

FOEN

UPC



0 47700 25716 2

C6665668

INCLUDES 1 IN CHAMBER

MODEL 700 TM M24

ORDER NO. 5716

BARREL LENGTH

CAPACITY*

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF	<i>Test OK</i> <i>11-26-91</i> <i>D/H</i>	
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

#	TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
		1st		
VF		10/22	Ejector Sticks	RW
		2nd		
		11/12/91	REAMED OUT EJECTOR HOLE	K.S.
		3rd		
			OK	
		4th		

FUNCTION
RD 6654
Rev 1

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6665668

①

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 26	9 1	RW
600	Proof	9 26	9 1	RW
607	Check Headspace	9 26	9 1	RW
610	Dis-assemble Gun	9 26	9 1	RW
612	Magnaflux Barrel Action	SEP 30 1991		KR
	Magnaflux Bolt	SEP 30 1991		KR
615	Rollmark Caliber	SEP 30 1991		SL
617	Drill and Tap Sight Holes	SEP 30 1991		FB.
618	Polish Barrel	OCT 2 1991		WT
620	Apply Coatings (Barrel Action)		10-13-91	TH
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		10/13/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/13/91	RW
	C) Inspect Ejector Hole for Chamfer		10/13/91	RW
	D) Oil Firing Pin Ass'y		10/13/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/22/91	TH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5 $\frac{3}{4}$	5 $\frac{1}{2}$			10-22-91	DH
	G) Safety Off Force	3 $\frac{1}{2}$	3 $\frac{1}{2}$	3 $\frac{1}{2}$			10-22-91	DH
	H) Trigger Pull Test & Retainability						10/22/91	JH
	I) Firing Pin Indent	.020	.020	.020			10-22-91	DH
	J) Assemble Stock						10/22/91	Rev
	K) Assemble Swivel Studs						11-27-91	AC
	L) Attach Front and Rear Sight Assemblies						10/22/91	Rev
	M) Iron Sight Alignment						10/22/91	Rev
	N) Detach Front & Rear Sights & place in numbered container						10/22/91	Rev
	O) Attach Scope to Rifle						10/22/91	Rev
	P) Detach & Attach Scope 20 Times						10/22/91	Rev
640	Gallery Target & Test						10-22-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						10-22-91	NF
655	Final Inspection							
	A) Headspace						11-27-91	AC
	B) Trigger Pull	259	263	268	273	273	10-23-91	DH
	C) Function						11-27-91	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-6665668
DATE 10/22/91
TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.22	2.33	2.48	2.59	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.20	2.39	2.50	2.63	
PULL #3	2.37	2.39	2.49	2.68	
PULL #4	2.35	2.44	2.43	2.73	
PULL #5	2.31	2.44	2.40	2.73	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.43	3.26		
PULL #2	3.32	3.35		
PULL #3	3.37	3.28		
PULL #4	3.42	3.38		
PULL #5	3.30	3.28		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.52	4.51		4.60
PULL #2	4.53	4.53		4.62
PULL #3	4.54	4.58		4.62
PULL #4	4.54	4.57		4.65
PULL #5	4.50	4.46		4.53
TOTAL				
AVG.				

Remington



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

MODEL 700™ M24

SERIAL NO.
C6665668

20

ORDER NO.
5716

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



5716 C6665668

ORDER 5716
MODEL 700™ M24
UPC



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0 47700 25716 7

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06663668
22 Oct 1991

CENTROIDAL DISTANCES

0 TO 1	.114856
1 TO 2	.138033
1 TO 3	.172409
1 TO 4	.187843
1 TO 5	.381577

5
37

-----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1168
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0036
THE RESULTING AVERAGE POB RADIUS FOR THIS RIFLE IS: .112045
THE POB FOR THIS RIFLE IS: .2116

22 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06685668

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 2.645

VS= 2.435

CS= 3.186

PATTERN #

1

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.189

1.028

1.088

MINIMUM X

-1.456

-1.048

-1.988

MAXIMUM Y

1.358

1.243

.883

MINIMUM Y

-1.077

-1.192

-1.036

CENTROID X

-.094

.067

.007

CENTROID Y

-.066

.049

-.166

POA TO CENTROID in.

.115

.083

.107

MIN RADIUS

.387

.273

.410

MEAN RADIUS

1.063

.949

.913

MAX RADIUS

1.787

1.380

1.235

HORIZONTAL SPREAD

2.645

2.076

2.076

VERTICAL SPREAD

2.435

2.435

1.919

EXTREME SPREAD

3.186

2.632

2.278

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

5

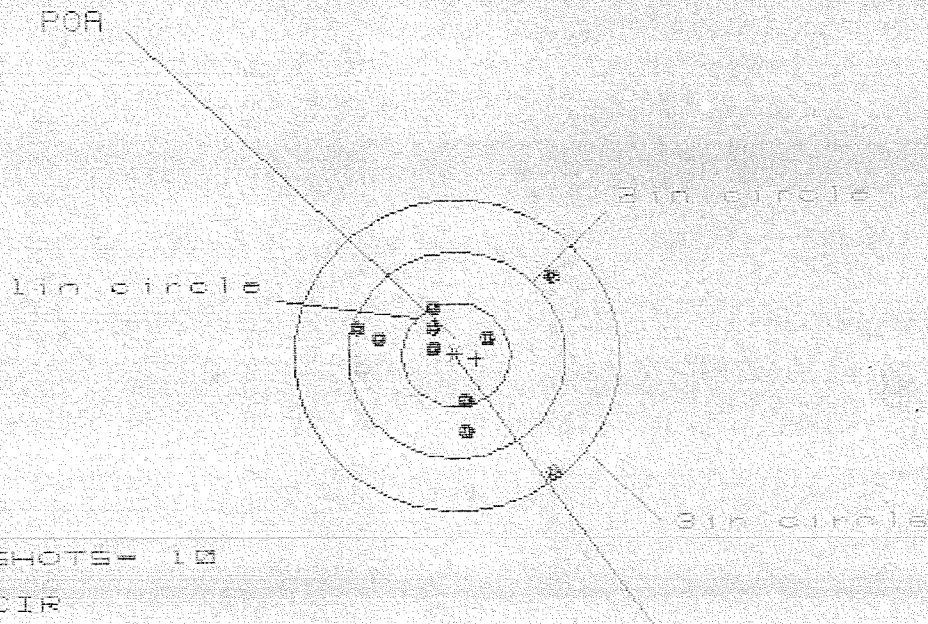
NUMBER IN THREE INCH CIRCLE =

8

22 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08065668

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 4

2in = 8

3in = 10

HS= 1.818

VS= 1.875

GS= 2.248

CENTROID *

PATTERN #

1

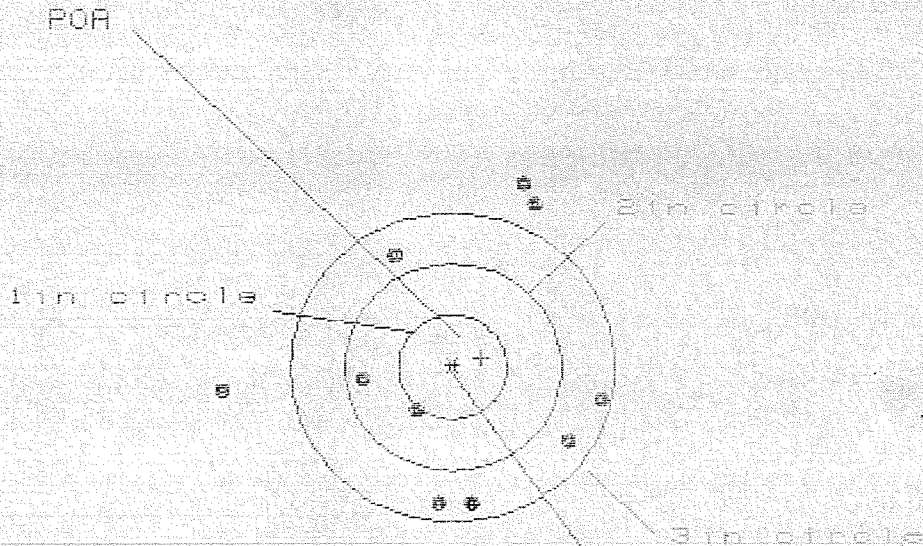
2

SHOTS (BEST OF)	10	9	9
MAXIMUM X	.925	1.025	.466
MINIMUM X	-.893	-.793	-.664
MAXIMUM Y	.768	.845	.458
MINIMUM Y	-1.107	-.823	-.742
CENTROID X	-.187	-.287	-.416
CENTROID Y	.036	.159	.078
POA TO CENTROID IN.	.191	.328	.423
MIN RADIUS	.232	.107	.076
MEAN RADIUS	.690	.571	.482
MAX RADIUS	1.427	1.212	.820
HORIZONTAL SPREAD	1.818	1.818	1.130
VERTICAL SPREAD	1.875	1.468	1.280
EXTREME SPREAD	2.248	1.891	1.387
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	

22 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6685668

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 0

2in = 2

3in = 7

HS = 3.515

VS = 3.112

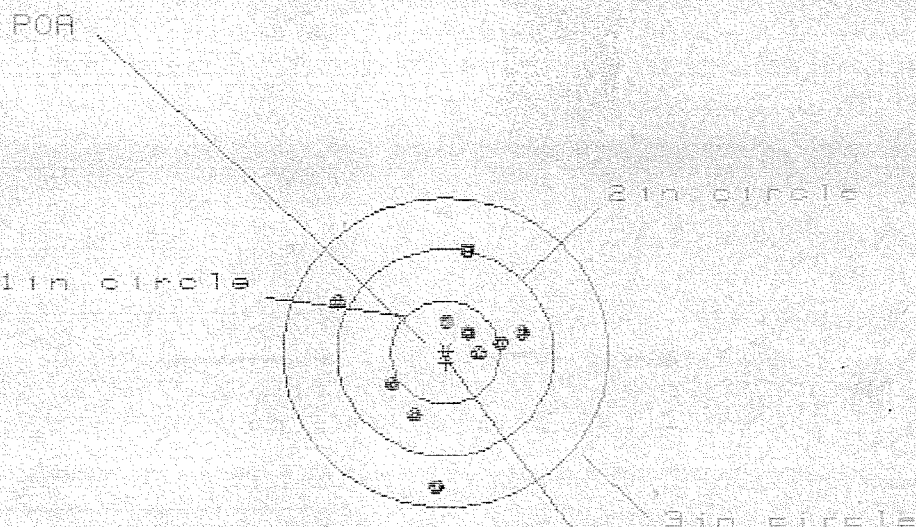
GS = 3.517

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.388	1.152	1.202
MINIMUM X	:	-2.127	-1.096	-1.046
MAXIMUM Y	:	1.776	1.750	1.776
MINIMUM Y	:	-1.337	-1.362	-1.143
CENTROID X	:	-.265	-.029	-.079
CENTROID Y	:	-.088	-.063	-.282
POA TO CENTROID in.	:	.279	.069	.293
MIN RADIUS	:	.529	.728	.586
MEAN RADIUS	:	1.370	1.288	1.180
MAX RADIUS	:	2.139	1.796	1.872
HORIZONTAL SPREAD	:	3.515	2.248	2.248
VERTICAL SPREAD	:	3.112	3.112	2.919
EXTREME SPREAD	:	3.517	3.209	3.062
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		7	

22 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665668

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 3

2in = 8

3in = 10

HS = 1.681

VS = 2.251

GS = 2.278

CENTROID *

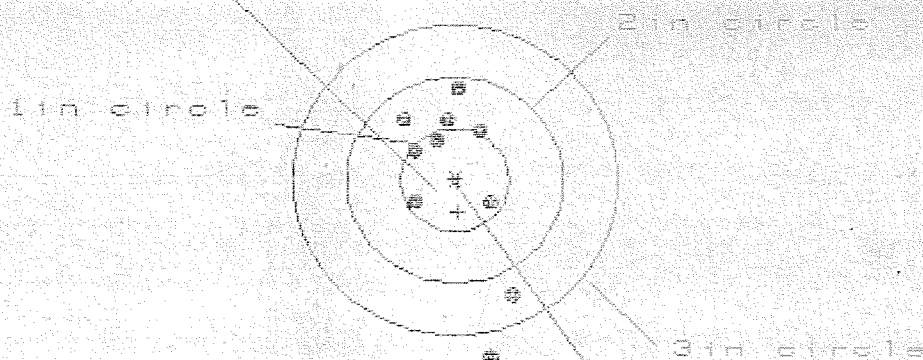
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.676	.665	.538
MINIMUM X	:	-1.005	-1.016	-.622
MAXIMUM Y	:	.962	.818	.863
MINIMUM Y	:	-1.289	-.725	-.680
CENTROID X	:	-.008	.003	.150
CENTROID Y	:	.101	.245	.200
POA TO CENTROID IN.	:	.102	.245	.238
MIN RADIUS	:	.251	.110	.177
MEAN RADIUS	:	.676	.585	.493
MAX RADIUS	:	1.293	1.077	.865
HORIZONTAL SPREAD	:	1.681	1.681	1.160
VERTICAL SPREAD	:	2.251	1.543	1.543
EXTREME SPREAD	:	2.278	1.715	1.631
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

22 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6685668

CENTERFIRE PATTERNS # 5

POB



OF SHOTS = 10

IN CIR

1in = 3

2in = 8

3in = 9

HS = 1.017

VS = 2.609

CS = 2.623

CENTROID *

PATTERN #			
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.578	.612	.471
MINIMUM X	-.439	-.405	-.329
MAXIMUM Y	.874	.681	.516
MINIMUM Y	-1.735	-1.316	-1.580
CENTROID X	-.029	-.063	-.139
CENTROID Y	.310	.503	.668
POB TO CENTROID in.	.312	.507	.682
MIN RADIUS	.408	.242	.060
MEAN RADIUS	.759	.582	.406
MAX RADIUS	1.762	1.452	.724
HORIZONTAL SPREAD	1.017	1.017	.799
VERTICAL SPREAD	2.609	1.997	1.896
EXTREME SPREAD	2.623	2.070	1.177
NUMBER IN ONE INCH CIRCLE	=	3	
NUMBER IN TWO INCH CIRCLE	=	8	
NUMBER IN THREE INCH CIRCLE	=	9	