

FORM

UPC



0 47700 25716 7

BARREL LENGTH

CAPACITY*

*INCLUDES 1 IN CHAMBER

C6649194

5716

ORDER NO.

MODEL 700 TM M24

Remington



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

MODEL 700 TM M24

SERIAL NO.

C6649194

ORDER NO.

5716

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

20



5716 C6649194

ORDER 5716

MODEL 700 TM M24

UPC

ORDER 5716

MODEL 700 TM M24

UPC



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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649194

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10 1	91	<i>RW</i>
600	Proof	10 1	91	<i>RW</i>
607	Check Headspace	10 1	91	<i>RW</i>
610	Dis-assemble Gun			<i>RW</i>
612	Magnaflux Barrel Action		OCT 10 1991	KR
	Magnaflux Bolt		OCT 10 1991	KR
615	Rollmark Caliber		OCT 10 1991	LS
617	Drill and Tap Sight Holes		OCT 10 1991	LS
618	Polish Barrel		10/15/91	WB
620	Apply Coatings (Barrel Action)		12-7-91	<i>LS</i>
	Apply Coating (Bolt)			<i>LS</i>
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	<i>JS</i>

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			12-7-91	QU
	G) Safety Off Force	4	4	4			12-7-91	QU
	H) Trigger Pull Test & Retainability						12-7-91	QU
	I) Firing Pin Indent	.021	.020	.020			12-7-91	QU
	J) Assemble Stock						12/7/91	KA
	K) Assemble Swivel Studs						12-11-91	AC
	L) Attach Front and Rear Sight Assemblies						12/7/91	KA
	M) Iron Sight Alignment						12/7/91	KA
	N) Detach Front & Rear Sights & place in numbered container						12/7/91	KA
	O) Attach Scope to Rifle						12/7/91	KA
	P) Detach & Attach Scope 20 Times						12/7/91	KA
640	Gallery Target & Test						12-9-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						12-9-91	NF
655	Final Inspection							
	A) Headspace						12-11-91	AC
	B) Trigger Pull	2.77	2.57	2.38	2.43	2.40	12-11-91	QU
	C) Function						12-11-91	AC
660	Pack						12-19-91	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-6649194

DATE 12-7-91

TESTER JY

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.56	2.59	2.44	2.77	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.54	2.61	2.35	2.57	
PULL #3	2.53	2.60	2.25	2.38	
PULL #4	2.54	2.66	2.22	2.43	
PULL #5	2.54	2.66	2.56	2.40	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.44	3.51		
PULL #2	3.51	3.55		
PULL #3	3.55	3.51		
PULL #4	3.33	3.48		
PULL #5	3.38	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	4.30	4.41		4.25
PULL #2	4.30	4.36		4.31
PULL #3	4.45	4.31		4.31
PULL #4	4.30	4.39		4.37
PULL #5	4.36	4.37		4.30
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06649194
9 Dec 1991

CENTROIDAL DISTANCES

0 TO 1	.104235
1 TO 2	.103586
1 TO 3	.115313
1 TO 4	.109179
1 TO 5	.117712

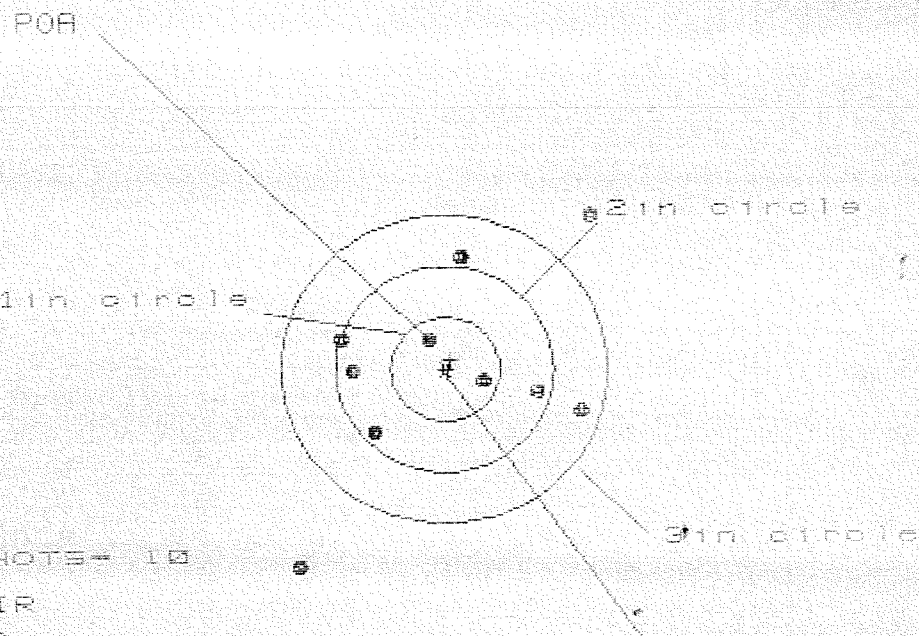
0 (----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0594
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0858
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .104355
THE AMR FOR THIS RIFLE IS: .987

9 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08649194

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.646

VS= 3.487

GS= 4.377

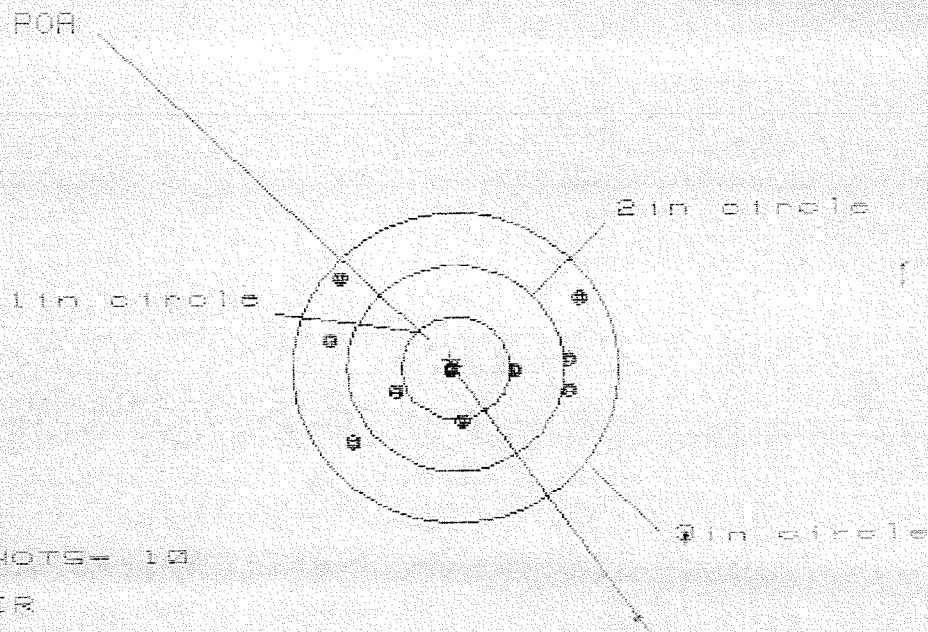
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.312	1.164	1.250
MINIMUM X	:	-1.334	-1.129	-1.983
MAXIMUM Y	:	1.530	1.313	1.025
MINIMUM Y	:	-1.957	-1.795	-1.631
CENTROID X	:	-.049	.099	-.047
CENTROID Y	:	-.092	.125	-.039
POA TO CENTROID in.	:	.105	.160	.061
MIN RADIUS	:	.305	.318	.264
MEAN RADIUS	:	1.103	.956	.828
MAX RADIUS	:	2.368	1.755	1.328
HORIZONTAL SPREAD	:	2.646	2.293	2.243
VERTICAL SPREAD	:	3.487	2.108	1.658
EXTREME SPREAD	:	4.377	2.864	2.351
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

1 in = 1

2 in = 4

3 in = 10

HS= 2.280

VS= 1.599

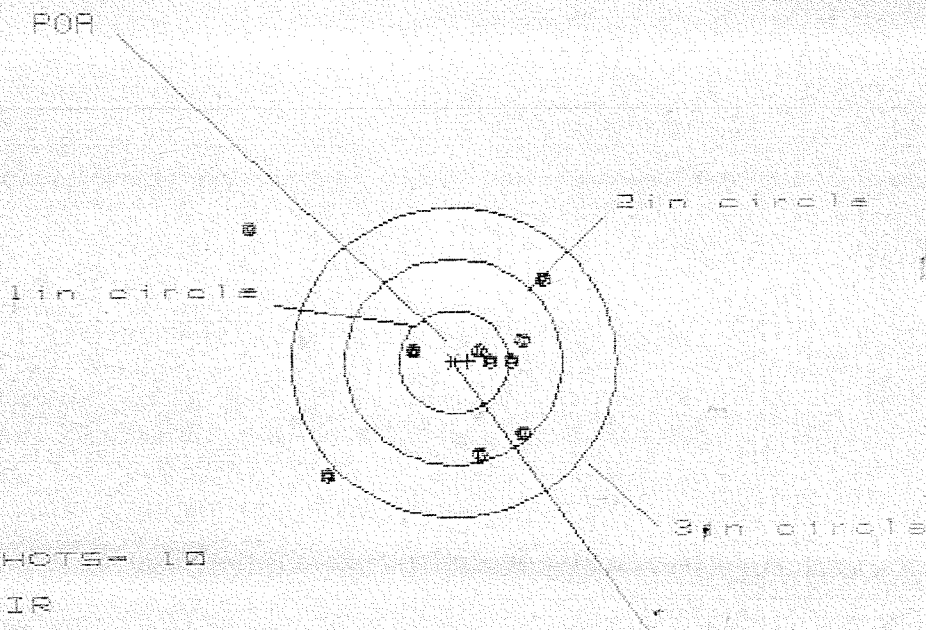
GS= 2.544

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.113	1.001	1.095
MINIMUM X	:	-1.167	-1.279	-1.154
MAXIMUM Y	:	.831	.751	.448
MINIMUM Y	:	-.768	-.676	-.582
CENTROID X	:	.054	.167	.042
CENTROID Y	:	-.081	-.173	-.267
POA TO CENTROID in.	:	.093	.240	.270
MIN RADIUS	:	.074	.170	.140
MEAN RADIUS	:	.901	.843	.777
MAX RADIUS	:	1.307	1.327	1.237
HORIZONTAL SPREAD	:	2.280	2.280	2.249
VERTICAL SPREAD	:	1.599	1.427	1.030
EXTREME SPREAD	:	2.544	2.544	2.262
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

8 Dec 1991

FILE: /PATTERNING/CENTERFIRE_PATT/C6649194

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 7

3 in = 8

HS= 2.740

VS= 2.401

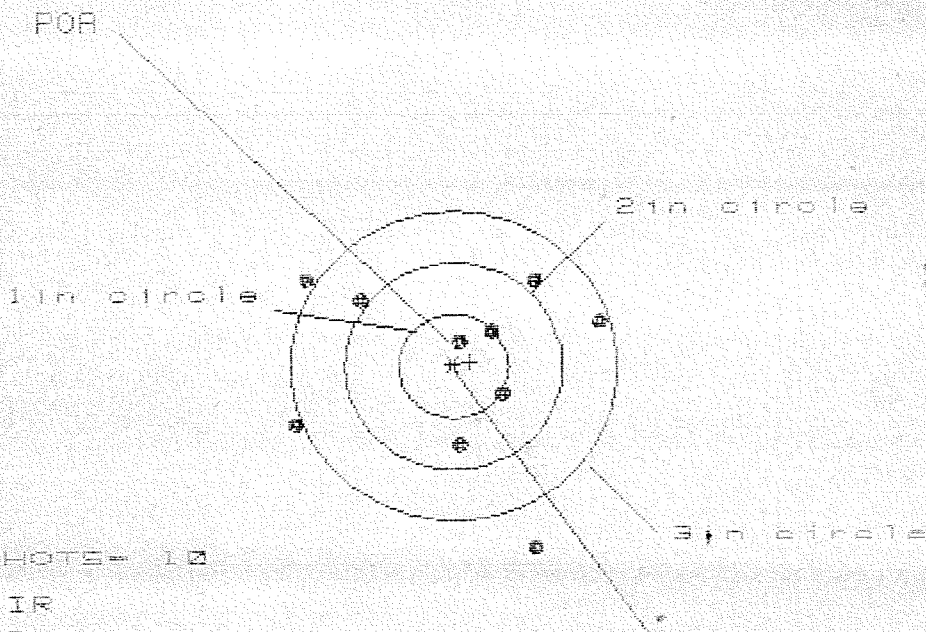
GS= 3.212

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.876	.669	.498
MINIMUM X	-1.864	-1.363	-1.769
MAXIMUM Y	1.354	.918	.806
MINIMUM Y	-1.047	-.896	-.812
CENTROID X	-.128	.079	.250
CENTROID Y	-.008	-.159	-.047
POA TO CENTROID in.	.128	.177	.254
MIN RADIUS	.284	.171	.102
MEAN RADIUS	.899	.685	.508
MAX RADIUS	2.304	1.632	.947
HORIZONTAL SPREAD	2.740	2.032	1.267
VERTICAL SPREAD	2.401	1.814	1.618
EXTREME SPREAD	3.212	2.724	1.730
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	

9 Dec 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 4

3 in = 7

HS= 2.758

VS= 2.662

GS= 3.407

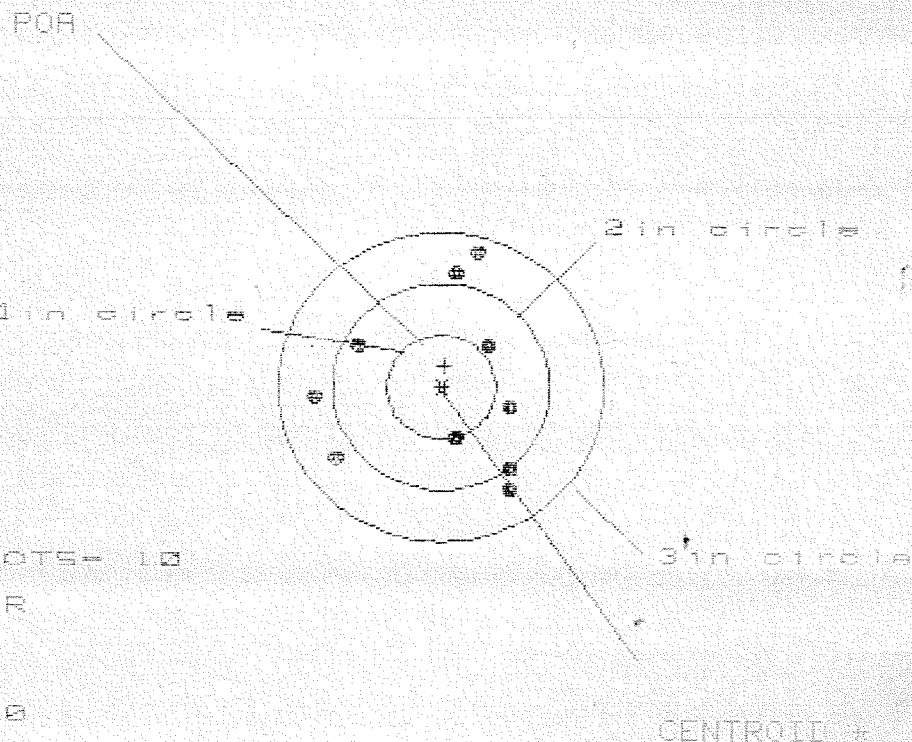
CENTROID #

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.313	1.400	1.236
MINIMUM X	-1.445	-1.358	-1.522
MAXIMUM Y	.878	.680	.760
MINIMUM Y	-1.784	-.986	-.986
CENTROID X	-.145	-.232	-.099
CENTROID Y	-.040	.158	.078
POA TO CENTROID in.	.150	.281	.104
MIN RADIUS	.259	.147	.139
MEAN RADIUS	1.071	.959	.862
MAX RADIUS	1.948	1.535	1.649
HORIZONTAL SPREAD	2.758	2.758	2.758
VERTICAL SPREAD	2.662	1.666	1.666
EXTREME SPREAD	3.407	2.908	2.908
NUMBER IN ONE INCH CIRCLE	= 2		
NUMBER IN TWO INCH CIRCLE	= 4		
NUMBER IN THREE INCH CIRCLE	= 7		

9 Dec 1981

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 10

HS= 1.928

VS= 2.282

GS= 2.338

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.672	.786	.785
MINIMUM X	:	-1.156	-1.122	-1.043
MAXIMUM Y	:	1.287	1.213	1.187
MINIMUM Y	:	-.945	-.852	-.744
CENTROID X	:	-.029	-.063	-.142
CENTROID Y	:	-.203	-.351	-.244
PQR TO CENTROID IN.	:	.210	.357	.283
MIN RADIUS	:	.474	.351	.483
MEAN RADIUS	:	.958	.905	.890
MAX RADIUS	:	1.322	1.220	1.125
HORIZONTAL SPREAD	:	1.828	1.828	1.828
VERTICAL SPREAD	:	2.282	2.063	1.850
EXTREME SPREAD	:	2.338	2.127	2.037
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	