

FORM

UPC



0 47700 25716 7

C6665827

*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 700TM M24

SERIAL NO.
C6665827

20

ORDER NO.
5716

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



5716 C6665827

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 #

C6665827

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

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			10/14/91	RL
	G) Safety Off Force	3	3	3			10/14/91	RL
	H) Trigger Pull Test & Retainability						10/11/91	RL
	I) Firing Pin Indent	.020	.020	.021			10/14/91	RL
	J) Assemble Stock						10/16/91	RL
	K) Assemble Swivel Studs						10-22-91	AC
	L) Attach Front and Rear Sight Assemblies						10/14/91	RL
	M) Iron Sight Alignment						10/16/91	RL
	N) Detach Front & Rear Sights & place in numbered container						10/16/91	RL
	O) Attach Scope to Rifle						10/16/91	RL
	P) Detach & Attach Scope 20 Times						10/16/91	RL
640	Gallery Target & Test						10-18-91	DH
	A) Time						10-18-91	DH
	B) Malfunctions						10-18-91	DH
	C) Pierced Primers						10-18-91	DH
	D) Optical Clarity of Scope						10-18-91	DH
645	Inspect for Live Ammo						10-18-91	DH
655	Final Inspection							
	A) Headspace						10-22-91	AC
	B) Trigger Pull	259	274	276	271	277	10-22-91	DH
	C) Function						10-22-91	AC
660	Pack						12-17-91	AF

Handle
slot

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C-6665827

DATE 10/11/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.26	2.41	2.40	259	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.17	2.39	2.50	274	
PULL #3	2.21	2.37	2.45	276	
PULL #4	2.51	2.41	2.40	271	
PULL #5	2.21	2.45	2.43	277	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.56	3.62		
PULL #2	3.65	3.69		
PULL #3	3.65	3.55		
PULL #4	3.28	3.68		
PULL #5	3.67	3.63		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.37	4.30		4.46
PULL #2	4.25	4.31		4.40
PULL #3	4.38	4.44		4.33
PULL #4	4.33	4.40		4.40
PULL #5	4.42	4.41		4.41
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665827
18 Oct 1991

CENTROIDAL DISTANCES

0 TO	1	.149084
1 TO	2	.113952
1 TO	3	.12839
1 TO	4	.494426
1 TO	5	.83961

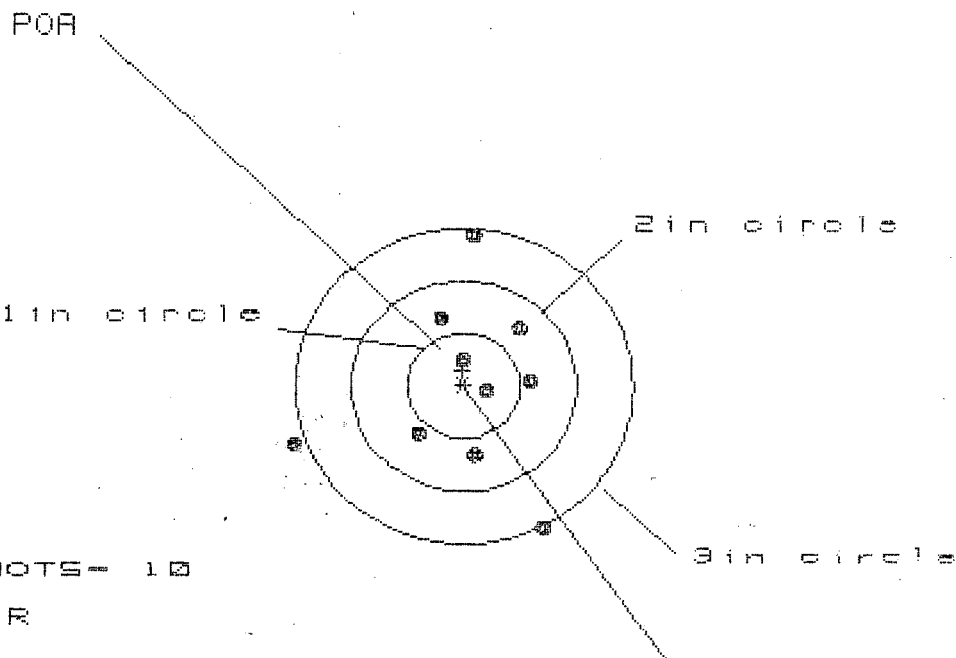
54 3 <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2452
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2042
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .019894
THE AMR FOR THIS RIFLE IS: .9208

18 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665827

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 2.161

VS= 2.783

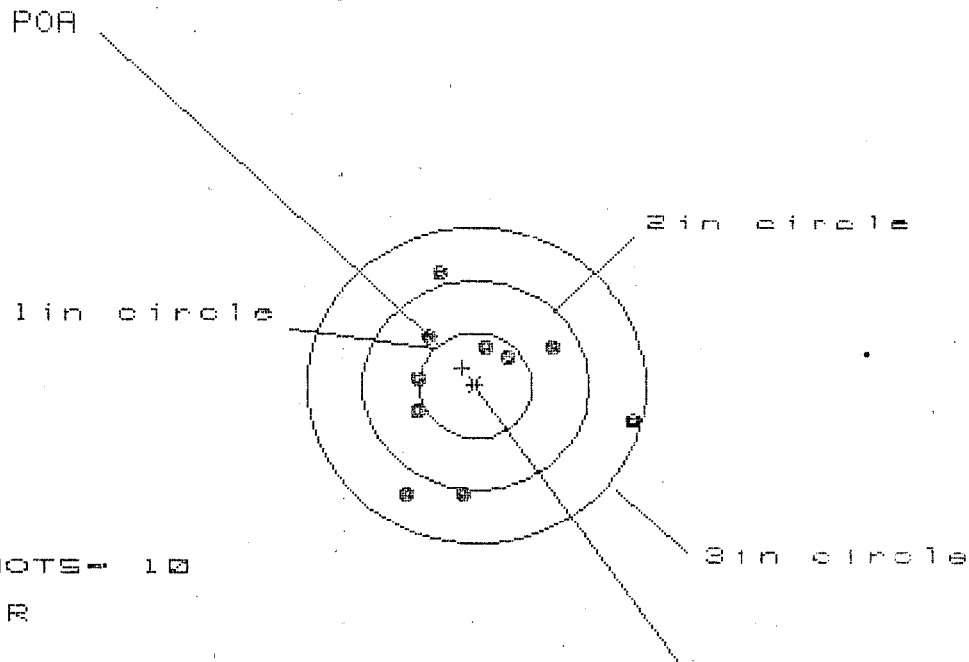
GS= 2.840

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.657	.490	.480
MINIMUM X	:	-1.504	-.590	-.600
MAXIMUM Y	:	1.474	1.408	.796
MINIMUM Y	:	-1.309	-1.375	-1.199
CENTROID X	:	.005	.172	.182
CENTROID Y	:	-.149	-.083	-.259
POA TO CENTROID in.	:	.149	.191	.316
MIN RADIUS	:	.174	.098	.078
MEAN RADIUS	:	.851	.740	.659
MAX RADIUS	:	1.619	1.460	1.292
HORIZONTAL SPREAD	:	2.161	1.080	1.080
VERTICAL SPREAD	:	2.783	2.783	1.995
EXTREME SPREAD	:	2.840	2.840	2.177
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 6

3 in = 10

HS = 2.0009

VS = 2.054

GS = 2.180

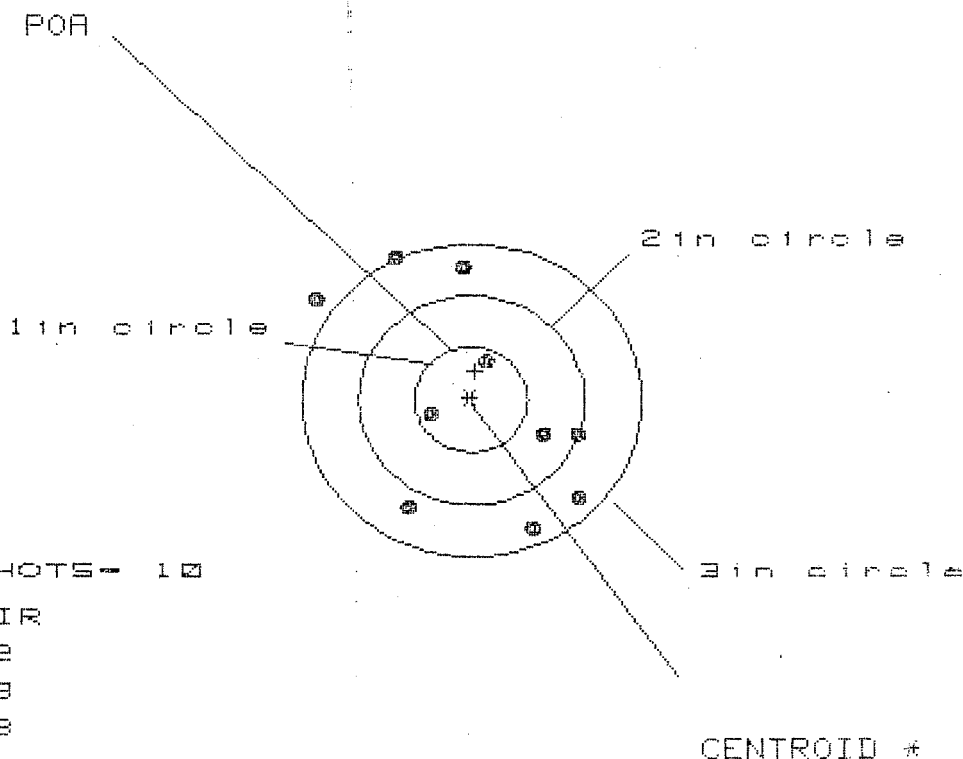
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.382	.825	.766
MINIMUM X	:	-.627	-.473	-.462
MAXIMUM Y	:	1.055	1.016	.886
MINIMUM Y	:	-.999	-1.038	-1.167
CENTROID X	:	.117	-.037	.022
CENTROID Y	:	-.170	-.131	-.001
POA TO CENTROID in.	:	.206	.136	.022
MIN RADIUS	:	.388	.329	.271
MEAN RADIUS	:	.798	.706	.628
MAX RADIUS	:	1.426	1.136	1.168
HORIZONTAL SPREAD	:	2.009	1.298	1.228
VERTICAL SPREAD	:	2.054	2.054	2.054
EXTREME SPREAD	:	2.180	2.078	2.061
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 3

3in = 8

HS= 2.368

VS= 2.670

GS= 2.931

PATTERN #

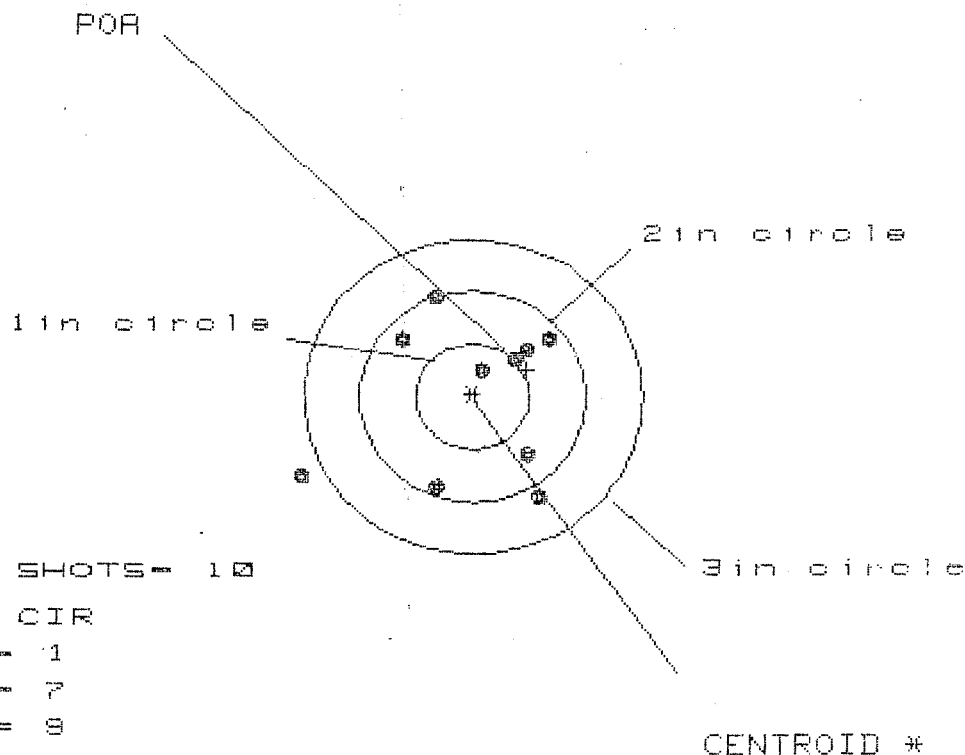
3

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.981	.826	.728
MINIMUM X	-1.387	-.787	-.842
MAXIMUM Y	1.396	1.499	1.581
MINIMUM Y	-1.274	-1.171	-.984
CENTROID X	-.035	.120	.218
CENTROID Y	-.271	-.374	-.561
POA TO CENTROID in.	.273	.393	.602
MIN RADIUS	.368	.451	.343
MEAN RADIUS	1.078	.991	.874
MAX RADIUS	1.667	1.693	1.618
HORIZONTAL SPREAD	2.368	1.613	1.570
VERTICAL SPREAD	2.670	2.670	2.565
EXTREME SPREAD	2.931	2.897	2.630
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1in = 1

2in = 7

3in = 9

HS= 2.166

VS= 1.960

GS= 2.523

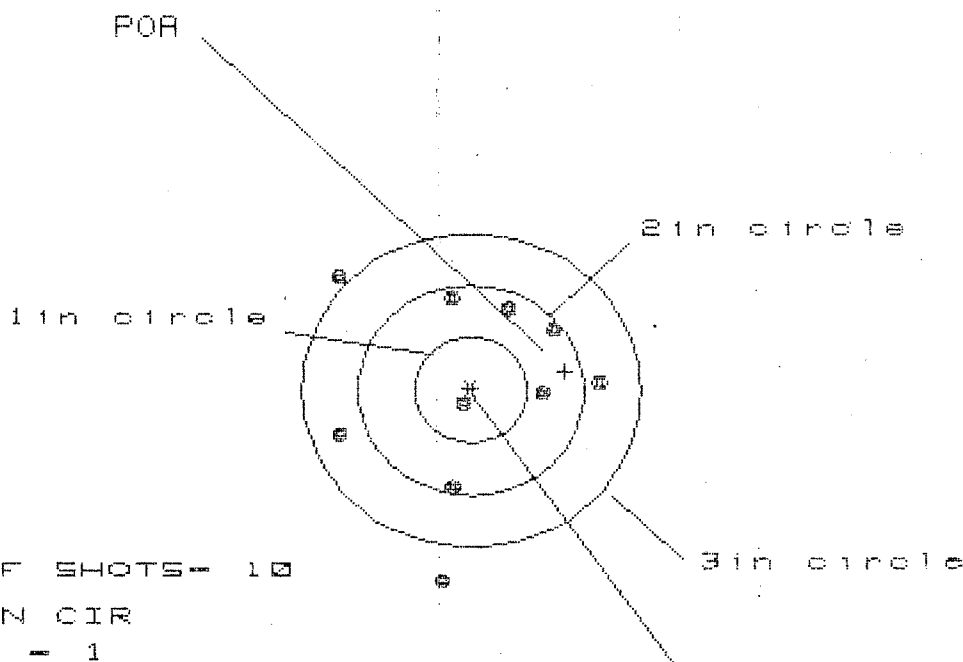
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.662	.495	.549
MINIMUM X	:	-1.504	-.789	-.735
MAXIMUM Y	:	.976	.892	.758
MINIMUM Y	:	-.984	-1.068	-1.071
CENTROID X	:	-.479	-.312	-.366
CENTROID Y	:	-.250	-.166	-.032
POA TO CENTROID in.	:	.540	.353	.367
MIN RADIUS	:	.285	.197	.053
MEAN RADIUS	:	.867	.728	.640
MAX RADIUS	:	1.685	1.152	1.152
HORIZONTAL SPREAD	:	2.166	1.284	1.284
VERTICAL SPREAD	:	1.960	1.960	1.829
EXTREME SPREAD	:	2.523	2.166	1.829
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 8

HS= 2.209

VS= 2.928

GS= 3.043

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	6
MAXIMUM X	:	1.091	1.059	.915
MINIMUM X	:	-1.118	-1.150	-1.294
MAXIMUM Y	:	1.098	.894	.776
MINIMUM Y	:	-1.030	-1.142	-1.030
CENTROID X	:	-.834	-.802	-.658
CENTROID Y	:	-.181	.023	-.089
POA TO CENTROID in.	:	.854	.802	.664
MIN RADIUS	:	.107	.312	.284
MEAN RADIUS	:	1.010	.902	.808
MAX RADIUS	:	1.053	1.457	1.406
HORIZONTAL SPREAD	:	2.209	2.209	2.209
VERTICAL SPREAD	:	2.928	2.036	1.806
EXTREME SPREAD	:	3.043	2.448	2.266
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			8	