

FORM

UPC



0 47700 25716 7

C6649023

*INCLUDES 1 IN CHAMBER

CAPACITY*

BARREL LENGTH

5716

ORDER NO.

MODEL 700 TM M24

Remington



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

MODEL 700 TM M24

SERIAL NO.
C6649023

20

ORDER NO.
5716

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



5716 C6649023

ORDER **5716**

MODEL 700 TM M24

UPC

ORDER **5716**

MODEL 700 TM M24

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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649023

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		11-13-91	JH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			11-14-91	JH
	G) Safety Off Force	3	3	3			11-14-91	JH
	H) Trigger Pull Test & Retainability						11-13-91	JH
	I) Firing Pin Indent	.0205	.020	.0205			11-14-91	JH
	J) Assemble Stock						11/15/91	RW
	K) Assemble Swivel Studs						11-21-91	JH
	L) Attach Front and Rear Sight Assemblies						11/15/91	RW
	M) Iron Sight Alignment						11/10/91	RW
	N) Detach Front & Rear Sights & place in numbered container						11/15/91	RW
	O) Attach Scope to Rifle						11/15/91	RW
	P) Detach & Attach Scope 20 Times						11/15/91	RW
640	Gallery Target & Test						11-19-91	DH
	A) Time						11-19-91	DH
	B) Malfunctions						11-19-91	DH
	C) Pierced Primers						11-19-91	DH
	D) Optical Clarity of Scope						11-19-91	DH
645	Inspect for Live Ammo						11-19-91	DH
655	Final Inspection							
	A) Headspace						11-21-91	JH
	B) Trigger Pull	2.59	2.51	2.56	2.52	2.52	11-19-91	DH
	C) Function						11-21-91	JH
660	Pack						12-20-91	NE

SWS TRIGGER PULL TEST

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

SERIAL NO C-6649023

DATE 11-13-91

TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.42	2.41	2.45	2.59	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.35	2.36	2.38	2.51	
PULL #3	2.27	2.33	2.41	2.56	
PULL #4	2.39	2.39	2.41	2.52	
PULL #5	2.41	2.40	2.46	2.52	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.59	3.17		
PULL #2	3.52	3.43		
PULL #3	3.47	3.44		
PULL #4	3.41	3.40		
PULL #5	3.46	3.47		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.45	4.50		4.53
PULL #2	4.46	4.50		4.48
PULL #3	4.38	4.31		4.41
PULL #4	4.45	4.29		4.43
PULL #5	4.31	4.54		4.58
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649023
19 Nov 1991

CENTROIDAL DISTANCES

0 TO	1	.126115
1 TO	2	.287127
1 TO	3	.158433
1 TO	4	.184296
1 TO	5	.283917

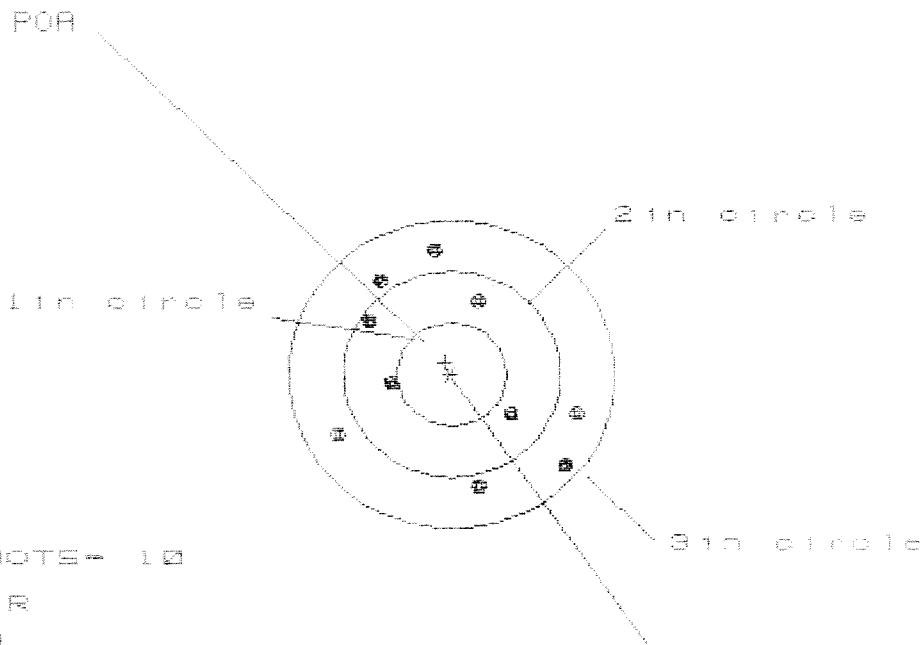
$\frac{5}{24}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0354
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.021
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0411502
THE AMR FOR THIS RIFLE IS: .872

13 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08545023

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 0

2in = 4

3in = 10

HS= 2.245

VS= 2.284

GS= 2.432

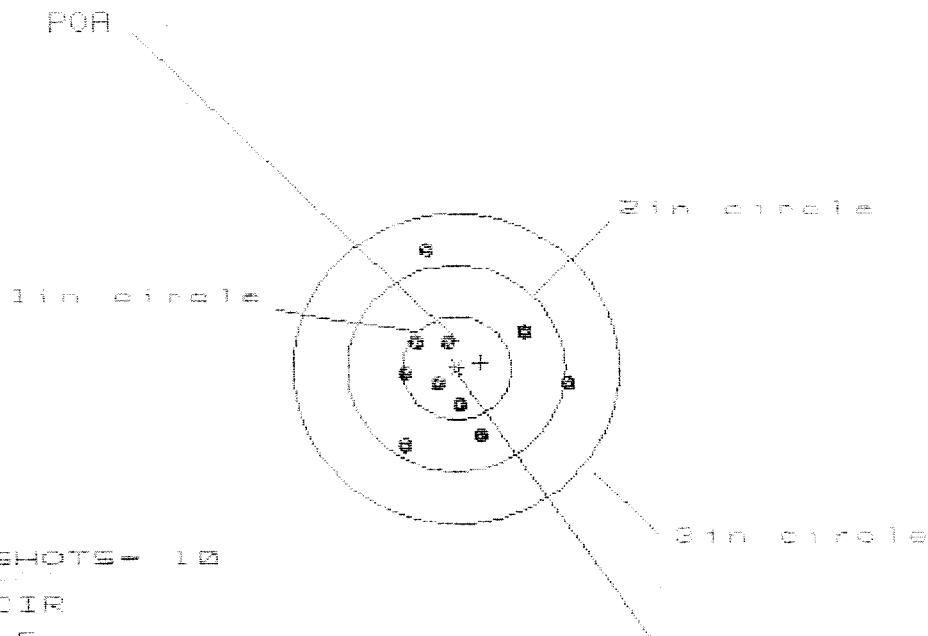
CENTROID #

PATTERN #			
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.141	1.257	1.133
MINIMUM X	-1.103	-.988	-.716
MAXIMUM Y	1.165	1.071	.984
MINIMUM Y	-1.119	-1.213	-1.300
CENTROID X	.056	-.059	.064
CENTROID Y	-.113	-.019	.068
POA TO CENTROID in.	.127	.062	.093
MIN RADIUS	.512	.424	.573
MEAN RADIUS	1.003	.945	.906
MAX RADIUS	1.341	1.334	1.319
HORIZONTAL SPREAD	2.245	2.245	1.849
VERTICAL SPREAD	2.284	2.284	2.284
EXTREME SPREAD	2.432	2.319	2.319
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	4	
NUMBER IN THREE INCH CIRCLE	=	10	

19 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08645023

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 5

2 in = 8

3 in = 10

HS= 1.495

VS= 1.958

GS= 1.962

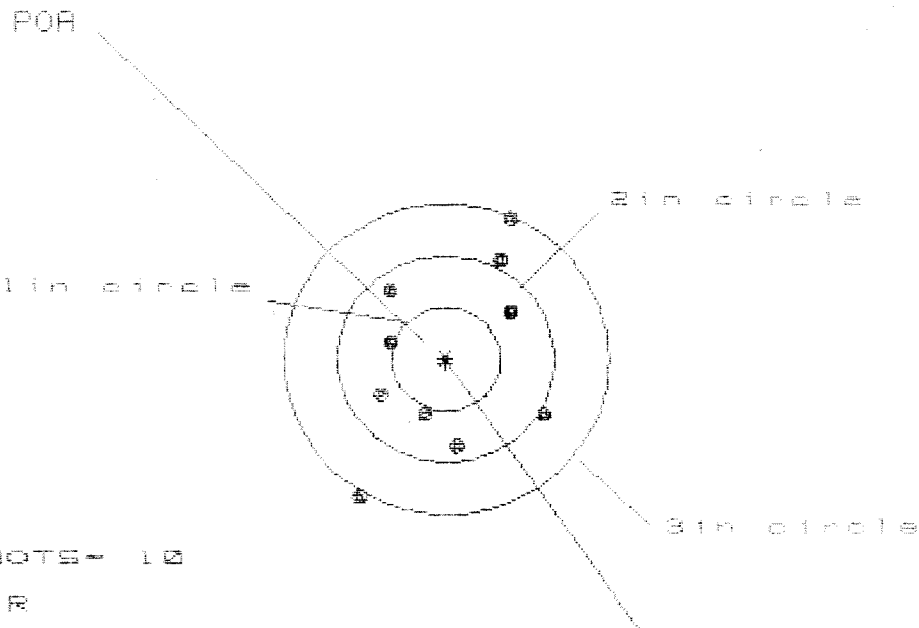
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.010	.974	.664
MINIMUM X	-.485	-.521	-.399
MAXIMUM Y	1.201	.502	.503
MINIMUM Y	-.757	-.623	-.622
CENTROID X	-.225	-.190	-.312
CENTROID Y	-.054	-.188	-.189
POA TO CENTROID in.	.232	.267	.365
MIN RADIUS	.215	.207	.085
MEAN RADIUS	.619	.541	.459
MAX RADIUS	1.243	.974	.833
HORIZONTAL SPREAD	1.495	1.495	1.063
VERTICAL SPREAD	1.958	1.125	1.125
EXTREME SPREAD	1.962	1.590	1.523
NUMBER IN ONE INCH CIRCLE	=	5	
NUMBER IN TWO INCH CIRCLE	=	8	
NUMBER IN THREE INCH CIRCLE	=	10	

19 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08649023

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 1.750

VS= 2.669

GS= 3.025

CENTROID *

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.898	.804	.863
MINIMUM X	-.852	-.704	-.645
MAXIMUM Y	1.344	1.197	.993
MINIMUM Y	-1.325	-1.025	-.876
CENTROID X	.905	.899	.840
CENTROID Y	.037	.184	.035
POA TO CENTROID in.	.037	.209	.053
MIN RADIUS	.524	.589	.559
MEAN RADIUS	.953	.884	.815
MAX RADIUS	1.575	1.298	1.081
HORIZONTAL SPREAD	1.750	1.508	1.508
VERTICAL SPREAD	2.669	2.222	1.869
EXTREME SPREAD	3.025	2.276	1.908
NUMBER IN ONE INCH CIRCLE =		8	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

15 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649023

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS = 2.891

VS = 2.728

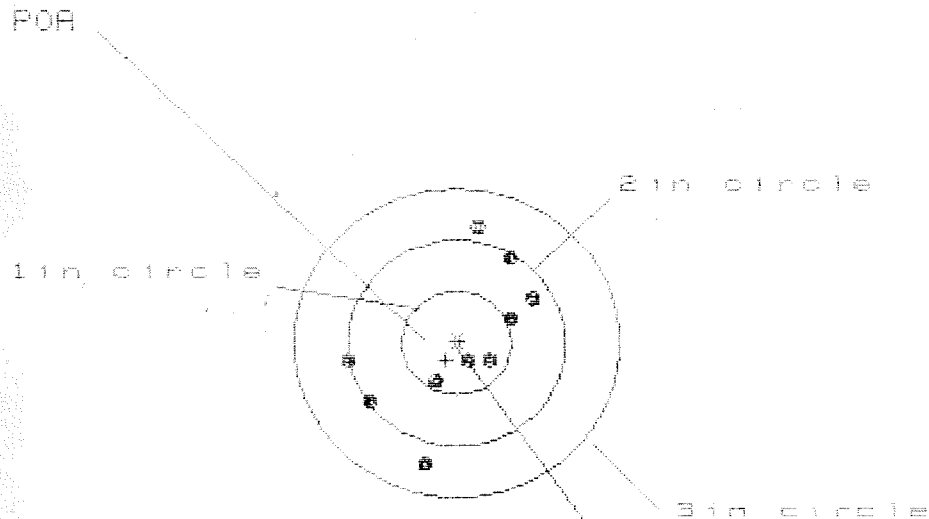
CS = 2.899

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	9
MAXIMUM X	:	1.469	1.434	1.474
MINIMUM X	:	-1.422	-1.457	-1.278
MAXIMUM Y	:	1.534	.975	.974
MINIMUM Y	:	-1.194	-1.024	-1.025
CENTROID X	:	.238	.273	.094
CENTROID Y	:	-.142	-.313	-.312
POA TO CENTROID in.	:	.278	.415	.325
MIN RADIUS	:	.497	.325	.372
MEAN RADIUS	:	1.035	.964	.883
MAX RADIUS	:	1.565	1.474	1.500
HORIZONTAL SPREAD	:	2.891	2.691	2.752
VERTICAL SPREAD	:	2.728	1.999	1.999
EXTREME SPREAD	:	2.899	2.899	2.798
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

19 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08049023

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 1.548

VS= 2.251

GS= 2.300

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.649	.616	.633
MINIMUM X	:	-.999	-1.032	-1.015
MAXIMUM Y	:	1.089	.959	.790
MINIMUM Y	:	-1.163	-.723	-.603
CENTROID X	:	.103	.136	.119
CENTROID Y	:	.167	.297	.177
POA TO CENTROID in.	:	.196	.326	.213
MIN RADIUS	:	.237	.343	.237
MEAN RADIUS	:	.750	.701	.647
MAX RADIUS	:	1.201	1.070	1.025
HORIZONTAL SPREAD	:	1.648	1.548	1.548
VERTICAL SPREAD	:	2.251	1.682	1.393
EXTREME SPREAD	:	2.300	1.921	1.841
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	