

FORM

UPC



0 47700 25716 7

06649205

*INCLUDES 1 IN CHAMBER

MODEL 700 TM M24

5716

ORDER NO.

BARREL LENGTH

CAPACITY*

Remington



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

MODEL 700TM M24

SERIAL NO.

C6649205

ORDER NO.

5716

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

20



5716 C6649205

ORDER 5716

MODEL 700TM M24

UPC

ORDER 5716

MODEL 700TM M24

UPC



0 47700 25716 7



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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649205

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	GS
617	Drill and Tap Sight Holes		OCT 10 1991	LB
618	Polish Barrel		10/15/91	WB
620	Apply Coatings (Barrel Action)		11/7/91	TH
	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		11-15-91	TH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			11/18/91	gH
	G) Safety Off Force	3	3	3			11/18/91	gH
	H) Trigger Pull Test & Retainability						11/15/91	gH
	I) Firing Pin Indent	.020	.020	.020			11-18-91	gH
	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	2.71	2.74	2.77	2.77	2.81	11-20-91	DH
	C) Function						11-27-91	DH
660	Pack							

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C 6649205

DATE 11-15-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.33	2.54	2.49	2.71	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE, LESS THAN 2#
PULL #2	2.31	2.52	2.53	2.74	
PULL #3	2.39	2.54	2.55	2.77	
PULL #4	2.54	2.51	2.51	2.77	
PULL #5	2.53	2.53	2.51	2.81	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.33	3.21		
PULL #2	3.26	3.31		
PULL #3	3.28	3.25		
PULL #4	3.30	3.47		
PULL #5	3.31	3.45		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.24	4.60		4.51
PULL #2	4.56	4.56		4.35
PULL #3	4.46	4.53		4.58
PULL #4	4.58	4.60		4.57
PULL #5	4.50	4.56		4.50
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06649205
20 Nov 1991

CENTROIDAL DISTANCES

0 TO 1	.108467
1 TO 2	.633202
1 TO 3	.167263
1 TO 4	.139846
1 TO 5	.173401

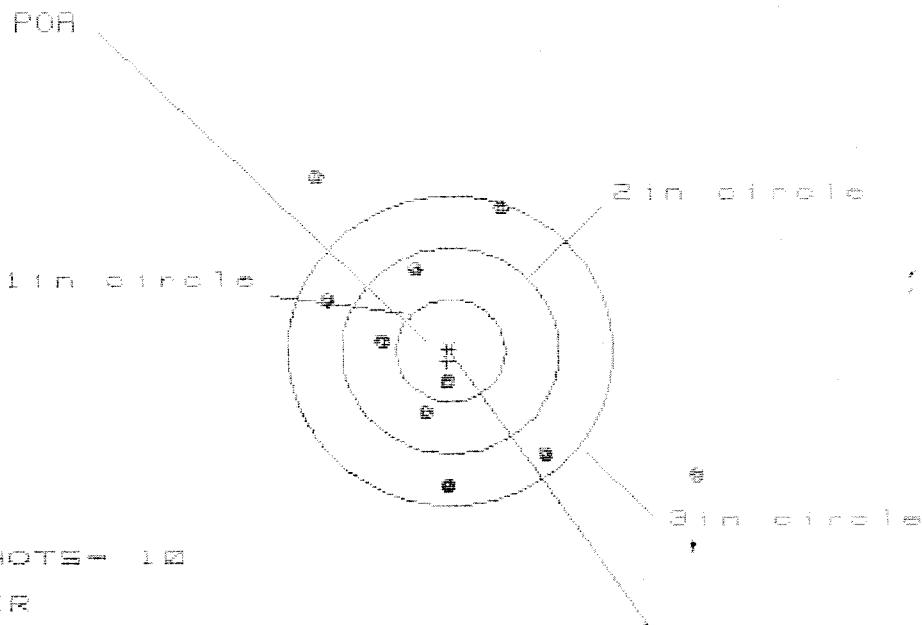
2 3 4 5 <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0836
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0472
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0968042
THE AMR FOR THIS RIFLE IS: .9694

28 NOV 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6849205

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 8

HS= 3.403

VS= 3.063

GS= 4.465

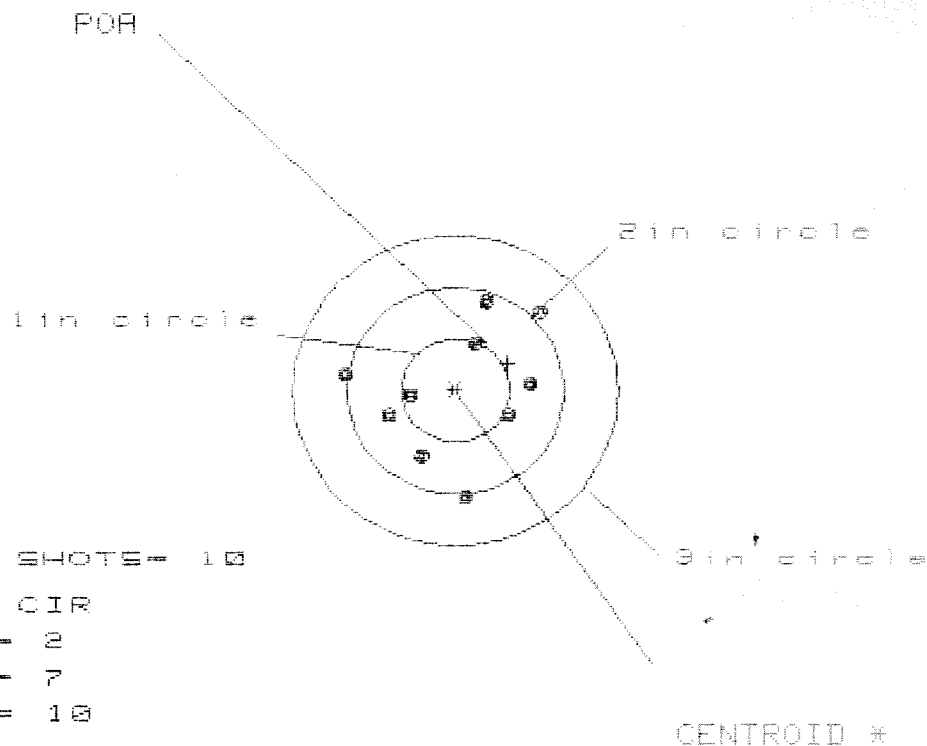
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.218	1.120	1.063
MINIMUM X	:	-1.185	-.938	-.978
MAXIMUM Y	:	1.714	1.583	1.449
MINIMUM Y	:	-1.349	-1.480	-1.282
CENTROID X	:	.034	-.213	-.096
CENTROID Y	:	.103	.234	.036
POA TO CENTROID in.	:	.109	.316	.102
MIN RADIUS	:	.272	.433	.222
MEAN RADIUS	:	1.245	1.072	.952
MAX RADIUS	:	2.511	1.840	1.578
HORIZONTAL SPREAD	:	3.403	2.058	1.981
VERTICAL SPREAD	:	3.063	3.063	2.701
EXTREME SPREAD	:	4.465	3.420	2.777
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

20 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649205

CENTERFIRE PATTERNS: # 2



OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 10

HS = 1.824

VS = 1.975

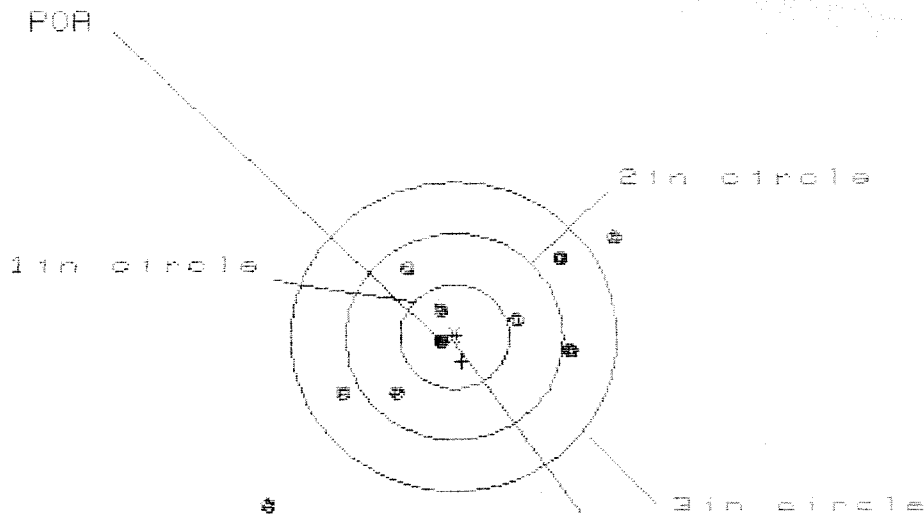
GS = 2.000

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.803	.734	.752
MINIMUM X	:	-1.021	-.932	-.914
MAXIMUM Y	:	.897	.983	.860
MINIMUM Y	:	-1.078	-.992	-.695
CENTROID X	:	-.482	-.571	-.589
CENTROID Y	:	-.264	-.350	-.227
POA TO CENTROID in.	:	.550	.670	.631
MIN RADIUS	:	.423	.329	.327
MEAN RADIUS	:	.755	.704	.662
MAX RADIUS	:	1.118	1.045	.936
HORIZONTAL SPREAD	:	1.824	1.666	1.666
VERTICAL SPREAD	:	1.975	1.975	1.554
EXTREME SPREAD	:	2.000	1.986	1.669
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

20 Nov 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 8

HS = 3.246

VS = 2.568

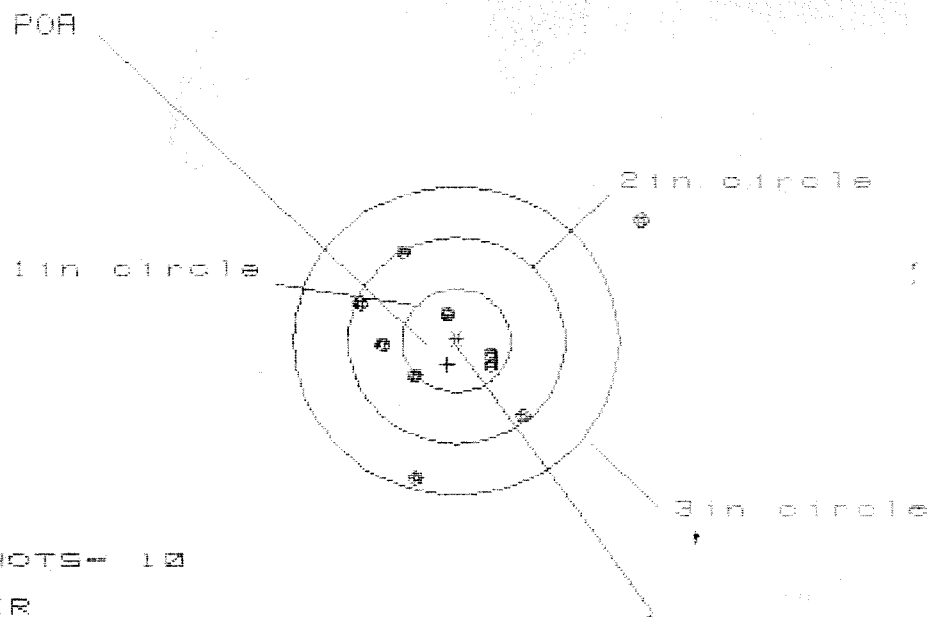
GS = 4.139

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.485	1.289	1.016
MINIMUM X	:	-1.761	-1.249	-1.088
MAXIMUM Y	:	.962	.783	.716
MINIMUM Y	:	-1.606	-.732	-.634
CENTROID X	:	-.070	.126	-.035
CENTROID Y	:	.234	.413	.315
FOR TO CENTROID in.	:	.245	.432	.317
MIN RADIUS	:	.121	.367	.194
MEAN RADIUS	:	1.028	.872	.765
MAX RADIUS	:	2.384	1.508	1.259
HORIZONTAL SPREAD	:	3.246	2.538	2.104
VERTICAL SPREAD	:	2.568	1.515	1.350
EXTREME SPREAD	:	4.139	2.956	2.443
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

28 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08848285

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 2.570

VS= 2.506

GS= 3.235

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.706	.780	.762
MINIMUM X	:	-.864	-.675	-.693
MAXIMUM Y	:	1.200	1.026	.880
MINIMUM Y	:	-1.306	-1.173	-.721
CENTROID X	:	.088	-.101	-.083
CENTROID Y	:	.232	.099	.245
POA TO CENTROID in.	:	.248	.141	.259
MIN RADIUS	:	.285	.291	.250
MEAN RADIUS	:	.852	.694	.621
MAX RADIUS	:	2.086	1.182	1.049
HORIZONTAL SPREAD	:	2.570	1.455	1.455
VERTICAL SPREAD	:	2.506	2.199	1.681
EXTREME SPREAD	:	3.235	2.206	1.943
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

28 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C88492B5

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 8

IS = 3.0002

VS = 2.049

GS = 3.138

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.675	1.101	.949
MINIMUM X	:	-1.407	-1.221	-.589
MAXIMUM Y	:	1.000	.974	1.016
MINIMUM Y	:	-1.049	-1.075	-1.033
CENTROID X	:	.012	-.174	-.022
CENTROID Y	:	-.069	-.043	-.085
POA TO CENTROID in.	:	.070	.180	.087
MIN RADIUS	:	.446	.404	.453
MEAN RADIUS	:	.967	.872	.816
MAX RADIUS	:	1.691	1.265	1.086
HORIZONTAL SPREAD	:	3.082	2.322	1.538
VERTICAL SPREAD	:	2.049	2.049	2.049
EXTREME SPREAD	:	3.138	2.334	2.062
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	