

MODEL

FORM

CAT INCLUDES 1 IN CHAMBER

6649229

UPC



6649229 7

0 47700 " 251

5716

ORDER NO.

BARREL LENGTH

CAPACITY

TM M24

700

Remington



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

MODEL 700TM M24

SERIAL NO.

C6649229

ORDER NO.

5716

20

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



5716 C6649229

ORDER 5716

MODEL 700TM M24

UPC

ORDER 5716

MODEL 700TM M24

UPC



0 47700 25716 7



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649229

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 4 1991	KR
	Magnaflux Bolt		OCT 4 1991	KR
615	Rollmark Caliber		OCT 4 1991	GB
617	Drill and Tap Sight Holes		OCT 4 1991	LUB
618	Polish Barrel		10/8/91	LUB
620	Apply Coatings (Barrel Action)		10-22-91	DA
	Apply Coating (Bolt)		10-22-91	DA
625	Final Assembly A) Clean inside of Bolt Assembly		10/22/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/22/91	RW
	C) Inspect Ejector Hole for Chamfer		10/22/91	RW
	D) Oil Firing Pin Ass'y		10/22/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/25/91	DH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			10/25/91	DH
	G) Safety Off Force	3	3	3			10/25/91	DH
	H) Trigger Pull Test & Retainability						10/25/91	DH
	I) Firing Pin Indent	.020	.020	.020			10/25/91	DH
	J) Assemble Stock						10/25/91	RW
	K) Assemble Swivel Studs						10-30-91	K
	L) Attach Front and Rear Sight Assemblies						10/25/91	RW
	M) Iron Sight Alignment						10/25/91	RW
	N) Detach Front & Rear Sights & place in numbered container						10/25/91	RW
	O) Attach Scope to Rifle						10/25/91	RW
	P) Detach & Attach Scope 20 Times						10/25/91	RW
640	Gallery Target & Test						10-28-91	DH
	A) Time						10-28-91	DH
	B) Malfunctions						10-28-91	DH
	C) Pierced Primers						10-28-91	DH
	D) Optical Clarity of Scope						10-28-91	DH
645	Inspect for Live Ammo						10-28-91	DH
655	Final Inspection							
	A) Headspace						10-30-91	K
	B) Trigger Pull	230	220	221	224	240	10-29-91	DH
	C) Function						10-30-91	K
660	Pack						12-18-91	N

SWS TRIGGER PULL TEST

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

SERIAL NO. C6649229
DATE 9-6-91
TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.54	2.66	2.50	2.36	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.36	2.42	2.60	2.20	
PULL #3	2.27	2.35	2.29	2.21	
PULL #4	2.30	2.27	2.45	2.24	
PULL #5	2.24	2.19	2.34	2.40	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.42	3.34		
PULL #2	3.30	3.34		
PULL #3	3.25	3.40		
PULL #4	3.16	3.46		
PULL #5	3.39	3.36		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.50	4.56		4.60
PULL #2	4.52	4.30		4.43
PULL #3	4.53	4.28		4.41
PULL #4	4.53	4.40		4.39
PULL #5	4.43	4.31		4.10
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 66649229
28 Oct 1991

CENTROIDAL DISTANCES

0 TO 1	.142594
1 TO 2	.404951
1 TO 3	.348554
1 TO 4	.274804
1 TO 5	.232723

³/₁₆ <----POA

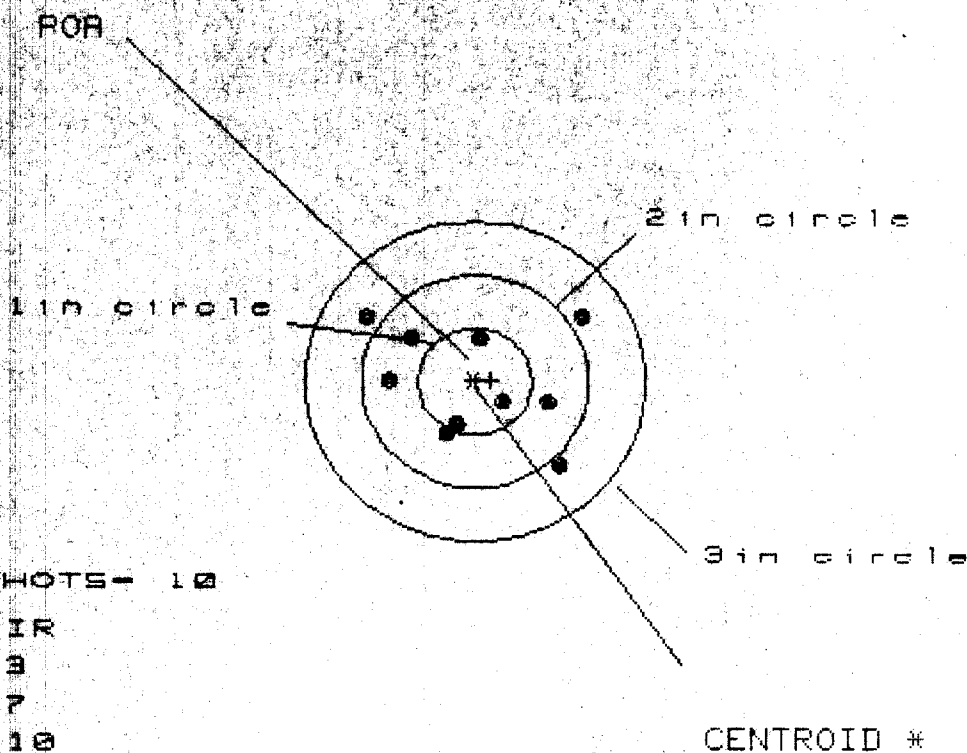
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0068
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0934
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0936472

THE AMR FOR THIS RIFLE IS: .9342

28 Oct 1991

FILE: PATTERNING/CENTERFIRE.PATT/CBD49229

CENTERFIRE PATTERNS # 1



* OF SHOTS- 10

* IN CIR

1in = 3

2in = 7

3in = 10

HS = 1.895

VS = 1.384

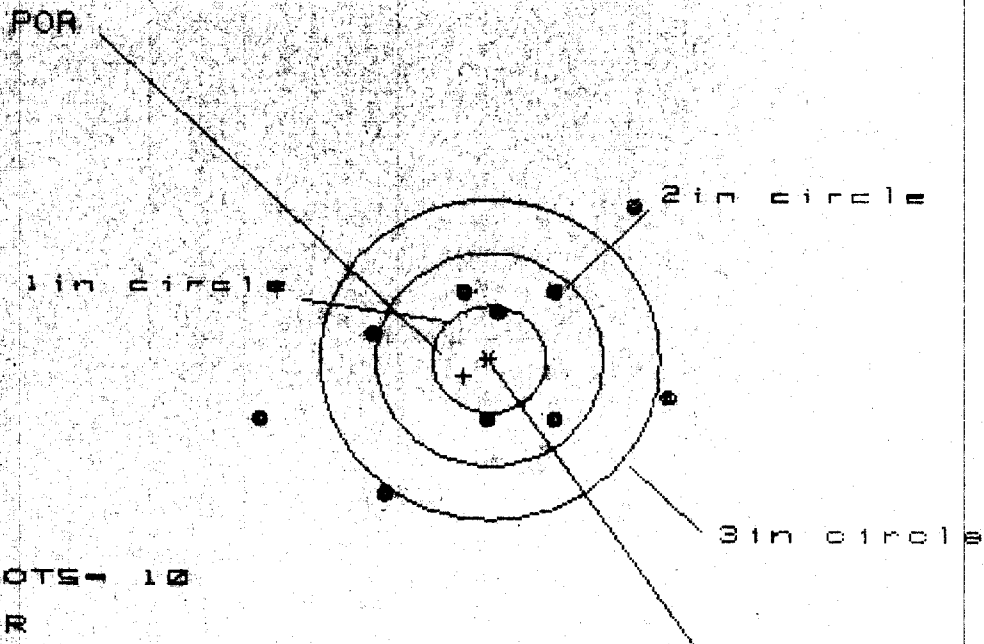
GS = 2.199

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.956	.876	.772
MINIMUM X	:	-.939	-.833	-.790
MAXIMUM Y	:	.638	.706	.585
MINIMUM Y	:	-.746	-.678	-.590
CENTROID X	:	-.142	-.248	-.144
CENTROID Y	:	-.013	-.081	-.169
POA TO CENTROID in.	:	.142	.261	.222
MIN RADIUS	:	.308	.319	.228
MEAN RADIUS	:	.711	.652	.579
MAX RADIUS	:	1.137	1.108	.971
HORIZONTAL SPREAD	:	1.895	1.709	1.562
VERTICAL SPREAD	:	1.384	1.384	1.175
EXTREME SPREAD	:	2.199	2.199	1.737
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			10	

28 Oct 1981

FILE: PATTERNING/CENTERFIRE PATT/08545229

CENTERFIRE PATTERNS # 2



* OF SHOTS - 10

* IN CIR

1in 1

2in 5

3in 4

HSI 3.605

VS 2.681

GS 3.763

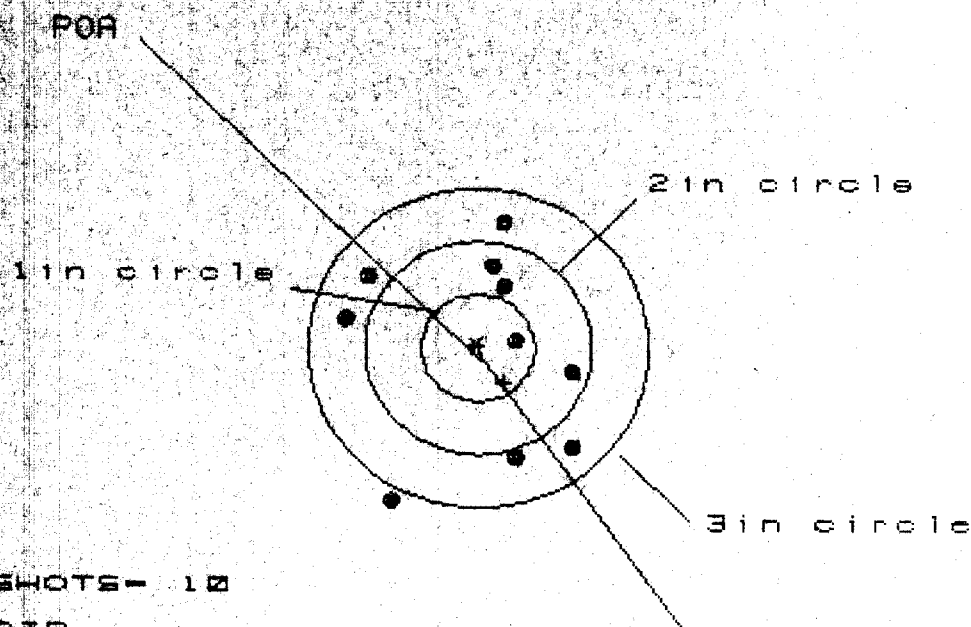
CENTROID *

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.622	1.402	1.530
MINIMUM X	:	-1.983	-1.230	-1.102
MAXIMUM Y	:	1.401	1.343	.736
MINIMUM Y	:	-1.280	-1.338	-1.170
CENTROID X	:	.226	.446	.318
CENTROID Y	:	.156	.214	.046
POR TO CENTROID in.	:	.274	.495	.321
MIN RADIUS	:	.470	.408	.501
MEAN RADIUS	:	1.150	1.031	.946
MAX RADIUS	:	2.052	1.741	1.552
HORIZONTAL SPREAD	:	3.605	2.632	2.632
VERTICAL SPREAD	:	2.681	2.681	1.906
EXTREME SPREAD	:	3.763	3.432	2.693
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		6	

20 Oct 1981

FILE: PATTERNING/CENTERFIRE PATT/C6645229

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 9

HE = 2.040

VS = 2.594

GS = 2.783

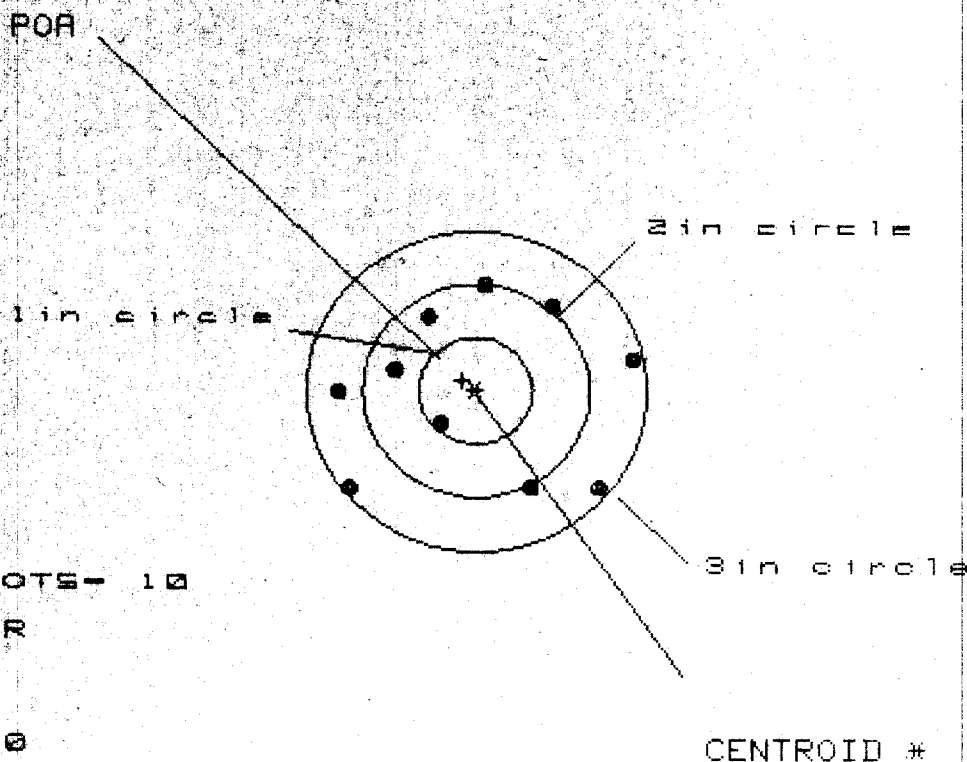
CENTROID #

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.839	.755	.849
MINIMUM X	:	-1.201	-1.285	-1.191
MAXIMUM Y	:	1.183	1.027	.892
MINIMUM Y	:	-1.411	-1.190	-1.325
CENTROID X	:	-.231	-.147	-.241
CENTROID Y	:	.324	.480	.615
POA TO CENTROID in:	:	.398	.502	.661
MIN RADIUS	:	.339	.271	.360
MEAN RADIUS	:	1.013	.908	.844
MAX RADIUS	:	1.602	1.317	1.360
HORIZONTAL SPREAD	:	2.040	2.040	2.040
VERTICAL SPREAD	:	2.594	2.217	2.217
EXTREME SPREAD	:	2.783	2.392	2.218
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

28 OCT 1991

FILE: PATTERNING/CENTERFIRE PATT/C6549223

CENTERFIRE PATTERNS # 4



* OF SHOTS - 10

* IN CIR

1 in = 1

2 in = 4

3 in = 10

HS = 2.556

VS = 1.873

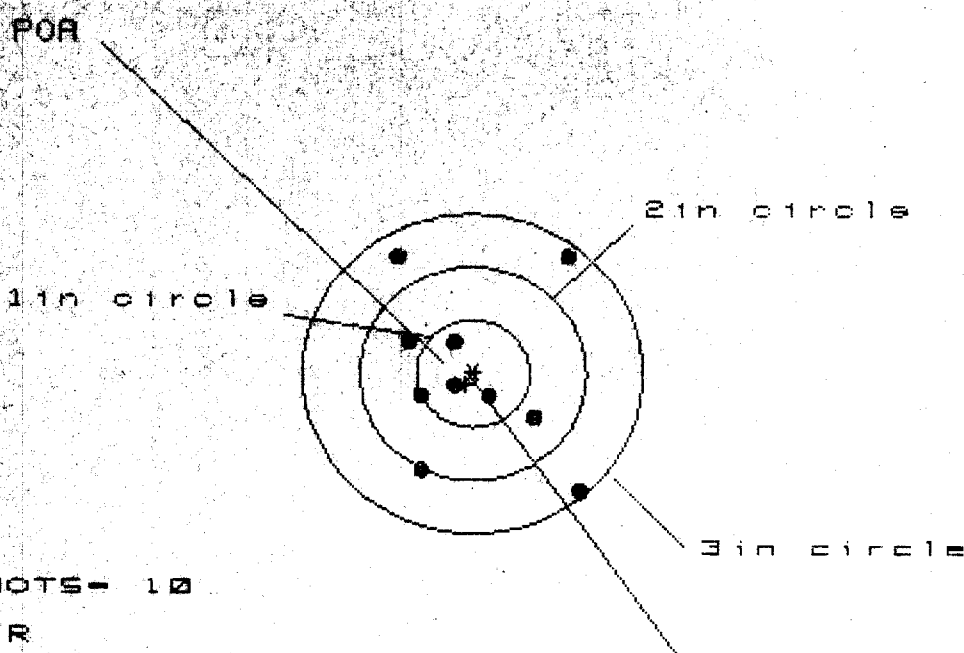
GS = 2.749

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.385	1.231	1.113
MINIMUM X	:	-1.171	-1.018	-1.136
MAXIMUM Y	:	.953	.985	.880
MINIMUM Y	:	-.920	-.888	-.993
CENTROID X	:	.119	-.034	.084
CENTROID Y	:	-.099	-.131	-.026
POA TO CENTROID in.	:	.155	.136	.088
MIN RADIUS	:	.443	.311	.468
MEAN RADIUS	:	1.043	.975	.940
MAX RADIUS	:	1.415	1.488	1.458
HORIZONTAL SPREAD	:	2.556	2.249	2.249
VERTICAL SPREAD	:	1.873	1.873	1.873
EXTREME SPREAD	:	2.749	2.430	2.396
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

28 Oct 1981

FILE:/PATTERNING/CENTERFIRE_PATT/C8649229

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 10

HS= 1.613

VS= 2.131

GS= 2.658

CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.912	.892	.774
MINIMUM X	:	-.701	-.600	-.488
MAXIMUM Y	:	1.070	.952	1.053
MINIMUM Y	:	-1.061	-.976	-.857
CENTROID X	:	.062	-.039	-.151
CENTROID Y	:	.099	.217	.098
POA TO CENTROID in.	:	.117	.220	.180
MIN RADIUS	:	.216	.178	.095
MEAN RADIUS	:	.754	.669	.560
MAX RADIUS	:	1.399	1.305	1.161
HORIZONTAL SPREAD	:	1.613	1.492	1.262
VERTICAL SPREAD	:	2.131	1.928	1.910
EXTREME SPREAD	:	2.658	2.274	1.931
NUMBER IN ONE INCH CIRCLE	=	4		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	10		