

FRM

UPC



0 47700 25716 7

C6649054

*INCLUDES 1 INCHAMBER

CAPACITY*

BARREL LENGTH

UNDER NO.

3/10

MODEL 700 TM M24

2300

Remington



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

MODEL 700 TM M24

SERIAL NO.

C6649054

ORDER NO.

5716

20

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



5716 C6649054

ORDER 5716

MODEL 700 TM M24

UPC



0 47700 25716 7

ORDER 5716

MODEL 700 TM M24

UPC



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

12/2

GUN SERIAL # C6649054

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	9 26	9 1	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	WB
618	Polish Barrel	OCT	4 1991	WB
620	Apply Coatings (Barrel Action)		10-18-91	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		12/3/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/3/91	KS
	C) Inspect Ejector Hole for Chamfer		12/3/91	KS
	D) Oil Firing Pin Ass'y		12/3/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		12-7-91	JU

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			12-7-91	QU
	G) Safety Off Force	3	3	3			12-7-91	QU
	H) Trigger Pull Test & Retainability						12-7-91	QU
	I) Firing Pin Indent	¹⁰²⁰ 1020	1020	1020			12-7-91	QU
	J) Assemble Stock						12/7/91	KL
	K) Assemble Swivel Studs						12-11-91	KL
	L) Attach Front and Rear Sight Assemblies						12/7/91	KL
	M) Iron Sight Alignment						12/7/91	KL
	N) Detach Front & Rear Sights & place in numbered container						12/7/91	KL
	O) Attach Scope to Rifle						12/7/91	KL
	P) Detach & Attach Scope 20 Times						12/7/91	KL
640	Gallery Target & Test						12/9/91	KT
	A) Time						12/9/91	KT
	B) Malfunctions						12/9/91	KT
	C) Pierced Primers						12/9/91	KT
	D) Optical Clarity of Scope						12/9/91	KT
645	Inspect for Live Ammo						12/9/91	KT
655	Final Inspection							
	A) Headspace						12-11-91	AC
	B) Trigger Pull	2.36	2.36	2.36	2.34	2.35	12-11-91	QU
	C) Function						12-11-91	AC
660	Pack						12-15-91	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-6649054DATE 12-7-91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.32	2.42	2.30	2.36	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.45	2.42	2.32	2.36	
PULL #3	2.44	2.47	2.25	2.36	
PULL #4	2.44	2.47	2.48	2.34	
PULL #5	2.54	2.47	2.51	2.35	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.19	3.51		
PULL #2	3.22	3.59		
PULL #3	3.34	3.51		
PULL #4	3.33	3.48		
PULL #5	3.44	3.44		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.26	4.23		4.34
PULL #2	4.21	4.26		4.43
PULL #3	4.21	4.36		4.39
PULL #4	4.22	4.32		4.39
PULL #5	4.24	4.43		4.39
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649854
9 Dec 1991

CENTROIDAL DISTANCES

0 TO	1	.0829759
1 TO	2	.149576
1 TO	3	.0988838
1 TO	4	.160639
1 TO	5	.0257099

4 <----POR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0536
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .046
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0706326

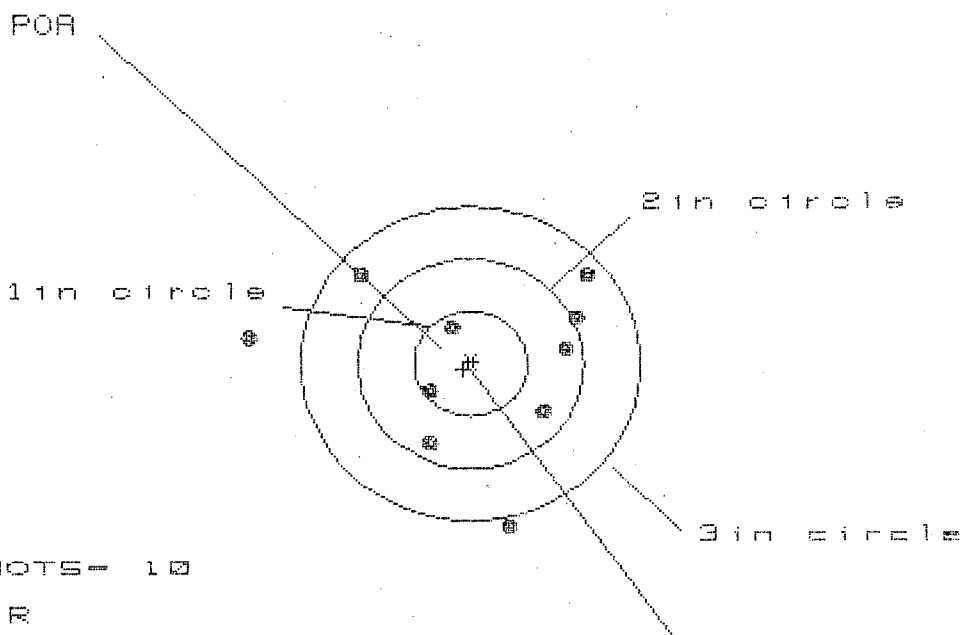
THE AMR FOR THIS RIFLE IS: 1.212

9 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8669054

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 3

CENTROID #

HS= 3.010

VS= 2.394

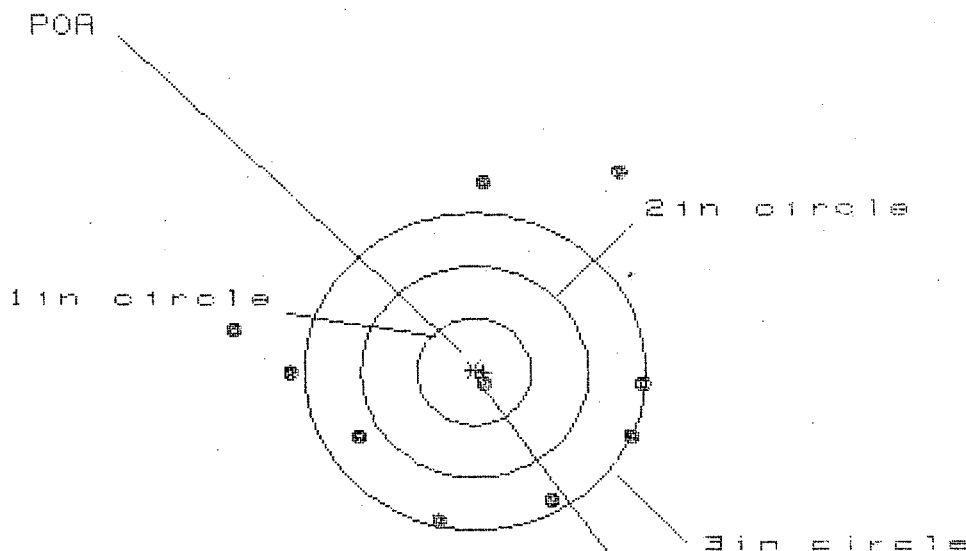
GS= 3.057

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.068	.853	.862
MINIMUM X	-1.942	-1.181	-1.172
MAXIMUM Y	.875	.908	.722
MINIMUM Y	-1.519	-1.486	-.908
CENTROID X	.063	.278	.269
CENTROID Y	.054	.021	.207
POA TO CENTROID in.	.083	.279	.339
MIN RADIUS	.388	.532	.405
MEAN RADIUS	1.055	.935	.855
MAX RADIUS	1.964	1.490	1.376
HORIZONTAL SPREAD	3.010	2.034	2.034
VERTICAL SPREAD	2.394	2.394	1.630
EXTREME SPREAD	3.057	2.705	2.156
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

9 Dec 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 1

3in = 6

HS= 3.539

VS= 3.305

GS= 3.641

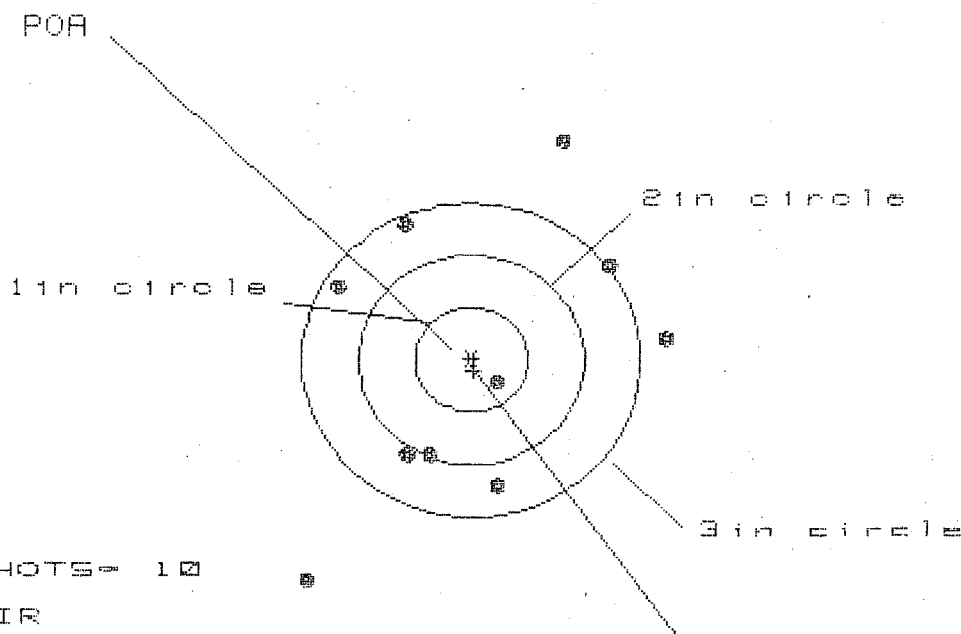
CENTROID #

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.454	1.592	1.349
MINIMUM X	-2.086	-1.947	-1.681
MAXIMUM Y	1.861	1.982	2.057
MINIMUM Y	-1.444	-1.238	-1.163
CENTROID X	-.079	-.218	.026
CENTROID Y	.007	-.200	-.275
POA TO CENTROID in.	.080	.296	.276
MIN RADIUS	.152	.289	.195
MEAN RADIUS	1.479	1.373	1.255
MAX RADIUS	2.239	2.036	2.057
HORIZONTAL SPREAD	3.539	3.539	3.029
VERTICAL SPREAD	3.305	3.220	3.220
EXTREME SPREAD	3.641	3.590	3.237
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =		1	
NUMBER IN THREE INCH CIRCLE =		6	

9 Dec 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 1

2in = 2

3in = 6

HS = 3.194

VS = 4.171

GS = 4.766

CENTROID #

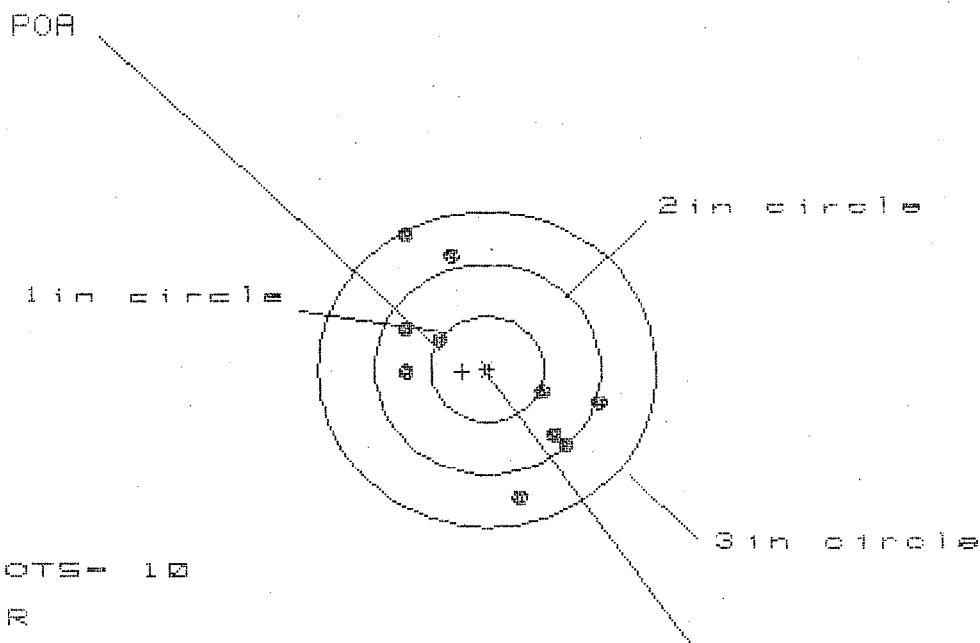
PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.729	1.567	1.651
MINIMUM X	-1.465	-1.368	-1.284
MAXIMUM Y	2.104	1.875	1.323
MINIMUM Y	-2.067	-1.417	-1.183
CENTROID X	-.024	.138	.054
CENTROID Y	.101	.331	.097
POA TO CENTROID in.	.104	.359	.111
MIN RADIUS	.330	.467	.276
MEAN RADIUS	1.439	1.332	1.196
MAX RADIUS	2.533	1.994	1.665
HORIZONTAL SPREAD	3.194	2.935	2.935
VERTICAL SPREAD	4.171	3.292	2.506
EXTREME SPREAD	4.766	3.351	2.970
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	6		

9 Dec 1991

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CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1in = 0

2in = 6

3in = 9

HS= 1.721

VS= 2.569

GS= 2.757

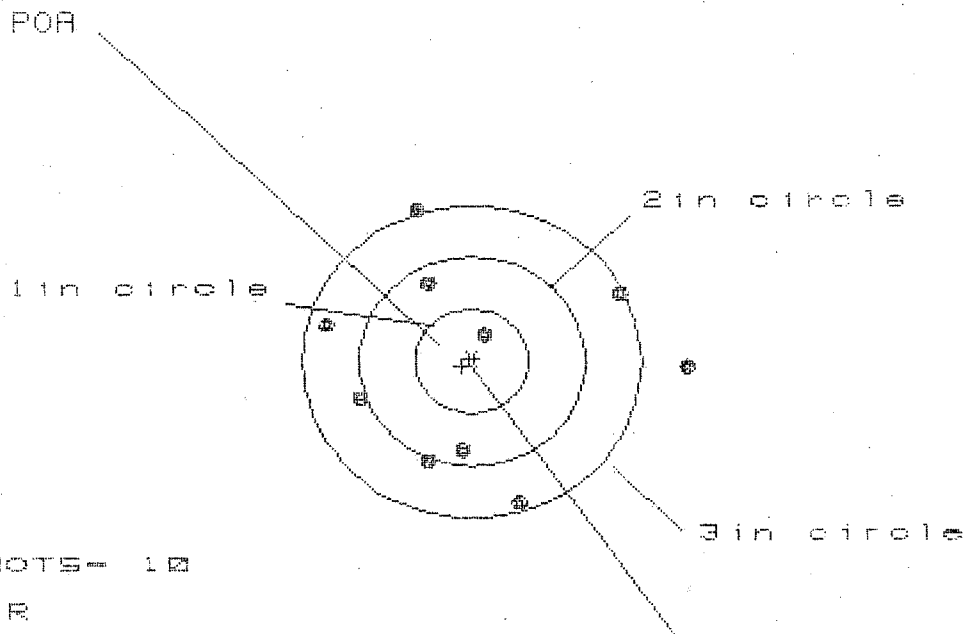
CENTROID #

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.976	.893	.915
MINIMUM X	-.745	-.802	-.780
MAXIMUM Y	1.306	1.203	1.064
MINIMUM Y	-1.263	-1.118	-.677
CENTROID X	.220	.303	.281
CENTROID Y	.020	-.125	.015
POA TO CENTROID in.	.221	.328	.281
MIN RADIUS	.518	.382	.463
MEAN RADIUS	.926	.843	.807
MAX RADIUS	1.504	1.257	1.117
HORIZONTAL SPREAD	1.721	1.695	1.695
VERTICAL SPREAD	2.569	2.321	1.740
EXTREME SPREAD	2.757	2.382	2.001
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

9 Dec 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 9

HS= 3.162

VS= 2.746

GS= 3.185

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.865	1.472	1.441
MINIMUM X	:	-1.296	-1.089	-1.120
MAXIMUM Y	:	1.426	1.422	.967
MINIMUM Y	:	-1.320	-1.324	-1.146
CENTROID X	:	.088	-.119	-.088
CENTROID Y	:	.048	.052	-.126
POA TO CENTROID in.	:	.101	.129	.154
MIN RADIUS	:	.284	.410	.522
MEAN RADIUS	:	1.161	1.063	1.002
MAX RADIUS	:	1.866	1.617	1.672
HORIZONTAL SPREAD	:	3.162	2.561	2.561
VERTICAL SPREAD	:	2.746	2.746	2.113
EXTREME SPREAD	:	3.185	2.875	2.581
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		9	