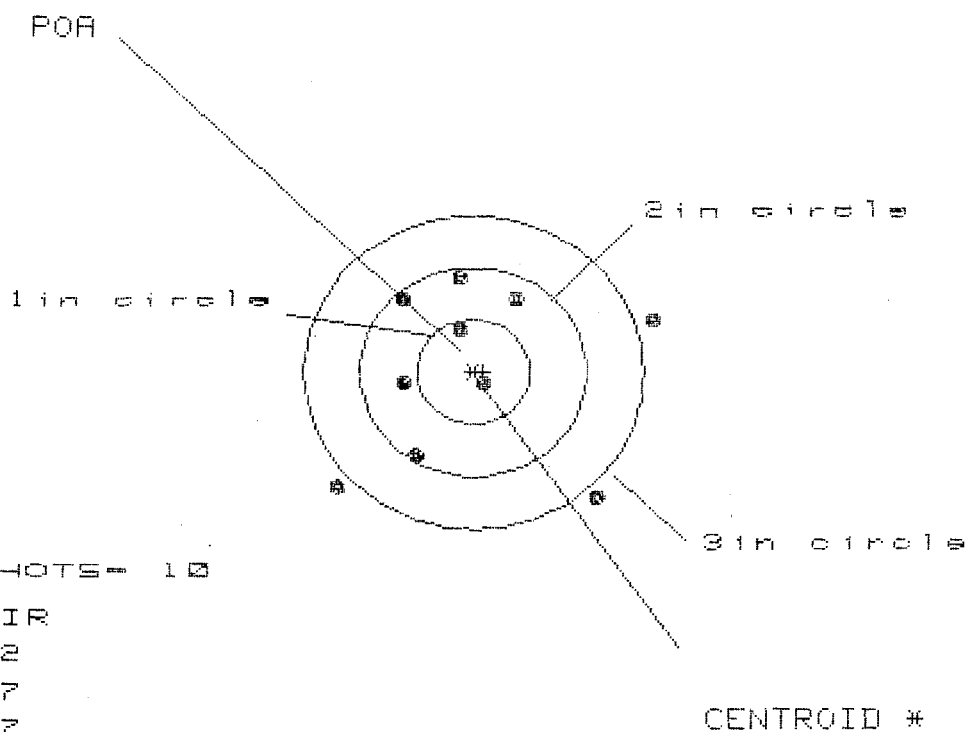
GS= 4.515

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.836	.686	.750
MINIMUM X	-1.352	-.920	-.856
MAXIMUM Y	1.553	1.276	1.330
MINIMUM Y	-2.490	-1.594	-1.434
CENTROID X	-.137	.013	-.051
CENTROID Y	.138	.415	.255
POA TO CENTROID in.	.195	.415	.260
MIN RADIUS	.478	.687	.621
MEAN RADIUS	1.255	1.051	.998
MAX RADIUS	2.833	1.626	1.582
HORIZONTAL SPREAD	2.188	1.606	1.606
VERTICAL SPREAD	4.043	2.870	2.764
EXTREME SPREAD	4.515	3.031	3.031
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

25 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C664B3B0

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 7

HS= 2.817

VS= 2.130

GS= 3.263

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.576	1.304	1.171
MINIMUM X	:	-1.241	-1.066	-.572
MAXIMUM Y	:	.918	.977	.846
MINIMUM Y	:	-1.212	-1.153	-1.284
CENTROID X	:	-.084	-.259	-.126
CENTROID Y	:	-.003	-.062	.069
POA TO CENTROID in.	:	.084	.267	.143
MIN RADIUS	:	.122	.270	.202
MEAN RADIUS	:	.966	.880	.778
MAX RADIUS	:	1.665	1.740	1.737
HORIZONTAL SPREAD	:	2.817	2.370	1.743
VERTICAL SPREAD	:	2.130	2.130	2.130
EXTREME SPREAD	:	3.263	2.592	2.592
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			7	

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6648980
13 Dec 1991

CENTROIDAL DISTANCES

0 TO	1	.212085
1 TO	2	.119202
1 TO	3	.312706
1 TO	4	.270749
1 TO	5	.177102

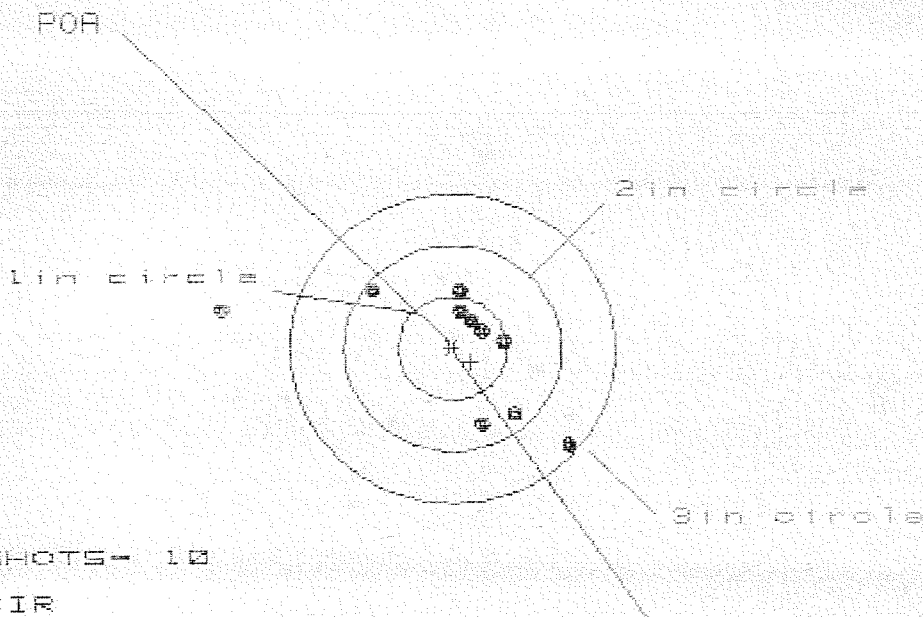
37 <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0624
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1392
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .152546
THE AMR FOR THIS RIFLE IS: .97

13 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C664B9B0.1

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 8

3 in = 9

HS= 3.136

VS= 1.583

GS= 3.397

CENTROID +

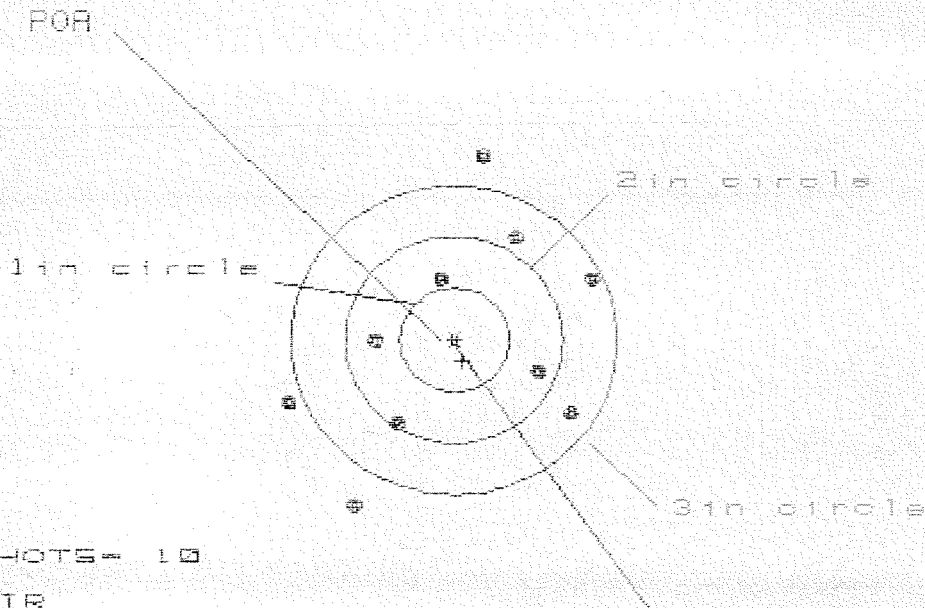
PATTERN # 1

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.026	.791	.418
MINIMUM X	-2.110	-1.010	-.919
MAXIMUM Y	.606	.642	.525
MINIMUM Y	-.977	-.941	-.830
CENTROID X	-.166	.069	-.030
CENTROID Y	.132	.096	.213
POA TO CENTROID in.	.212	.118	.215
MIN RADIUS	.321	.196	.173
MEAN RADIUS	.829	.634	.532
MAX RADIUS	2.136	1.229	1.021
HORIZONTAL SPREAD	3.136	1.809	1.337
VERTICAL SPREAD	1.583	1.583	1.355
EXTREME SPREAD	3.397	2.353	1.790
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		9	

13 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06040980.1

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 4

3 in = 7

HS = 2.720

VS = 3.482

GS = 3.683

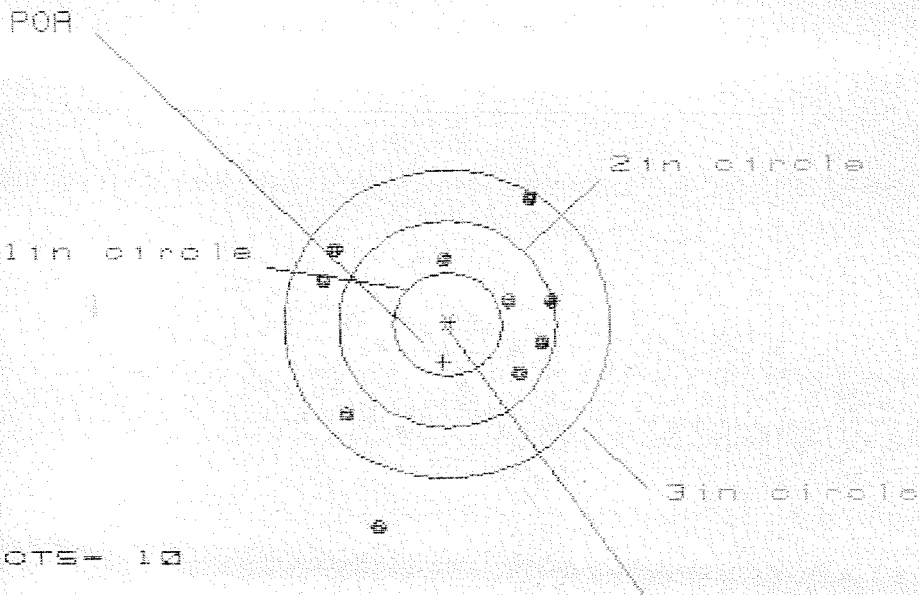
CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.232	1.129	1.151
MINIMUM X	-1.488	-1.591	-1.569
MAXIMUM Y	1.833	1.650	1.050
MINIMUM Y	-1.649	-0.949	-1.743
CENTROID X	-0.071	.032	.010
CENTROID Y	.204	.387	.180
POA TO CENTROID in.	.216	.388	.181
MIN RADIUS	.576	.455	.625
MEAN RADIUS	1.219	1.127	1.054
MAX RADIUS	1.890	1.754	1.657
HORIZONTAL SPREAD	2.720	2.720	2.720
VERTICAL SPREAD	3.482	2.599	1.793
EXTREME SPREAD	3.683	2.969	2.948
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

13 Dec 1981

FILE:/PATTERNING/CENTERFIRE_PATT/C684B390.1

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 0

2in = 5

3in = 9

HS= 2.128

VS= 3.200

GS= 3.492

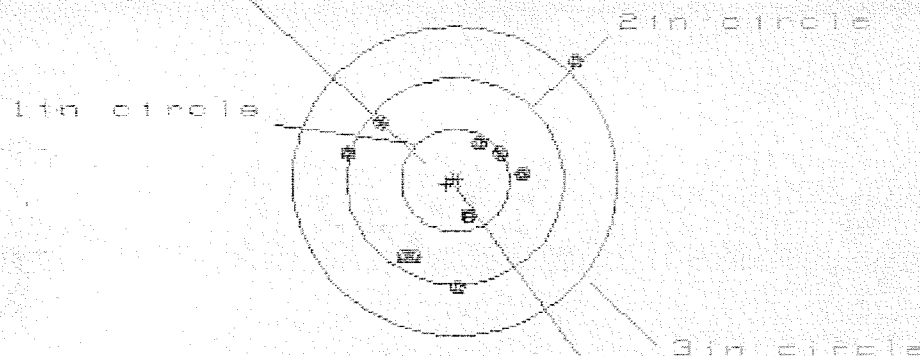
PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	.972
MINIMUM X	-1.156
MAXIMUM Y	1.279
MINIMUM Y	-1.921
CENTROID X	.038
CENTROID Y	.369
POA TO CENTROID in.	.371
MIN RADIUS	.557
MEAN RADIUS	1.128
MAX RADIUS	2.023
HORIZONTAL SPREAD	2.128
VERTICAL SPREAD	3.200
EXTREME SPREAD	3.492
NUMBER IN ONE INCH CIRCLE	0
NUMBER IN TWO INCH CIRCLE	5
NUMBER IN THREE INCH CIRCLE	9

13 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C664B980.1

CENTERFIRE PATTERNS # 4

POB



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 2.128

VS= 2.258

GS= 2.535

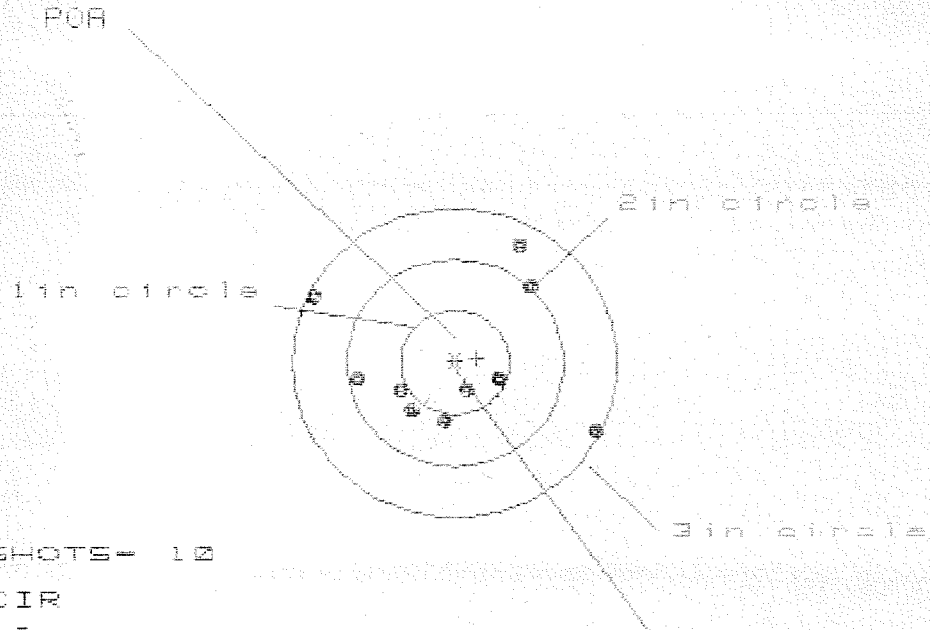
CENTROID *

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.148	.728	.743
MINIMUM X	-.980	-.853	-.838
MAXIMUM Y	1.210	.748	.634
MINIMUM Y	-1.048	-.913	-.714
CENTROID X	.086	-.041	-.056
CENTROID Y	.033	-.102	.012
POB TO CENTROID IN.	.092	.110	.058
MIN RADIUS	.339	.298	.390
MEAN RADIUS	.823	.721	.695
MAX RADIUS	1.668	.940	.884
HORIZONTAL SPREAD	2.128	1.581	1.581
VERTICAL SPREAD	2.258	1.661	1.348
EXTREME SPREAD	2.535	1.778	1.592
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

08/08/1991

FILE:/PATTERNING/CENTERFIRE_PATT/C854B380.1

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 2.655

VS= 1.841

GS= 2.965

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.317
MINIMUM X	-1.338
MAXIMUM Y	1.149
MINIMUM Y	-.692
CENTROID X	-.199
CENTROID Y	-.042
POB TO CENTROID in.	.203
MIN RADIUS	.231
MEAN RADIUS	.859
MAX RADIUS	1.487
HORIZONTAL SPREAD	2.655
VERTICAL SPREAD	1.841
EXTREME SPREAD	2.965
NUMBER IN ONE INCH CIRCLE	2
NUMBER IN TWO INCH CIRCLE	6
NUMBER IN THREE INCH CIRCLE	10