

FORM

UPC



0 47700 25716 7

C6665715

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.

C6665715

ORDER NO.

5716

20

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



5716 C6665715

ORDER 5716

MODEL 700™ M24

UPC

ORDER 5716

MODEL 700™ M24

UPC



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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6665715

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	LS
617	Drill and Tap Sight Holes		OCT 4 1991	LS
618	Polish Barrel		10/8/91	WS
620	Apply Coatings (Barrel Action)		10-22-91	LS
	Apply Coating (Bolt)		10-22-91	LS
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		10/28/91	LS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 $\frac{3}{4}$	4 $\frac{3}{4}$	4 $\frac{1}{2}$			10-30-91	DH
	G) Safety Off Force	2	2	2			10-30-91	DA
	H) Trigger Pull Test & Retainability						10/28/91	DH
	I) Firing Pin Indent	.022	.021	.021			10-30-91	DH
	J) Assemble Stock						10/30/91	RW
	K) Assemble Swivel Studs						11-8-91	AC
	L) Attach Front and Rear Sight Assemblies						10/30/91	RW
	M) Iron Sight Alignment						10/30/91	RW
	N) Detach Front & Rear Sights & place in numbered container						10/30/91	RW
	O) Attach Scope to Rifle						10/30/91	RW
	P) Detach & Attach Scope 20 Times						10/30/91	RW
640	Gallery Target & Test						10-30-91	N
	A) Time						"	N
	B) Malfunctions						"	N
	C) Pierced Primers						"	N
	D) Optical Clarity of Scope						"	N
645	Inspect for Live Ammo						10-30-91	N
655	Final Inspection							
	A) Headspace						11-8-91	AC
	B) Trigger Pull	224	211	202	217	211	10-31-91	DH
	C) Function						11-8-91	AC
660	Pack						12-8-91	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6665715

DATE 10/28/91

TESTER JF

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.39	2.26	2.31	2.24	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.37	2.22	2.28	2.11	
PULL #3	2.19	2.34	2.29	2.02	
PULL #4	2.32	2.44	2.46	2.17	
PULL #5	2.31	2.28	2.18	2.11	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.22	3.17		
PULL #2	3.48	3.37		
PULL #3	3.33	3.45		
PULL #4	3.45	3.41		
PULL #5	3.53	3.63		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.32	4.15		4.36
PULL #2	4.26	4.22		4.36
PULL #3	4.31	4.34		4.23
PULL #4	4.34	4.38		4.39
PULL #5	4.26	4.21		4.27
TOTAL				
AVG.				

$$\begin{array}{r} 91 \\ 62 \\ \hline 29 \end{array}$$

$$\begin{array}{r} 160.00 \\ 160.00 \\ \hline 320.00 \end{array}$$

CENTROIDAL DISTANCE CALCULATIONS
FOP RIFLE # C6665715
30 Oct 1991

CENTROIDAL DISTANCES

0 TO	1	.0720694
1 TO	2	.159402
1 TO	3	.250569
1 TO	4	.102728
1 TO	5	.523463

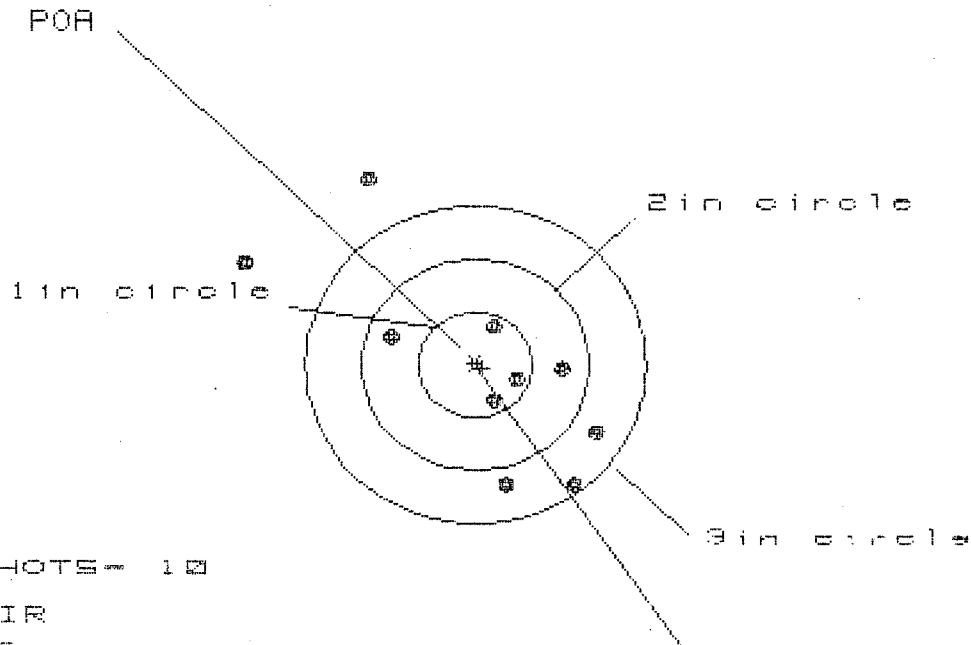
$\frac{4.3}{5}$ ←----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0108
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.042
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0433663
THE AMR FOR THIS RIFLE IS: .9016

30 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665715

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 8

HS= 3.136

VS= 2.903

GS= 3.565

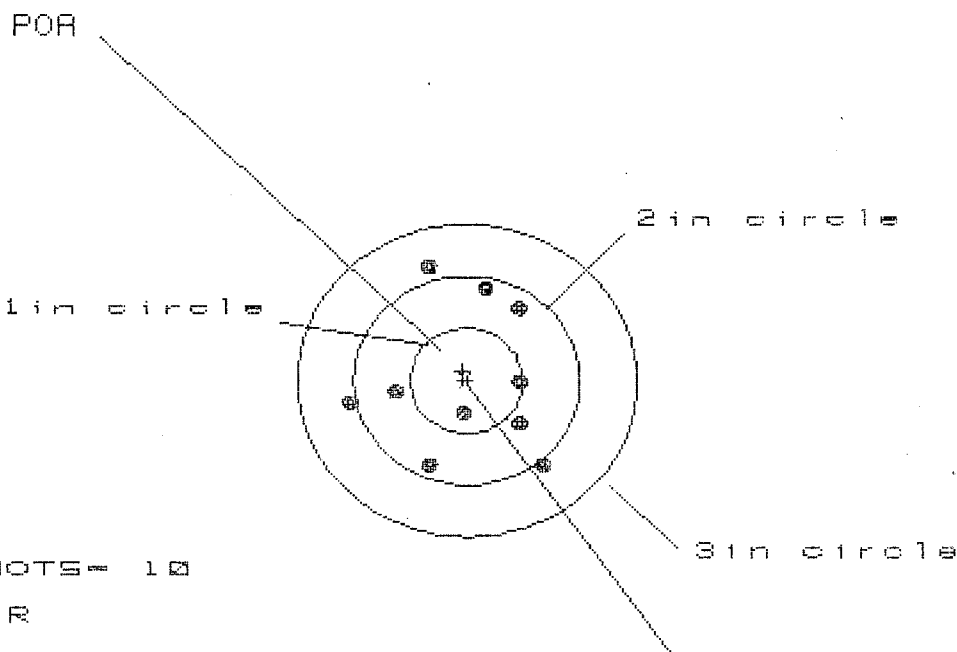
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.075	.846	.703
MINIMUM X	-2.061	-1.142	-1.066
MAXIMUM Y	1.779	1.885	.741
MINIMUM Y	-1.124	-1.018	-.782
CENTROID X	-.063	.166	.309
CENTROID Y	.035	-.071	-.307
POA TO CENTROID in.	.072	.181	.435
MIN RADIUS	.389	.162	.181
MEAN RADIUS	1.075	.865	.659
MAX RADIUS	2.271	2.204	1.204
HORIZONTAL SPREAD	3.136	1.988	1.769
VERTICAL SPREAD	2.903	2.903	1.523
EXTREME SPREAD	3.565	3.373	2.031
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS= 1.688

VS= 1.944

GS= 2.131

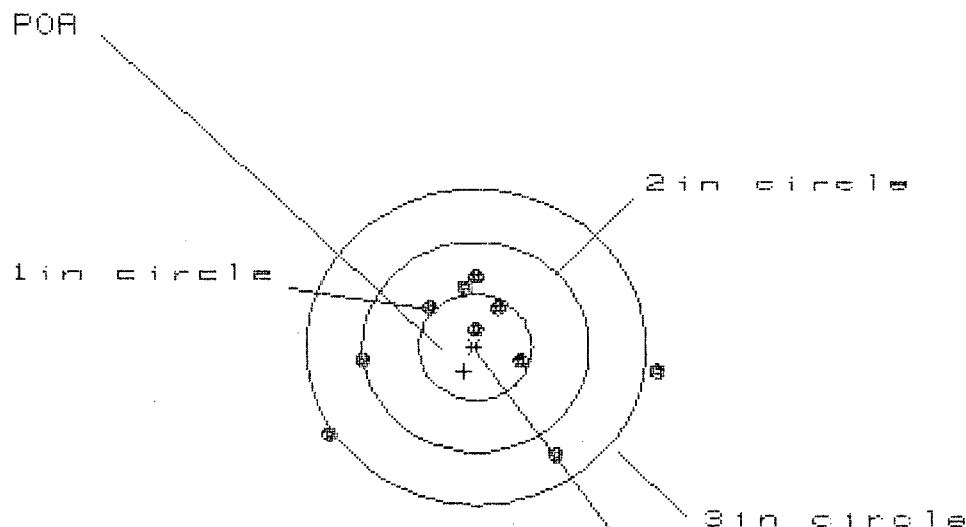
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.688	.639	.508
MINIMUM X	:	-1.008	-1.049	-.763
MAXIMUM Y	:	1.098	1.056	1.041
MINIMUM Y	:	-.846	-.724	-.739
CENTROID X	:	.032	.073	.204
CENTROID Y	:	-.093	-.215	-.200
POA TO CENTROID in.	:	.099	.228	.286
MIN RADIUS	:	.301	.196	.283
MEAN RADIUS	:	.794	.730	.678
MAX RADIUS	:	1.159	1.070	1.042
HORIZONTAL SPREAD	:	1.688	1.688	1.271
VERTICAL SPREAD	:	1.944	1.780	1.780
EXTREME SPREAD	:	2.131	1.858	1.858
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 = 3

2in = 6

3in = 8

HS= 2.998

VS= 1.740

GS= 3.061

CENTROID #

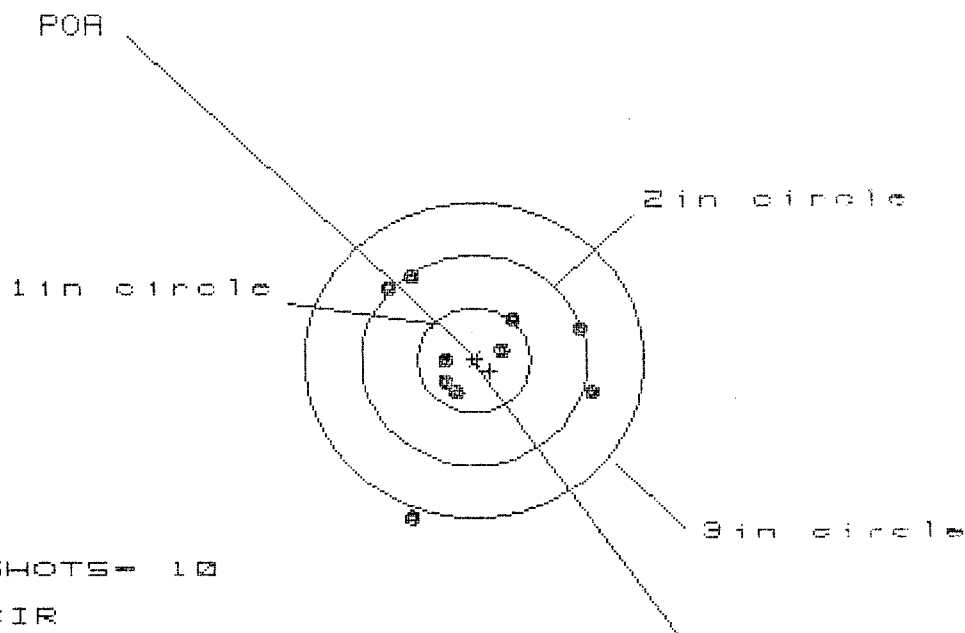
PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.651	.880	.735
MINIMUM X	:	-1.347	-1.164	-.978
MAXIMUM Y	:	.708	.687	.582
MINIMUM Y	:	-1.032	-1.053	-1.158
CENTROID X	:	.098	-.085	.060
CENTROID Y	:	.227	.248	.353
POA TO CENTROID in.	:	.247	.263	.358
MIN RADIUS	:	.180	.213	.050
MEAN RADIUS	:	.834	.737	.588
MAX RADIUS	:	1.662	1.433	1.371
HORIZONTAL SPREAD	:	2.998	2.044	1.713
VERTICAL SPREAD	:	1.740	1.740	1.740
EXTREME SPREAD	:	3.061	2.055	1.930
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1in = 5

2in = 5

3in = 9

HS= 1.784

VS= 2.377

GS= 2.426

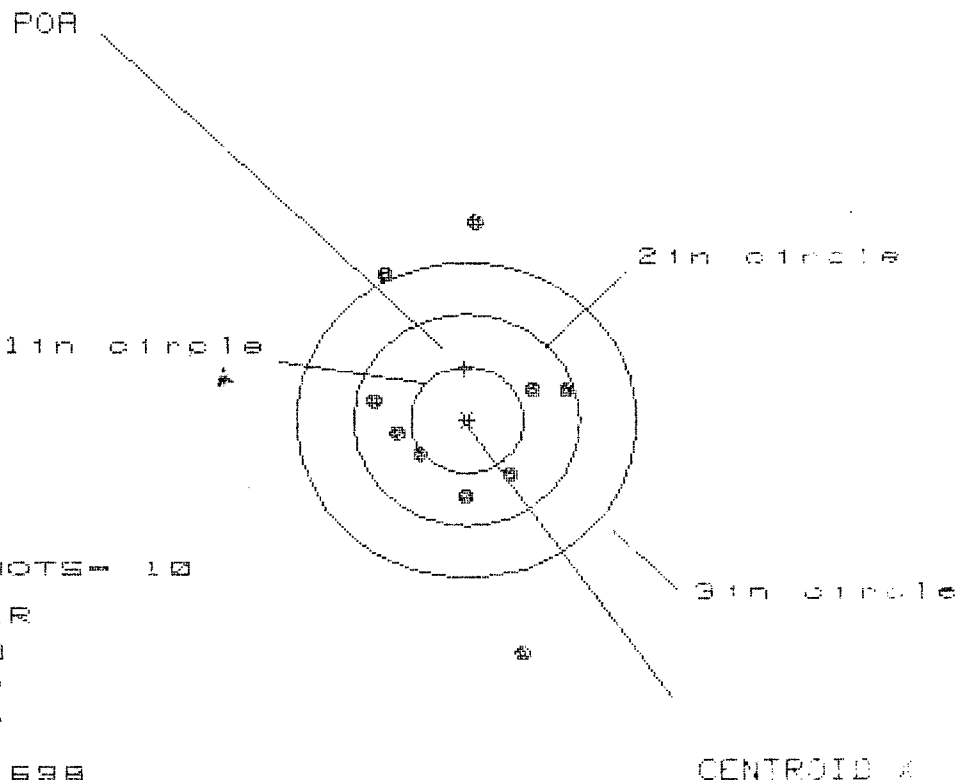
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.024	.957	1.032
MINIMUM X	:	-.760	-.827	-.708
MAXIMUM Y	:	.839	.668	.611
MINIMUM Y	:	-1.538	-.479	-.536
CENTROID X	:	-.140	-.073	-.192
CENTROID Y	:	.103	.274	.331
POA TO CENTROID in.	:	.174	.284	.383
MIN RADIUS	:	.244	.201	.276
MEAN RADIUS	:	.743	.638	.585
MAX RADIUS	:	1.653	1.060	1.035
HORIZONTAL SPREAD	:	1.784	1.784	1.740
VERTICAL SPREAD	:	2.377	1.147	1.147
EXTREME SPREAD	:	2.426	2.033	1.784
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 0

2in = 7

3in = 7

HS= 1.698

VS= 4.070

GS= 4.097

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.909	.967	.982
MINIMUM X	:	-.789	-.731	-.716
MAXIMUM Y	:	1.854	1.607	1.317
MINIMUM Y	:	-2.216	-.963	-.762
CENTROID X	:	.019	-.039	-.054
CENTROID Y	:	-.482	-.235	-.436
POA TO CENTROID in.	:	.482	.239	.440
MIN RADIUS	:	.549	.642	.527
MEAN RADIUS	:	1.062	.941	.811
MAX RADIUS	:	2.278	1.612	1.447
HORIZONTAL SPREAD	:	1.698	1.698	1.698
VERTICAL SPREAD	:	4.070	2.570	2.079
EXTREME SPREAD	:	4.097	2.571	2.187
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		7	