

FORM

UPC



0 47700 25716 7

06665773

INCLUDES 1 IN CHAMBER

.000 TM M24

5716

ORDER NO.

BARREL LENGTH

CAPACITY*

Remington



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

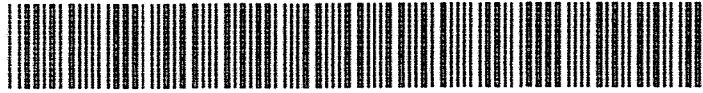
MODEL 700TM M24

SERIAL NO.
C6665773

ORDER NO.
5716

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

20



5716 C6665773

ORDER 5716

MODEL 700TM M24

UPC

ORDER 5716

MODEL 700TM M24

UPC



0 47700 25716 7



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6665773

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	SS.
617	Drill and Tap Sight Holes		SEP 30 1991	FB
618	Polish Barrel		OCT 2 1991	WB
620	Apply Coatings (Barrel Action)		10-13-91	JA
	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	JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/2	5	5			10-22-91	D/H
	G) Safety Off Force	2 3/4	2 3/4	2 3/4			10-22-91	DH
	H) Trigger Pull Test & Retainability						10/22/91	JD
	I) Firing Pin Indent	.020	.020	.020			10-22-91	DH
	J) Assemble Stock						10/24/91	RW
	K) Assemble Swivel Studs						11-12-91	AC
	L) Attach Front and Rear Sight Assemblies						10/24/91	RW
	M) Iron Sight Alignment						10/24/91	RW
	N) Detach Front & Rear Sights & place in numbered container						10/24/91	RW
	O) Attach Scope to Rifle						10/24/91	RW
	P) Detach & Attach Scope 20 Times						10/24/91	RW
640	Gallery Target & Test						10-25-91	AC
	A) Time						10-25-91	AC
	B) Malfunctions						10-25-91	AC
	C) Pierced Primers						10-25-91	AC
	D) Optical Clarity of Scope						10-25-91	AC
645	Inspect for Live Ammo						10-25-91	AC
655	Final Inspection							
	A) Headspace						11-12-91	AC
	B) Trigger Pull	241	266	241	242	238	10-30-91	D/H
	C) Function						11-12-91	AC
660	Pack						12-18-91	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-6665773

DATE 10/22/91

TESTER JEP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.44	2.45	2.41	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.35	2.44	2.25	2.66	
PULL #3	2.43	2.44	2.43	2.41	
PULL #4	2.44	2.36	2.48	2.42	
PULL #5	2.48	2.43	2.39	2.38	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.67	3.22		
PULL #2	3.55	3.32		
PULL #3	3.45	3.27		
PULL #4	3.46	3.30		
PULL #5	3.46	3.39		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.39	4.46		4.23
PULL #2	4.28	4.26		4.44
PULL #3	4.34	4.46		4.21
PULL #4	4.45	4.31		4.42
PULL #5	4.25	4.36		4.47
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665773
25 Oct 1991

CENTROIDAL DISTANCES

0 TO 1	.442019
1 TO 2	.379796
1 TO 3	.3828
1 TO 4	.62794
1 TO 5	.313211

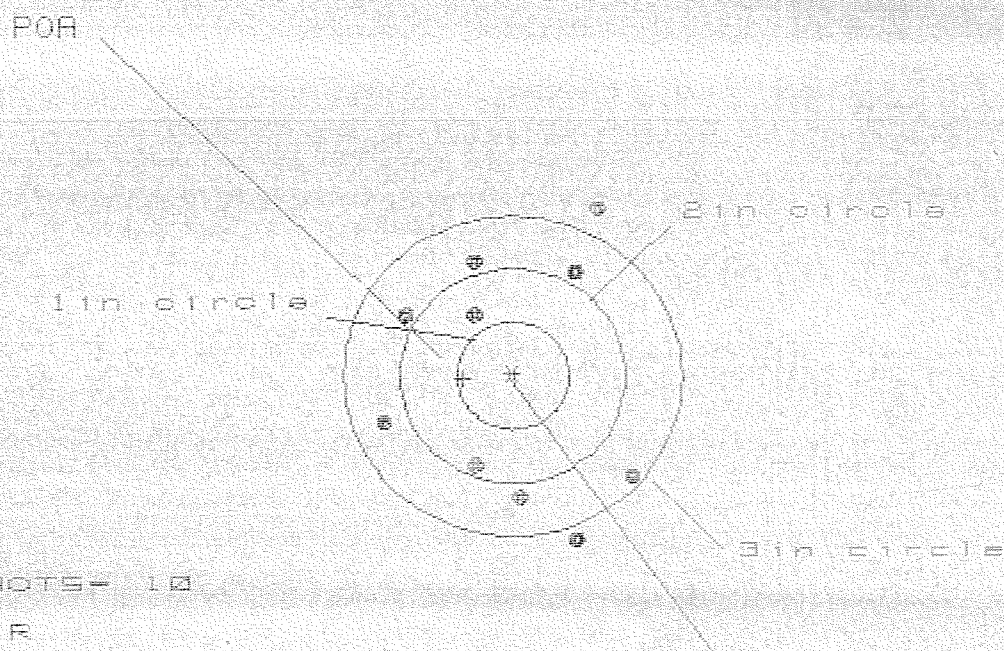
$\frac{1}{4.25}$ <----POH

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2994
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2138
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .367901
THE AMR FOR THIS RIFLE IS: 1.174

25 Oct 1991

FILE: /PATTERNING/CENTERFIRE_PATT/C6665773

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 0

2in = 2

3in = 8

HS= 2.107

VS= 3.087

GS= 3.094

CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.014	1.103	1.189
MINIMUM X	:	-1.093	-1.004	-.918
MAXIMUM Y	:	1.575	1.254	1.087
MINIMUM Y	:	-1.512	-1.337	-1.170
CENTROID X	:	.441	.352	.266
CENTROID Y	:	.030	-.145	.022
POA TO CENTROID in.	:	.442	.380	.267
MIN RADIUS	:	.624	.675	.572
MEAN RADIUS	:	1.194	1.114	1.042
MAX RADIUS	:	1.769	1.503	1.488
HORIZONTAL SPREAD	:	2.107	2.107	2.107
VERTICAL SPREAD	:	3.087	2.591	2.257
EXTREME SPREAD	:	3.094	2.754	2.472
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		8	

25 Oct 1991

FILE: /PATTERNING/CENTERFIRE_PATT/C6665773

CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 8

HS= 2.947

VS= 2.676

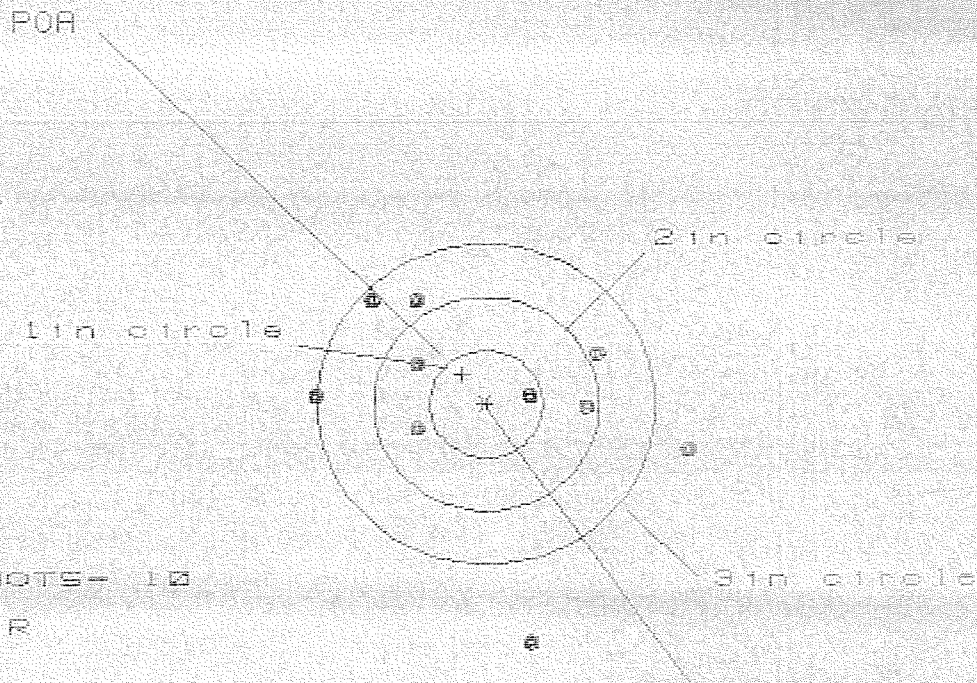
GS= 3.981

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.532	1.375	1.389
MINIMUM X	:	-1.415	-1.181	-1.009
MAXIMUM Y	:	.935	.742	.685
MINIMUM Y	:	-1.741	-1.336	-1.243
CENTROID X	:	.323	.480	.308
CENTROID Y	:	-.331	-.137	-.230
POA TO CENTROID in.	:	.462	.499	.385
MIN RADIUS	:	.322	.129	.301
MEAN RADIUS	:	1.193	1.036	.977
MAX RADIUS	:	2.243	1.562	1.463
HORIZONTAL SPREAD	:	2.947	2.556	2.398
VERTICAL SPREAD	:	2.676	2.078	1.928
EXTREME SPREAD	:	3.981	2.834	2.455
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

25 Oct 1991

FILE: \PATTERNING\CENTERFIRE_PATT\06665773

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 7

HS= 3.264

VS= 3.126

GS= 3.447

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.755	1.802	1.213
MINIMUM X	:	-1.509	-1.462	-1.237
MAXIMUM Y	:	.951	.709	.624
MINIMUM Y	:	-2.175	-.680	-.550
CENTROID X	:	.211	.164	-.061
CENTROID Y	:	-.276	-.034	.051
POA TO CENTROID in.	:	.347	.168	.080
MIN RADIUS	:	.345	.441	.318
MEAN RADIUS	:	1.165	1.020	.874
MAX RADIUS	:	2.216	1.926	1.256
HORIZONTAL SPREAD	:	3.264	3.264	2.450
VERTICAL SPREAD	:	3.126	1.389	1.174
EXTREME SPREAD	:	3.447	3.309	2.476
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

25 Oct 1991

FILE: /PATTERNING/CENTERFIRE_PATT/08885773

CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 3

2 in = 4

3 in = 7

HS= 3.011

VS= 2.869

GS= 3.515

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.303	1.113	1.109
MINIMUM X	:	-1.708	-.563	-.567
MAXIMUM Y	:	1.068	.984	.748
MINIMUM Y	:	-1.801	-1.885	-1.472
CENTROID X	:	-.109	.081	.085
CENTROID Y	:	-.273	-.189	.047
POA TO CENTROID in.	:	.294	.205	.097
MIN RADIUS	:	.273	.262	.332
MEAN RADIUS	:	1.050	.941	.802
MAX RADIUS	:	1.869	1.886	1.501
HORIZONTAL SPREAD	:	3.011	1.676	1.676
VERTICAL SPREAD	:	2.869	2.869	2.220
EXTREME SPREAD	:	3.515	3.079	2.617
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			4	
NUMBER IN THREE INCH CIRCLE =			7	

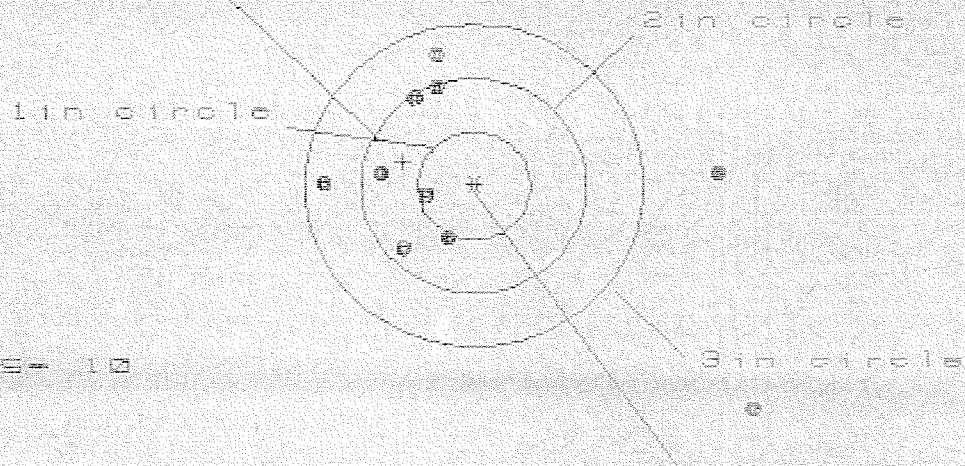
25 Oct 1991

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CENTERFIRE PATTERNS

5

POA



OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 8

HS= 3.785

VS= 3.335

GS= 4.346

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.421	2.463	.387
MINIMUM X	:	-1.364	-1.095	-.787
MAXIMUM Y	:	1.217	.982	.971
MINIMUM Y	:	-2.118	-.817	-.829
CENTROID X	:	.631	.362	.054
CENTROID Y	:	-.219	.016	.027
POA TO CENTROID in.	:	.668	.362	.061
MIN RADIUS	:	.421	.341	.294
MEAN RADIUS	:	1.269	.944	.686
MAX RADIUS	:	3.216	2.465	.997
HORIZONTAL SPREAD	:	3.785	3.558	1.174
VERTICAL SPREAD	:	3.335	1.799	1.799
EXTREME SPREAD	:	4.346	3.560	1.820
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	