

FORM

UPC



0 47700 25716 7

C6649067

*INCLUDES 1 IN CHAMBER

CAPACITY*

BARREL LENGTH

MODEL 700 TM M24

ORDER NO.

5716

Remington



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

MODEL 700™ M24

SERIAL NO.

C6649067

ORDER NO.

5716

20

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



5716 C6649067

ORDER 5716

MODEL 700™ M24

UPC



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ORDER 5716

MODEL 700™ M24

UPC



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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649067

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	GCT	3 1991	Kcd
	Magnaflux Bolt	OCT	3 1991	Kcd
615	Rollmark Caliber	OCT	3 1991	EG
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		12/3/91	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			12-4-91	W
	G) Safety Off Force	3	3	3			12-4-91	W
	H) Trigger Pull Test & Retainability						12/3/91	WB
	I) Firing Pin Indent	1021	10205	10215			12-4-91	W
	J) Assemble Stock						12/5/91	RW
	K) Assemble Swivel Studs						12-7-91	AC
	L) Attach Front and Rear Sight Assemblies						12/5/91	RW
	M) Iron Sight Alignment						12/5/91	RW
	N) Detach Front & Rear Sights & place in numbered container						12/5/91	RW
	O) Attach Scope to Rifle						12/5/91	RW
	P) Detach & Attach Scope 20 Times						12/5/91	RW
640	Gallery Target & Test						12-5-91	AC
	A) Time						12-5-91	AC
	B) Malfunctions						12-5-91	AC
	C) Pierced Primers						12-5-91	AC
	D) Optical Clarity of Scope						12-5-91	AC
645	Inspect for Live Ammo						12-5-91	AC
655	Final Inspection							
	A) Headspace						12-7-91	AC
	B) Trigger Pull	243	238	238	242	244	12-7-91	DH
	C) Function						12-7-91	AC
660	Pack						12-19-91	N

SWS TRIGGER PULL TEST

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

SERIAL NO. C6649067
DATE 12/3/91
TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.22	2.30	2.35	2.43	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.19	2.36	2.39	2.38	
PULL #3	2.18	2.34	2.46	2.38	
PULL #4	2.18	2.41	2.46	2.42	
PULL #5	2.18	2.21	2.36	2.44	
TOTAL	10.95	11.62	12.06		
AVG.	2.19	2.32	2.41		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.04	3.00		
PULL #2	3.05	3.05		
PULL #3	3.00	3.03		
PULL #4	3.02	3.00		
PULL #5	3.03	3.02		
TOTAL	15.14	15.10		
AVG.	3.03	3.02		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.08	4.04		4.16
PULL #2	4.00	4.03		4.12
PULL #3	4.06	4.00		4.11
PULL #4	4.02	4.00		4.04
PULL #5	4.03	4.03		4.12
TOTAL	20.19	20.10		20.55
AVG.	4.04	4.02		4.11

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06649067
5 Dec 1991

CENTROIDAL DISTANCES

0 TO 1	.640345
1 TO 2	.654059
1 TO 3	.777064
1 TO 4	.624239
1 TO 5	.112614

$\bar{x}$ (----) POA
 $\bar{y}$

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0978
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.223
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .243503

THE AMR FOR THIS RIFLE IS: .8348

5 Oct 1991

FILE://PATTERNING/CENTERFIRE_PATT/C6649067

CENTERFIRE PATTERNS # 1

POB

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 2

2in = 3

3in = 8

HS= 3.240

VS= 2.086

GS= 3.651

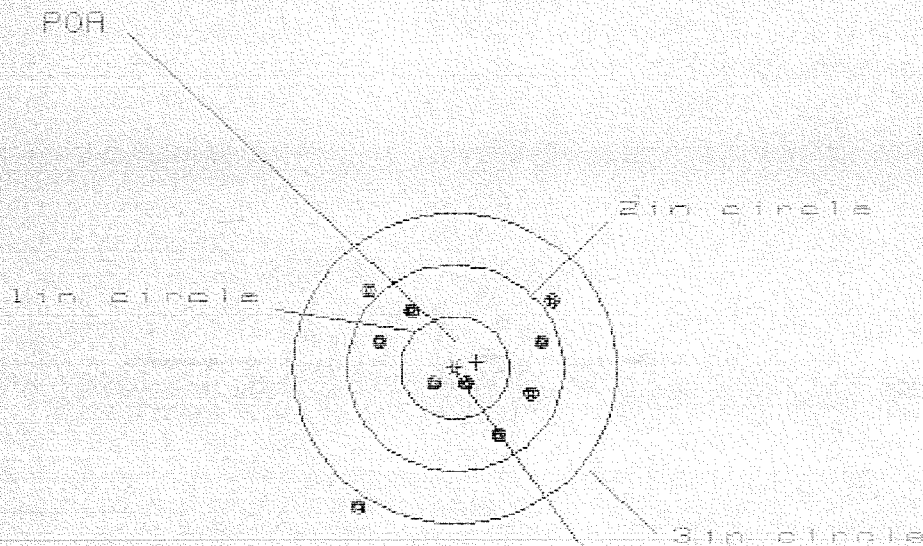
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.390	1.184	1.242
MINIMUM X	-1.850	-1.368	-1.220
MAXIMUM Y	1.065	.952	1.020
MINIMUM Y	-1.021	-1.010	-.942
CENTROID X	.109	.315	.167
CENTROID Y	-.631	-.518	-.586
POB TO CENTROID in.	.641	.606	.610
MIN RADIUS	.184	.227	.177
MEAN RADIUS	1.095	.974	.913
MAX RADIUS	2.113	1.423	1.376
HORIZONTAL SPREAD	3.240	2.552	2.462
VERTICAL SPREAD	2.086	1.962	1.962
EXTREME SPREAD	3.651	2.656	2.656
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	8		

5 Dec 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in - 2

2 in - 7

3 in - 9

HS= 1.769

VS= 2.171

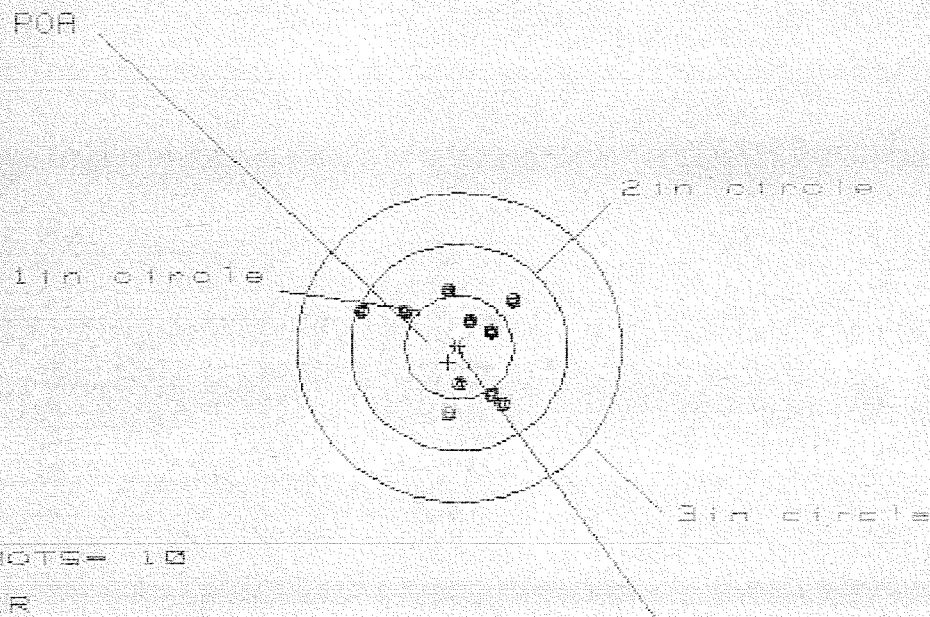
GS= 2.712

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.907	.811	.694
MINIMUM X	:	-.862	-.934	-.870
MAXIMUM Y	:	.785	.631	.594
MINIMUM Y	:	-1.386	-.828	-.749
CENTROID X	:	-.199	-.103	.014
CENTROID Y	:	-.054	.100	.021
POA TO CENTROID in.	:	.206	.143	.025
MIN RADIUS	:	.180	.266	.195
MEAN RADIUS	:	.809	.722	.653
MAX RADIUS	:	1.632	1.127	.914
HORIZONTAL SPREAD	:	1.769	1.745	1.564
VERTICAL SPREAD	:	2.171	1.459	1.343
EXTREME SPREAD	:	2.712	1.892	1.611
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			9	

5 Dec 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 3

2in = 10

3in = 10

HS= 1.398

VS= 1.239

GS= 1.585

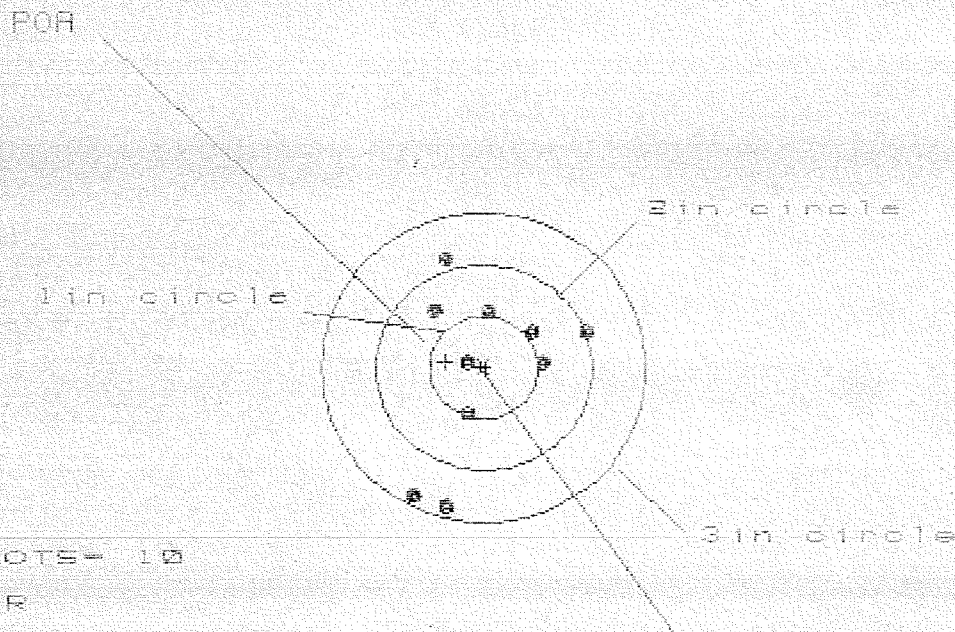
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.494	.393	.431
MINIMUM X	:	-.904	-.554	-.516
MAXIMUM Y	:	.555	.589	.521
MINIMUM Y	:	-.684	-.650	-.718
CENTROID X	:	.099	.200	.162
CENTROID Y	:	.146	.112	.130
POA TO CENTROID in.	:	.177	.229	.242
MIN RADIUS	:	.265	.216	.212
MEAN RADIUS	:	.562	.503	.482
MAX RADIUS	:	.957	.694	.737
HORIZONTAL SPREAD	:	1.398	.947	.947
VERTICAL SPREAD	:	1.239	1.239	1.239
EXTREME SPREAD	:	1.585	1.291	1.285
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		10	
NUMBER IN THREE INCH CIRCLE	=		10	

5 Dec 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 10

HS = 1.595

VS = 2.379

GS = 2.379

CENTROID +

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.975	.934	.851
MINIMUM X	:	-.620	-.661	-.563
MAXIMUM Y	:	1.048	.900	.729
MINIMUM Y	:	-1.331	-1.362	-1.772
CENTROID X	:	.352	.393	.476
CENTROID Y	:	-.056	.092	.263
POA TO CENTROID in.	:	.356	.404	.543
MIN RADIUS	:	.138	.160	.294
MEAN RADIUS	:	.790	.697	.572
MAX RADIUS	:	1.382	1.514	.869
HORIZONTAL SPREAD	:	1.595	1.595	1.414
VERTICAL SPREAD	:	2.379	2.262	1.501
EXTREME SPREAD	:	2.379	2.278	1.519
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

5 Dec 1991

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CENTERFIRE PATTERNS # 5

POB

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 2.248

VS= 1.940

GS= 2.549

PATTERN #

5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.453	.841	.762
MINIMUM X	-.795	-.633	-.507
MAXIMUM Y	.815	.725	.597
MINIMUM Y	-1.125	-1.215	-1.348
CENTROID X	.128	-.034	.046
CENTROID Y	-.520	-.430	-.302
POB TO CENTROID in.	.536	.431	.305
MIN RADIUS	.428	.391	.240
MEAN RADIUS	.918	.799	.698
MAX RADIUS	1.667	1.219	1.343
HORIZONTAL SPREAD	2.248	1.474	1.268
VERTICAL SPREAD	1.940	1.940	1.940
EXTREME SPREAD	2.549	1.966	1.966
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	