

FORM

UPC



05548987

CAPACITY*
*INCLUDES 1 IN CHAMBER

MODEL 700 TM M24

ORDER NO. 5715

BARREL LENGTH

Remington



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

MODEL 700TM M24

SERIAL NO.

C6648987

ORDER NO.

5716

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

2/0



5716 C6648987

ORDER 5716

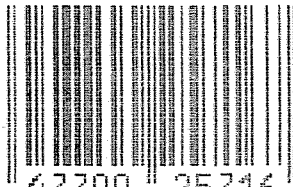
MODEL 700TM M24

UPC

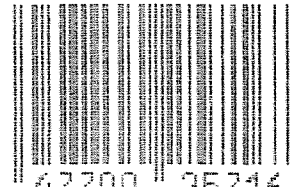
ORDER 5716

MODEL 700TM M24

UPC



0 47700 25716 7



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6648987

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	7 2 9 1		RW
612	Magnaflux Barrel Action		JUL 22 1991	LS
	Magnaflux Bolt		JUL 22 1991	LS
615	Rollmark Caliber		JUL 22 1991	LS
617	Drill and Tap Sight Holes		JUL 22 1991	LB
618	Polish Barrel		7/22/91	WB
620	Apply Coatings (Barrel Action)		8-22-91	LS
	Apply Coating (Bolt)			
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		9/11/91	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			9/11/91	SL
	G) Safety Off Force	2	2	2			9/11/91	SL
	H) Trigger Pull Test & Retainability						9/11/91	SL
	I) Firing Pin Indent	.0205	.0205	.020			9/11/91	SL
	J) Assemble Stock						10/2/91	RW
	K) Assemble Swivel Studs						10/14/91	SL
	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	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						10-10-91	NF
655	Final Inspection							
	A) Headspace						10/14/91	SL
	B) Trigger Pull	2.51	2.53	2.48	2.50	2.32	10/14/91	SL
	C) Function						10/14/91	SL
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 C-6648987

DATE 9-11-91

TESTER SM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.51	2.50	2.51	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.37	2.48	2.55	2.53	
PULL #3	2.34	2.67	2.49	2.48	
PULL #4	2.37	2.46	2.51	2.50	
PULL #5	2.45	2.56	2.55	2.32	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.61	3.53		
PULL #2	3.65	3.67		
PULL #3	3.64	3.63		
PULL #4	3.58	3.64		
PULL #5	3.56	3.69		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.25	4.47		4.37
PULL #2	4.20	4.52		4.35
PULL #3	4.40	4.52		4.41
PULL #4	4.20	4.40		4.46
PULL #5	4.59	4.51		4.51
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6648987
10 Oct 1991

CENTROIDAL DISTANCES

0 TO 1	.496566
1 TO 2	.301788
1 TO 3	.881766
1 TO 4	.320058
1 TO 5	.63717

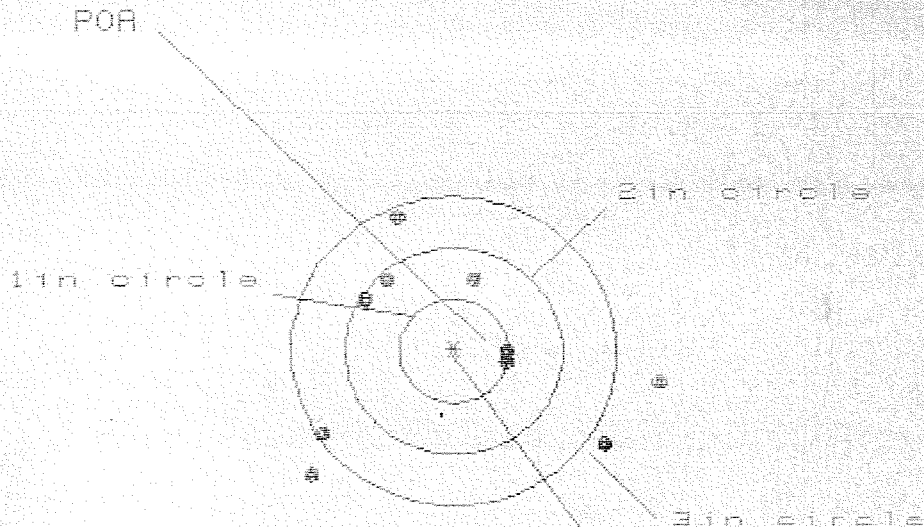
$\frac{1}{5} \sum_{i=1}^5 x_i$ <---- POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1134
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0202
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .115185
THE AMR FOR THIS RIFLE IS: 1.036

10 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C864B9B7

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 4

HS= 3.245

VS= 2.495

GS= 3.373

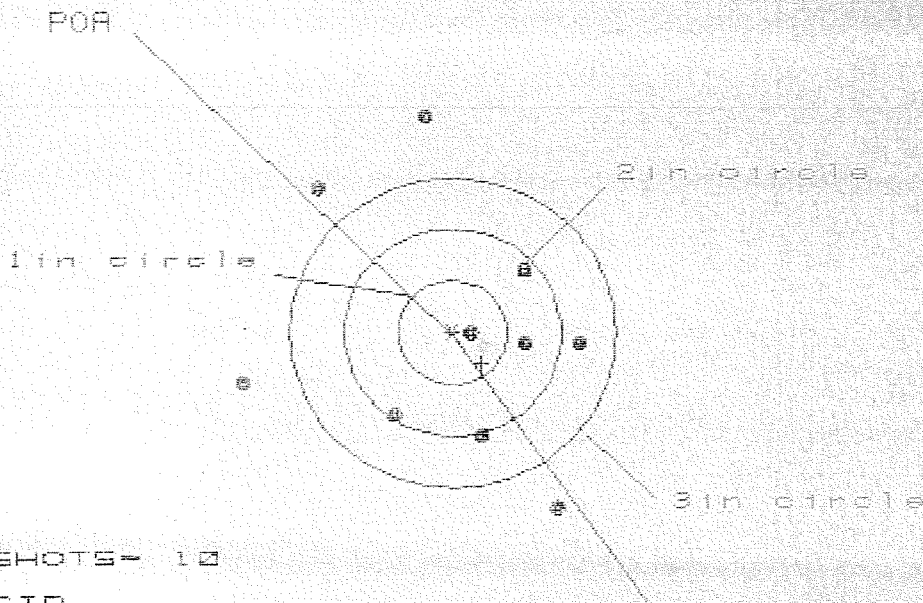
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.916	1.606	1.466
MINIMUM X	:	-1.329	-1.116	-1.167
MAXIMUM Y	:	1.320	1.292	1.141
MINIMUM Y	:	-1.175	-1.203	-1.037
CENTROID X	:	-.487	-.700	-.560
CENTROID Y	:	.097	.125	.276
POA TO CENTROID in.	:	.497	.711	.625
MIN RADIUS	:	.486	.699	.573
MEAN RADIUS	:	1.176	1.085	.977
MAX RADIUS	:	1.933	1.834	1.796
HORIZONTAL SPREAD	:	3.245	2.722	2.634
VERTICAL SPREAD	:	2.495	2.495	2.178
EXTREME SPREAD	:	3.373	2.864	2.864
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	7		

18 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08648987

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 5

HS= 2.145

VS= 3.853

GS= 4.046

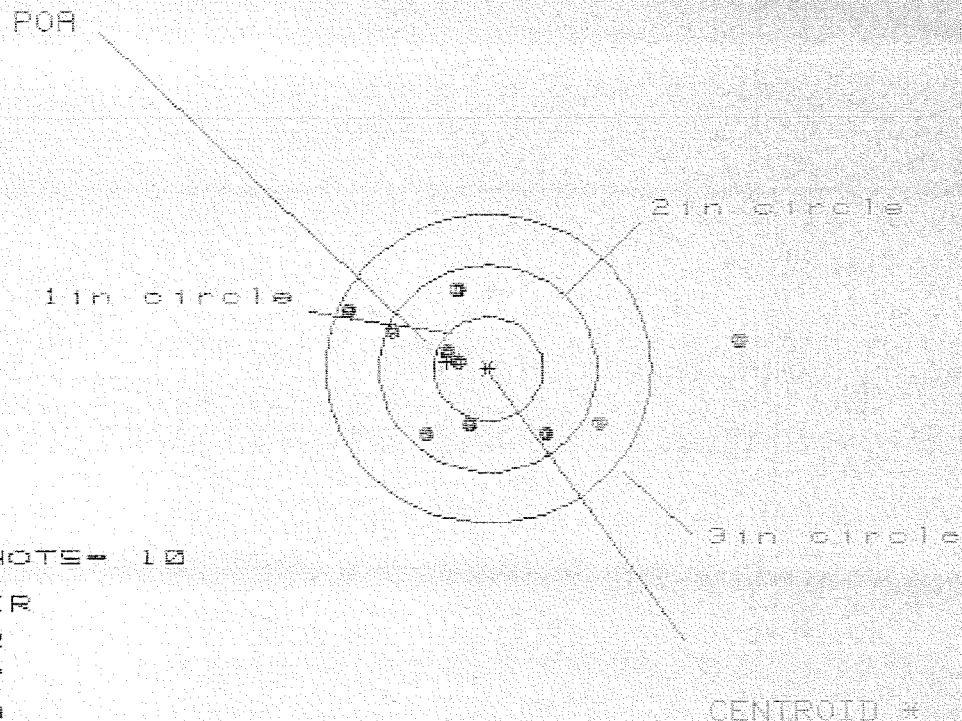
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.207	1.179	.903
MINIMUM X	:	-1.938	-1.966	-1.515
MAXIMUM Y	:	2.147	1.612	1.583
MINIMUM Y	:	-1.706	-1.468	-1.497
CENTROID X	:	-.261	-.233	.013
CENTROID Y	:	.297	.059	.088
POA TO CENTROID in.	:	.395	.240	.089
MIN RADIUS	:	.215	.341	.268
MEAN RADIUS	:	1.296	1.180	1.021
MAX RADIUS	:	2.162	2.052	2.191
HORIZONTAL SPREAD	:	3.145	3.145	2.448
VERTICAL SPREAD	:	3.853	3.080	3.080
EXTREME SPREAD	:	4.046	3.797	3.797
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	

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FILE: PATTERNING/CENTERFIRE_PATT/C864B9B7

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 3.625

VS= 1.349

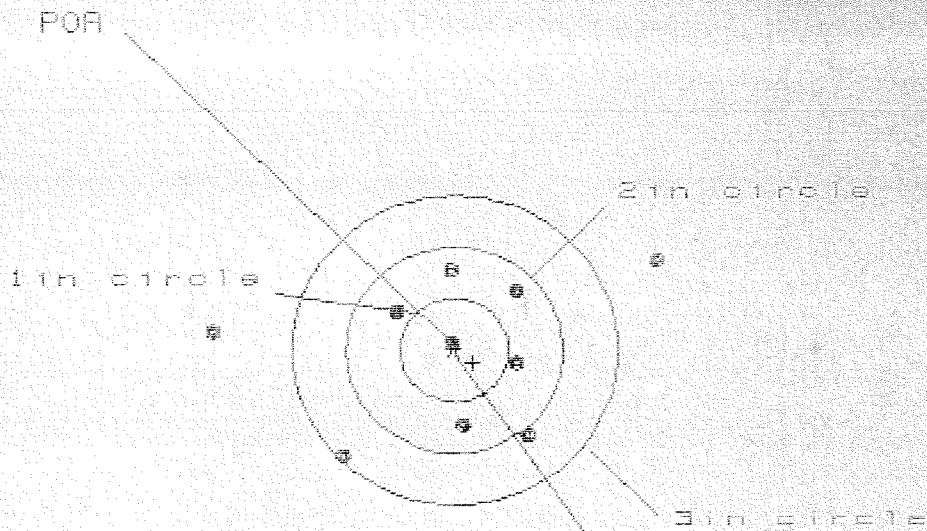
GS= 3.638

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.347	1.317	1.190
MINIMUM X	:	-1.278	-1.017	-.768
MAXIMUM Y	:	.745	.776	.853
MINIMUM Y	:	-.684	-.573	-.496
CENTROID X	:	.379	.118	.245
CENTROID Y	:	-.069	-.100	-.177
POA TO CENTROID in.	:	.385	.155	.302
MIN RADIUS	:	.331	.152	.283
MEAN RADIUS	:	.961	.732	.693
MAX RADIUS	:	2.364	1.416	1.270
HORIZONTAL SPREAD	:	3.625	2.334	1.958
VERTICAL SPREAD	:	1.349	1.349	1.349
EXTREME SPREAD	:	3.638	2.594	2.172
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			9	

10 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6648987

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 8

HS= 4.105

VS= 1.900

GS= 4.164

CENTROID *

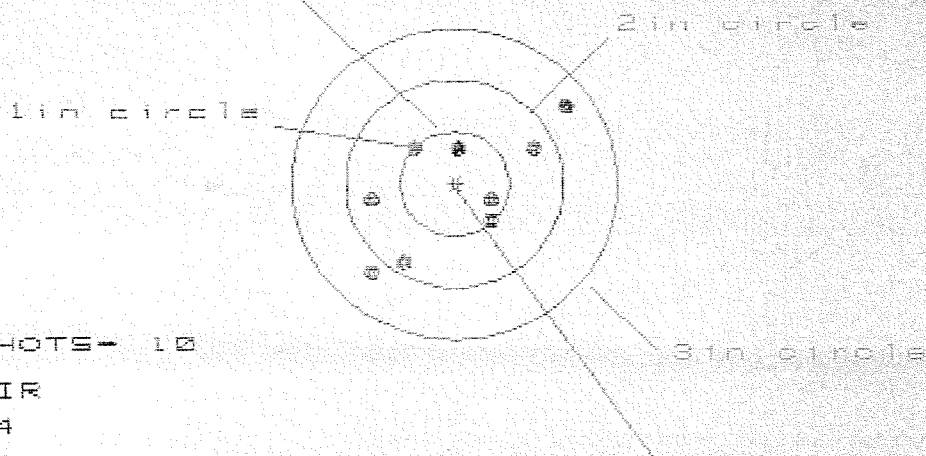
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.900	1.655	.624
MINIMUM X	:	-2.205	-1.260	-1.053
MAXIMUM Y	:	.833	.840	.902
MINIMUM Y	:	-1.067	-1.052	-.946
CENTROID X	:	-.168	.077	-.130
CENTROID Y	:	.123	.100	.002
POA TO CENTROID in.	:	.200	.132	.130
MIN RADIUS	:	.071	.307	.189
MEAN RADIUS	:	1.048	.914	.785
MAX RADIUS	:	2.209	1.860	1.415
HORIZONTAL SPREAD	:	4.105	2.915	1.677
VERTICAL SPREAD	:	1.900	1.900	1.848
EXTREME SPREAD	:	4.164	3.460	2.286
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

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FILE:/PATTERNING/CENTERFIRE_PATT/C864B987

CENTERFIRE PATTERNS # 5

POA



OF SHOTS- 10

IN CIR

1in = 4

2in = 8

3in = 10

HS= 1.848

VS= 1.510

GS= 2.386

CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.048	.873	.786
MINIMUM X	-.808	-.692	-.745
MAXIMUM Y	.701	.450	.359
MINIMUM Y	-.809	-.731	-.762
CENTROID X	-.030	-.146	-.059
CENTROID Y	-.347	-.425	-.334
POA TO CENTROID in.	.349	.450	.339
MIN RADIUS	.312	.409	.343
MEAN RADIUS	.697	.644	.572
MAX RADIUS	1.254	1.007	.902
HORIZONTAL SPREAD	1.848	1.565	1.531
VERTICAL SPREAD	1.510	1.181	1.121
EXTREME SPREAD	2.386	1.957	1.689
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		