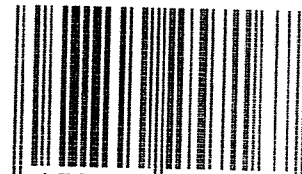


FORM

UPC



0 47700 25716 2

06665803

Remington



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

MODEL 700 TM M24

SERIAL NO.

C6665803

ORDER NO.

5716

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

20



5716 C6665803

ORDER 5716

MODEL 700 TM M24

UPC

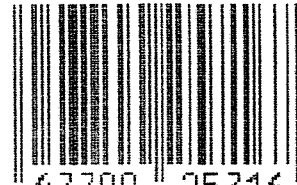
ORDER 5716

MODEL 700 TM M24

UPC



0 47700 25716 7



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6665803

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		9/23/91	KJ
600	Proof		9/23/91	KJ
607	Check Headspace		9/23/91	KJ
610	Dis-assemble Gun		9/23/91	KJ
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	KB
618	Polish Barrel		OCT 2 1991	WB
620	Apply Coatings (Barrel Action)		11-2-91	JS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake		10/9/91	RW

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			10-10-91	AC
	G) Safety Off Force	3	3	3			10-10-91	AC
	H) Trigger Pull Test & Retainability						10/9/91	RW
	I) Firing Pin Indent	.022	.021	.021			10-9-91	AC
	J) Assemble Stock						10/15/91	KA
	K) Assemble Swivel Studs						10-21-91	AC
	L) Attach Front and Rear Sight Assemblies						10/15/91	KA
	M) Iron Sight Alignment						10/15/91	KA
	N) Detach Front & Rear Sights & place in numbered container						10/15/91	KA
	O) Attach Scope to Rifle						10/15/91	KA
	P) Detach & Attach Scope 20 Times						10/15/91	KA
640	Gallery Target & Test						10-16-91	AC
	A) Time						10-16-91	AC
	B) Malfunctions						10-16-91	AC
	C) Pierced Primers						10-16-91	AC
	D) Optical Clarity of Scope						10-16-91	AC
645	Inspect for Live Ammo						10-16-91	AC
655	Final Inspection							
	A) Headspace						10-21-91	AC
	B) Trigger Pull	2.50	2.33	2.47	2.51	2.53	10-16-91	D/H
	C) Function						10-21-91	AC
660	Pack						12-17-91	N

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6665803

DATE 10/9/91

TESTER RW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.31	2.24	2.18	250	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.54	2.20	2.24	233	
PULL #3	2.31	2.22	2.21	247	
PULL #4	2.56	2.23	2.22	251	
PULL #5	2.61	2.23	2.25	253	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.17	3.28		
PULL #2	3.21	3.23		
PULL #3	3.20	3.21		
PULL #4	3.23	3.26		
PULL #5	3.27	3.18		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.11	4.28		4.13
PULL #2	4.02	4.05		4.24
PULL #3	4.09	4.12		4.29
PULL #4	4.05	4.13		4.26
PULL #5	4.02	4.03		4.30
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665803
16 Oct 1991

CENTROIDAL DISTANCES

0 TO	1	.585623
1 TO	2	.757279
1 TO	3	.892624
1 TO	4	1.05287
1 TO	5	1.23673

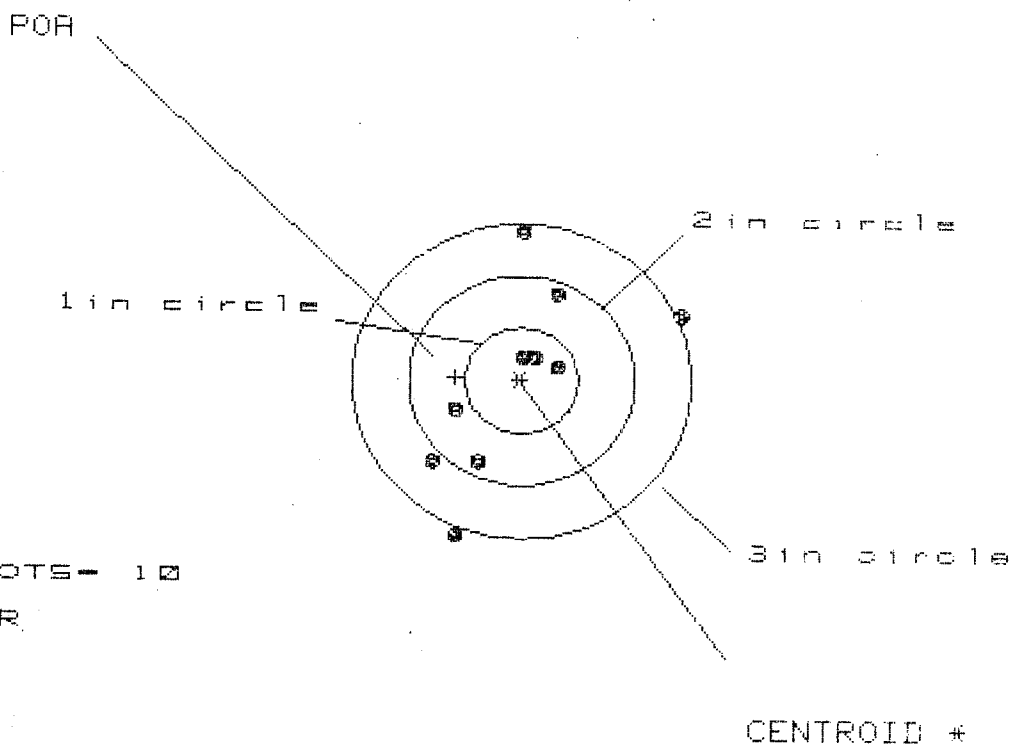
43
5 1 <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1862
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0483
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .192489
THE HMF FOR THIS RIFLE IS: 1.029

16 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06665803

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in - 3

2 in - 6

3 in - 8

HS- 2.190

VS= 2.955

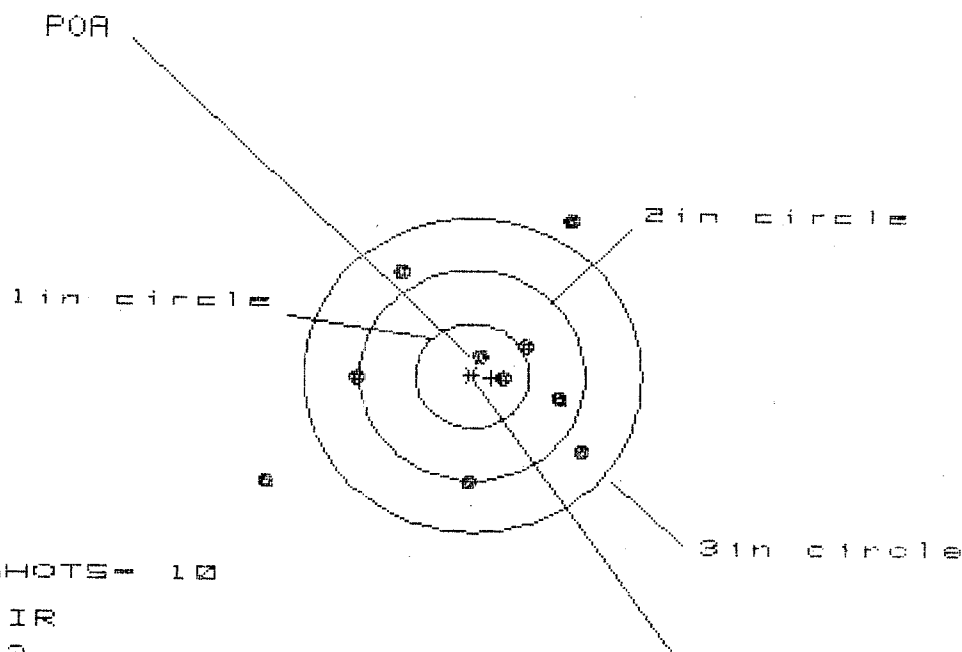
GS= 3.004

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.450	1.388	.441
MINIMUM X	:	-.740	-.802	-.628
MAXIMUM Y	:	1.465	1.299	1.353
MINIMUM Y	:	-1.490	-.985	-.931
CENTROID X	:	.585	.647	.473
CENTROID Y	:	-.027	.139	.085
POA TO CENTROID in.	:	.585	.661	.481
MIN RADIUS	:	.216	.043	.194
MEAN RADIUS	:	.892	.773	.717
MAX RADIUS	:	1.591	1.453	1.357
HORIZONTAL SPREAD	:	2.190	2.190	1.069
VERTICAL SPREAD	:	2.955	2.284	2.284
EXTREME SPREAD	:	3.004	2.607	2.396
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			8	

16 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8665803

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 2.773

VS= 2.570

GS= 3.681

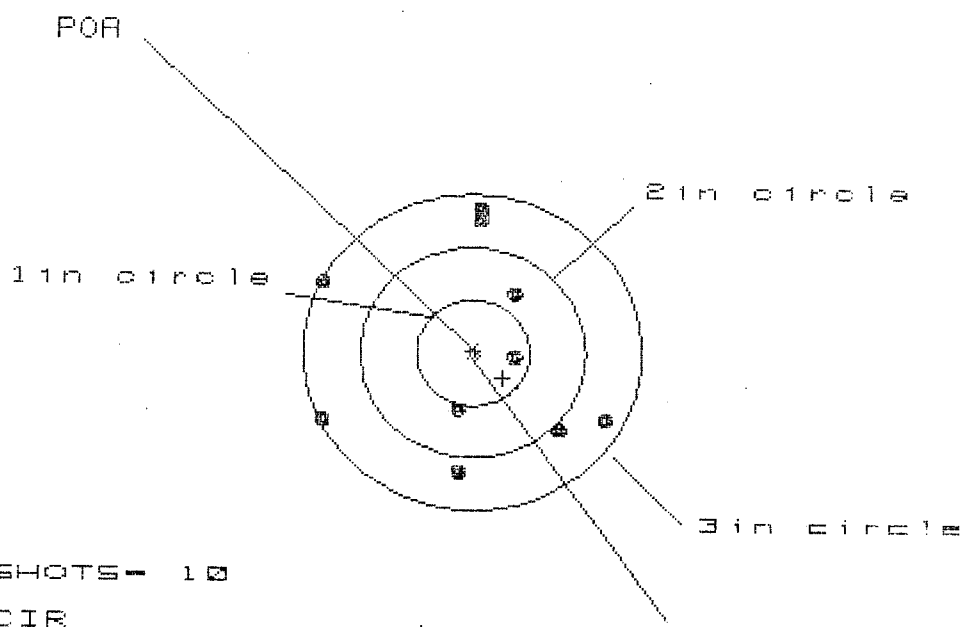
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.994	.797	.883
MINIMUM X	:	-1.779	-1.271	-1.185
MAXIMUM Y	:	1.518	1.405	1.057
MINIMUM Y	:	-1.052	-1.165	-.990
CENTROID X	:	-.171	.026	-.060
CENTROID Y	:	.017	.130	-.045
POA TO CENTROID in.	:	.172	.133	.075
MIN RADIUS	:	.207	.095	.146
MEAN RADIUS	:	1.017	.849	.773
MAX RADIUS	:	2.050	1.565	1.301
HORIZONTAL SPREAD	:	2.773	2.068	2.068
VERTICAL SPREAD	:	2.570	2.570	2.047
EXTREME SPREAD	:	3.681	2.713	2.374
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			4	
NUMBER IN THREE INCH CIRCLE =			8	

16 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06665803

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 3

3 in = 9

HS = 2.543

VS = 2.505

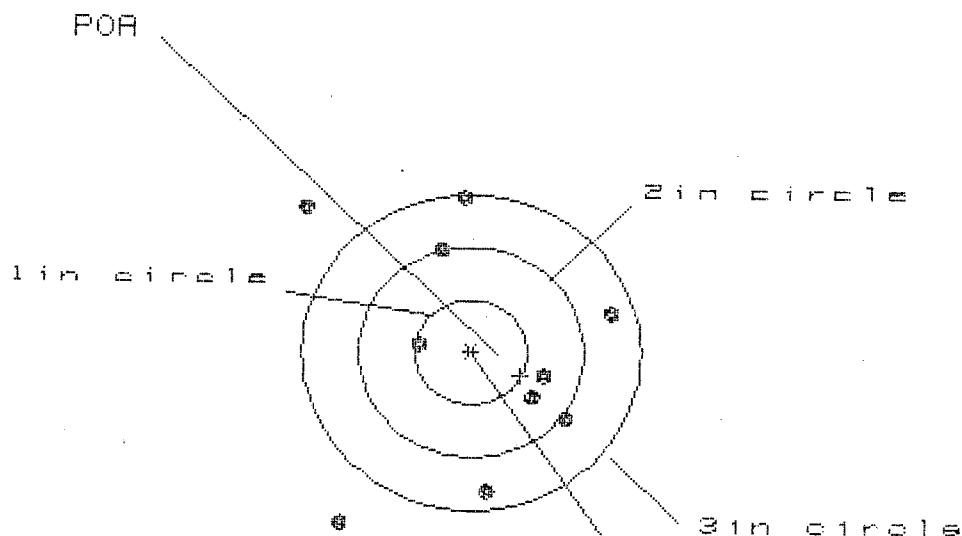
GS = 2.864

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.199	1.050	.864
MINIMUM X	:	-1.344	-1.486	-.480
MAXIMUM Y	:	1.327	1.402	1.330
MINIMUM Y	:	-1.178	-1.103	-1.175
CENTROID X	:	-.268	-.119	.067
CENTROID Y	:	.236	.161	.233
POA TO CENTROID in.	:	.357	.200	.242
MIN RADIUS	:	.409	.257	.088
MEAN RADIUS	:	1.087	1.009	.903
MAX RADIUS	:	1.502	1.593	1.351
HORIZONTAL SPREAD	:	2.543	2.536	1.344
VERTICAL SPREAD	:	2.505	2.505	2.505
EXTREME SPREAD	:	2.864	2.536	2.517
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		9	

16 Oct 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in - 1

2in - 3

3in = 8

HS= 2.685

VS= 3.127

GS= 3.318

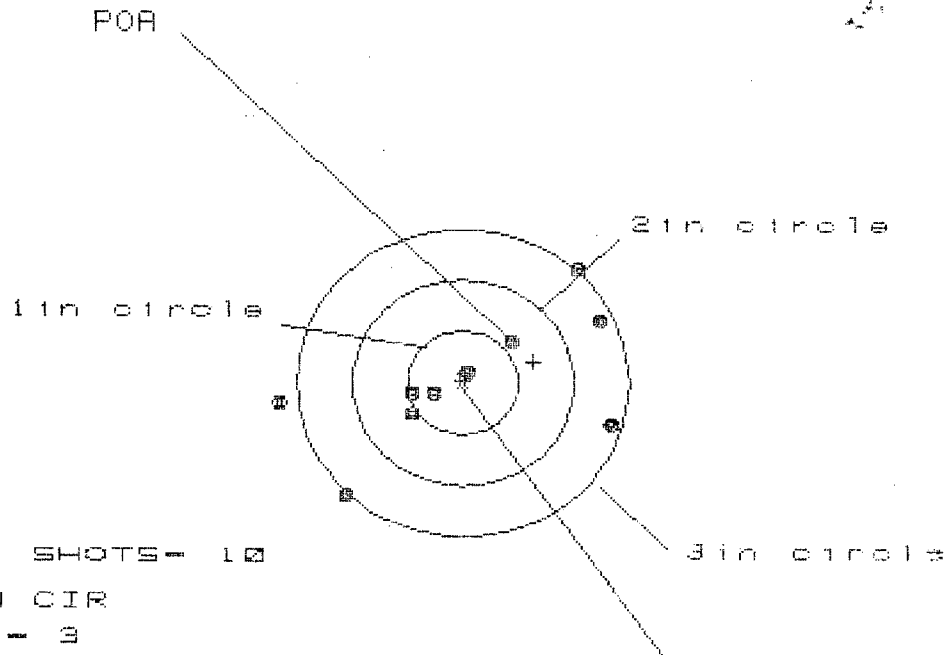
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.204	1.040	.878
MINIMUM X	:	-1.481	-1.290	-.787
MAXIMUM Y	:	1.468	1.620	1.431
MINIMUM Y	:	-1.659	-1.507	-1.386
CENTROID X	:	-.438	-.274	-.112
CENTROID Y	:	.222	.070	.259
POA TO CENTROID in.	:	.491	.283	.282
MIN RADIUS	:	.469	.484	.425
MEAN RADIUS	:	1.203	1.074	.940
MAX RADIUS	:	2.012	1.984	1.471
HORIZONTAL SPREAD	:	2.685	2.330	1.665
VERTICAL SPREAD	:	3.127	3.127	2.817
EXTREME SPREAD	:	3.318	3.318	2.820
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

18 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CG685823

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 8

HS= 2.930

VS= 2.187

GS= 3.029

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.306	1.125	.965
MINIMUM X	-1.624	-1.282	-.849
MAXIMUM Y	1.063	1.045	.902
MINIMUM Y	-1.124	-1.142	-.574
CENTROID X	-.639	-.458	-.290
CENTROID Y	-.204	-.186	-.043
POA TO CENTROID in.	.670	.494	.301
MIN RADIUS	.070	.167	.203
MEAN RADIUS	.945	.888	.791
MAX RADIUS	1.633	1.717	1.122
HORIZONTAL SPREAD	2.930	2.407	1.814
VERTICAL SPREAD	2.187	2.187	1.476
EXTREME SPREAD	3.029	3.029	1.495
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		