

FORM

UPC



0 47700 25716 2

C6665671

INCLUDES 1 IN CHAMBER

MODEL 700™ M24

ORDER NO.

5716

BARREL LENGTH

CAPACITY*

Remington



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

MODEL 700TM M24

SERIAL NO.
C6665671

20

ORDER NO.
5716

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



5716 C6665671

ORDER 5716
MODEL 700TM M24
UPC



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ORDER 5716
MODEL 700TM M24
UPC



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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6665671

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		9/25/91	KL
600	Proof		9/25/91	KL
607	Check Headspace		9/25/91	KL
610	Dis-assemble Gun		9/25/91	KL
612	Magnaflux Barrel Action		OCT 2 1991	KR
	Magnaflux Bolt		OCT 2 1991	KR
615	Rollmark Caliber		OCT 2 1991	GB
617	Drill and Tap Sight Holes		OCT 2 1991	FB
618	Polish Barrel		OCT 4 1991	WB
620	Apply Coatings (Barrel Action)		10-14-91	AA
	Apply Coating (Bolt)		10-14-91	AA
625	Final Assembly A) Clean inside of Bolt Assembly		10/16/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/16/91	KL
	C) Inspect Ejector Hole for Chamfer		10/16/91	KL
	D) Oil Firing Pin Ass'y		10/16/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		10/17/91	KL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 $\frac{1}{4}$	5 $\frac{3}{4}$	6			10-17-91	DH
	G) Safety Off Force	3 $\frac{1}{4}$	3	2 $\frac{1}{2}$			10-17-91	DH
	H) Trigger Pull Test & Retainability						10/17/91	JH
	I) Firing Pin Indent	.020	.020	.020			10-17-91	DH
	J) Assemble Stock						10/22/91	YK
	K) Assemble Swivel Studs						10/30/91	K
	L) Attach Front and Rear Sight Assemblies						10/27/91	YK
	M) Iron Sight Alignment						10/22/91	YK
	N) Detach Front & Rear Sights & place in numbered container						10/22/91	YK
	O) Attach Scope to Rifle						10/22/91	YK
	P) Detach & Attach Scope 20 Times						10/22/91	YK
640	Gallery Target & Test						10-23-91	DH
	A) Time						10-23-91	DH
	B) Malfunctions						10-23-91	DH
	C) Pierced Primers						10-23-91	DH
	D) Optical Clarity of Scope						10-23-91	DH
645	Inspect for Live Ammo						10-23-91	DH
655	Final Inspection							
	A) Headspace						10-30-91	AC
	B) Trigger Pull	267	273	260	264	264	10-28-91	DH
	C) Function						10-30-91	AC
660	Pack						12-17-91	VF

SWS TRIGGER PULL TEST

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

SERIAL NO C.6665671

DATE 10/17/81

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.55	2.46	2.50	2.67	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.45	2.39	2.55	2.73	
PULL #3	2.46	2.49	2.30	2.60	
PULL #4	2.35	2.55	2.38	2.64	
PULL #5	2.50	2.54	2.44	2.64	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.48	3.28		
PULL #2	3.34	3.30		
PULL #3	3.19	3.26		
PULL #4	3.43	3.35		
PULL #5	3.41	3.38		
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	4.38		4.35
PULL #2	4.37	4.37		4.27
PULL #3	4.29	4.42		4.49
PULL #4	4.26	4.28		4.32
PULL #5	4.23	4.29		4.41
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06665671
24 Oct 1991

CENTROIDAL DISTANCES

0 TO 1	.206306
1 TO 2	.299043
1 TO 3	.219317
1 TO 4	.491273
1 TO 5	.301144

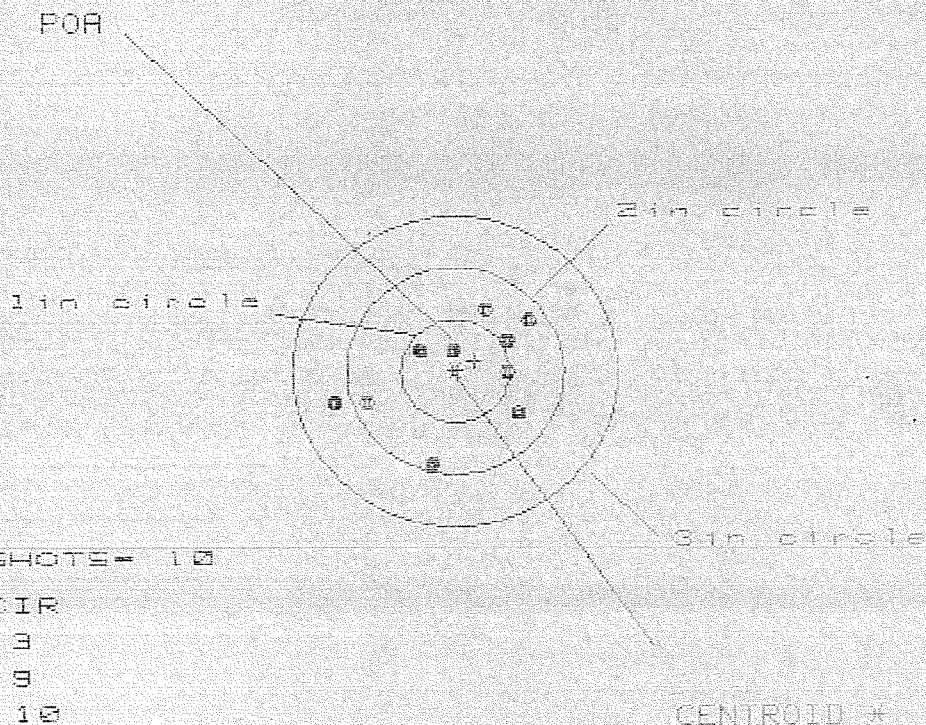
$\bar{x}_c$ ←--- POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .022
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0298
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0370411
THE AMR FOR THIS RIFLE IS: .933

24 Oct 1991

FILE://PATTERNING/CENTERFIRE_PATT/C8585621

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 9

3 in = 10

HS= 1.794

VS= 1.446

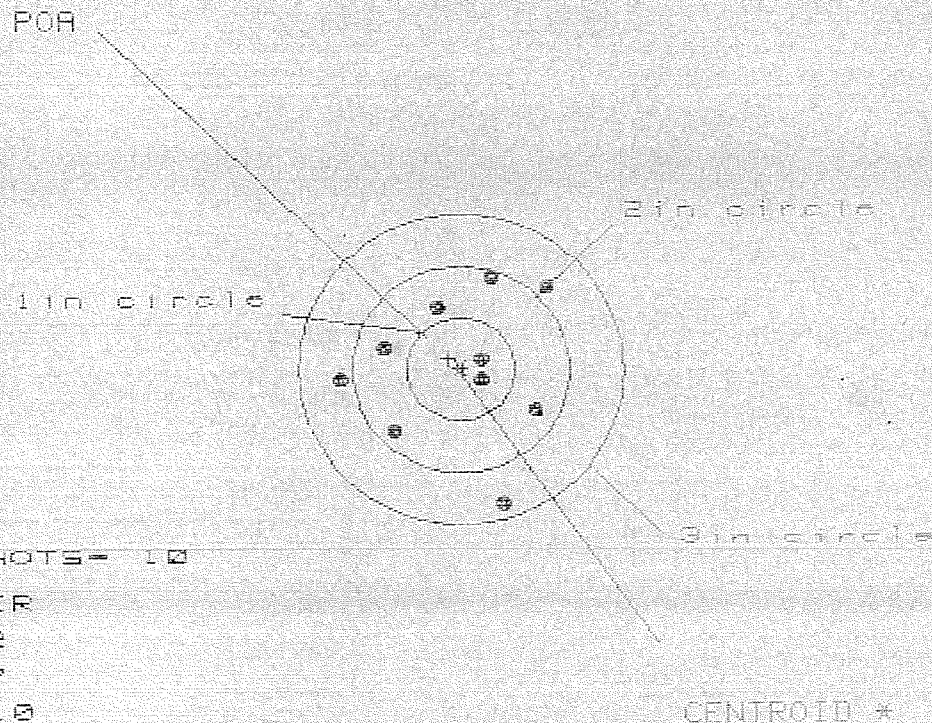
GS= 1.942

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.680	.556	.509
MINIMUM X	:	-1.114	-.932	-.979
MAXIMUM Y	:	.582	.551	.439
MINIMUM Y	:	-.864	-.895	-.557
CENTROID X	:	-.181	-.057	-.010
CENTROID Y	:	-.099	-.068	.044
POA TO CENTROID in.	:	.207	.089	.045
MIN RADIUS	:	.240	.271	.245
MEAN RADIUS	:	.673	.598	.523
MAX RADIUS	:	1.148	.987	1.072
HORIZONTAL SPREAD	:	1.794	1.488	1.488
VERTICAL SPREAD	:	1.446	1.446	.996
EXTREME SPREAD	:	1.942	1.670	1.670
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

24 Oct 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS = 1.845

VS = 2.211

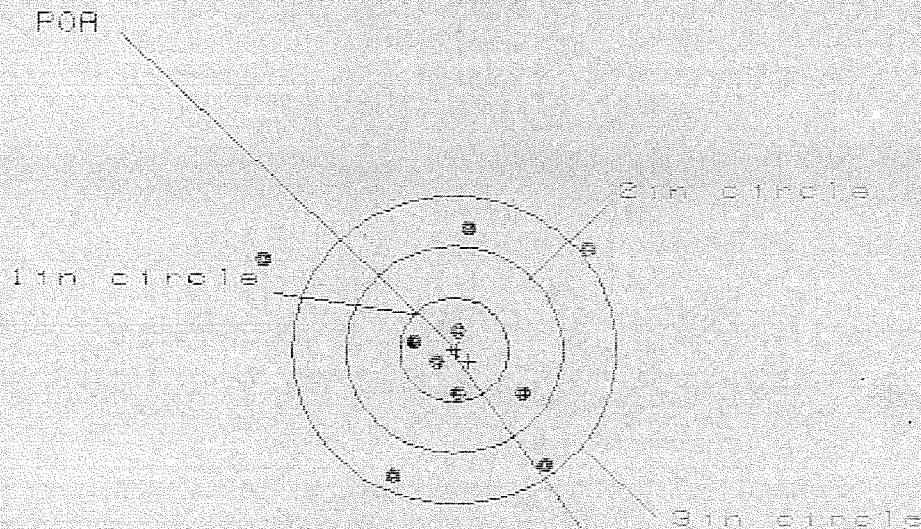
CS = 2.215

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.779	.827	.800
MINIMUM X	:	-1.066	-1.018	-.914
MAXIMUM Y	:	.881	.733	.814
MINIMUM Y	:	-1.331	-.765	-.684
CENTROID X	:	.112	.064	-.040
CENTROID Y	:	-.104	.044	-.037
POA TO CENTROID in.	:	.152	.077	.054
MIN RADIUS	:	.249	.245	.359
MEAN RADIUS	:	.803	.726	.689
MAX RADIUS	:	1.400	1.053	.939
HORIZONTAL SPREAD	:	1.845	1.845	1.714
VERTICAL SPREAD	:	2.211	1.498	1.498
EXTREME SPREAD	:	2.215	2.062	1.741
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 4

2in = 5

3in = 8

HS = 2.997

VS = 2.385

GS = 3.208

CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.276	1.085	.739
MINIMUM X	:	-1.721	-.807	-.671
MAXIMUM Y	:	1.168	1.263	1.400
MINIMUM Y	:	-1.217	-1.122	-.985
CENTROID X	:	-.133	.058	-.078
CENTROID Y	:	.115	.020	-.117
POA TO CENTROID in.	:	.176	.061	.141
MIN RADIUS	:	.232	.338	.179
MEAN RADIUS	:	.952	.849	.727
MAX RADIUS	:	1.924	1.542	1.403
HORIZONTAL SPREAD	:	2.997	1.892	1.410
VERTICAL SPREAD	:	2.385	2.385	2.385
EXTREME SPREAD	:	3.208	2.915	2.505
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

24 Oct 1991

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CENTERFIRE PATTERNS

4

POB

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 0

2 in = 5

3 in = 9

HS= 2.716

VS= 3.088

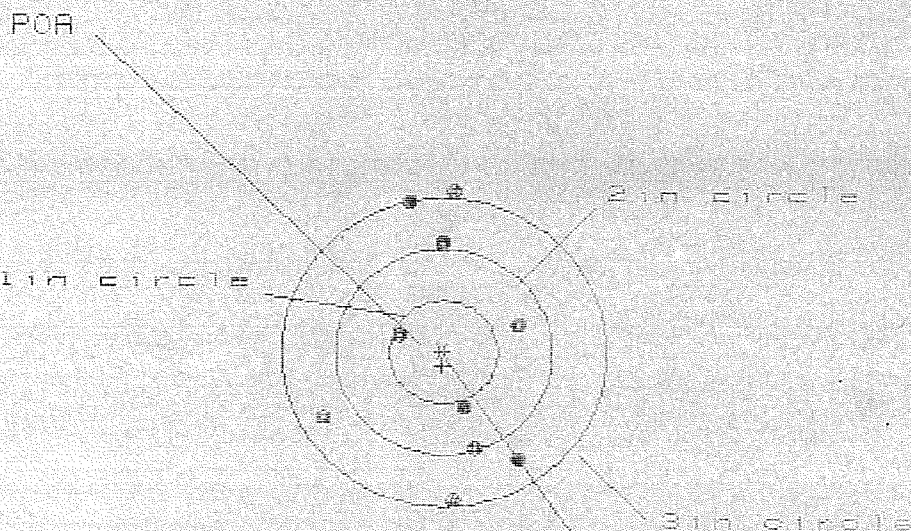
GS= 3.102

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.357	1.364	1.194
MINIMUM X	:	-1.360	-1.352	-1.839
MAXIMUM Y	:	1.428	1.243	1.296
MINIMUM Y	:	-1.660	-1.579	-1.526
CENTROID X	:	.301	.294	.464
CENTROID Y	:	-.194	-.009	-.061
POB TO CENTROID in.	:	.358	.295	.468
MIN RADIUS	:	.626	.661	.663
MEAN RADIUS	:	1.145	1.065	1.024
MAX RADIUS	:	1.661	1.585	1.527
HORIZONTAL SPREAD	:	2.716	2.716	2.833
VERTICAL SPREAD	:	3.088	2.822	2.822
EXTREME SPREAD	:	3.102	2.915	2.832
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS = 1.817

VS = 3.047

GS = 3.047

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.661	.670	.631
MINIMUM X	:	-1.156	-1.147	-1.186
MAXIMUM Y	:	1.601	1.633	1.450
MINIMUM Y	:	-1.446	-1.268	-1.064
CENTROID X	:	.011	.002	.041
CENTROID Y	:	.133	-.045	-.249
POA TO CENTROID in.	:	.133	.045	.253
MIN RADIUS	:	.476	.399	.208
MEAN RADIUS	:	1.092	1.013	.893
MAX RADIUS	:	1.603	1.663	1.452
HORIZONTAL SPREAD	:	1.817	1.817	1.817
VERTICAL SPREAD	:	3.047	2.901	2.514
EXTREME SPREAD	:	3.047	2.928	2.517
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			4	
NUMBER IN THREE INCH CIRCLE =			9	