

FORM

UPC



0 47700 25716 7

C6649174

MODEL 700 TM M24

ORDER NO. 5716

BARREL LENGTH

CAPACITY*

*INCLUDES 1 IN CHAMBER

Remington



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

MODEL 700 TM M24

SERIAL NO.

C6649174

ORDER NO.

5716

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

20



5716 C6649174

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 # C6649174

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10 1	91	RW
600	Proof	10 1	91	RW
607	Check Headspace	10 1	91	RW
610	Dis-assemble Gun	10 1	91	RW
612	Magnaflux Barrel Action		OCT 10 1991	KK
	Magnaflux Bolt		OCT 10 1991	KK
615	Rollmark Caliber		OCT 10 1991	LL
617	Drill and Tap Sight Holes		OCT 10 1991	EB
618	Polish Barrel		10/15/91	WB
620	Apply Coatings (Barrel Action)		11-8-91	JA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		11/11/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/11/91	RW
	C) Inspect Ejector Hole for Chamfer		11/11/91	RW
	D) Oil Firing Pin Ass'y		11/11/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		12-5-91	JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			12-6-91	QH
	G) Safety Off Force	2	2	2			12-6-91	QH
	H) Trigger Pull Test & Retainability						12-5-91	QH
	I) Firing Pin Indent	.021	.021	.021			12-6-91	QH
	J) Assemble Stock						12/6/91	RW
	K) Assemble Swivel Studs						12-7-91	AC
	L) Attach Front and Rear Sight Assemblies						12/6/91	RW
	M) Iron Sight Alignment						12/6/91	RW
	N) Detach Front & Rear Sights & place in numbered container						12/6/91	RW
	O) Attach Scope to Rifle						12/6/91	RW
	P) Detach & Attach Scope 20 Times						12/6/91	RW
640	Gallery Target & Test						12-6-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						12-6-91	NF
655	Final Inspection							
	A) Headspace						12-7-91	AC
	B) Trigger Pull	229	237	237	235	252	12-7-91	DIH
	C) Function						12-7-91	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-6649174

DATE 12-5-91

TESTER JEL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.45	2.39	2.51	2.29	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.40	2.40	2.50	2.37	
PULL #3	2.20	2.46	2.49	2.37	
PULL #4	2.46	2.46	2.46	2.35	
PULL #5	2.34	2.48	2.44	2.52	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.44	3.51		
PULL #2	3.38	3.51		
PULL #3	3.51	3.44		
PULL #4	3.46	3.46		
PULL #5	3.48	3.46		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.25	4.57		4.49
PULL #2	4.25	4.48		4.39
PULL #3	4.32	4.46		4.44
PULL #4	4.28	4.50		4.43
PULL #5	4.53	4.49		4.45
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649174
6 Dec 1991

CENTROIDAL DISTANCES

0 TO	1	.476618
1 TO	2	.490988
1 TO	3	.200202
1 TO	4	.437676
1 TO	5	1.12406

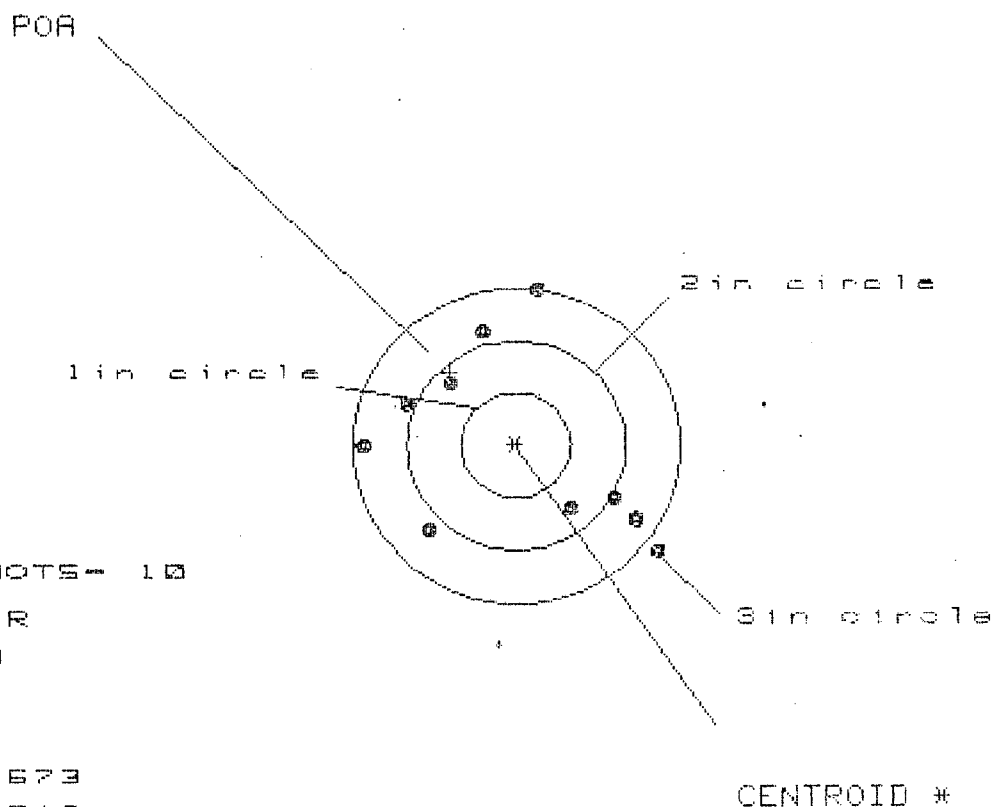
4 13⁺ 5 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.16
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.421
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .450379
THE AMR FOR THIS RIFLE IS: 1.263

6 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649174

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 2

3 in = 8

HS= 2.673

VS= 2.512

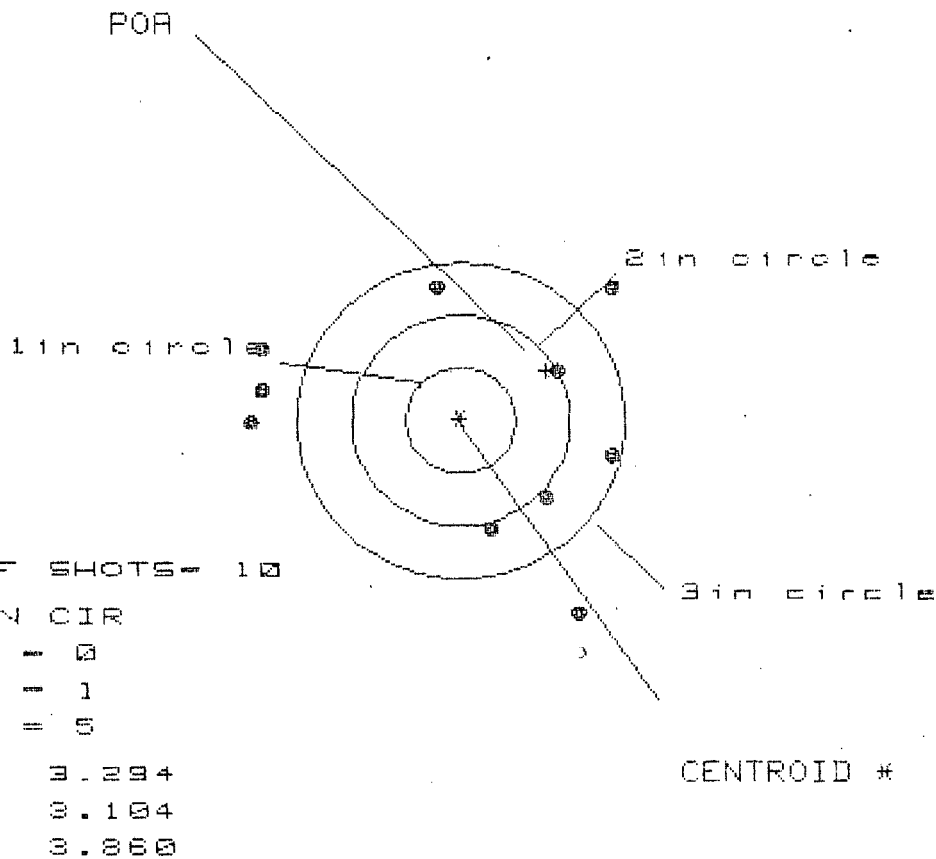
GS= 2.867

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.310
MINIMUM X	-1.363
MAXIMUM Y	1.486
MINIMUM Y	-1.026
CENTROID X	.604
CENTROID Y	-.697
POA TO CENTROID in.	.922
MIN RADIUS	.785
MEAN RADIUS	1.169
MAX RADIUS	1.664
HORIZONTAL SPREAD	2.673
VERTICAL SPREAD	2.512
EXTREME SPREAD	2.867
NUMBER IN ONE INCH CIRCLE =	0
NUMBER IN TWO INCH CIRCLE =	2
NUMBER IN THREE INCH CIRCLE =	9

8 Dec 1991

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CENTERFIRE PATTERNS # 4

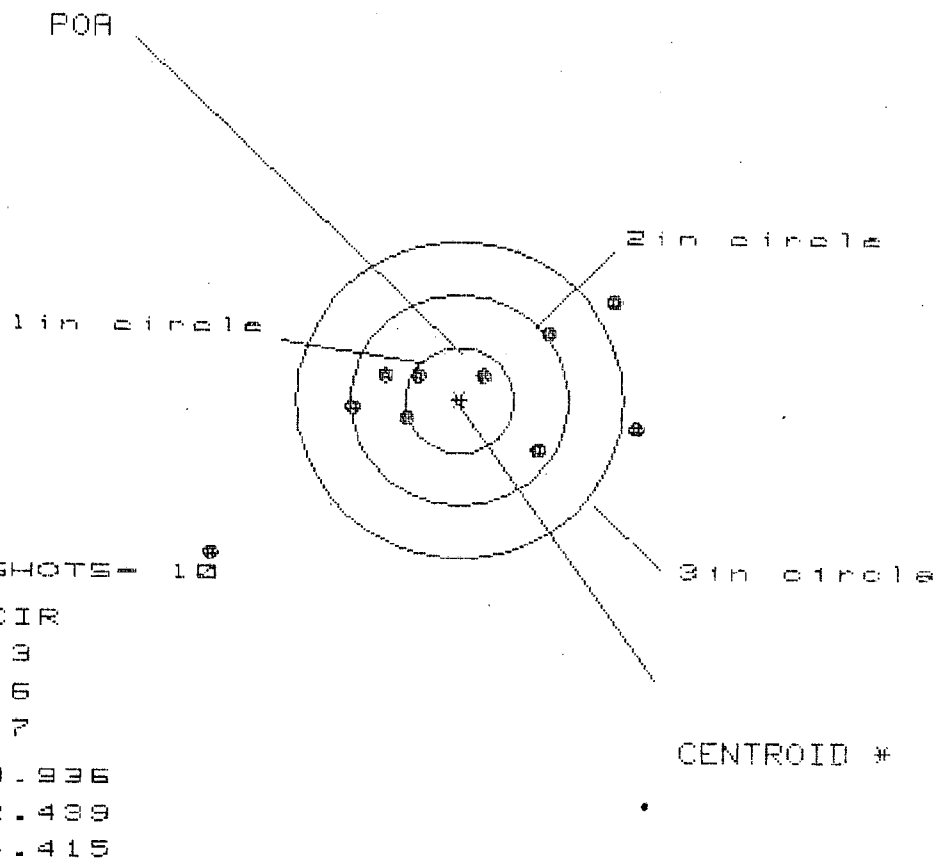


PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.411	1.533	1.321
MINIMUM X	:	-1.883	-1.761	-1.972
MAXIMUM Y	:	1.272	1.068	1.129
MINIMUM Y	:	-1.832	-1.267	-1.206
CENTROID X	:	-.780	-.902	-.690
CENTROID Y	:	-.472	-.268	-.329
POA TO CENTROID in.	:	.911	.941	.765
MIN RADIUS	:	.969	1.005	.825
MEAN RADIUS	:	1.553	1.488	1.414
MAX RADIUS	:	2.139	1.858	1.980
HORIZONTAL SPREAD	:	3.294	3.294	3.294
VERTICAL SPREAD	:	3.104	2.335	2.335
EXTREME SPREAD	:	3.860	3.536	3.536
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		1	
NUMBER IN THREE INCH CIRCLE	=		5	

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CENTERFIRE PATTERNS # 3

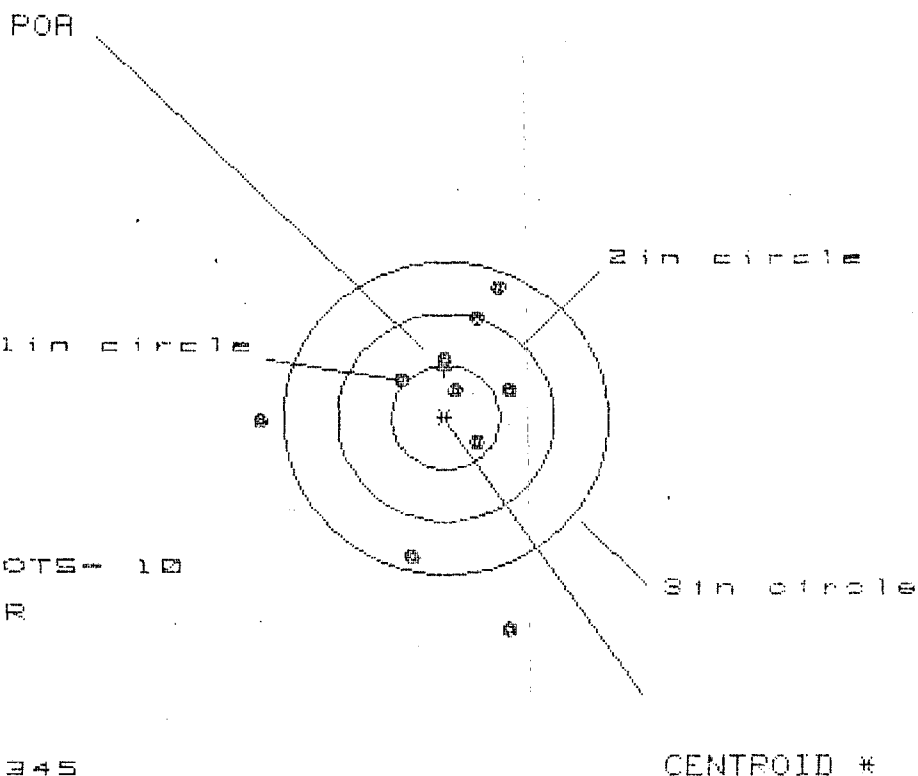


PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.665	1.413	1.557
MINIMUM X	:	-2.271	-1.218	-1.074
MAXIMUM Y	:	.934	.767	.614
MINIMUM Y	:	-1.505	-.593	-.497
CENTROID X	:	-.218	.034	-.110
CENTROID Y	:	-.238	-.071	-.167
POA TO CENTROID in.	:	.323	.079	.200
MIN RADIUS	:	.331	.126	.218
MEAN RADIUS	:	1.098	.902	.821
MAX RADIUS	:	2.724	1.470	1.588
HORIZONTAL SPREAD	:	3.936	2.631	2.631
VERTICAL SPREAD	:	2.439	1.360	1.111
EXTREME SPREAD	:	4.415	2.639	2.639
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS = 2.345

VS = 3.298

GS = 3.299

CENTROID *

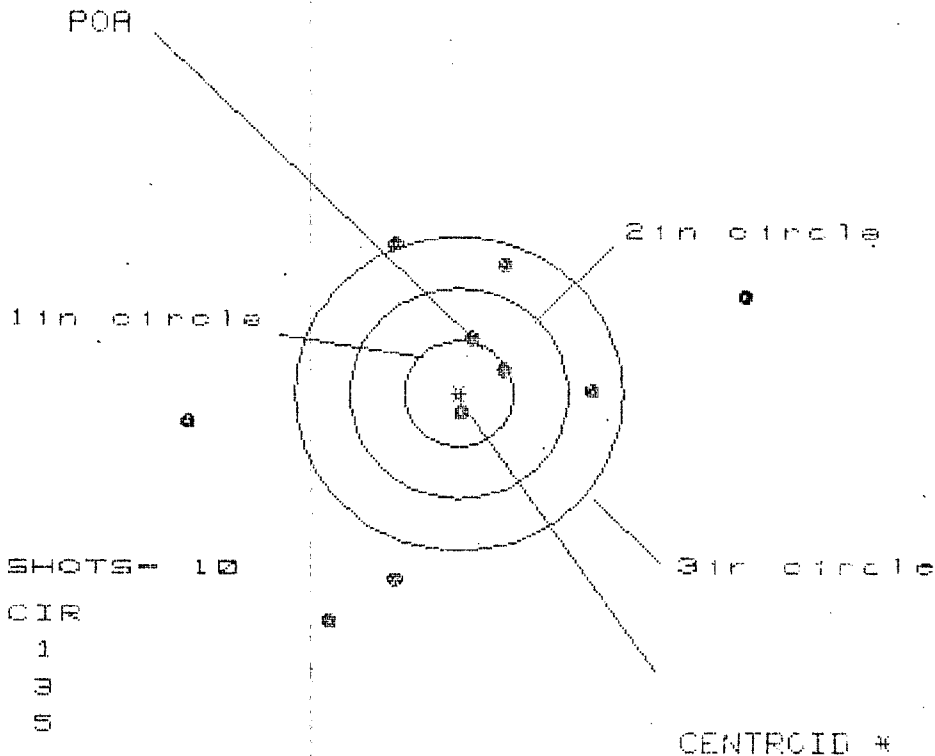
PATTERN #	2	2	2
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.599	.659	.449
MINIMUM X	-1.746	-1.679	-.547
MAXIMUM Y	1.294	1.071	1.034
MINIMUM Y	-2.004	-1.592	-1.629
CENTROID X	.012	-.055	.155
CENTROID Y	-.466	-.243	-.206
POR TO CENTROID in.	.466	.249	.258
MIN RADIUS	.288	.129	.100
MEAN RADIUS	1.005	.827	.680
MAX RADIUS	2.092	1.705	1.682
HORIZONTAL SPREAD	2.345	2.338	.996
VERTICAL SPREAD	3.298	2.663	2.663
EXTREME SPREAD	3.299	2.780	2.780
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

8 Dec 1991

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CENTERFIRE PATTERNS

1



OF SHOTS - 10

IN CIR

1in = 1

2in = 3

3in = 5

HS = 5.117

VS = 3.669

GS = 5.240

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.641	1.515	1.242
MINIMUM X	-2.476	-2.183	-1.125
MAXIMUM Y	1.478	1.577	1.559
MINIMUM Y	-2.191	-2.092	-2.110
CENTROID X	-.418	-.711	-.438
CENTROID Y	-.229	-.328	-.310
POA TO CENTROID in.	.476	.783	.537
MIN RADIUS	.187	.337	.116
MEAN RADIUS	1.498	1.408	1.223
MAX RADIUS	2.786	2.259	2.392
HORIZONTAL SPREAD	5.117	3.698	2.368
VERTICAL SPREAD	3.669	3.669	3.669
EXTREME SPREAD	5.240	3.727	3.727
NUMBER IN ONE INCH CIRCLE	= 1		
NUMBER IN TWO INCH CIRCLE	= 3		
NUMBER IN THREE INCH CIRCLE	= 5		