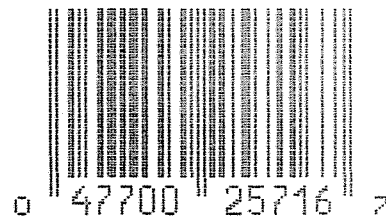


FOEN

UPC



06665703

*INCLUDES 1 IN CHAMBER

MODEL 700 TH M24

ORDER NO. 5716

BARREL LENGTH

CAPACITY*

Remington



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

MODEL 700 TM M24

SERIAL NO.

C6665703

ORDER NO.

5716

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

20

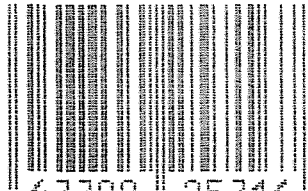


5716 C6665703

ORDER 5716

MODEL 700 TM M24

UPC

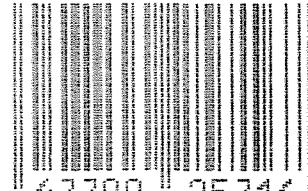


0 47700 25716 7

ORDER 5716

MODEL 700 TM M24

UPC



0 47700 25716 7

GFM

M-24
CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6665703

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 26	91	RW
600	Proof	9 26	91	RW
607	Check Headspace	9 26	91	RW
610	Dis-assemble Gun	9 26	91	RW
612	Magnaflux Barrel Action		SEP 30 1991	KR
	Magnaflux Bolt		SEP 30 1991	KR
615	Rollmark Caliber		SEP 30 1991	GL
617	Drill and Tap Sight Holes		SEP 30 1991	KB
618	Polish Barrel		OCT 2 1991	WT
620	Apply Coatings (Barrel Action)		10-13-91	TA
	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	RM

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	44	4		4		10-22-91	DH
	G) Safety Off Force	2	2		2		10-22-91	DH
	H) Trigger Pull Test & Retainability						10/22/91	JU.
	I) Firing Pin Indent	.022	.021		.021		10-22-91	DH
	J) Assemble Stock						10/23/91	RW
	K) Assemble Swivel Studs						10-30-91	AC
	L) Attach Front and Rear Sight Assemblies						10/23/91	RW
	M) Iron Sight Alignment						10/23/91	RW
	N) Detach Front & Rear Sights & place in numbered container						10/23/91	RW
	O) Attach Scope to Rifle						10/23/91	RW
	P) Detach & Attach Scope 20 Times						10/23/91	RW
640	Gallery Target & Test						10/23/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						10/23/91	KT
655	Final Inspection							
	A) Headspace						10-30-91	AC
	B) Trigger Pull	249	249	255	255	259	10-28-91	DH
	C) Function						10-30-91	AC
660	Pack						12-18-91	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-6665703
DATE 10/22/91
TESTER JF

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.39	2.40	2.49	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.23	2.38	2.43	2.49	
PULL #3	2.30	2.38	2.38	2.55	
PULL #4	2.32	2.43	2.43	2.55	
PULL #5	2.40	2.38	2.45	2.59	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.43	3.42		
PULL #2	3.40	3.45		
PULL #3	3.37	3.45		
PULL #4	3.37	3.42		
PULL #5	3.40	3.43		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.41	4.31		4.26
PULL #2	4.29	4.31		4.28
PULL #3	4.33	4.26		4.28
PULL #4	4.42	4.33		4.28
PULL #5	4.32	4.29		4.29
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665703
23 Oct 1991

CENTROIDAL DISTANCES

0 TO	1	.109018
1 TO	2	.498353
1 TO	3	.293874
1 TO	4	.181706
1 TO	5	.348662

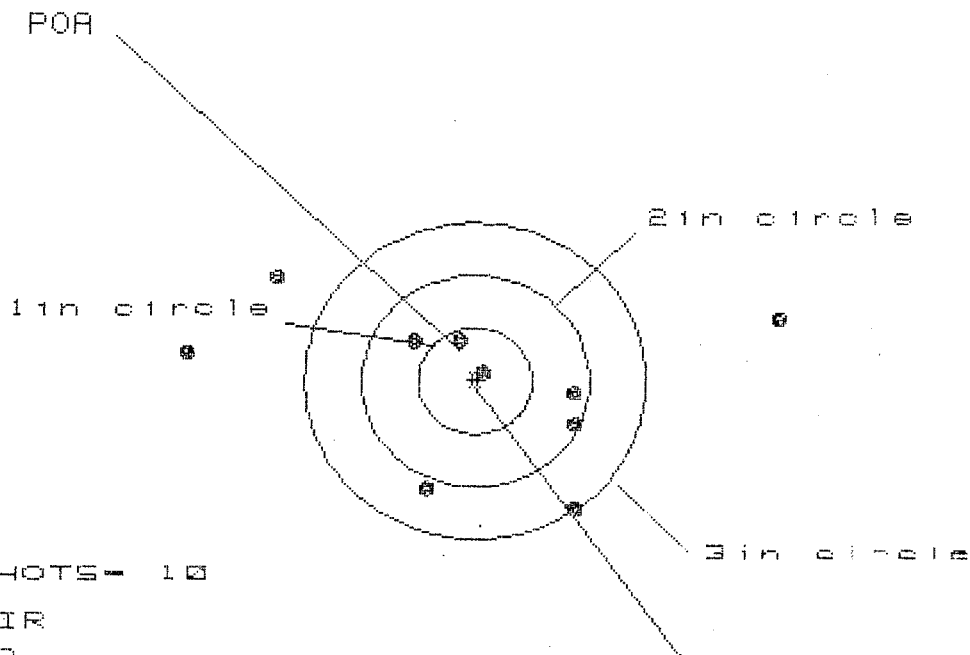
$\frac{3}{4}$ 52 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0506
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .056
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0754742
THE AMR FOR THIS RIFLE IS: 1.027

23 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8665703

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 7

HS= 5.214

VS= 2.191

GS= 5.221

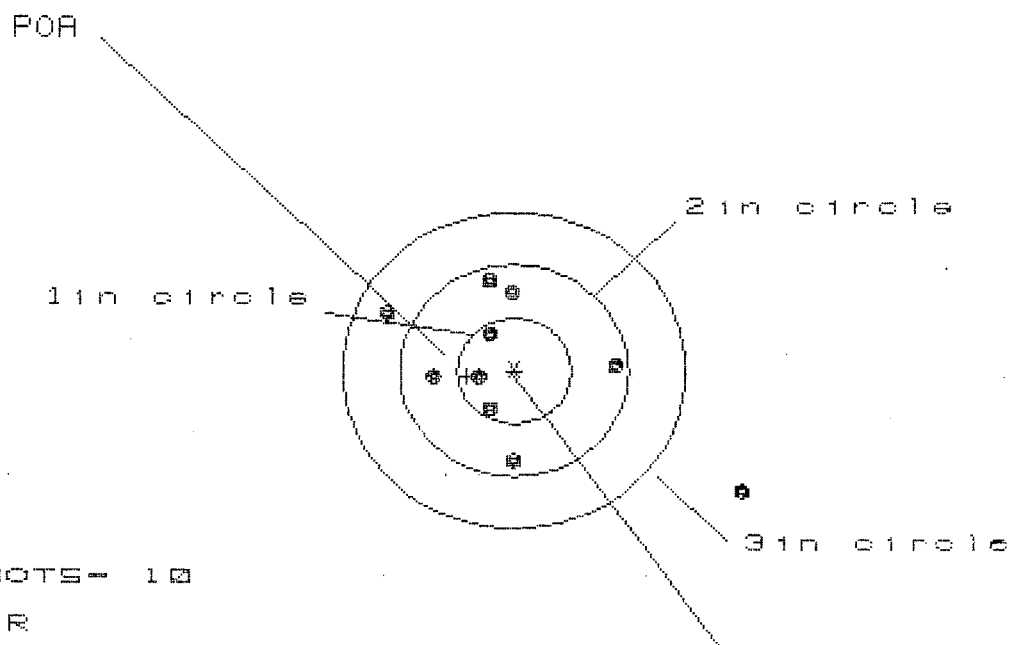
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.704	1.204	.928
MINIMUM X	:	-2.510	-2.210	-1.755
MAXIMUM Y	:	.988	1.055	1.103
MINIMUM Y	:	-1.203	-1.136	-1.008
CENTROID X	:	-.067	-.367	-.091
CENTROID Y	:	-.086	-.153	-.201
POA TO CENTROID in.	:	.109	.398	.221
MIN RADIUS	:	.124	.395	.241
MEAN RADIUS	:	1.303	1.166	.981
MAX RADIUS	:	2.769	2.244	2.073
HORIZONTAL SPREAD	:	5.214	3.414	2.683
VERTICAL SPREAD	:	2.191	2.191	2.191
EXTREME SPREAD	:	5.221	3.695	3.427
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

23 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665703

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 9

HS= 3.142

VS= 2.058

GS= 3.581

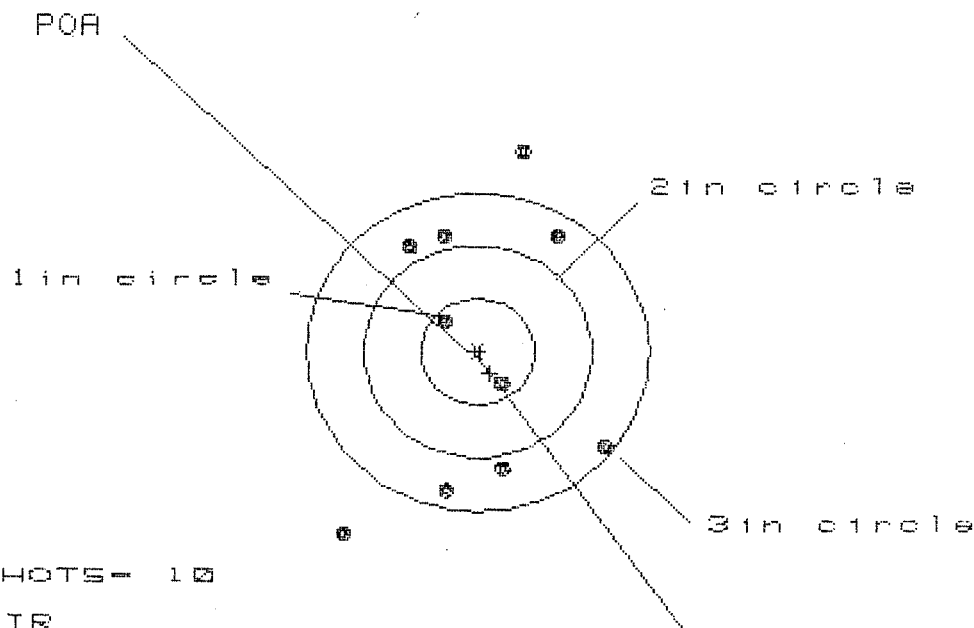
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.023	1.099	.988
MINIMUM X	:	-1.119	-.894	-.627
MAXIMUM Y	:	.869	.737	.787
MINIMUM Y	:	-1.189	-1.026	-.976
CENTROID X	:	.413	.188	.299
CENTROID Y	:	.048	.180	.130
POA TO CENTROID in.	:	.415	.260	.326
MIN RADIUS	:	.330	.218	.256
MEAN RADIUS	:	.895	.671	.640
MAX RADIUS	:	2.347	1.107	.991
HORIZONTAL SPREAD	:	3.142	1.993	1.615
VERTICAL SPREAD	:	2.058	1.763	1.763
EXTREME SPREAD	:	3.581	2.061	1.781
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

23 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8865783

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 2

3in = 8

HS= 2.272

VS= 3.608

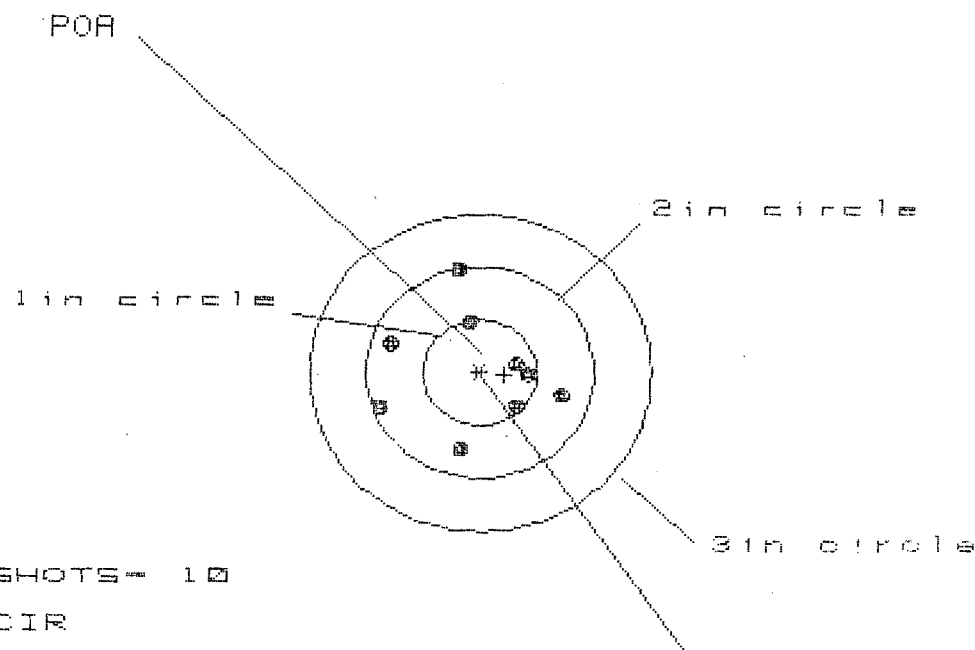
GS= 3.939

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.131	1.004	1.043
MINIMUM X	:	-1.141	-.760	-.721
MAXIMUM Y	:	1.910	1.721	1.124
MINIMUM Y	:	-1.698	-1.462	-1.247
CENTROID X	:	-.108	.018	-.021
CENTROID Y	:	.205	.394	.179
POA TO CENTROID in.	:	.232	.394	.180
MIN RADIUS	:	.341	.406	.279
MEAN RADIUS	:	1.224	1.127	1.029
MAX RADIUS	:	2.046	1.749	1.364
HORIZONTAL SPREAD	:	2.272	1.764	1.764
VERTICAL SPREAD	:	3.608	3.183	2.371
EXTREME SPREAD	:	3.939	3.272	2.568
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		8	

23 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06665703

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 5

2in = 9

3in = 10

HS= 1.542

VS= 1.747

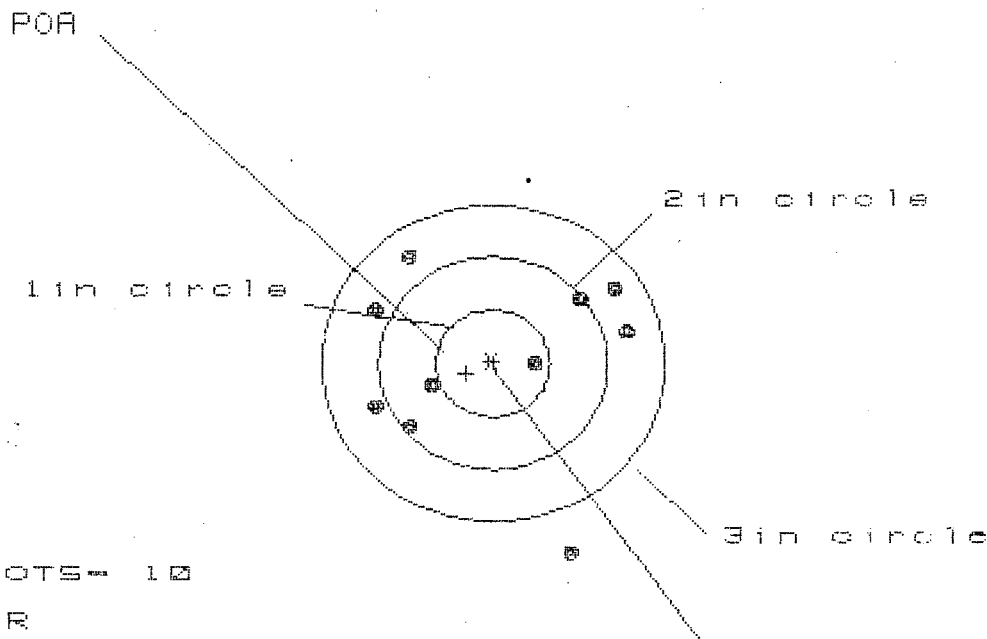
GS= 1.749

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.669	.645	.532
MINIMUM X	:	-.873	-.897	-.955
MAXIMUM Y	:	1.001	.575	.552
MINIMUM Y	:	-.746	-.635	-.658
CENTROID X	:	-.216	-.191	-.078
CENTROID Y	:	.018	-.093	-.070
POA TO CENTROID in.	:	.216	.212	.105
MIN RADIUS	:	.311	.319	.210
MEAN RADIUS	:	.646	.588	.508
MAX RADIUS	:	1.026	.945	1.037
HORIZONTAL SPREAD	:	1.542	1.542	1.487
VERTICAL SPREAD	:	1.747	1.210	1.210
EXTREME SPREAD	:	1.749	1.565	1.565
NUMBER IN ONE INCH CIRCLE =	:		5	
NUMBER IN TWO INCH CIRCLE =	:		9	
NUMBER IN THREE INCH CIRCLE =	:		10	

23 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8865703

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 9

HS= 2.197

VS= 2.846

GS= 3.171

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.173	1.247	1.393
MINIMUM X	:	-1.024	-.950	-.804
MAXIMUM Y	:	1.016	.812	.872
MINIMUM Y	:	-1.831	-.792	-.732
CENTROID X	:	.231	.157	.011
CENTROID Y	:	.095	.298	.208
POA TO CENTROID in.	:	.249	.337	.239
MIN RADIUS	:	.345	.483	.429
MEAN RADIUS	:	1.068	.960	.901
MAX RADIUS	:	1.948	1.258	1.401
HORIZONTAL SPREAD	:	2.197	2.197	2.197
VERTICAL SPREAD	:	2.846	1.604	1.604
EXTREME SPREAD	:	3.171	2.390	2.314
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	