

BARREL LENGTH

CAPACITY*

*INCLUDES 1 IN CHAMBER

C6649050

UPC



0 47700 25716 7

FORM

Smith
Smead®

MODEL 700 TM M24

ADDER M
E71E

Remington



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

MODEL 700 TM M24

SERIAL NO.

C6649050

ORDER NO.

5716

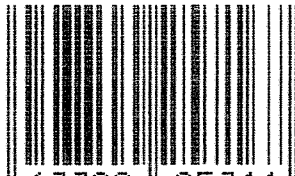
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off. Marca Registrada Marque Deposee.



5716 C6649050

ORDER 5716
MODEL 700 TM M24

UPC



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ORDER 5716
MODEL 700 TM M24

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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649050

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 26	9 1	RW
600	Proof	9 26	9 1	RW
607	Check Headspace	9 26	9 1	RW
610	Dis-assemble Gun	2	9 1	RW
612	Magnaflux Barrel Action	OCT	3 1991	KCD
	Magnaflux Bolt	OCT	3 1991	KCD
615	Rollmark Caliber	OCT	3 1991	GS
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	
	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		11-11-91	RL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			11-11-91	JH
	G) Safety Off Force	4	4	4			11-11-91	JH
	H) Trigger Pull Test & Retainability						11-11-91	JH
	I) Firing Pin Indent	.0205	.020	.0205			11-11-91	JH
	J) Assemble Stock						11/11/91	RW
	K) Assemble Swivel Studs						11-27-91	AC
	L) Attach Front and Rear Sight Assemblies						11/11/91	RW
	M) Iron Sight Alignment						11/11/91	RW
	N) Detach Front & Rear Sights & place in numbered container						11/11/91	RW
	O) Attach Scope to Rifle						11/11/91	RW
	P) Detach & Attach Scope 20 Times						11/11/91	RW
640	Gallery Target & Test						11-14-91	DH
	A) Time						11-14-91	DH
	B) Malfunctions						11-14-91	DH
	C) Pierced Primers						11-14-91	DH
	D) Optical Clarity of Scope						11-14-91	DH
645	Inspect for Live Ammo						11-14-91	DH
655	Final Inspection							
	A) Headspace						11-27-91	AC
	B) Trigger Pull	2.14	2.04	2.04	1.96	2.05	11-14-91	DH
	C) Function						11-27-91	AC
660	Pack						12-19-91	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-6649050

DATE 11-11-91

TESTER JLP.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.27	2.40	2.40	2.14	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.32	2.40	2.39	2.04	
PULL #3	2.27	2.42	2.44	2.04	
PULL #4	2.45	2.39	2.38	1.96	
PULL #5	2.42	2.37	2.30	2.05	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.63	3.25		
PULL #2	3.50	3.22		
PULL #3	3.64	3.19		
PULL #4	3.66	3.27		
PULL #5	3.58	3.30		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.38	4.44		4.44
PULL #2	4.19	4.20		4.53
PULL #3	4.21	4.38		4.38
PULL #4	4.27	4.35		4.42
PULL #5	4.20	4.42		4.33
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06649050
15 Nov 1991

CENTROIDAL DISTANCES

0	TO	1	.12855
1	TO	2	.283656
1	TO	3	.155438
1	TO	4	.194201
1	TO	5	.125734

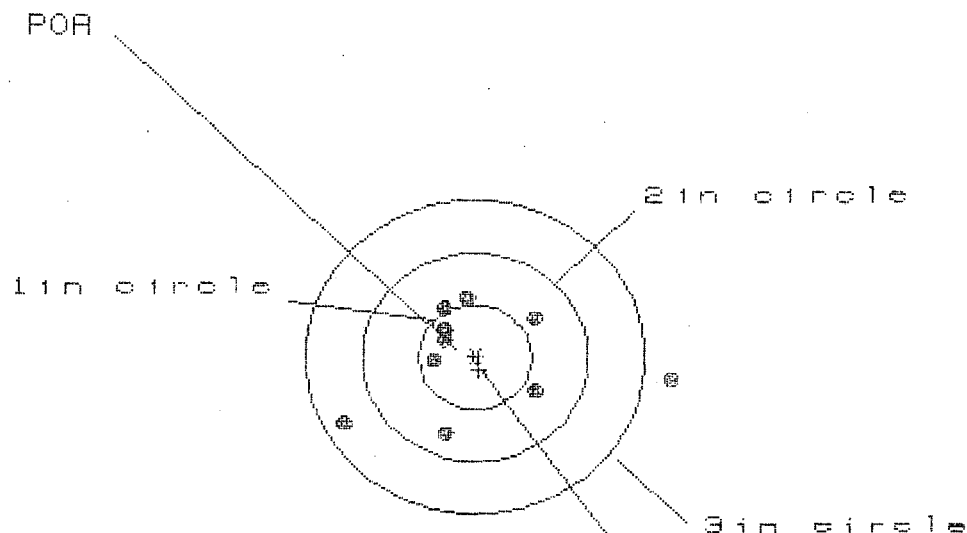
σ^2 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0202
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0842
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0865891
THE AMR FOR THIS RIFLE IS: .8912

15 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649050.1

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 9

HS= 2.944

VS= 1.282

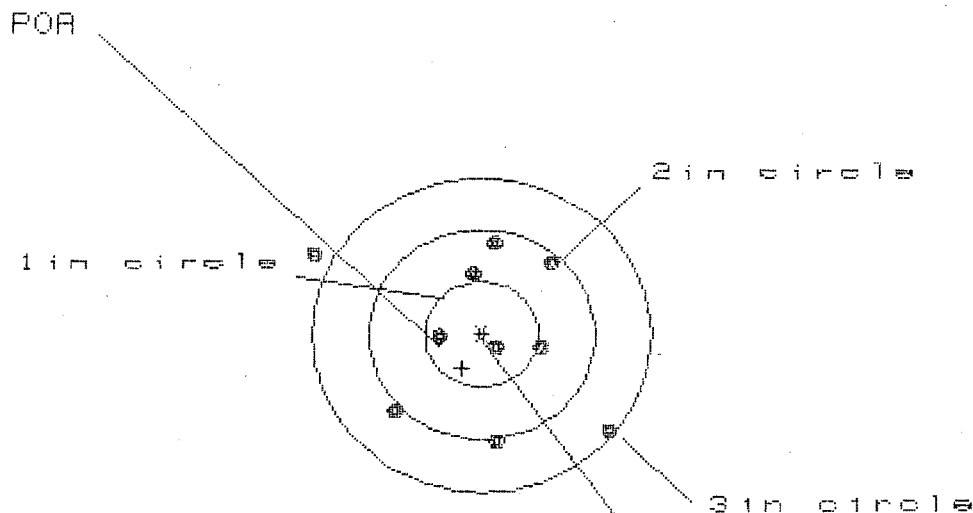
GS= 2.967

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.749	.710	.585
MINIMUM X	-1.195	-1.001	-.274
MAXIMUM Y	.584	.558	.479
MINIMUM Y	-.698	-.724	-.803
CENTROID X	-.030	-.224	-.099
CENTROID Y	.125	.151	.230
POA TO CENTROID in.	.129	.270	.250
MIN RADIUS	.343	.151	.237
MEAN RADIUS	.737	.571	.494
MAX RADIUS	1.764	1.181	.823
HORIZONTAL SPREAD	2.944	1.711	.859
VERTICAL SPREAD	1.282	1.282	1.282
EXTREME SPREAD	2.967	1.988	1.351
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	9		

15 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08649050.1

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS= 2.603

VS= 1.918

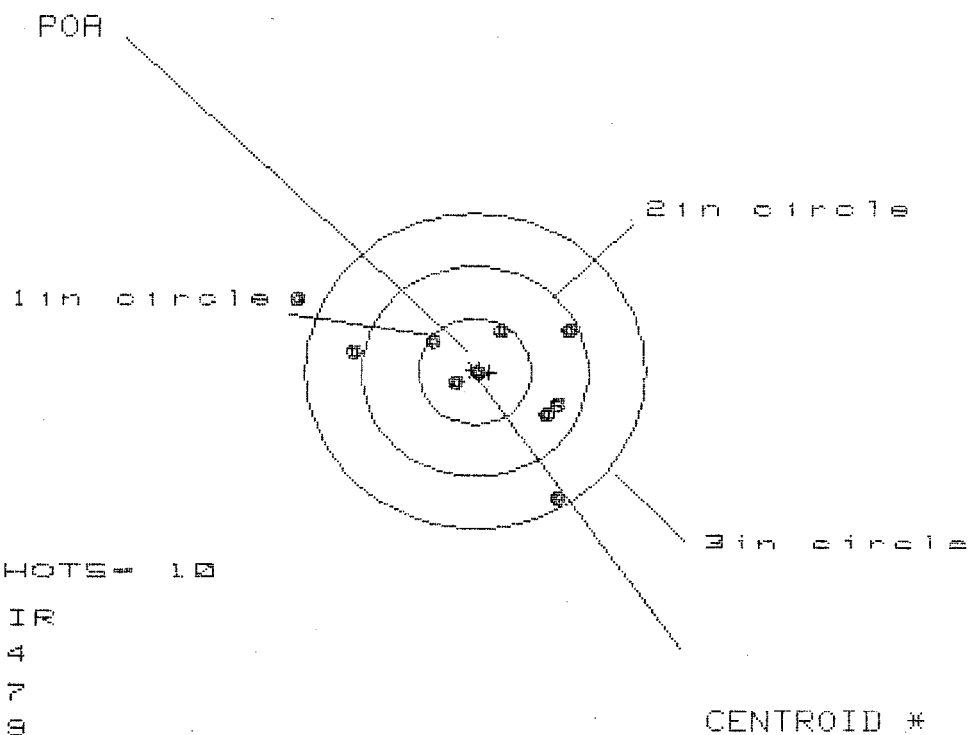
GS= 3.099

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.119	.954	.564
MINIMUM X	:	-1.484	-.902	-.783
MAXIMUM Y	:	.909	.996	.894
MINIMUM Y	:	-1.009	-.922	-1.024
CENTROID X	:	.176	.341	.222
CENTROID Y	:	.320	.233	.335
POA TO CENTROID in.	:	.365	.413	.402
MIN RADIUS	:	.227	.083	.212
MEAN RADIUS	:	.869	.759	.694
MAX RADIUS	:	1.677	1.254	1.083
HORIZONTAL SPREAD	:	2.603	1.856	1.347
VERTICAL SPREAD	:	1.918	1.918	1.918
EXTREME SPREAD	:	3.099	2.074	1.955
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

15 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649050.1

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 4

2in = 7

3in = 9

HS= 2.482

VS= 1.877

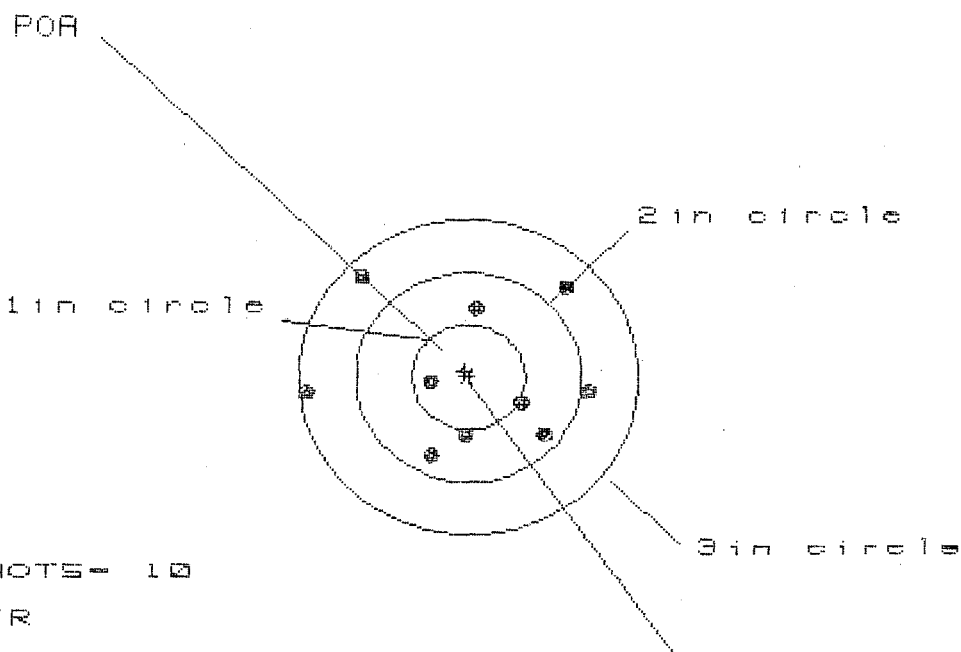
GS= 2.976

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.864	.684	.748
MINIMUM X	-1.618	-1.229	-1.165
MAXIMUM Y	.713	.488	.352
MINIMUM Y	-1.164	-1.084	-.498
CENTROID X	-.130	.050	-.014
CENTROID Y	.006	-.074	.062
POA TO CENTROID in.	.130	.089	.064
MIN RADIUS	.052	.181	.080
MEAN RADIUS	.791	.684	.594
MAX RADIUS	1.768	1.269	1.179
HORIZONTAL SPREAD	2.482	1.913	1.913
VERTICAL SPREAD	1.877	1.572	.850
EXTREME SPREAD	2.976	2.233	1.920
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

15 Nov 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 10

HS= 2.458

VS= 1.637

GS= 2.459

CENTROID #

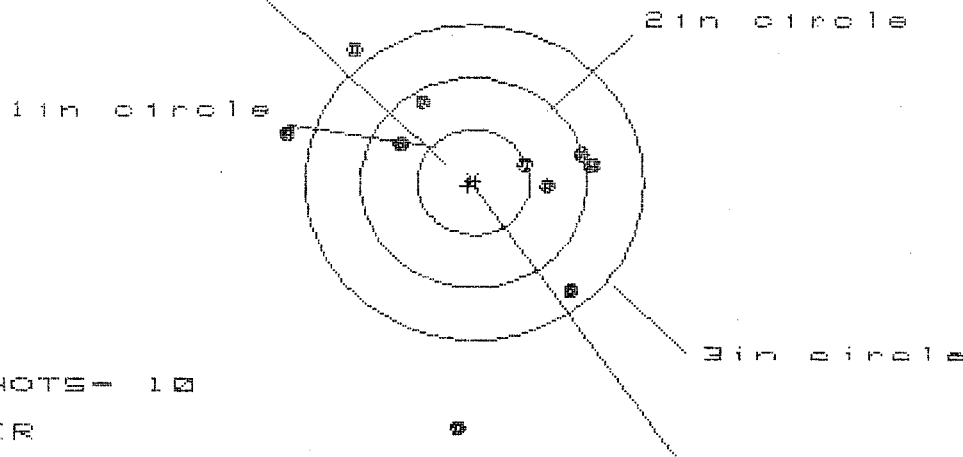
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.033	.875	.734
MINIMUM X	:	-1.425	-1.132	-.637
MAXIMUM Y	:	.917	.906	.910
MINIMUM Y	:	-.720	-.731	-.618
CENTROID X	:	.035	.193	.334
CENTROID Y	:	-.058	-.047	-.160
POA TO CENTROID in.	:	.068	.199	.371
MIN RADIUS	:	.337	.435	.254
MEAN RADIUS	:	.870	.796	.683
MAX RADIUS	:	1.428	1.450	1.055
HORIZONTAL SPREAD	:	2.458	2.007	1.371
VERTICAL SPREAD	:	1.637	1.637	1.528
EXTREME SPREAD	:	2.459	2.276	1.925
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			10	

15 May 1991

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CENTERFIRE PATTERNS # 5

POA



OF SHOTS - 10

IN CIR

1in = 1

2in = 5

3in = 7

HS = 2.793

VS = 3.594

GS = 3.704

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.094	1.080	.865
MINIMUM X	:	-1.699	-1.713	-1.256
MAXIMUM Y	:	1.253	.993	1.017
MINIMUM Y	:	-2.341	-1.309	-1.285
CENTROID X	:	.050	.064	.278
CENTROID Y	:	.028	.288	.264
POA TO CENTROID in.	:	.057	.295	.384
MIN RADIUS	:	.453	.430	.220
MEAN RADIUS	:	1.189	1.022	.884
MAX RADIUS	:	2.345	1.724	1.616
HORIZONTAL SPREAD	:	2.793	2.793	2.121
VERTICAL SPREAD	:	3.594	2.302	2.302
EXTREME SPREAD	:	3.704	2.981	2.981
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			7	