

FORM

UPC



0 47700 25716 2

06665670

MODEL 700 TM M24

5716

ORDER NO.

BARREL LENGTH

CAPACITY*

*INCLUDES 1 IN CHAMBER

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6665670

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	JS
617	Drill and Tap Sight Holes	OCT	4 1991	LB
618	Polish Barrel		10/8/91	WLB
620	Apply Coatings (Barrel Action)		10-22-91	JA
	Apply Coating (Bolt)			
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		10/23/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11-7-91	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			11-11-91	JS
	G) Safety Off Force	4	4	4			11-11-91	JS
	H) Trigger Pull Test & Retainability						11-7-91	JS
	I) Firing Pin Indent	.020	.0205	.0205			11-11-91	JS
	J) Assemble Stock						11/11/91	RW
	K) Assemble Swivel Studs						11-19-91	D/H
	L) Attach Front and Rear Sight Assemblies						11/11/91	RW
	M) Iron Sight Alignment						11/11/91	RW
	N) Detach Front & Rear Sights & place in numbered container						11/11/91	RW
	O) Attach Scope to Rifle						11/11/91	RW
	P) Detach & Attach Scope 20 Times						11/11/91	RW
640	Gallery Target & Test						11-14-91	AC
	A) Time						11-14-91	AC
	B) Malfunctions						11-14-91	AC
	C) Pierced Primers						11-14-91	AC
	D) Optical Clarity of Scope						11-14-91	AC
645	Inspect for Live Ammo						11-14-91	AC
655	Final Inspection							
	A) Headspace						11-19-91	D/H
	B) Trigger Pull	283	272	267	272	272	11-14-91	D/H
	C) Function						11-19-91	D/H
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-6665670

DATE 11-7-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.52	2.54	2.50	2.83	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.55	2.49	2.52	2.72	
PULL #3	2.55	2.60	2.48	2.67	
PULL #4	2.46	2.55	2.51	2.72	
PULL #5	2.46	2.48	2.44	2.72	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.60	3.31		
PULL #2	3.32	3.41		
PULL #3	3.47	3.40		
PULL #4	3.44	3.28		
PULL #5	3.44	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	4.38	4.31		4.42
PULL #2	4.33	4.26		4.41
PULL #3	4.37	4.33		4.28
PULL #4	4.32	4.15		4.38
PULL #5	4.30	4.38		4.41
TOTAL				
AVG.				

Remington



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

MODEL 700 TM M24

SERIAL NO.

C6665670

ORDER NO.

5716

20

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



5716 C6665670

ORDER 5716

MODEL 700 TM M24

UPC

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MODEL 700 TM M24

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0 47700 25716 7



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CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06665670
15 NOV 1991

CENTROIDAL DISTANCES

0 TO 1	.431845
1 TO 2	.312866
1 TO 3	.309079
1 TO 4	.0905207
1 TO 5	.445926

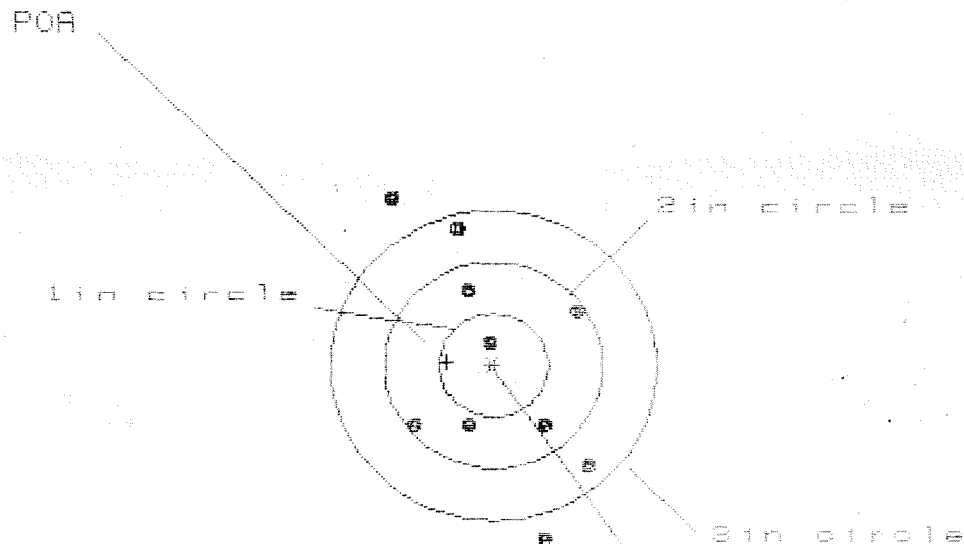
⁵
#4 -----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .318
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1522
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .352546
THE AMR FOR THIS RIFLE IS: 1.028

15 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06665670

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 8

HS= 1.776

VS= 3.336

GS= 3.588

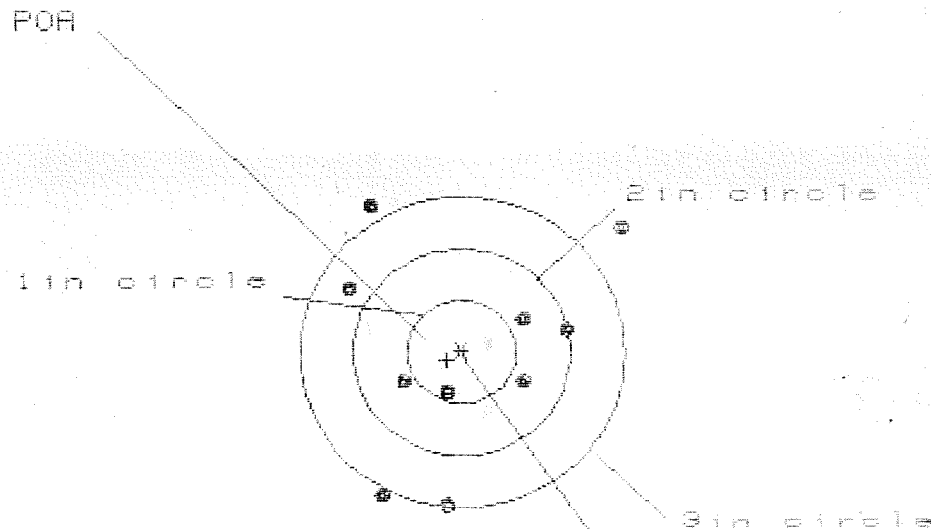
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.877	.777	.817
MINIMUM X	-.899	-.850	-.810
MAXIMUM Y	1.633	1.506	1.315
MINIMUM Y	-1.703	-1.521	-1.006
CENTROID X	.431	.531	.491
CENTROID Y	-.027	-.209	-.018
POA TO CENTROID in.	.432	.571	.491
MIN RADIUS	.251	.455	.265
MEAN RADIUS	1.053	.957	.865
MAX RADIUS	1.864	1.565	1.371
HORIZONTAL SPREAD	1.776	1.627	1.627
VERTICAL SPREAD	3.336	3.027	2.322
EXTREME SPREAD	3.588	3.118	2.615
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

15 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08665670

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 7

HS= 2.578

VS= 2.822

GS= 3.477

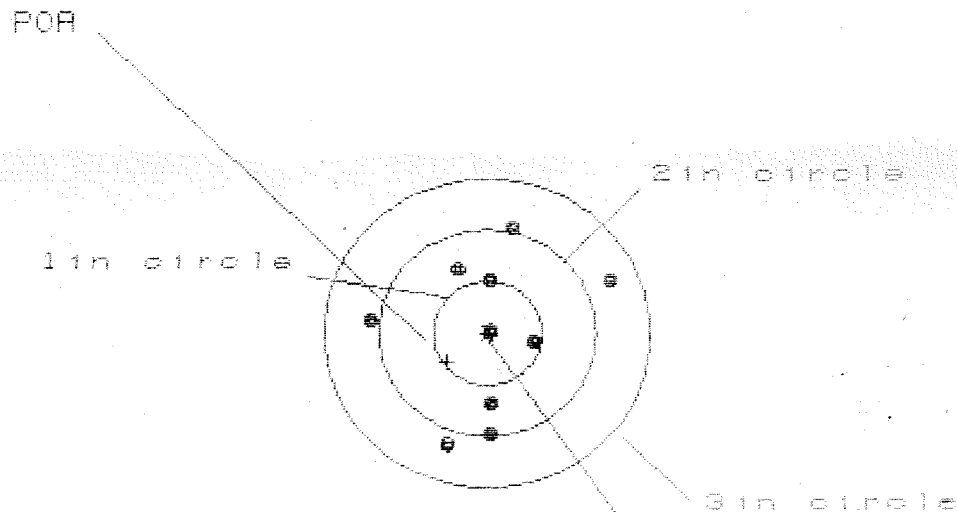
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.502	1.092	1.006
MINIMUM X	:	-1.075	-1.909	-1.995
MAXIMUM Y	:	1.392	1.533	.912
MINIMUM Y	:	-1.430	-1.289	-1.097
CENTROID X	:	.137	-.030	.056
CENTROID Y	:	.080	-.061	-.253
POA TO CENTROID in.	:	.158	.068	.259
MIN RADIUS	:	.380	.234	.041
MEAN RADIUS	:	1.107	.990	.865
MAX RADIUS	:	1.966	1.681	1.349
HORIZONTAL SPREAD	:	2.578	2.001	2.001
VERTICAL SPREAD	:	2.822	2.822	2.009
EXTREME SPREAD	:	3.477	2.906	2.312
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			7	

15 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6685670

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 10

HS= 2.209

VS= 2.135

GS= 2.245

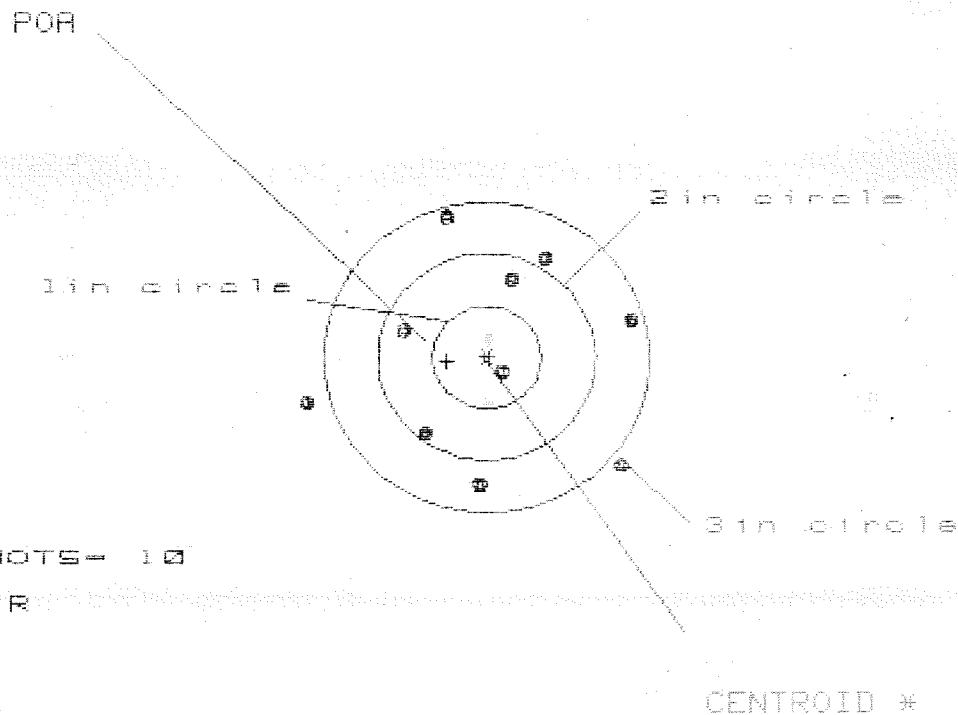
CENTROID *

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.102	.541	.510
MINIMUM X	-1.107	-.985	-1.016
MAXIMUM Y	1.069	1.126	1.000
MINIMUM Y	-1.066	-1.009	-.995
CENTROID X	.370	.248	.279
CENTROID Y	.276	.219	.345
POR TO CENTROID in.	.462	.330	.444
MIN RADIUS	.027	.156	.140
MEAN RADIUS	.778	.741	.698
MAX RADIUS	1.217	1.183	1.053
HORIZONTAL SPREAD	2.209	1.526	1.526
VERTICAL SPREAD	2.135	2.135	1.995
EXTREME SPREAD	2.245	2.221	2.008
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

15 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6663670

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 8

HS= 3.036

VS= 2.641

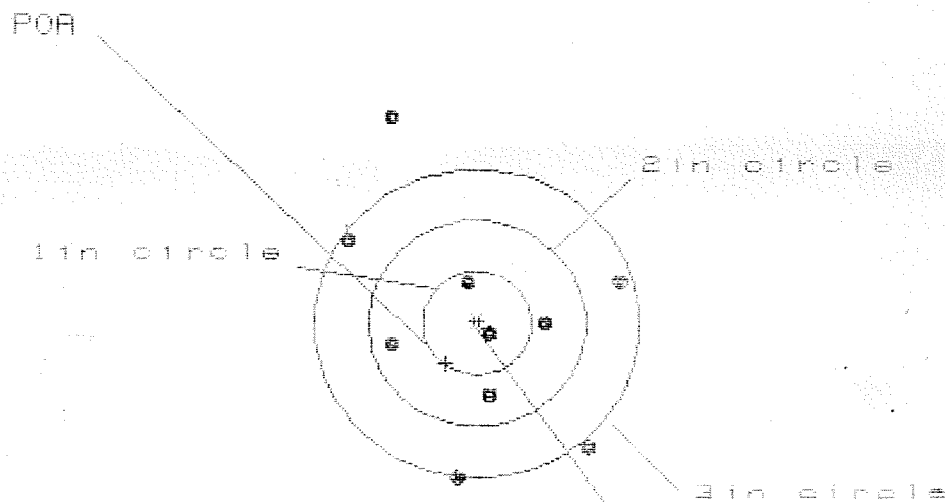
GS= 3.143

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.353	1.166	1.296
MINIMUM X	:	-1.683	-.938	-.808
MAXIMUM Y	:	1.355	1.305	1.168
MINIMUM Y	:	-1.286	-1.336	-1.473
CENTROID X	:	.368	.555	.425
CENTROID Y	:	.038	.088	.225
POA TO CENTROID in.	:	.370	.562	.481
MIN RADIUS	:	.224	.190	.347
MEAN RADIUS	:	1.128	1.047	.976
MAX RADIUS	:	1.742	1.509	1.479
HORIZONTAL SPREAD	:	3.036	2.104	2.104
VERTICAL SPREAD	:	2.641	2.641	2.641
EXTREME SPREAD	:	3.143	2.906	2.663
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

15 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8685670

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 7

HS= 2.470

VS= 3.501

GS= 3.696

CENTROID X

PATTERN #	5	9	3
SHOTS (BEST OF)	10	9	3
MAXIMUM X	1.267	1.174	1.236
MINIMUM X	-1.293	-1.296	-1.184
MAXIMUM Y	1.992	1.053	.927
MINIMUM Y	-1.509	-1.288	-1.413
CENTROID X	.284	.377	.265
CENTROID Y	.394	.173	.298
POA TO CENTROID in.	.485	.414	.399
MIN RADIUS	.178	.078	.132
MEAN RADIUS	1.074	.924	.870
MAX RADIUS	2.159	1.670	1.504
HORIZONTAL SPREAD	2.470	2.470	2.470
VERTICAL SPREAD	3.501	2.341	2.341
EXTREME SPREAD	3.696	3.003	2.534
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		