

FORM

UPC



0 47700 25716 7

06665787

*INCLUDES 1 IN CHAMBER

MODEL 700 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.
C6665787

ORDER NO.
5716

20

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



5716 C6665787

ORDER 5716

MODEL 700TM M24

UPC



0 47700 25716 7

ORDER 5716

MODEL 700TM M24

UPC



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6665-787

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	LS
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		10/28/91	JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/4	4 1/4	4 1/4			10/28/91	WB
	G) Safety Off Force	3 1/2	3 1/2	3 1/2			10/28/91	WB
	H) Trigger Pull Test & Retainability						10/28/91	JA
	I) Firing Pin Indent	.0215	.0205	.0205			10/28/91	WB
	J) Assemble Stock						10/29/91	RW
	K) Assemble Swivel Studs						11-12-91	AC
	L) Attach Front and Rear Sight Assemblies						10/29/91	RW
	M) Iron Sight Alignment						10/29/91	RW
	N) Detach Front & Rear Sights & place in numbered container						10/29/91	RW
	O) Attach Scope to Rifle						10/29/91	RW
	P) Detach & Attach Scope 20 Times						10/29/91	RW
640	Gallery Target & Test						10-29-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						10-29-91	NF
655	Final Inspection							
	A) Headspace						11-12-91	AC
	B) Trigger Pull	237	241	236	233	240	10-30-91	D/H
	C) Function						11-12-91	AC
660	Pack						12-17-91	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-6665787

DATE 10/28/91

TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.29	2.38	237	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.39	2.39	2.45	241	
PULL #3	2.39	2.40	2.48	236	
PULL #4	2.41	2.36	2.50	233	
PULL #5	2.27	2.42	2.51	240	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.50	3.41		
PULL #2	3.56	3.39		
PULL #3	3.46	3.33		
PULL #4	3.42	3.41		
PULL #5	3.39	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	4.42	4.32		4.26
PULL #2	4.40	4.34		4.27
PULL #3	4.37	4.36		4.27
PULL #4	4.24	4.37		4.29
PULL #5	4.32	4.34		4.37
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06665787
29 Oct 1991

CENTROIDAL DISTANCES

0 TO 1	.026
1 TO 2	.136297
1 TO 3	.244724
1 TO 4	.307376
1 TO 5	.0950789

& <----POB

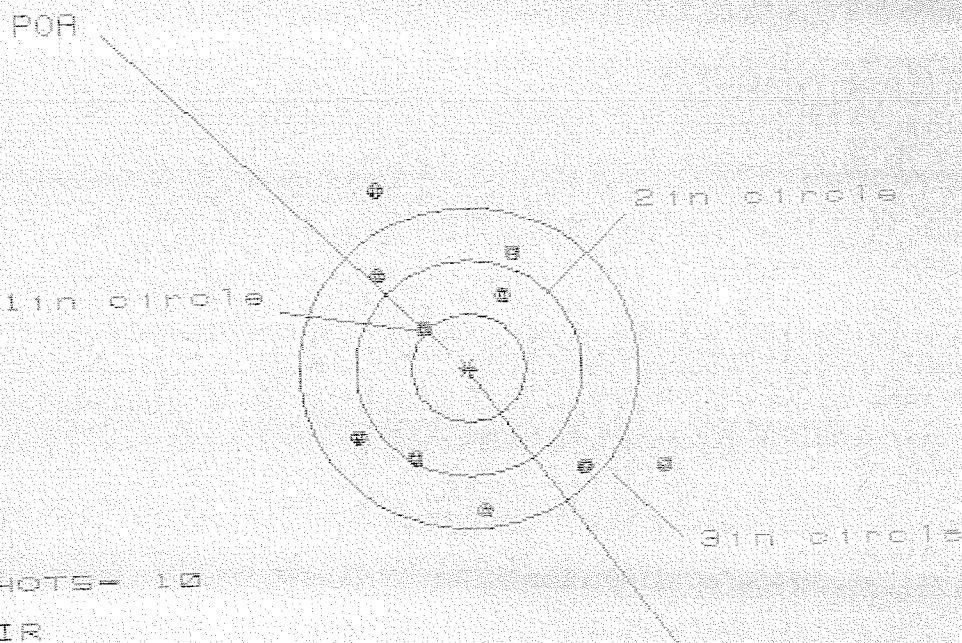
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0424
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.109
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .116956

THE AMR FOR THIS RIFLE IS: .966

29 Oct 1991

FILE: /PATTERNING/CENTERFIRE_PATT/C8665707

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 0

2in = 2

3in = 8

HS= 2.628

VS= 3.033

GS= 3.516

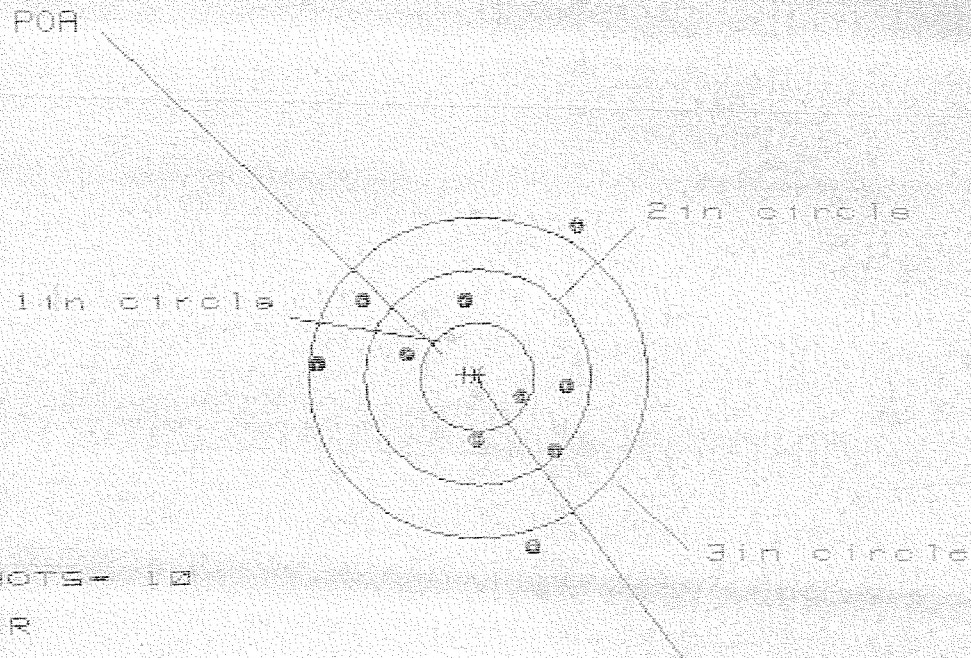
CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.662	1.167	1.098
MINIMUM X	:	-0.966	-0.782	-0.851
MAXIMUM Y	:	1.661	1.560	1.151
MINIMUM Y	:	-1.372	-1.473	-1.278
CENTROID X	:	-0.010	-0.194	-0.125
CENTROID Y	:	.024	.125	-0.071
POA TO CENTROID in.	:	.026	.231	.143
MIN RADIUS	:	.551	.358	.562
MEAN RADIUS	:	1.221	1.113	1.054
MAX RADIUS	:	1.892	1.657	1.394
HORIZONTAL SPREAD	:	2.628	1.949	1.949
VERTICAL SPREAD	:	3.033	3.033	2.429
EXTREME SPREAD	:	3.516	3.142	2.564
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		8	

29 Oct 1991

FILE: /PATTERNING/CENTERFIRE_PATT/06685787

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 1

2in = 6

3in = 8

HS = 2.307

VS = 3.055

GS = 3.075

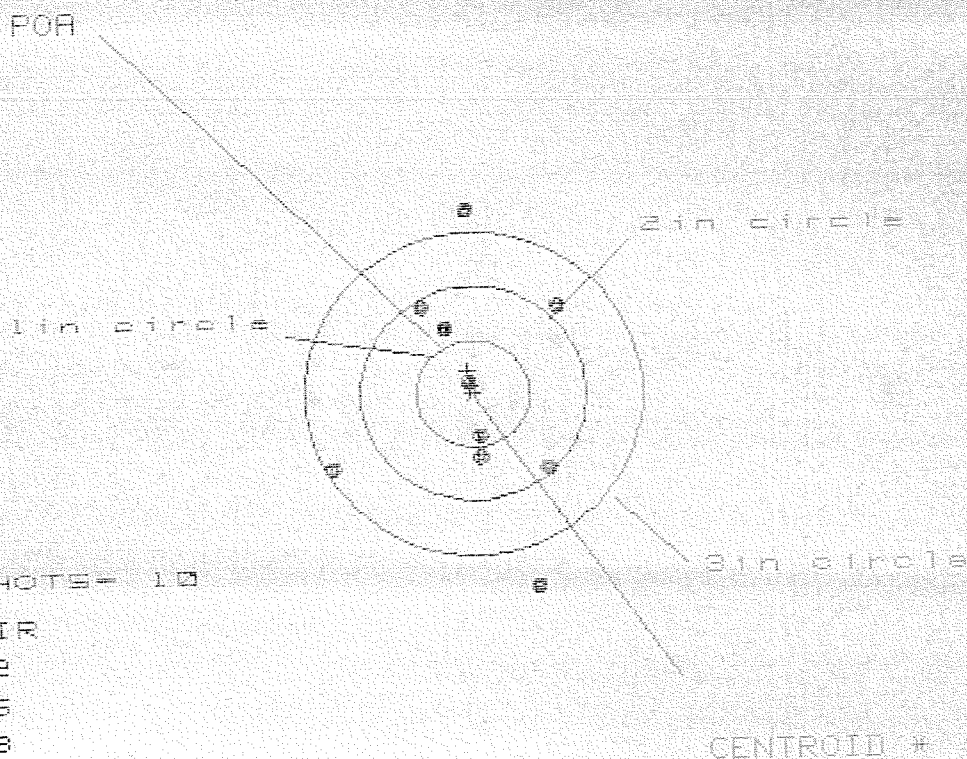
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.863	.920	.912
MINIMUM X	:	-1.444	-1.387	-1.272
MAXIMUM Y	:	1.431	1.250	.695
MINIMUM Y	:	-1.624	-.875	-.718
CENTROID X	:	.119	.062	-.053
CENTROID Y	:	-.020	.161	.004
POA TO CENTROID in.	:	.120	.172	.054
MIN RADIUS	:	.443	.538	.526
MEAN RADIUS	:	1.026	.948	.860
MAX RADIUS	:	1.703	1.552	1.273
HORIZONTAL SPREAD	:	2.307	2.307	2.184
VERTICAL SPREAD	:	3.055	2.125	1.413
EXTREME SPREAD	:	3.075	2.668	2.284
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

29 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8685787

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS= 2.032

VS= 3.551

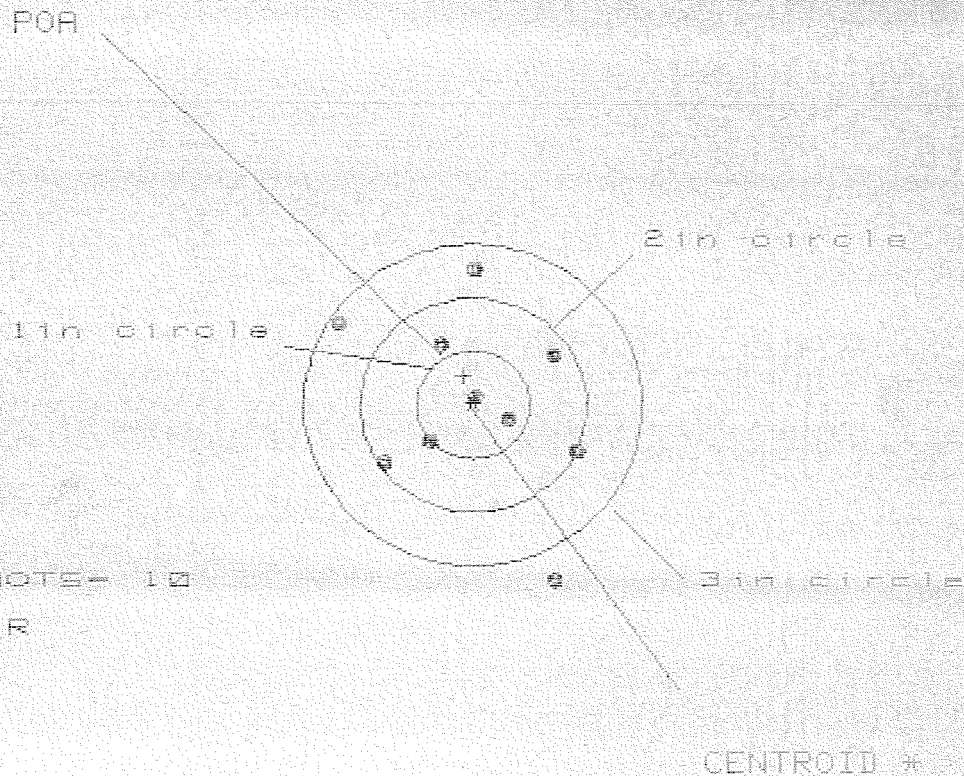
GS= 3.607

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.798	.858	.854
MINIMUM X	:	-1.234	-1.174	-1.178
MAXIMUM Y	:	1.719	1.516	.846
MINIMUM Y	:	-1.832	-.907	-.718
CENTROID X	:	.051	-.009	-.005
CENTROID Y	:	-.213	-.010	-.199
POA TO CENTROID in.	:	.219	.013	.199
MIN RADIUS	:	.153	.082	.117
MEAN RADIUS	:	.995	.881	.788
MAX RADIUS	:	1.909	1.516	1.380
HORIZONTAL SPREAD	:	2.032	2.032	2.032
VERTICAL SPREAD	:	3.551	2.423	1.564
EXTREME SPREAD	:	3.607	2.677	2.564
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

29 Oct 1993

FILE:/PATTERNING/CENTERFIRE_PATT/C6683787

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 2.080

VS= 2.896

GS= 3.043

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.884	.964	.824
MINIMUM X	:	-1.196	-1.116	-.887
MAXIMUM Y	:	1.304	1.127	1.203
MINIMUM Y	:	-1.592	-.753	-.677
CENTROID X	:	.086	.007	.147
CENTROID Y	:	-.268	-.091	-.166
POA TO CENTROID in.	:	.282	.092	.222
MIN RADIUS	:	.058	.153	.065
MEAN RADIUS	:	.890	.798	.713
MAX RADIUS	:	1.744	1.263	1.203
HORIZONTAL SPREAD	:	2.080	2.080	1.711
VERTICAL SPREAD	:	2.896	1.880	1.880
EXTREME SPREAD	:	3.043	2.429	2.072
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			9	

29 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66657B7

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.539

VS= 2.461

GS= 2.638

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.772	.792	.699
MINIMUM X	:	-.767	-.747	-.657
MAXIMUM Y	:	1.023	.864	.495
MINIMUM Y	:	-1.438	-.894	-.787
CENTROID X	:	-.034	-.054	.039
CENTROID Y	:	-.068	.091	-.017
POA TO CENTROID in.	:	.076	.106	.042
MIN RADIUS	:	.056	.155	.037
MEAN RADIUS	:	.698	.625	.533
MAX RADIUS	:	1.449	1.142	.795
HORIZONTAL SPREAD	:	1.539	1.539	1.356
VERTICAL SPREAD	:	2.461	1.758	1.282
EXTREME SPREAD	:	2.638	1.902	1.420
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	