

FORM

UPC



0 47700 25716 2

C6665825

*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.
C6665825

ORDER NO.
5716

20

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



5716 C6665825

ORDER **5716**

MODEL 700 TM M24

UPC



0 47700 25716 7

ORDER **5716**

MODEL 700 TM M24

UPC



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6665825

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	8 1991	KR
	Magnaflux Bolt	OCT	8 1991	KR
615	Rollmark Caliber	OCT	8 1991	LS
617	Drill and Tap Sight Holes	OCT	8 1991	LB
618	Polish Barrel		10/15/91	WB
620	Apply Coatings (Barrel Action)		11-8-91	DA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/11/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/11/91	RW
	C) Inspect Ejector Hole for Chamfer		11/11/91	RW
	D) Oil Firing Pin Ass'y		11/11/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11-14-91	JL

op. #	OP. NAME	READINGS				DATE	INIT
625 cont.	F) Safety On Force	4	4	4		11/18/91	SH
	G) Safety Off Force	3	3	3		11/18/91	SH
	H) Trigger Pull Test & Retainability					11-14-91	SH
	I) Firing Pin Indent	.020	.020	.020		11/18/91	SH
	J) Assemble Stock					11/18/91	RW
	K) Assemble Swivel Studs					11-26-91	SH
	L) Attach Front and Rear Sight Assemblies					11/18/91	RW
	M) Iron Sight Alignment					11/18/91	RW
	N) Detach Front & Rear Sights & place in numbered container					11/18/91	RW
	O) Attach Scope to Rifle					11/18/91	RW
	P) Detach & Attach Scope 20 Times					11/18/91	RW
640	Gallery Target & Test					11-20-91	D/H
	A) Time					11-20-91	D/H
	B) Malfunctions					11-20-91	D/H
	C) Pierced Primers					11-20-91	D/H
	D) Optical Clarity of Scope					11-20-91	D/H
645	Inspect for Live Ammo					11-20-91	D/H
655	Final Inspection						
	A) Headspace					11-26-91	SH
	B) Trigger Pull	2.48	2.44	2.47	2.57	2.58	11-20-91 D/H
	C) Function					11-26-91	SH
660	Pack					12-19-91	NF

SWS TRIGGER PULL TEST

7MM 90

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO C-6665825DATE 11-14-91TESTER [Signature]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.34	2.35	2.50	2.48	MIN. SETTING,
PULL #2	2.31	2.38	2.53	2.44	NO AVG. OF 5
PULL #3	2.18	2.40	2.44	2.47	READINGS ACCEPT-
PULL #4	2.30	2.33	2.48	2.57	ABLE LESS THAN 2#
PULL #5	2.21	2.44	2.51	2.58	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES			COMMENTS
PULL #1	3.34	3.25			
PULL #2	3.32	3.20			
PULL #3	3.22	3.18			
PULL #4	3.25	3.29			
PULL #5	3.32	3.19			
TOTAL					
AVG.					

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.59	4.54		4.57
PULL #2	4.53	4.47		4.38
PULL #3	4.43	4.58		4.29
PULL #4	4.49	4.47		4.60
PULL #5	4.51	4.35		4.56
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06665825
20 Nov 1991

CENTROIDAL DISTANCES

0 TO	1	.225144
1 TO	2	.470562
1 TO	3	.311006
1 TO	4	.775645
1 TO	5	.228267

$\frac{4}{23}$ <----POA
2

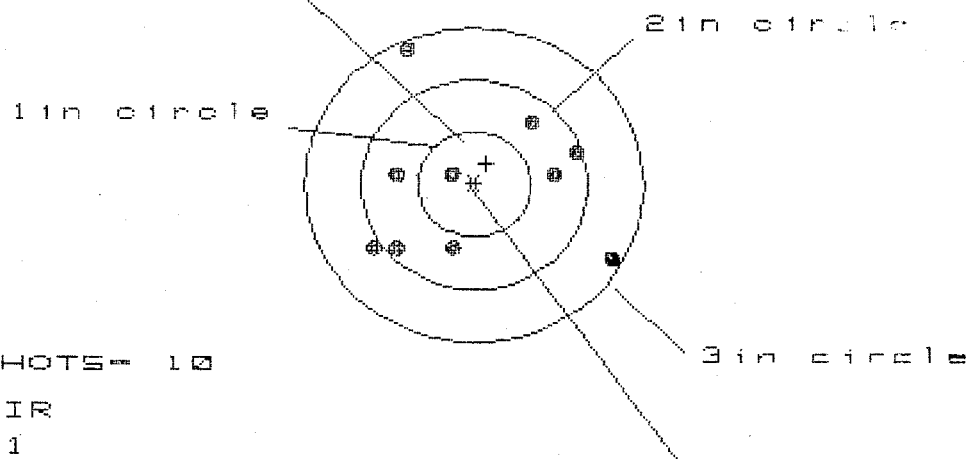
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1344
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1358
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .191063
THE AMR FOR THIS RIFLE IS: .9164

28 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665825

CENTERFIRE PATTERNS

POA



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 10

HS= 2.112

VS= 2.011

GS= 2.708

CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.196	1.127	.973
MINIMUM X	:	-.923	-.991	-.850
MAXIMUM Y	:	1.283	.702	.629
MINIMUM Y	:	-.728	-.585	-.542
CENTROID X	:	-.109	-.041	-.182
CENTROID Y	:	-.197	-.340	-.267
POA TO CENTROID in.	:	.226	.342	.323
MIN RADIUS	:	.210	.354	.210
MEAN RADIUS	:	.879	.820	.738
MAX RADIUS	:	1.424	1.270	1.054
HORIZONTAL SPREAD	:	2.118	2.118	1.823
VERTICAL SPREAD	:	2.011	1.287	1.171
EXTREME SPREAD	:	2.708	2.121	2.054
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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FILE:/PATTERNING/CENTERFIRE_PATT/C6665825

CENTERFIRE PATTERNS

2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS= 2.261

VS= 2.946

GS= 3.082

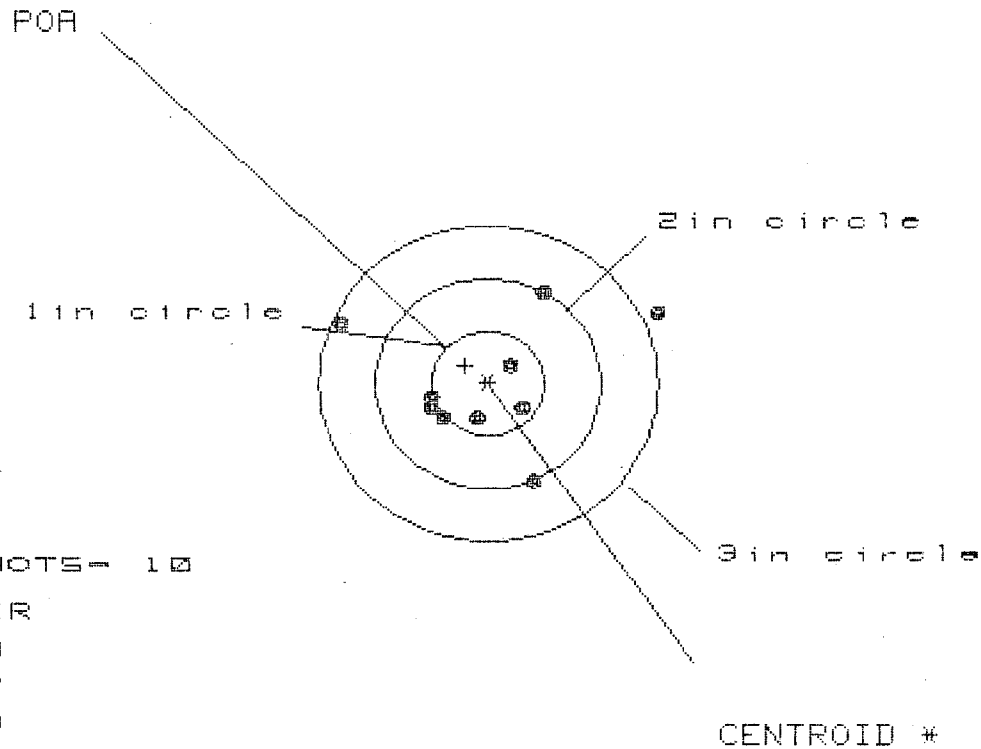
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.887	.942	.777
MINIMUM X	:	-1.373	-1.319	-1.218
MAXIMUM Y	:	1.292	1.108	1.122
MINIMUM Y	:	-1.654	-1.340	-1.326
CENTROID X	:	.093	.038	.203
CENTROID Y	:	-.622	-.438	-.452
POA TO CENTROID in.	:	.629	.440	.495
MIN RADIUS	:	.247	.131	.294
MEAN RADIUS	:	.999	.887	.812
MAX RADIUS	:	1.724	1.433	1.370
HORIZONTAL SPREAD	:	2.261	2.261	1.995
VERTICAL SPREAD	:	2.946	2.448	2.448
EXTREME SPREAD	:	3.082	2.599	2.599
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			9	

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS = 2.719

VS = 1.783

GS = 2.720

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.461	.634	.498
MINIMUM X	:	-1.258	-1.096	-.499
MAXIMUM Y	:	.833	.908	.995
MINIMUM Y	:	-.950	-.875	-.788
CENTROID X	:	.201	.039	.175
CENTROID Y	:	-.172	-.247	-.334
POA TO CENTROID in.	:	.264	.250	.377
MIN RADIUS	:	.266	.280	.216
MEAN RADIUS	:	.771	.646	.552
MAX RADIUS	:	1.610	1.296	1.112
HORIZONTAL SPREAD	:	2.719	1.730	.997
VERTICAL SPREAD	:	1.783	1.783	1.783
EXTREME SPREAD	:	2.720	2.277	1.785
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			9	

20 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665825

CENTERFIRE PATTERNS

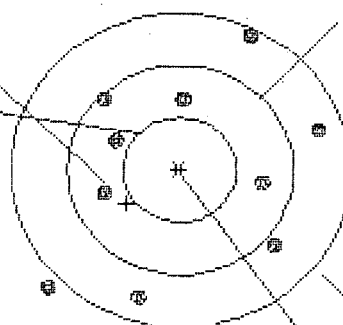
4

POA

1 in circle

2 in circle

3 in circle



CENTROID *

OF SHOTS- 10

IN CIR

1 in = 0

2 in = 5

3 in = 9

HS= 2.310

VS= 2.543

GS= 2.967

PATTERN #

4

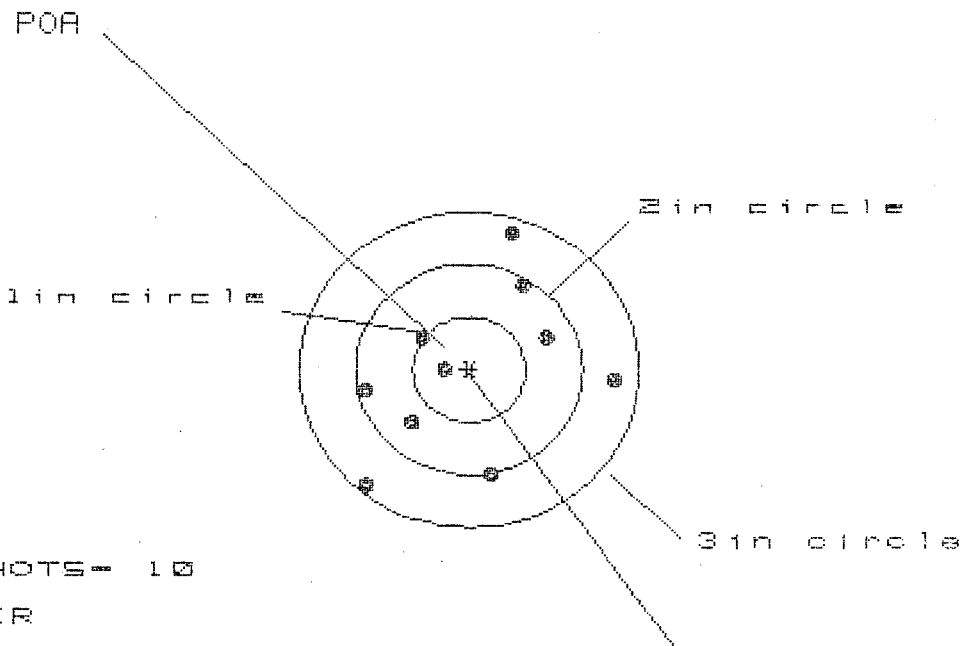
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.179	1.053	1.111
MINIMUM X	-1.131	-0.786	-0.728
MAXIMUM Y	1.294	1.170	0.727
MINIMUM Y	-1.249	-1.373	-1.227
CENTROID X	.471	.597	.539
CENTROID Y	.318	.442	.296
POA TO CENTROID in.	.568	.743	.615
MIN RADIUS	.591	.589	.661
MEAN RADIUS	1.029	.952	.912
MAX RADIUS	1.594	1.474	1.317
HORIZONTAL SPREAD	2.310	1.839	1.839
VERTICAL SPREAD	2.543	2.543	1.954
EXTREME SPREAD	2.967	2.732	2.289
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

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FILE:/PATTERNING/CENTERFIRE_PATT/08685825

CENTERFIRE PATTERNS

5



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 2.228

VS= 2.394

GS= 2.709

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.298	1.194	1.223
MINIMUM X	:	-.938	-.986	-.957
MAXIMUM Y	:	1.350	1.234	.867
MINIMUM Y	:	-1.044	-1.123	-.968
CENTROID X	:	.016	.120	.091
CENTROID Y	:	-.006	.110	-.045
POA TO CENTROID in.	:	.018	.162	.101
MIN RADIUS	:	.207	.334	.282
MEAN RADIUS	:	.904	.853	.791
MAX RADIUS	:	1.398	1.256	1.224
HORIZONTAL SPREAD	:	2.228	2.180	2.180
VERTICAL SPREAD	:	2.394	2.357	1.835
EXTREME SPREAD	:	2.709	2.365	2.182
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	