

FORM

UPC



0 47700 25716 7

C6665672

*INCLUDES 1 IN CHAMBER

MODEL 700 TM M24

ORDER NO. 5716

BARREL LENGTH

CAPACITY

Remington



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

MODEL 700™ M24

SERIAL NO.

C6665672

ORDER NO.

5716

20

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



5716 C6665672

ORDER 5716

MODEL 700™ M24

UPC

ORDER 5716

MODEL 700™ M24

UPC



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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6665672

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10 1 91	10 1 91	RW
600	Proof	10 1 91	10 1 91	RW
607	Check Headspace	10 1 91	10 1 91	RW
610	Dis-assemble Gun	10 1 91	10 1 91	RW
612	Magnaflux Barrel Action	OCT	4 1991	KR
	Magnaflux Bolt	OCT	4 1991	KR
615	Rollmark Caliber	OCT	4 1991	GS.
617	Drill and Tap Sight Holes	OCT	4 1991	FB
618	Polish Barrel		10/8/91	CVB
620	Apply Coatings (Barrel Action)		10-22-91	HA
	Apply Coating (Bolt)		10-22-91	HA
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		10/30/91	JP

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			10/31/91	DH
	G) Safety Off Force	3	3	3			10/31/91	DH
	H) Trigger Pull Test & Retainability						10/30/91	DH
	I) Firing Pin Indent	1021	1021	1021			10/31/91	DH
	J) Assemble Stock						10/31/91	RW
	K) Assemble Swivel Studs						11-12-91	AC
	L) Attach Front and Rear Sight Assemblies						10/31/91	RW
	M) Iron Sight Alignment						10/31/91	RW
	N) Detach Front & Rear Sights & place in numbered container						10/31/91	RW
	O) Attach Scope to Rifle						10/31/91	RW
	P) Detach & Attach Scope 20 Times						10/31/91	RW
640	Gallery Target & Test						11-1-91	DH
	A) Time						11-1-91	DH
	B) Malfunctions						11-1-91	DH
	C) Pierced Primers						11-1-91	DH
	D) Optical Clarity of Scope						11-1-91	DH
645	Inspect for Live Ammo						11-1-91	DH
655	Final Inspection							
	A) Headspace						11-12-91	AC
	B) Trigger Pull	2.45	2.59	2.58	2.44	2.42	11-5-91	DH
	C) Function						11-12-91	AC
660	Pack						12-17-91	N

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. C-6665672

DATE 10/30/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.51	2.51	2.48	2.45	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.45	2.48	2.50	2.59	
PULL #3	2.45	2.36	2.35	2.58	
PULL #4	2.41	2.44	2.31	2.44	
PULL #5	2.35	2.55	2.36	2.42	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.58	3.51		
PULL #2	3.55	3.48		
PULL #3	3.52	3.45		
PULL #4	3.39	3.39		
PULL #5	3.42	3.53		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.55	4.58		4.53
PULL #2	4.45	4.60		4.33
PULL #3	4.42	4.51		4.61
PULL #4	4.53	4.48		4.54
PULL #5	4.54	4.58		4.38
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665672
1 Nov 1991

CENTROIDAL DISTANCES

0 TO	1	.26786
1 TO	2	.676114
1 TO	3	.450004
1 TO	4	.149933
1 TO	5	.303621

$\frac{2}{4}$ <----POA

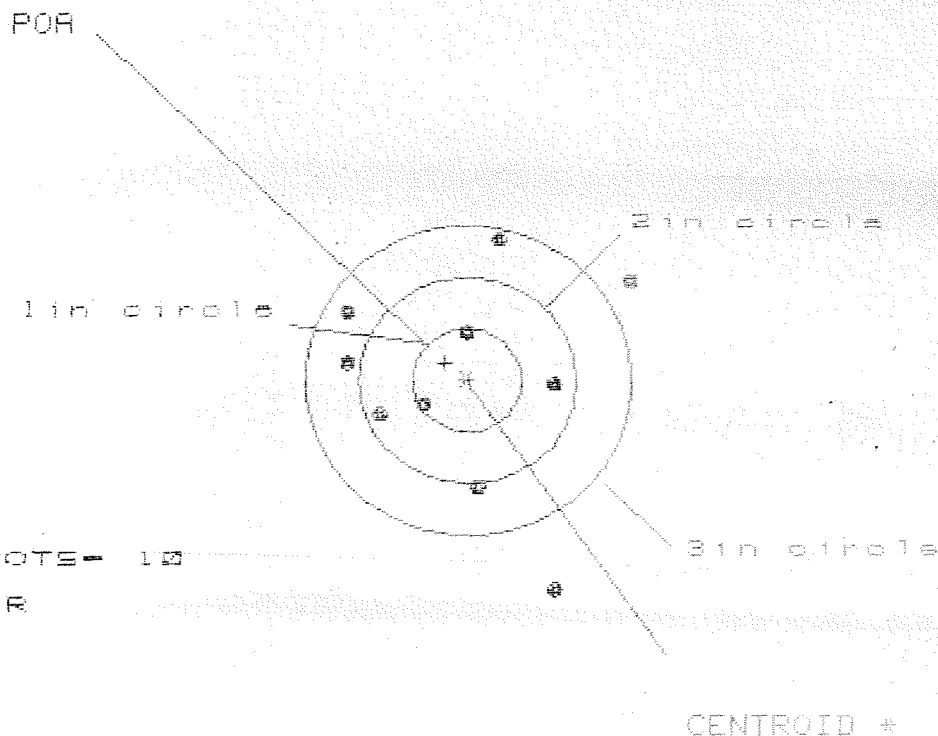
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .004
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .012
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .199352

THE AMR FOR THIS RIFLE IS: 1.043

1 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06065672

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS= 2.635

VS= 3.397

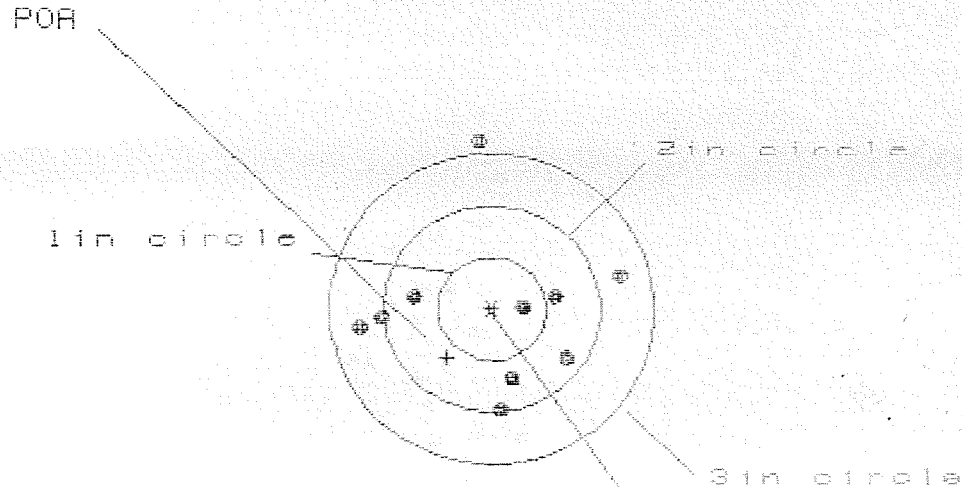
GS= 3.422

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.496	1.579	1.116
MINIMUM X	:	-1.139	-1.056	-0.858
MAXIMUM Y	:	1.345	1.117	1.216
MINIMUM Y	:	-2.052	-1.289	-1.191
CENTROID X	:	.207	.124	-.074
CENTROID Y	:	-.170	.058	-.040
POA TO CENTROID in.	:	.268	.136	.084
MIN RADIUS	:	.488	.298	.379
MEAN RADIUS	:	1.160	1.019	.894
MAX RADIUS	:	2.184	1.764	1.365
HORIZONTAL SPREAD	:	2.635	2.635	1.974
VERTICAL SPREAD	:	3.397	2.406	2.406
EXTREME SPREAD	:	3.422	2.754	2.421
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

1 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8685672

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 1

2in = 6

3in = 3

HS = 2.410

VS = 2.544

GS = 2.552

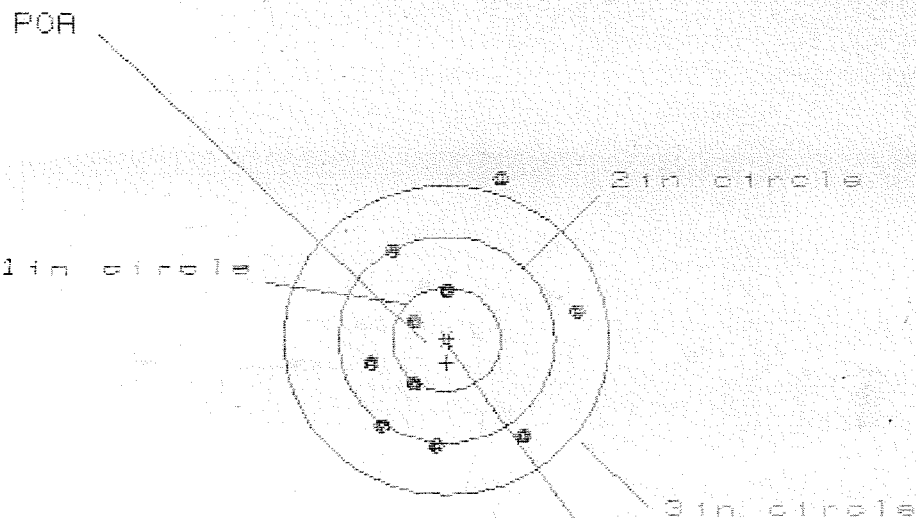
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.198	1.185	.856
MINIMUM X	:	-1.212	-1.225	-1.077
MAXIMUM Y	:	1.606	.474	.407
MINIMUM Y	:	-.938	-.759	-.700
CENTROID X	:	.416	.429	.281
CENTROID Y	:	.473	.294	.235
POR TO CENTROID in.	:	.630	.520	.366
MIN RADIUS	:	.334	.389	.529
MEAN RADIUS	:	.922	.823	.774
MAX RADIUS	:	1.610	1.276	1.078
HORIZONTAL SPREAD	:	2.410	2.410	1.933
VERTICAL SPREAD	:	2.544	1.233	1.107
EXTREME SPREAD	:	2.552	2.459	1.949
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			9	

1 Nov 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 9

HS= 1.858

VS= 2.530

GS= 2.626

CENTROID #

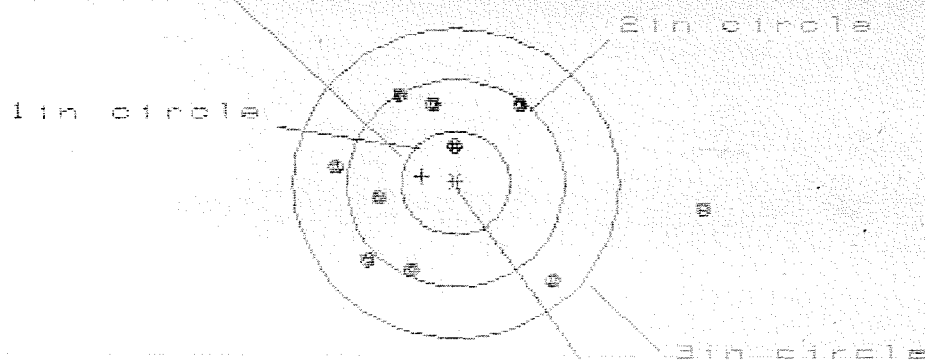
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.175	1.235	.905
MINIMUM X	:	-.683	-.623	-.469
MAXIMUM Y	:	1.537	1.019	1.078
MINIMUM Y	:	-.993	-.823	-.764
CENTROID X	:	-.003	-.063	-.217
CENTROID Y	:	.228	.058	-.001
POA TO CENTROID in.	:	.228	.085	.217
MIN RADIUS	:	.308	.305	.184
MEAN RADIUS	:	.899	.795	.693
MAX RADIUS	:	1.627	1.320	1.124
HORIZONTAL SPREAD	:	1.858	1.858	1.374
VERTICAL SPREAD	:	2.530	1.842	1.842
EXTREME SPREAD	:	2.626	2.124	2.124
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

1 May 1991

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CENTERFIRE PATTERNS # 4

POA



OF SHOTS = 10

IN CIR

1in = 1

2in = 4

3in = 9

HS = 3.433

VS = 1.795

GS = 3.464

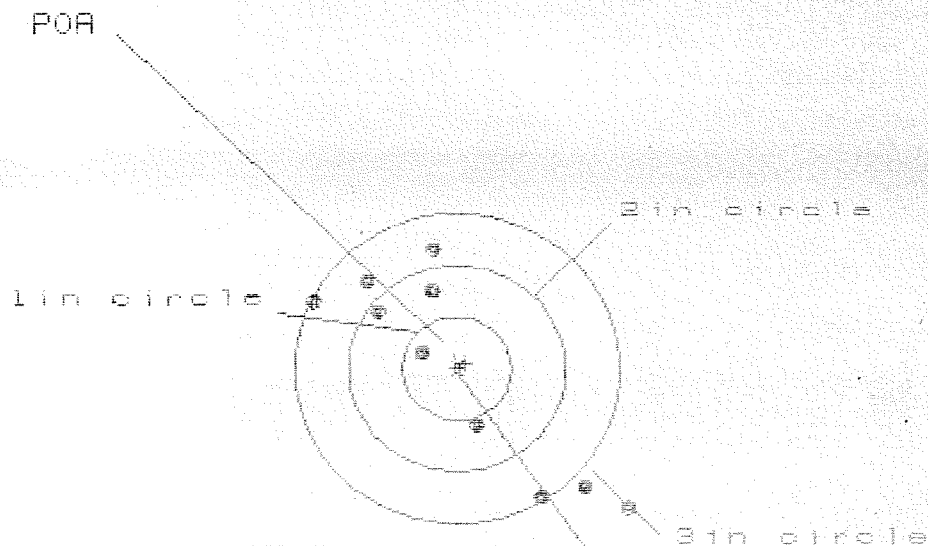
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	9
MAXIMUM X	:	2.330	1.162	1.020
MINIMUM X	:	-1.103	-.844	-.699
MAXIMUM Y	:	.887	.856	.738
MINIMUM Y	:	-.908	-.939	-1.033
CENTROID X	:	.311	.052	-.093
CENTROID Y	:	-.062	-.031	.087
POA TO CENTROID in.	:	.317	.060	.127
MIN RADIUS	:	.361	.407	.439
MEAN RADIUS	:	1.074	.878	.769
MAX RADIUS	:	2.347	1.494	1.216
HORIZONTAL SPREAD	:	3.433	2.006	1.719
VERTICAL SPREAD	:	1.795	1.795	1.771
EXTREME SPREAD	:	3.464	2.309	2.092
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

1 Nov 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 5

HS= 2.878

VS= 2.474

GS= 3.488

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.546	1.318	1.063
MINIMUM X	:	-1.332	-1.160	-.995
MAXIMUM Y	:	1.174	1.030	.874
MINIMUM Y	:	-1.388	-1.404	-1.560
CENTROID X	:	-.074	-.246	-.411
CENTROID Y	:	-.055	.089	.245
POA TO CENTROID in.	:	.092	.261	.478
MIN RADIUS	:	.345	.126	.124
MEAN RADIUS	:	1.158	.997	.828
MAX RADIUS	:	2.020	1.815	1.888
HORIZONTAL SPREAD	:	2.878	2.478	2.058
VERTICAL SPREAD	:	2.474	2.434	2.434
EXTREME SPREAD	:	3.488	3.048	2.821
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			4	
NUMBER IN THREE INCH CIRCLE =			5	