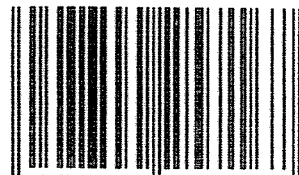


FORM

UPC



0 47700 25716 2

C6649239

INCLUDES 1 IN CHAMBER

Remington



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

MODEL 700 TM M24

SERIAL NO.

C6649239

ORDER NO.

5716

20

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



5716 C6649239

ORDER 5716

MODEL 700 TM M24

UPC



0 47700 25716 7

ORDER 5716

MODEL 700 TM M24

UPC



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649239

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 1 0 1991	KR
	Magnaflux Bolt		OCT 1 0 1991	KR
615	Rollmark Caliber		OCT 1 0 1991	GL
617	Drill and Tap Sight Holes		OCT 1 0 1991	WB
618	Polish Barrel		10/15/91	WB
620	Apply Coatings (Barrel Action)		11/8/91	WB
	Apply Coating (Bolt)		11/8/91	WB
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	GL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			12-5-91	AK
	G) Safety Off Force	2	2	3			12-6-91	AK
	H) Trigger Pull Test & Retainability						12-5-91	AK
	I) Firing Pin Indent	1020	10205	10205			12-5-91	AK
	J) Assemble Stock						12/6/91	RW
	K) Assemble Swivel Studs						12-7-91	AK
	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	KT
	A) Time						"	KT
	B) Malfunctions						"	1-7
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	14
645	Inspect for Live Ammo						12/6/91	KT
655	Final Inspection							
	A) Headspace						12-7-91	AK
	B) Trigger Pull	273	265	265	273	280	12-7-91	DH
	C) Function						12-7-91	AC
660	Pack						12-19-91	AF

SWS TRIGGER PULL TEST

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

SERIAL NO. 06649239

DATE 12-5-91

TESTER 97

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.20	2.35	2.40	273	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.29	2.33	2.44	265	
PULL #3	2.45	2.40	2.39	265	
PULL #4	2.45	2.35	2.49	273	
PULL #5	2.35	2.29	2.50	280	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.40	3.49		
PULL #2	3.20	3.44		
PULL #3	3.22	3.25		
PULL #4	3.28	3.38		
PULL #5	3.24	3.41		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.38	4.33		4.34
PULL #2	4.18	4.36		4.37
PULL #3	4.45	4.31		4.38
PULL #4	4.32	4.33		4.40
PULL #5	4.31	4.35		4.41
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06649239
6 Dec 1991

CENTROIDAL DISTANCES

0 TO	1	.179936
1 TO	2	.563863
1 TO	3	.854013
1 TO	4	.46924
1 TO	5	.165148

2 ⁴³ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0838
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .064
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .105444
THE AMR FOR THIS RIFLE IS: 1.138

6 Dec 1991

FILE: PATTERNING/CENTERFIRE_PATT/C6B49239

CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

CENTROID *

* OF SHOTS = 10

* IN CIR

1in = 1

2in = 3

3in = 8

ME = 2.715

VS = 2.301

CS = 3.234

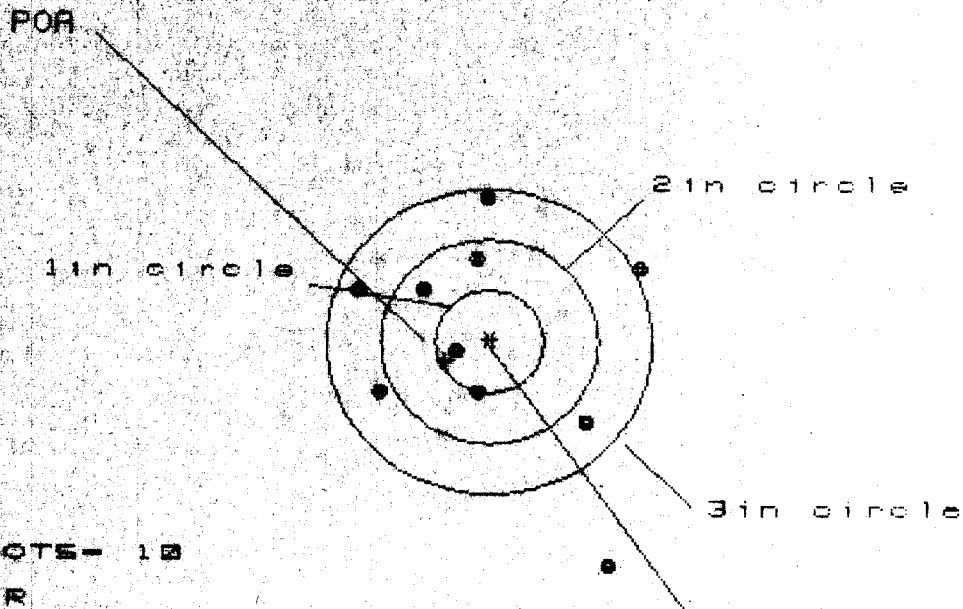
PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.107	.928	.848
MINIMUM X	:	-1.608	-.850	-.734
MAXIMUM Y	:	1.054	.976	.948
MINIMUM Y	:	-1.247	-1.325	-1.203
CENTROID X	:	.099	.278	.162
CENTROID Y	:	.114	.192	.070
POA TO CENTROID in.	:	.151	.338	.176
MIN RADIUS	:	.249	.411	.243
MEAN RADIUS	:	1.084	1.002	.943
MAX RADIUS	:	1.755	1.390	1.241
HORIZONTAL SPREAD	:	2.715	1.778	1.582
VERTICAL SPREAD	:	2.301	2.301	2.151
EXTREME SPREAD	:	3.234	2.667	2.357
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

6 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6648239

CENTERFIRE PATTERNS

4



* OF SHOTS- 10

* IN CIR

1in = 1

2in = 4

3in = 8

HEI 2.574

VEI 3.593

GEI 3.756

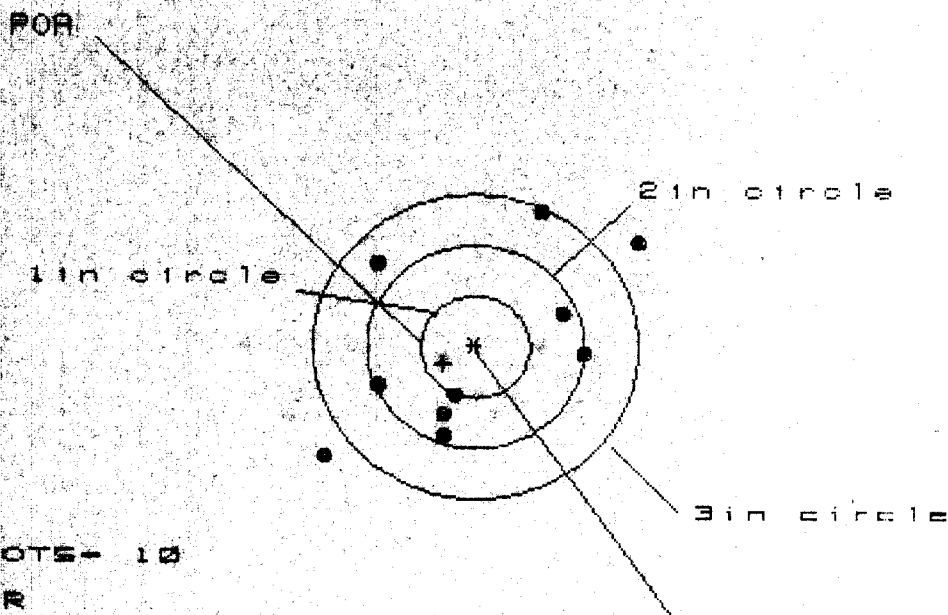
CENTROID *

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.390	1.514	1.206
MINIMUM X	:	-1.184	-1.060	-.871
MAXIMUM Y	:	1.437	1.197	1.256
MINIMUM Y	:	-2.156	-.984	-.925
CENTROID X	:	.413	.289	.100
CENTROID Y	:	.186	.426	.367
POA TO CENTROID in.	:	.453	.515	.380
MIN RADIUS	:	.339	.410	.304
MEAN RADIUS	:	1.150	.972	.857
MAX RADIUS	:	2.427	1.585	1.520
HORIZONTAL SPREAD	:	2.574	2.574	2.077
VERTICAL SPREAD	:	3.593	2.181	2.181
EXTREME SPREAD	:	3.756	2.699	2.451
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

6 Dec 1991

FILE: PATTERNING/CENTERFIRE_PATT/C8649233

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 1 1 1

2 1 3 5

3 1 3 8

H 1 2.955

V 1 2.332

G 1 3.591

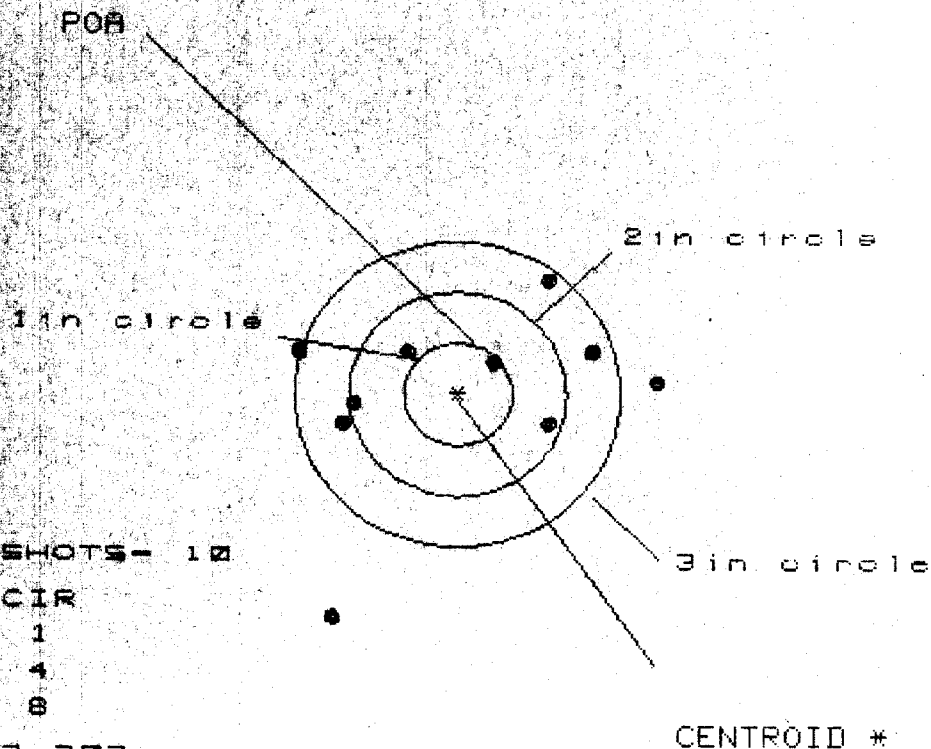
CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.544	1.201	1.046
MINIMUM X	:	-1.411	-1.240	-.897
MAXIMUM Y	:	1.307	1.420	1.306
MINIMUM Y	:	-1.025	-.912	-.867
CENTROID X	:	.298	.127	.282
CENTROID Y	:	.168	.055	.169
POA TO CENTROID in.	:	.342	.138	.329
MIN RADIUS	:	.500	.342	.494
MEAN RADIUS	:	1.120	1.000	.951
MAX RADIUS	:	1.847	1.622	1.449
HORIZONTAL SPREAD	:	2.955	2.441	1.943
VERTICAL SPREAD	:	2.332	2.332	2.173
EXTREME SPREAD	:	3.591	3.087	2.355
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

6 Dec 1991

FILE: PATTERNING/CENTERFIRE_PATT/C6649239

CENTERFIRE PATTERNS # 2



* OF SHOTS - 10

* IN CIR

1in = 1

2in = 4

3in = 8

HS = 3.203

VS = 3.234

GS = 3.802

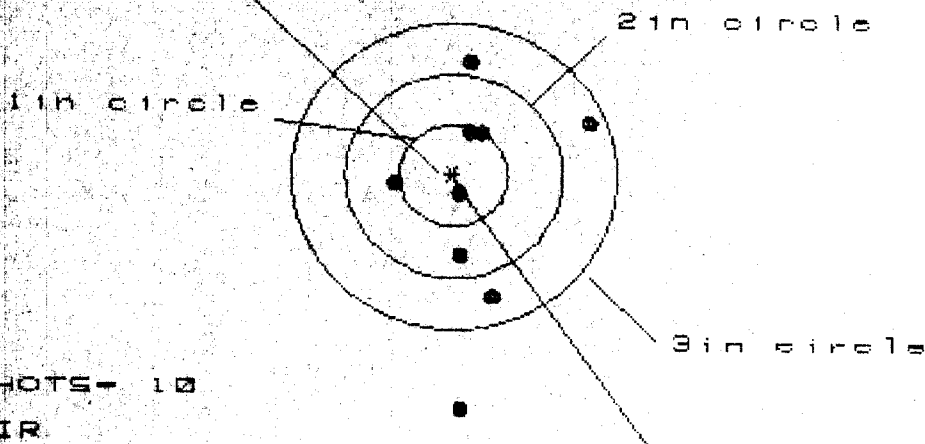
PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.788	1.655	1.325
MINIMUM X	:	-1.415	-1.548	-1.341
MAXIMUM Y	:	1.095	.858	.847
MINIMUM Y	:	-2.139	-.551	-.562
CENTROID X	:	-.335	-.202	-.409
CENTROID Y	:	-.319	-.082	-.071
POA TO CENTROID in.	:	.463	.218	.416
MIN RADIUS	:	.450	.214	.369
MEAN RADIUS	:	1.226	1.049	.965
MAX RADIUS	:	2.448	1.658	1.349
HORIZONTAL SPREAD	:	3.203	3.203	2.666
VERTICAL SPREAD	:	3.234	1.409	1.409
EXTREME SPREAD	:	3.802	3.212	2.666
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

8 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649239

CENTERFIRE PATTERNS # 1

POB



* OF SHOTS- 10

* IN CIR

1 in = 3

2 in = 5

3 in = 2

HSI = 2.034

VS = 4.256

GS = 4.662

CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.213	1.011	.996
MINIMUM X	:	-1.821	-.719	-.734
MAXIMUM Y	:	1.971	1.329	1.071
MINIMUM Y	:	-2.285	-2.066	-1.185
CENTROID X	:	-.056	.146	.161
CENTROID Y	:	.171	-.048	.210
POB TO CENTROID in.	:	.180	.154	.265
MIN RADIUS	:	.224	.151	.306
MEAN RADIUS	:	1.111	.928	.755
MAX RADIUS	:	2.683	2.069	1.189
HORIZONTAL SPREAD	:	3.034	1.730	1.730
VERTICAL SPREAD	:	4.256	3.395	2.256
EXTREME SPREAD	:	4.662	3.395	2.263
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	8		