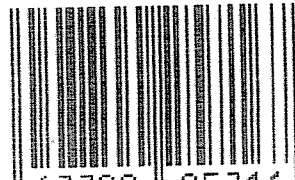


FORM

UPC



0 47700 25716 7

BARREL LENGTH

CAPACITY*

*INCLUDES 1 IN CHAMBER

C6649188

MODEL 700 TM M24

ORDER NO.

5716

Remington



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

MODEL 700 TM M24

SERIAL NO.

C6649188

ORDER NO.

5716

20

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



5716 C6649188

ORDER 5716

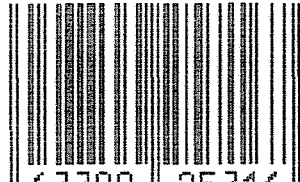
MODEL 700 TM M24

UPC

ORDER 5716

MODEL 700 TM M24

UPC



0 47700 25716 7



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649188

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	KR
	Magnaflux Bolt		OCT 10 1991	KR
615	Rollmark Caliber		OCT 10 1991	SL
617	Drill and Tap Sight Holes		OCT 10 1991	LB
618	Polish Barrel		10/15/91	WB
620	Apply Coatings (Barrel Action)		11-2-91	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		11/12/91	SL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	3 1/2	3 1/2	3 3/4			11-18-91	DH
	G) Safety Off Force	2	2	2			11-18-91	DH
	H) Trigger Pull Test & Retainability						11/18/91	DM
	I) Firing Pin Indent	.020	.020	.020			11-18-91	DH
	J) Assemble Stock						11/19/91	RW
	K) Assemble Swivel Studs						11-27-91	DH
	L) Attach Front and Rear Sight Assemblies						11/19/91	RW
	M) Iron Sight Alignment						11/19/91	RW
	N) Detach Front & Rear Sights & place in numbered container						11/19/91	RW
	O) Attach Scope to Rifle						11/19/91	RW
	P) Detach & Attach Scope 20 Times						11/19/91	RW
640	Gallery Target & Test						11-20-91	AC
	A) Time						11-20-91	AC
	B) Malfunctions						11-20-91	AC
	C) Pierced Primers						11-20-91	AC
	D) Optical Clarity of Scope						11-20-91	AC
645	Inspect for Live Ammo						11-20-91	AC
655	Final Inspection							
	A) Headspace						11-27-91	DH
	B) Trigger Pull	2.50	2.42	2.29	2.40	2.31	11-20-91	DH
	C) Function						11-27-91	DH
660	Pack						12-19-91	VF

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6649188
DATE 11-18-91
TESTER JP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.44	2.50	2.50	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.39	2.42	2.55	2.42	
PULL #3	2.50	2.57	2.44	2.29	
PULL #4	2.45	2.40	2.40	2.40	
PULL #5	2.40	2.46	2.49	2.31	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.63	3.46		
PULL #2	3.49	3.47		
PULL #3	3.48	3.44		
PULL #4	3.47	3.44		
PULL #5	3.47	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	4.27	4.25		4.30
PULL #2	4.27	4.29		4.23
PULL #3	4.18	4.23		4.36
PULL #4	4.25	4.34		4.37
PULL #5	4.25	4.31		4.24
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649188
20 Nov 1991

CENTROIDAL DISTANCES

0 TO	1	.458416
1 TO	2	.451749
1 TO	3	.498306
1 TO	4	.594077
1 TO	5	.821015

$\frac{5}{42+1}$ <----POA
1

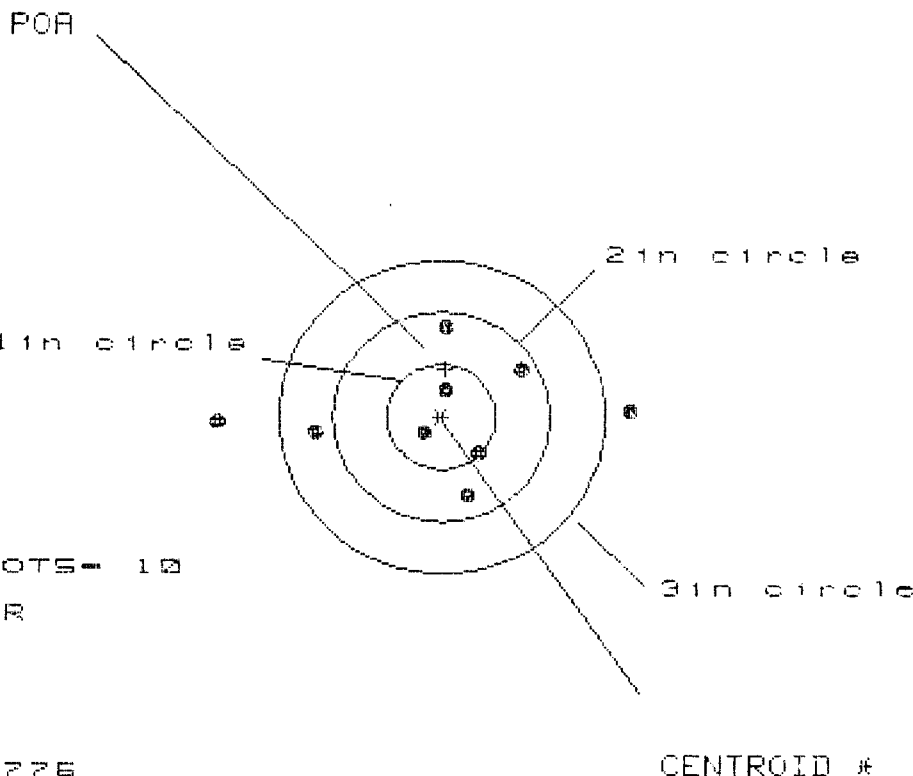
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0792
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0754
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .109354

THE AMP FOR THIS RIFLE IS: 1.043

28 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66491B3

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 8

HS= 3.776

VS= 1.628

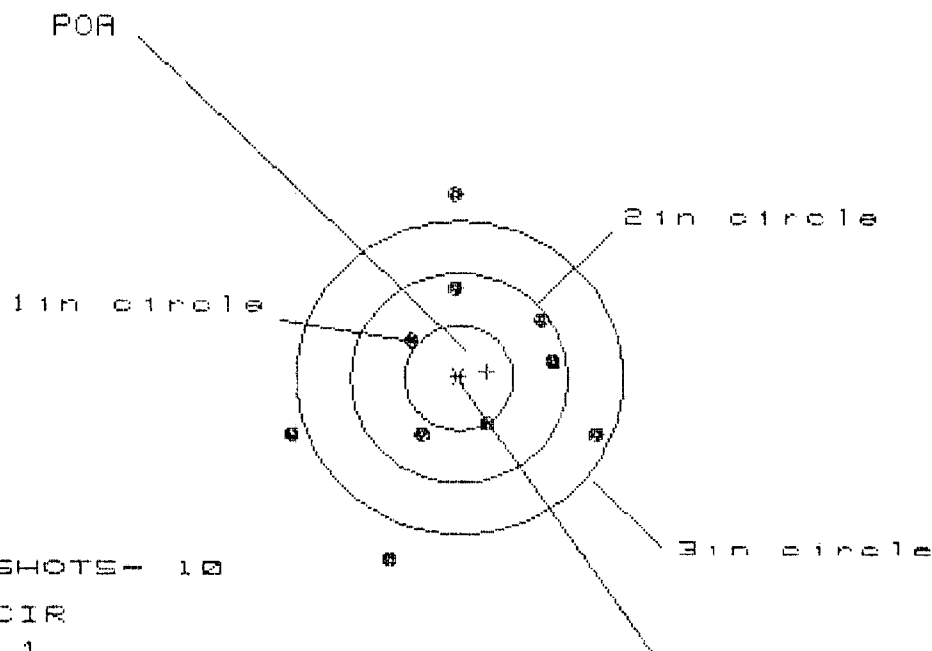
GS= 3.788

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.728	1.500	.654
MINIMUM X	:	-2.048	-1.383	-1.196
MAXIMUM Y	:	.892	.883	.891
MINIMUM Y	:	-.736	-.745	-.737
CENTROID X	:	-.036	.192	.004
CENTROID Y	:	-.457	-.448	-.456
POA TO CENTROID in.	:	.459	.487	.457
MIN RADIUS	:	.214	.288	.238
MEAN RADIUS	:	.881	.733	.625
MAX RADIUS	:	2.050	1.502	1.202
HORIZONTAL SPREAD	:	3.776	2.883	1.849
VERTICAL SPREAD	:	1.628	1.628	1.628
EXTREME SPREAD	:	3.788	2.890	1.944
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

28 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C86491B8

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 7

HS= 2.795

VS= 3.471

GS= 3.525

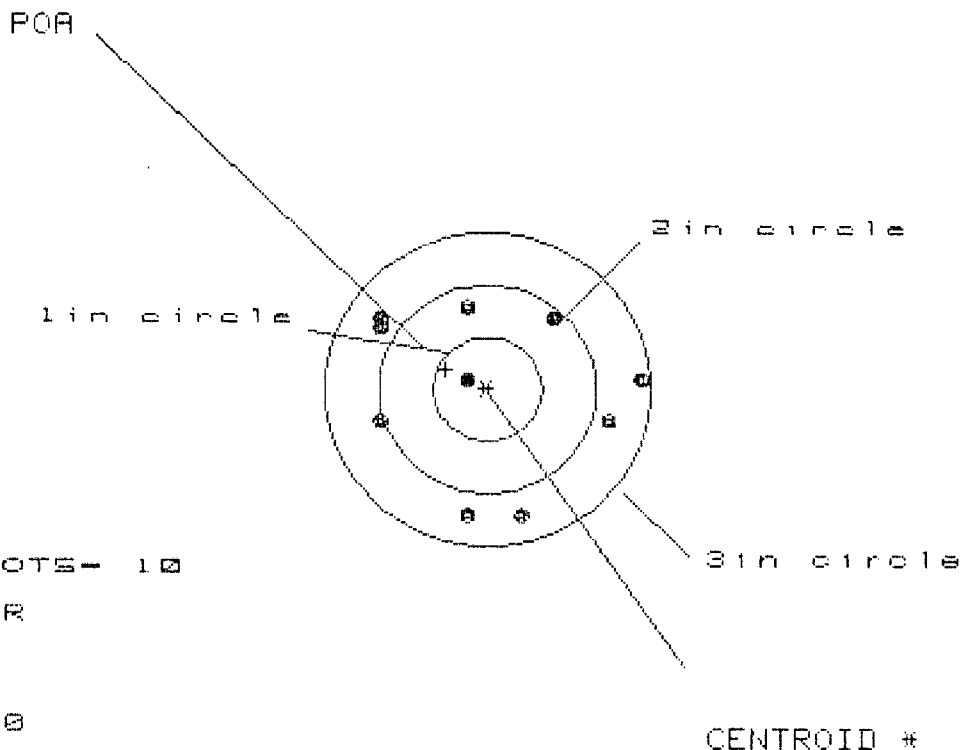
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.223	1.154	1.144
MINIMUM X	:	-1.572	-1.641	-1.651
MAXIMUM Y	:	1.744	1.552	.844
MINIMUM Y	:	-1.727	-.769	-.575
CENTROID X	:	-.257	-.188	-.178
CENTROID Y	:	-.063	.129	-.065
POR TO CENTROID in.	:	.265	.228	.190
MIN RADIUS	:	.479	.542	.445
MEAN RADIUS	:	1.084	.983	.901
MAX RADIUS	:	1.836	1.812	1.748
HORIZONTAL SPREAD	:	2.795	2.795	2.795
VERTICAL SPREAD	:	3.471	2.321	1.419
EXTREME SPREAD	:	3.525	2.799	2.796
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

28 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649188

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 10

HS= 2.432

VS= 2.001

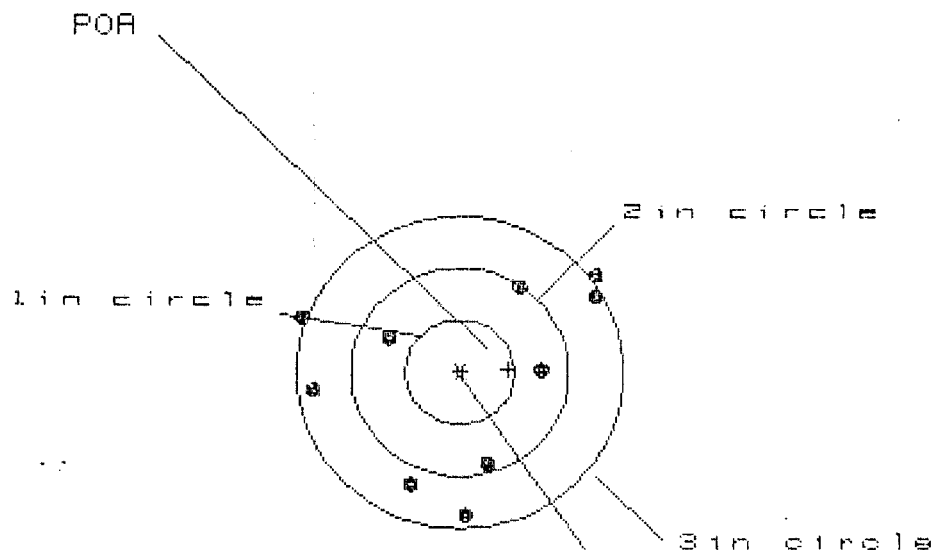
GS= 2.459

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.399	1.293	1.355
MINIMUM X	:	-1.033	-.877	-.815
MAXIMUM Y	:	.835	.842	.697
MINIMUM Y	:	-1.166	-1.159	-1.296
CENTROID X	:	.386	.230	.168
CENTROID Y	:	-.192	-.199	-.054
POA TO CENTROID in.	:	.431	.304	.177
MIN RADIUS	:	.234	.122	.037
MEAN RADIUS	:	1.038	.973	.901
MAX RADIUS	:	1.401	1.329	1.429
HORIZONTAL SPREAD	:	2.432	2.170	2.170
VERTICAL SPREAD	:	2.001	2.001	1.993
EXTREME SPREAD	:	2.459	2.313	2.313
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		10	

28 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66491B8

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 4

3 in = 8

HS= 2.717

VS= 2.265

GS= 2.824

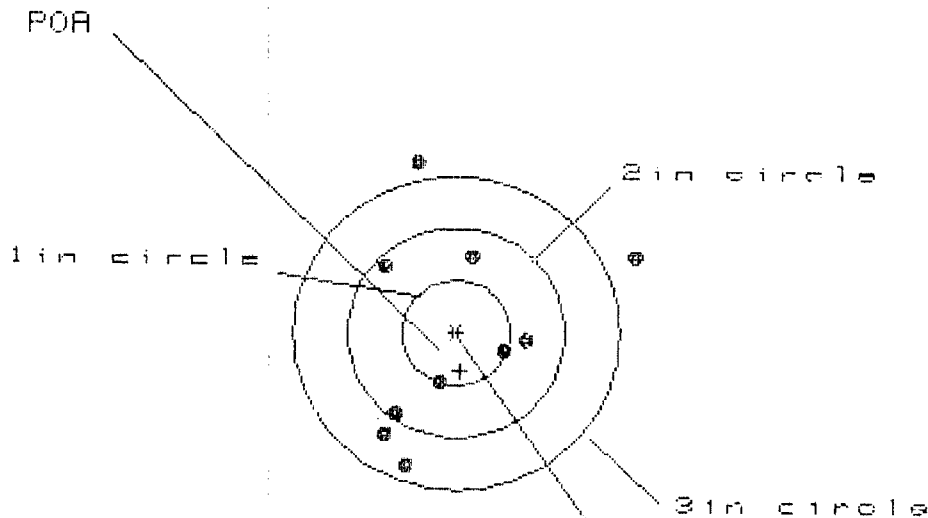
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.221	1.055	1.186
MINIMUM X	:	-1.496	-1.567	-1.436
MAXIMUM Y	:	.929	.992	1.038
MINIMUM Y	:	-1.336	-1.273	-1.149
CENTROID X	:	-.448	-.282	-.413
CENTROID Y	:	-.029	-.092	-.216
POA TO CENTROID in.	:	.449	.297	.466
MIN RADIUS	:	.750	.593	.732
MEAN RADIUS	:	1.192	1.129	1.081
MAX RADIUS	:	1.599	1.569	1.482
HORIZONTAL SPREAD	:	2.717	2.622	2.622
VERTICAL SPREAD	:	2.265	2.265	2.187
EXTREME SPREAD	:	2.824	2.824	2.753
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

28 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66491B8

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 3

HS= 2.349

VS= 2.901

GS= 2.956

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.666	.823	.802
MINIMUM X	:	-.683	-.498	-.519
MAXIMUM Y	:	1.605	1.684	1.056
MINIMUM Y	:	-1.296	-1.217	-1.006
CENTROID X	:	-.041	-.226	-.205
CENTROID Y	:	.364	.285	.074
POA TO CENTROID in.	:	.367	.363	.218
MIN RADIUS	:	.454	.349	.137
MEAN RADIUS	:	1.018	.918	.776
MAX RADIUS	:	1.814	1.693	1.106
HORIZONTAL SPREAD	:	2.349	1.321	1.321
VERTICAL SPREAD	:	2.901	2.901	2.062
EXTREME SPREAD	:	2.956	2.904	2.166
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			8	