

FORM

UPC



0 47700 25716 7

06665763

*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 TM M24

SERIAL NO.
C6665763

ORDER NO.
5716

20

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



5716 C6665763

ORDER **5716**

MODEL 700 TM M24

UPC

ORDER **5716**

MODEL 700 TM M24

UPC



0 47700 25716 7



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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6665763

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	GS
617	Drill and Tap Sight Holes		OCT 4 1991	LB
618	Polish Barrel		10/8/91	W.B
620	Apply Coatings (Barrel Action)		10-22-91	DA
	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		10/22/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/30/91	W

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4 $\frac{1}{4}$	3 $\frac{1}{2}$			10-30-91	DH
	G) Safety Off Force	2 $\frac{1}{2}$	2 $\frac{1}{4}$	2 $\frac{1}{2}$			10-30-91	DH
	H) Trigger Pull Test & Retainability						10/30/91	JH
	I) Firing Pin Indent	.021	.021	.021			10-30-91	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						10-31-91	N
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						10-31-91	NF
655	Final Inspection							
	A) Headspace						11-12-91	AC
	B) Trigger Pull	2.54	2.31	2.32	2.34	2.36	11-5-91	DH
	C) Function						11-12-91	AC
660	Pack						12-30-91	NF

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6665 763

DATE 10/30/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.34	2.60	2.31	2.54	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.37	2.63	2.48	2.31	
PULL #3	2.31	2.30	2.32	2.32	
PULL #4	2.26	2.28	2.30	2.34	
PULL #5	2.36	2.32	2.35	2.36	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.41	3.54		
PULL #2	3.46	3.54		
PULL #3	3.47	3.59		
PULL #4	3.42	3.51		
PULL #5	3.29	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	4.34	4.40		4.51
PULL #2	4.53	4.35		4.36
PULL #3	4.49	4.46		4.44
PULL #4	4.43	4.34		4.31
PULL #5	4.31	4.41		4.50
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665763
31 Oct 1991

CENTROIDAL DISTANCES

0 TO 1	.225291
1 TO 2	.333635
1 TO 3	.0543415
1 TO 4	.420577
1 TO 5	.227528

4 <----POA

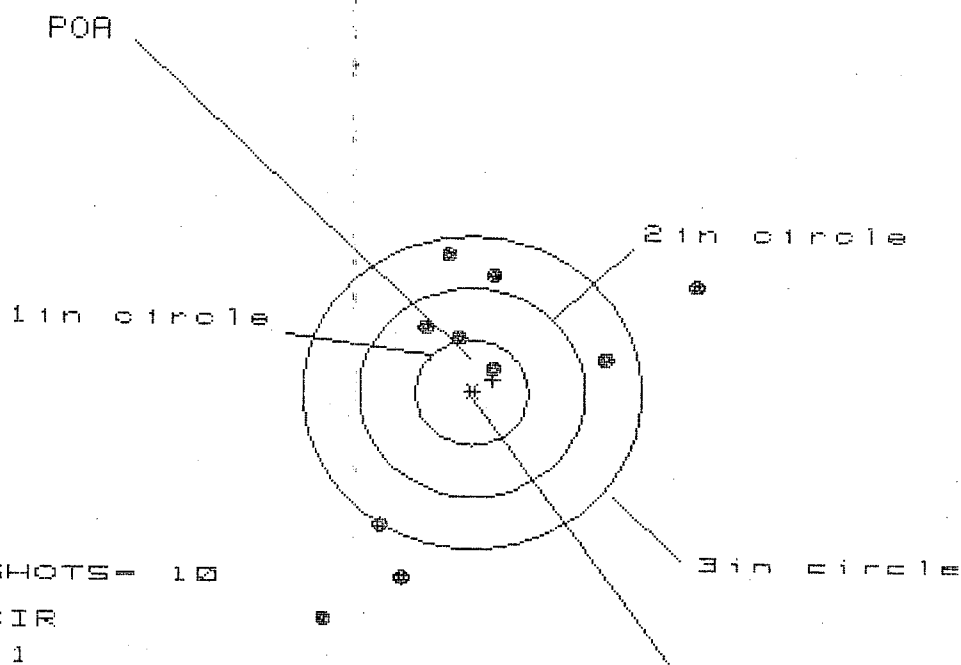
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.11
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0578
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .124261

THE AMR FOR THIS RIFLE IS: 1.142

31 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6565763

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 6

HS= 3.271

VS= 3.444

GS= 4.555

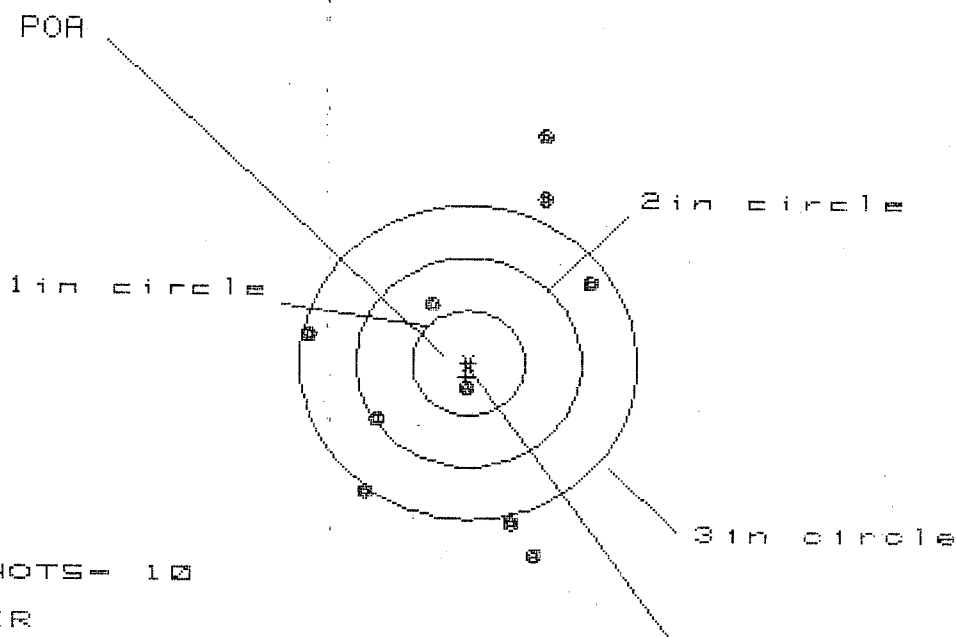
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.971	1.826	1.222
MINIMUM X	:	-1.300	-1.003	-.774
MAXIMUM Y	:	1.323	1.087	1.189
MINIMUM Y	:	-2.121	-2.003	-1.901
CENTROID X	:	-.184	-.039	-.268
CENTROID Y	:	-.130	.106	.004
POA TO CENTROID in.	:	.225	.113	.268
MIN RADIUS	:	.283	.087	.303
MEAN RADIUS	:	1.335	1.127	1.039
MAX RADIUS	:	2.488	2.157	1.986
HORIZONTAL SPREAD	:	3.271	2.829	1.996
VERTICAL SPREAD	:	3.444	3.090	3.090
EXTREME SPREAD	:	4.555	3.851	3.126
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		6	

31 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665763

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 1

2in = 3

3in = 6

HS= 2.548

VS= 3.945

GS= 3.946

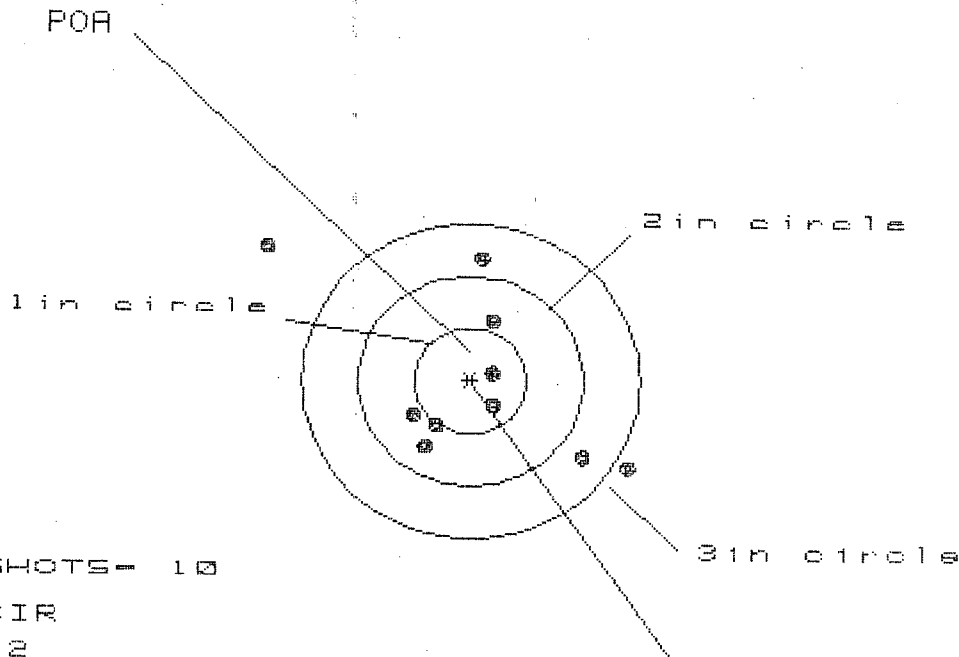
CENTROID #

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.091	1.167	1.254
MINIMUM X	:	-1.457	-1.381	-1.294
MAXIMUM Y	:	2.128	1.833	1.635
MINIMUM Y	:	-1.817	-1.580	-1.457
CENTROID X	:	.020	-.056	-.143
CENTROID Y	:	.134	-.103	.095
POA TO CENTROID in.	:	.135	.117	.171
MIN RADIUS	:	.239	.056	.245
MEAN RADIUS	:	1.359	1.221	1.158
MAX RADIUS	:	2.235	1.991	1.850
HORIZONTAL SPREAD	:	2.548	2.548	2.548
VERTICAL SPREAD	:	3.945	3.413	3.092
EXTREME SPREAD	:	3.946	3.414	3.222
NUMBER IN ONE INCH CIRCLE =	:	1		
NUMBER IN TWO INCH CIRCLE =	:	3		
NUMBER IN THREE INCH CIRCLE =	:	6		

31 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8665763

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 3.224

VS= 2.122

GS= 3.860

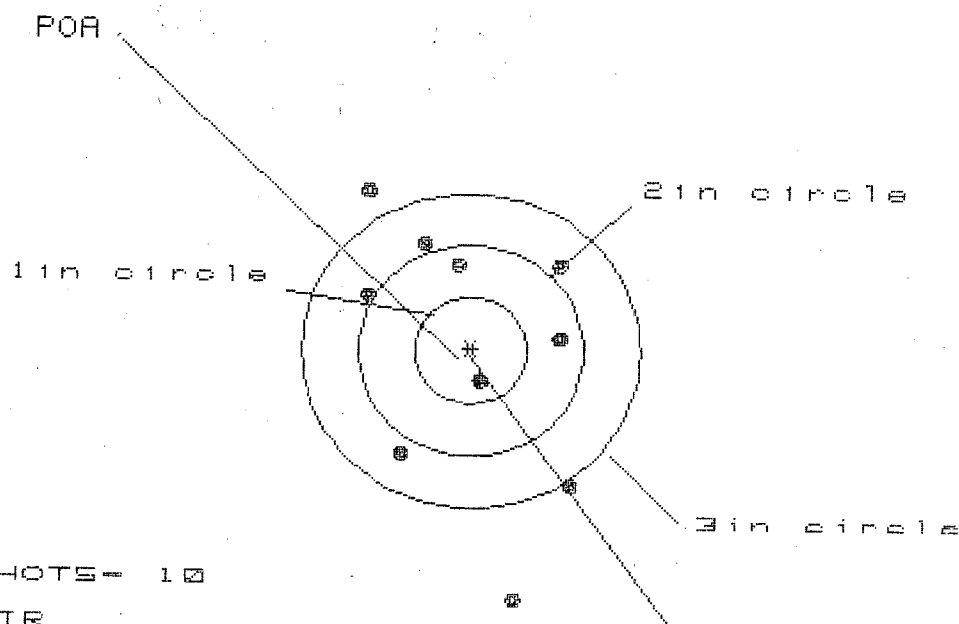
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.375	1.170	.928
MINIMUM X	:	-1.849	-.709	-.563
MAXIMUM Y	:	1.325	1.315	1.234
MINIMUM Y	:	-.797	-.649	-.608
CENTROID X	:	-.196	.009	-.137
CENTROID Y	:	-.077	-.225	-.143
POA TO CENTROID in.	:	.211	.225	.198
MIN RADIUS	:	.214	.109	.191
MEAN RADIUS	:	.929	.753	.666
MAX RADIUS	:	2.275	1.338	1.236
HORIZONTAL SPREAD	:	3.224	1.879	1.491
VERTICAL SPREAD	:	2.122	1.964	1.841
EXTREME SPREAD	:	3.860	2.321	2.027
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

31 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6685763

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 7

HS= 1.802

VS= 3.871

GS= 4.101

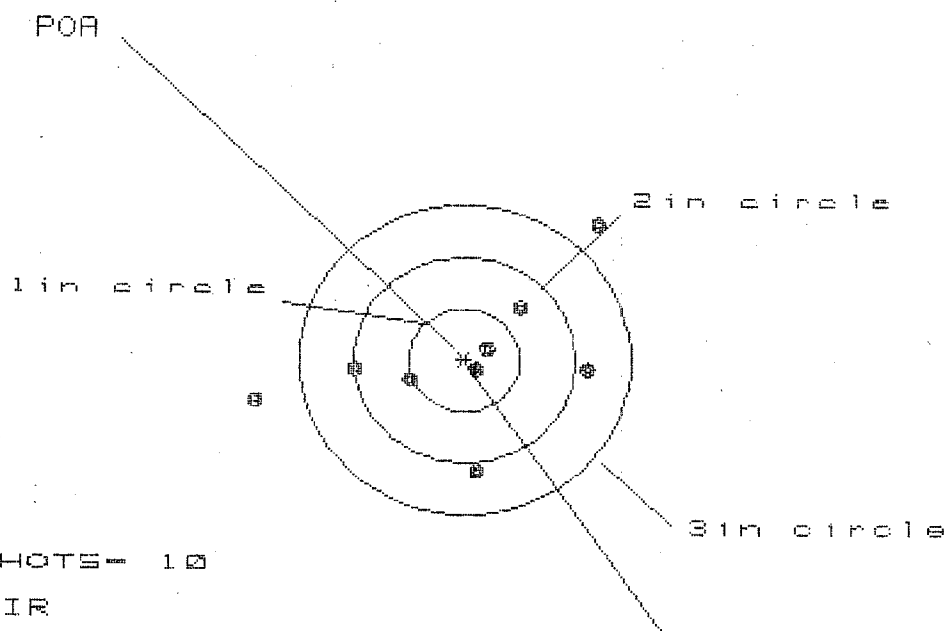
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.850	.898	.789
MINIMUM X	:	-.952	-.904	-1.013
MAXIMUM Y	:	1.536	1.276	.883
MINIMUM Y	:	-2.335	-1.561	-1.401
CENTROID X	:	-.086	-.134	-.025
CENTROID Y	:	.279	.539	.379
POA TO CENTROID in.	:	.292	.555	.380
MIN RADIUS	:	.292	.540	.384
MEAN RADIUS	:	1.210	1.048	.983
MAX RADIUS	:	2.375	1.801	1.608
HORIZONTAL SPREAD	:	1.802	1.802	1.802
VERTICAL SPREAD	:	3.871	2.837	2.284
EXTREME SPREAD	:	4.101	3.344	2.598
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			3	
NUMBER IN THREE INCH CIRCLE =			7	

31 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665763

CENTERFIRE PATTERNS # 5



PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.224	1.017	.989
MINIMUM X	:	-1.864	-1.242	-1.115
MAXIMUM Y	:	1.301	1.262	.652
MINIMUM Y	:	-1.112	-1.151	-.993
CENTROID X	:	-.104	.103	-.024
CENTROID Y	:	.083	.122	-.035
POA TO CENTROID in.	:	.133	.160	.043
MIN RADIUS	:	.147	.104	.032
MEAN RADIUS	:	.875	.737	.609
MAX RADIUS	:	1.897	1.621	1.115
HORIZONTAL SPREAD	:	3.088	2.259	2.104
VERTICAL SPREAD	:	2.413	2.413	1.646
EXTREME SPREAD	:	3.503	2.658	2.104
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	