

FORM

UPC



0 47700 25716 7

06636157

*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 700TM M24

SERIAL NO.

C6636157

ORDER NO.

5716

20

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



5716 C6636157

ORDER 5716

MODEL 700TM M24

UPC



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ORDER 5716

MODEL 700TM M24

UPC



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CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6636157**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/27/91	KA
600	Proof		6/27/91	KA
607	Check Headspace		6/27/91	KA
610	Dis-assemble Gun		6/27/91	KA
612	Magnaflux Barrel Action		JUL 2 1991	KR
	Magnaflux Bolt		JUL 2 1991	KR
615	Rollmark Caliber		JUL 2 1991	KR
617	Drill and Tap Sight Holes		JUL 2 1991	LB
618	Polish Barrel		JUL 17 1991	WB
620	Apply Coatings (Barrel Action)		8/6/91	KA
	Apply Coating (Bolt)			KA
625	Final Assembly A) Clean inside of Bolt Assembly		10/30/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/30/91	KA
	C) Inspect Ejector Hole for Chamfer		10/30/91	KA
	D) Oil Firing Pin Ass'y		10/30/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		10/31/91	KA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			10/31/91	JL
	G) Safety Off Force	4	4	4			10/31/91	JL
	H) Trigger Pull Test & Retainability						10/31/91	JL
	I) Firing Pin Indent	020	021	021			10/31/91	JL
	J) Assemble Stock						10/31/91	JL
	K) Assemble Swivel Studs						11-12-91	AC
	L) Attach Front and Rear Sight Assemblies						10/31/91	JL
	M) Iron Sight Alignment						10/31/91	JL
	N) Detach Front & Rear Sights & place in numbered container						10/31/91	JL
	O) Attach Scope to Rifle						10/31/91	JL
	P) Detach & Attach Scope 20 Times						10/31/91	JL
640	Gallery Target & Test						11-1-91	DH
	A) Time						11-1-91	DH
	B) Malfunctions						11-1-91	DH
	C) Pierced Primers						11-1-91	DH
	D) Optical Clarity of Scope						11-1-91	DH
645	Inspect for Live Ammo						11-1-91	DH
655	Final Inspection							
	A) Headspace						11-12-91	AC
	B) Trigger Pull	2.19	2.26	2.26	2.26	2.18	11-5-91	DH
	C) Function						11-12-91	AC
660	Pack						12-18-91	V

SWS TRIGGER PULL TEST

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

SERIAL NO. C6636157

DATE 10/31/91

TESTER JY

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.49	2.39	2.19	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.29	2.244	2.26	
PULL #3	2.26	2.31	2.23	2.26	
PULL #4	2.49	2.30	2.31	2.26	
PULL #5	2.38	2.29	2.28	2.18	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.33	3.40		
PULL #2	3.34	3.36		
PULL #3	3.30	3.39		
PULL #4	3.37	3.32		
PULL #5	3.33	3.37		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.30	4.39		4.43
PULL #2	4.34	4.40		4.46
PULL #3	4.36	4.47		4.43
PULL #4	4.37	4.41		4.45
PULL #5	4.36	4.45		4.43
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636156
25 JUL 1991

CENTROIDAL DISTANCES

0 TO	1	.0403113
1 TO	2	.219313
1 TO	3	.286252
1 TO	4	.163518
1 TO	5	.25046

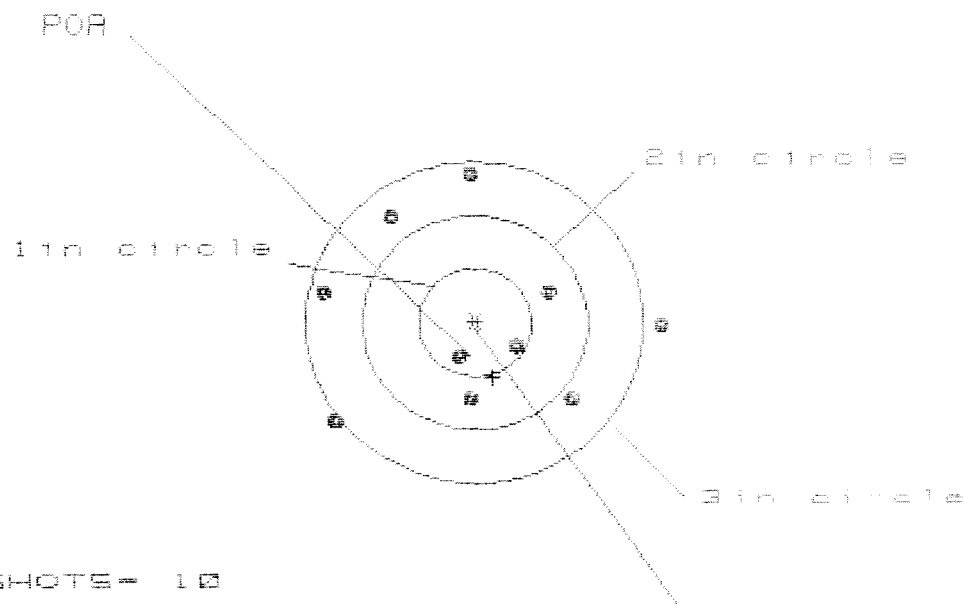
24
3 <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0518
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0004
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0518015
THE AMR FOR THIS RIFLE IS: .894

1 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636157

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 2.985

VS= 2.265

GS= 2.999

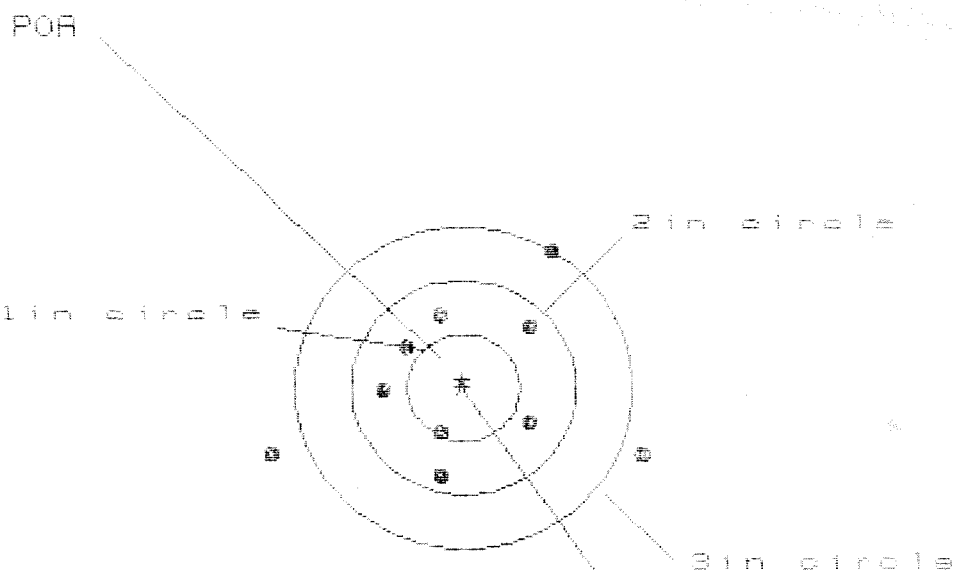
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.633	1.083	.955
MINIMUM X	-1.352	-1.170	-1.298
MAXIMUM Y	1.350	1.350	1.236
MINIMUM Y	-.915	-.915	-.833
CENTROID X	-.156	-.338	-.289
CENTROID Y	.511	.511	.625
POR TO CENTROID in.	.534	.613	.660
MIN RADIUS	.334	.327	.435
MEAN RADIUS	1.048	.989	.936
MAX RADIUS	1.633	1.375	1.310
HORIZONTAL SPREAD	2.985	2.253	2.253
VERTICAL SPREAD	2.265	2.265	2.069
EXTREME SPREAD	2.999	2.552	2.455
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		8	

1 Nov 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 8

HS= 3.284

VS= 2.044

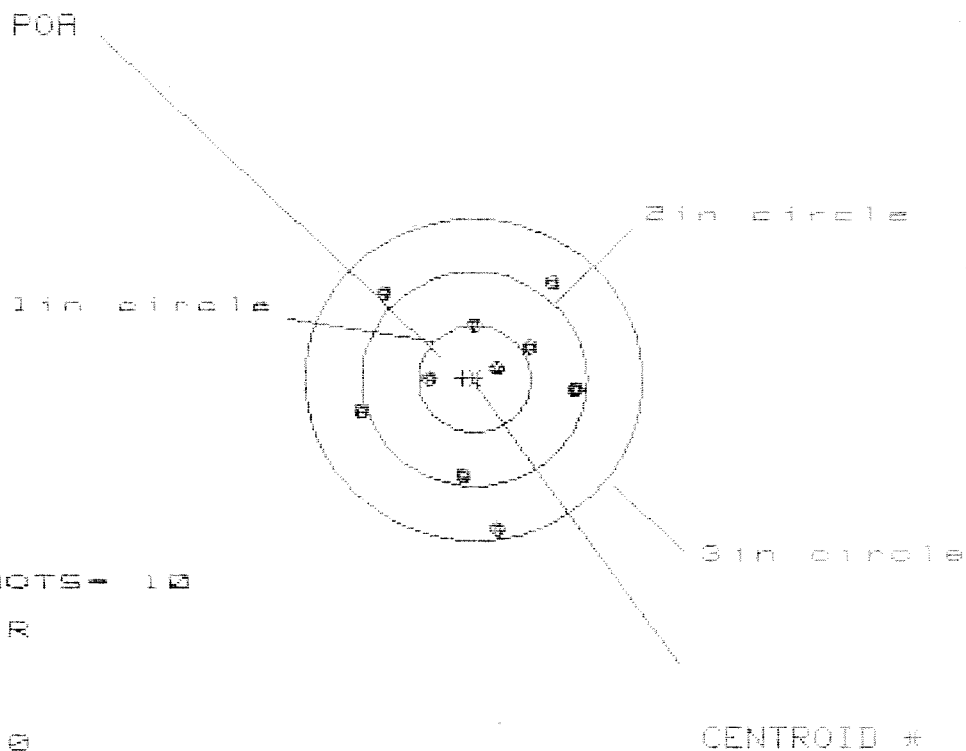
GS= 3.284

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.617	1.432	.778
MINIMUM X	:	-1.667	-.946	-.767
MAXIMUM Y	:	1.237	1.167	1.081
MINIMUM Y	:	-.807	-.877	-.963
CENTROID X	:	.012	.197	.018
CENTROID Y	:	-.077	-.007	.079
POA TO CENTROID in.	:	.078	.198	.081
MIN RADIUS	:	.438	.528	.526
MEAN RADIUS	:	.970	.885	.767
MAX RADIUS	:	1.784	1.588	1.332
HORIZONTAL SPREAD	:	3.284	2.378	1.545
VERTICAL SPREAD	:	2.044	2.044	2.044
EXTREME SPREAD	:	3.284	2.451	2.259
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

1 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636157

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 1.871

VS= 2.257

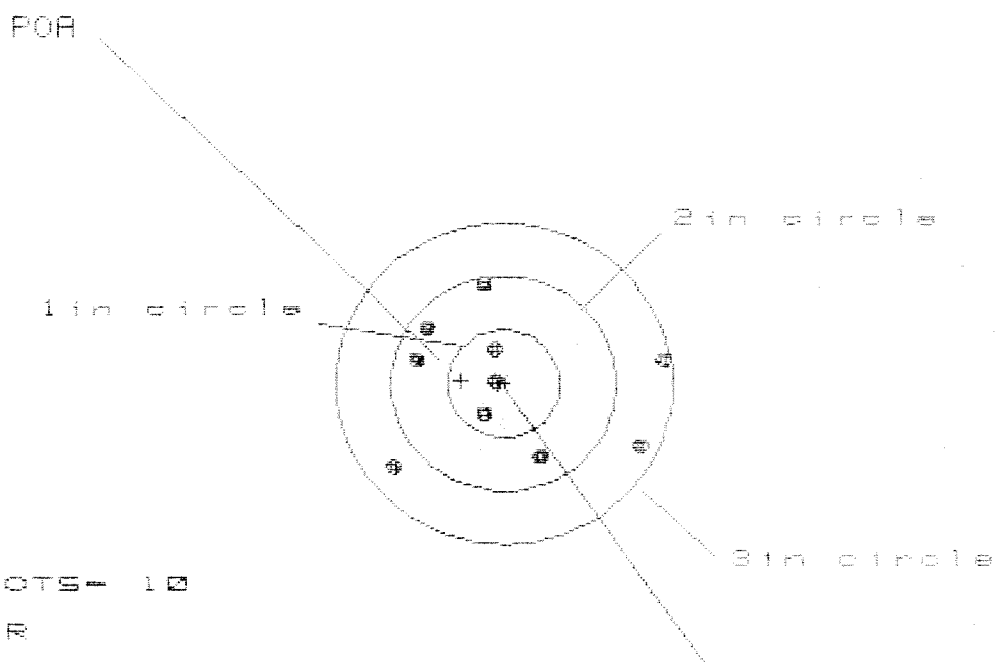
GS= 2.421

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.850	.874	.773
MINIMUM X	:	-1.021	-.997	-1.098
MAXIMUM Y	:	.872	.718	.799
MINIMUM Y	:	-1.385	-1.028	-.947
CENTROID X	:	.106	.082	.183
CENTROID Y	:	-.007	.147	.066
POA TO CENTROID in.	:	.106	.169	.194
MIN RADIUS	:	.214	.241	.125
MEAN RADIUS	:	.818	.735	.682
MAX RADIUS	:	1.401	1.092	1.157
HORIZONTAL SPREAD	:	1.871	1.871	1.871
VERTICAL SPREAD	:	2.257	1.746	1.746
EXTREME SPREAD	:	2.421	2.042	2.042
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

1 Nov 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 2.405

VS= 1.702

GS= 2.631

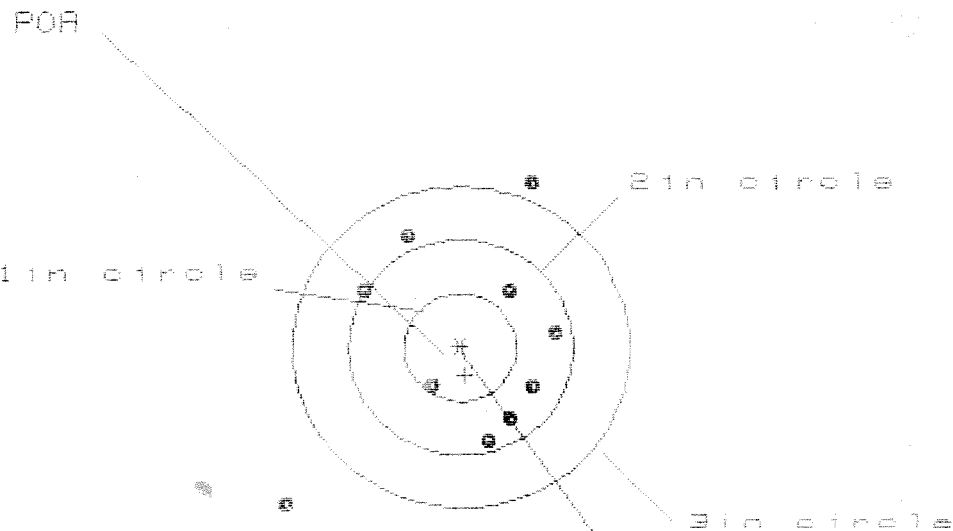
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.431	1.392	.653
MINIMUM X	:	-.974	-.815	-.641
MAXIMUM Y	:	.904	.933	.870
MINIMUM Y	:	-.798	-.769	-.832
CENTROID X	:	.380	.221	.048
CENTROID Y	:	-.026	-.055	.000
POA TO CENTROID in.	:	.381	.228	.048
MIN RADIUS	:	.073	.159	.303
MEAN RADIUS	:	.814	.726	.624
MAX RADIUS	:	1.456	1.481	1.051
HORIZONTAL SPREAD	:	2.405	2.207	1.295
VERTICAL SPREAD	:	1.702	1.702	1.702
EXTREME SPREAD	:	2.631	2.222	1.867
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

1 Nov 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 2.444

VS= 3.038

GS= 3.773

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.863	.687	.747
MINIMUM X	:	-1.581	-1.057	-.997
MAXIMUM Y	:	1.547	1.381	1.030
MINIMUM Y	:	-1.491	-1.067	-.894
CENTROID X	:	-.036	.140	.080
CENTROID Y	:	.257	.423	.250
POA TO CENTROID in.	:	.260	.445	.263
MIN RADIUS	:	.412	.477	.484
MEAN RADIUS	:	1.043	.900	.807
MAX RADIUS	:	2.173	1.462	1.191
HORIZONTAL SPREAD	:	2.444	1.744	1.744
VERTICAL SPREAD	:	3.038	2.448	1.924
EXTREME SPREAD	:	3.773	2.491	2.039
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	