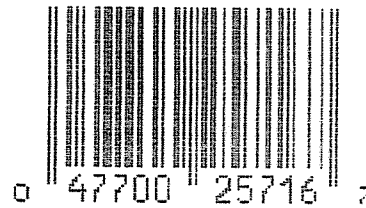


FORM

UPC



06665782

•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.

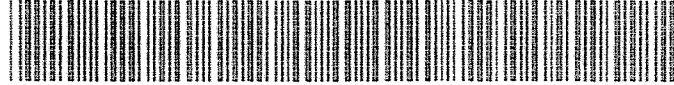
C6665782

ORDER NO.

5716

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

20



5716 C6665782

ORDER 5716

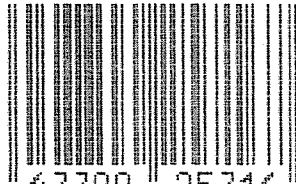
MODEL 700 TM M24

UPC

ORDER 5716

MODEL 700 TM M24

UPC



0 47700 25716 7



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6665782

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		RW
612	Magnaflux Barrel Action		OCT 1 0 1991	KR
	Magnaflux Bolt		OCT 1 0 1991	KR
615	Rollmark Caliber		OCT 1 0 1991	GL
617	Drill and Tap Sight Holes		OCT 1 0 1991	LB
618	Polish Barrel		10/15/91	WB
620	Apply Coatings (Barrel Action)		11/2/91	AB
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		12/3/91	KH
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/3/91	KH
	C) Inspect Ejector Hole for Chamfer		12/3/91	KH
	D) Oil Firing Pin Ass'y		12/3/91	KH
	E) Adjust Trigger Pull to Min Setting and Stake		12-9-91	GH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			12-9-91	JK
	G) Safety Off Force	3	3	3			12-9-91	JK
	H) Trigger Pull Test & Retainability						12-9-91	JK
	I) Firing Pin Indent	.020	.020	.020			12-9-91	JK
	J) Assemble Stock						12/9/91	JK
	K) Assemble Swivel Studs						12-13-91	JK
	L) Attach Front and Rear Sight Assemblies						12/9/91	JK
	M) Iron Sight Alignment						14/9/91	JK
	N) Detach Front & Rear Sights & place in numbered container						12/9/91	JK
	O) Attach Scope to Rifle						12/9/91	JK
	P) Detach & Attach Scope 20 Times						12/9/91	JK
640	Gallery Target & Test						2/10/91	KT
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	KT
645	Inspect for Live Ammo						12/10/91	KT
655	Final Inspection							
	A) Headspace						12-13-91	JK
	B) Trigger Pull	2.34	2.43	2.45	2.52	2.37	12-11-91	JK
	C) Function						12-13-91	JK
660	Pack						12-17-91	JK

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6665782

DATE 12-9-91

TESTER JL.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.48	2.34	2.59	2.34	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.39	2.53	2.55	2.43	
PULL #3	2.45	2.58	2.48	2.45	
PULL #4	2.47	2.55	2.51	2.52	
PULL #5	2.49	2.43	2.51	2.37	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.59	3.44		
PULL #2	3.60	3.40		
PULL #3	3.65	3.38		
PULL #4	3.55	3.58		
PULL #5	3.51	3.50		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.66	4.76		4.39
PULL #2	4.59	4.54		4.55
PULL #3	4.63	4.50		4.52
PULL #4	4.56	4.54		4.64
PULL #5	4.26	4.56		4.56
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 0665782
10 Dec 1991

CENTROIDAL DISTANCES

0 TO	1	.0840238
1 TO	2	.119101
1 TO	3	.480937
1 TO	4	.332357
1 TO	5	.253332

reg. 4 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0612
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0318
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0689687

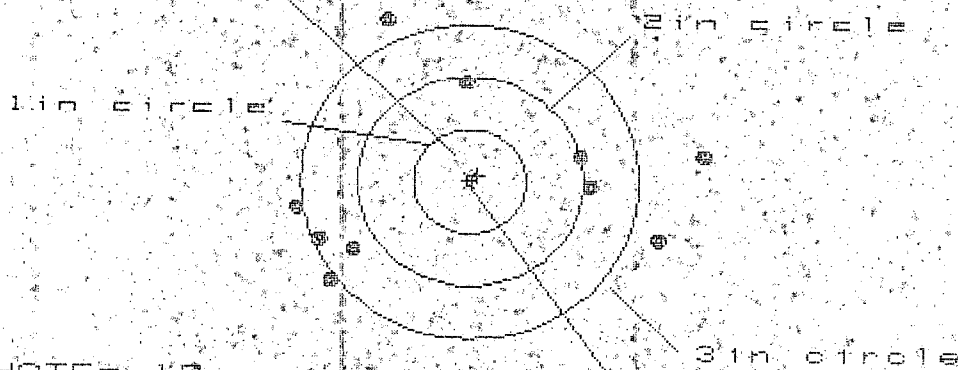
THE AMR FOR THIS RIFLE IS: 1.269

18 Dec 1991

FILE: PATTERNING CENTERFIRE PATT/06865782

CENTERFIRE PATTERNS # 1

POA



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 1

3 in = 5

HS= 3.581

VS= 2.463

GS= 3.618

CENTROID *

PATTERN #

1

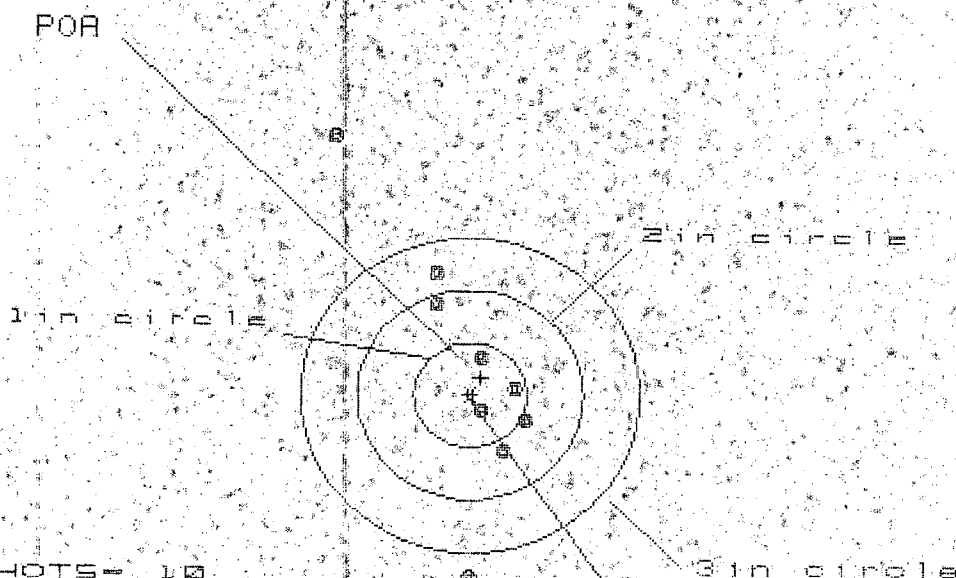
SHOTS (BEST OF)

	10	9	8
MAXIMUM X	2.084	1.881	1.554
MINIMUM X	-1.497	-1.265	-1.030
MAXIMUM Y	1.519	1.551	1.488
MINIMUM Y	-.944	-.912	-.875
CENTROID X	-.066	-.298	-.533
CENTROID Y	-.052	-.084	-.021
POA TO CENTROID in.	.085	.310	.534
MIN RADIUS	.925	.979	.892
MEAN RADIUS	1.427	1.330	1.220
MAX RADIUS	2.104	1.948	1.557
HORIZONTAL SPREAD	3.581	3.146	2.584
VERTICAL SPREAD	2.463	2.463	2.463
EXTREME SPREAD	3.618	3.161	2.589
NUMBER IN ONE INCH CIRCLE	= 0		
NUMBER IN TWO INCH CIRCLE	= 1		
NUMBER IN THREE INCH CIRCLE	= 5		

10 Dec 1991

FILE: PATTERNING/CENTERFIRE_PATT/C6665782

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 6

3 in = 7

HS = 1.216

VS = 4.577

GS = 4.888

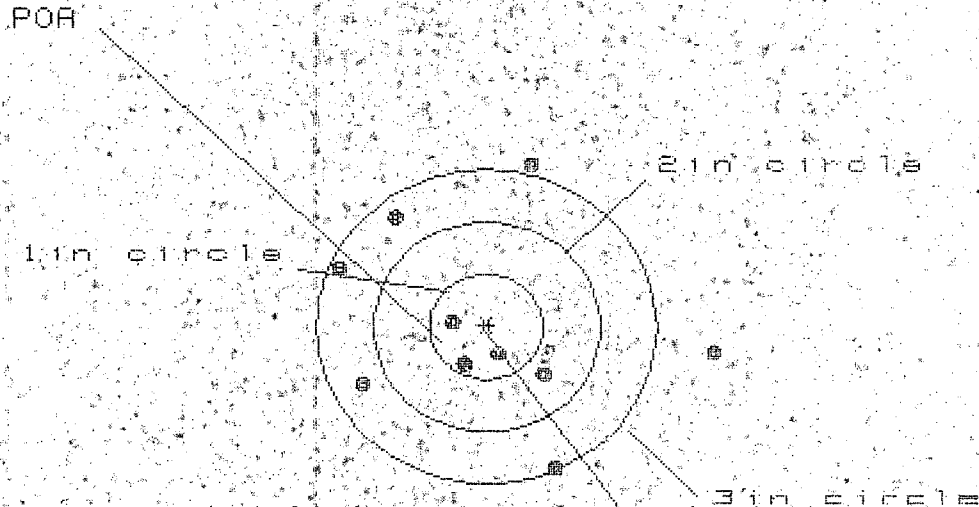
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.544	.414	.409
MINIMUM X	:	-1.172	-.456	-.405
MAXIMUM Y	:	2.430	1.443	1.208
MINIMUM Y	:	-2.147	-1.827	-1.737
CENTROID X	:	-.093	.037	-.014
CENTROID Y	:	-.168	-.438	-.203
POR TO CENTROID in.	:	.192	.439	.203
MIN RADIUS	:	.195	.127	.121
MEAN RADIUS	:	1.079	.874	.713
MAX RADIUS	:	2.698	1.923	1.742
HORIZONTAL SPREAD	:	1.716	.870	.814
VERTICAL SPREAD	:	4.577	3.320	2.945
EXTREME SPREAD	:	4.888	3.432	2.958
NUMBER IN ONE INCH CIRCLE =	:		3	
NUMBER IN TWO INCH CIRCLE =	:		6	
NUMBER IN THREE INCH CIRCLE =	:		7	

18 Dec 1991

FILE: PATTERNING/CENTERFIRE_PATT/06665782

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 3

2in = 4

3in = 7

HS = 3.359

VS = 2.898

GS = 3.444

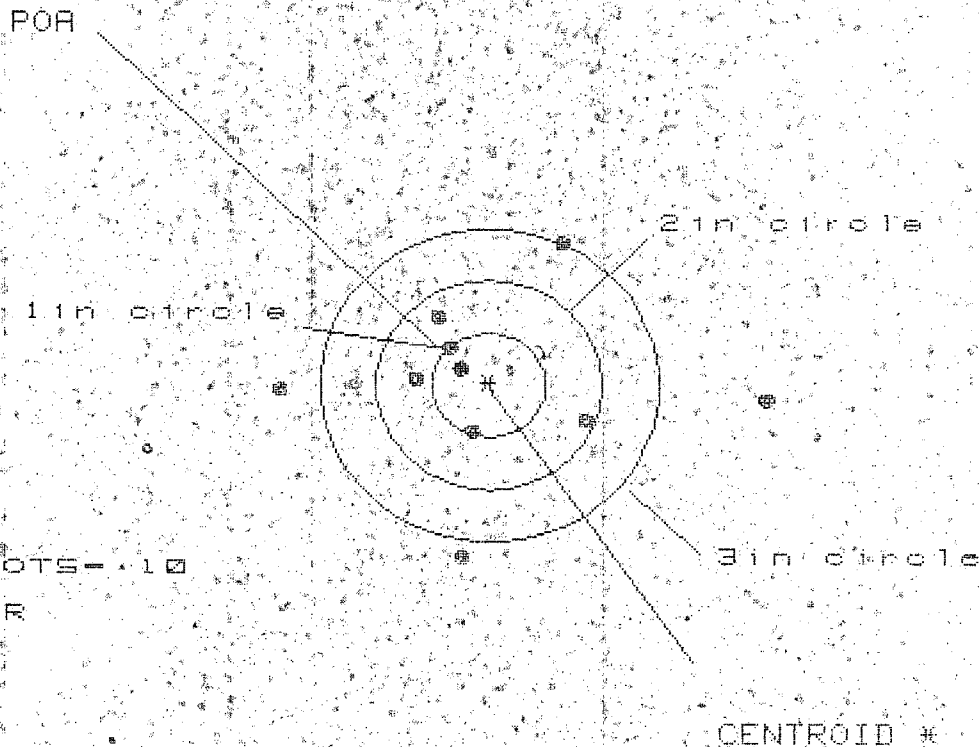
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.033	.863	.942
MINIMUM X	:	-1.326	-1.101	-1.022
MAXIMUM Y	:	1.512	1.487	1.184
MINIMUM Y	:	-1.385	-1.411	-1.225
CENTROID X	:	.198	-.027	-.106
CENTROID Y	:	.350	.376	.191
POA TO CENTROID in.	:	.403	.377	.218
MIN RADIUS	:	.264	.078	.164
MEAN RADIUS	:	1.072	.933	.828
MAX RADIUS	:	2.046	1.655	1.546
HORIZONTAL SPREAD	:	3.359	1.964	1.964
VERTICAL SPREAD	:	2.898	2.898	2.410
EXTREME SPREAD	:	3.444	2.907	2.812
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	7		

10 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C86657B2

CENTERFIRE PATTERNS # 4



PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.456	1.075	.882
MINIMUM X	:	-1.810	-1.537	-.597
MAXIMUM Y	:	1.378	1.366	1.357
MINIMUM Y	:	-1.649	-1.661	-1.670
CENTROID X	:	.249	.024	.169
CENTROID Y	:	-.158	-.146	-.137
POA TO CENTROID in.	:	.295	.148	.218
MIN RADIUS	:	.289	.152	.212
MEAN RADIUS	:	1.107	.894	.828
MAX RADIUS	:	2.458	1.662	1.676
HORIZONTAL SPREAD	:	4.266	2.612	1.479
VERTICAL SPREAD	:	3.027	3.027	3.027
EXTREME SPREAD	:	4.266	3.143	3.143
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	6		

18 Dec 1991

FILE: PATTERNING/CENTERFIRE_PATT/C5685782

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 0

2 in = 2

3 in = 5

HS= 2.369

VS= 6.289

GS= 6.334

PATTERN #

5

SHOTS (BEST OF)

	10	9	8
MAXIMUM X	1.212	1.311	1.341
MINIMUM X	-1.157	-1.058	-1.028
MAXIMUM Y	3.301	1.514	1.186
MINIMUM Y	-2.988	-2.621	-1.587
CENTROID X	.018	.081	-.111
CENTROID Y	.187	-.180	.148
POA TO CENTROID in.	.188	.197	.185
MIN RADIUS	.793	.484	.658
MEAN RADIUS	1.662	1.425	1.259
MAX RADIUS	3.420	2.632	1.637
HORIZONTAL SPREAD	2.369	2.369	2.369
VERTICAL SPREAD	6.289	4.135	2.773
EXTREME SPREAD	6.334	4.135	3.167
NUMBER IN ONE INCH CIRCLE =	0	0	0
NUMBER IN TWO INCH CIRCLE =	2	2	2
NUMBER IN THREE INCH CIRCLE =	5	5	5