

FORN

UPC



0 47700 25716 7

C6665836

*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™ M24

SERIAL NO.

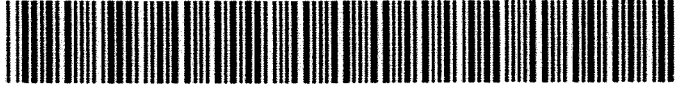
C6665836

ORDER NO.

5716

20

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



5716 C6665836

ORDER 5716

MODEL 700™ M24

UPC



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ORDER 5716

MODEL 700™ M24

UPC



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6665836

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	9/25/91	KL
600	Proof		9/25/91	KL
607	Check Headspace		9/25/91	KL
610	Dis-assemble Gun		9/25/91	KL
612	Magnaflux Barrel Action		OCT 2 1991	KR
	Magnaflux Bolt		OCT 2 1991	KR
615	Rollmark Caliber		OCT 2 1991	JS
617	Drill and Tap Sight Holes		OCT 2 1991	KB
618	Polish Barrel		OCT 4 1991	WB
620	Apply Coatings (Barrel Action)		10-14-91	QA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/31/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/31/91	KL
	C) Inspect Ejector Hole for Chamfer		10/31/91	KL
	D) Oil Firing Pin Ass'y		10/31/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		11-1-91	KL

op. #	OP. NAME	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	4	4	4	11-1-91	JU		
	G) Safety Off Force	3	3	3	11-1-91	JU		
	H) Trigger Pull Test & Retainability				11-1-91	JU		
	I) Firing Pin Indent	.0205	.020	.0205	11-1-91	JU		
	J) Assemble Stock				11/1/91	JU		
	K) Assemble Swivel Studs				11-12-91	AC		
	L) Attach Front and Rear Sight Assemblies				11/1/91	JU		
	M) Iron Sight Alignment				11/1/91	JU		
	N) Detach Front & Rear Sights & place in numbered container				11/1/91	JU		
	O) Attach Scope to Rifle				11/1/91	JU		
	P) Detach & Attach Scope 20 Times				11/1/91	JU		
640	Gallery Target & Test				11-4-91	DH		
	A) Time				11-4-91	DH		
	B) Malfunctions				11-4-91	DH		
	C) Pierced Primers				11-4-91	DH		
	D) Optical Clarity of Scope				11-4-91	DH		
645	Inspect for Live Ammo				11-4-91	DH		
655	Final Inspection							
	A) Headspace				11-12-91	AC		
	B) Trigger Pull	231	215	210	212	228	11-6-91	DH
	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-6665836

DATE 10/1/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.66	2.29	2.22	2.31	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.51	2.41	2.33	2.15	
PULL #3	2.50	2.36	2.48	2.10	
PULL #4	2.36	2.45	2.31	2.12	
PULL #5	2.55	2.18	2.25	2.28	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.22	3.69		
PULL #2	3.58	3.66		
PULL #3	3.59	3.67		
PULL #4	3.61	3.55		
PULL #5	3.48	3.38		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.24	4.26		4.35
PULL #2	4.25	4.33		4.30
PULL #3	4.23	4.28		4.39
PULL #4	4.32	4.36		4.32
PULL #5	4.28	4.33		4.40
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665836
5 Nov 1991

CENTROIDAL DISTANCES

0 TO	1	.383005
1 TO	2	.50908
1 TO	3	.501209
1 TO	4	.60945
1 TO	5	.511489

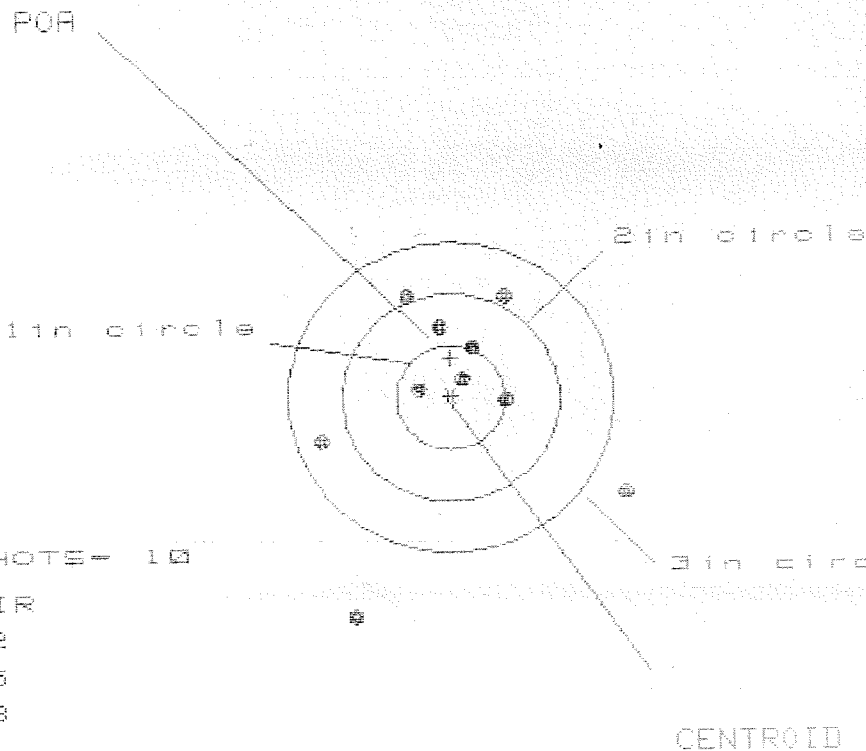
←----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .023
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0356
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0423835
THE AMR FOR THIS RIFLE IS: .0034

4 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06685836

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.769

VS= 3.145

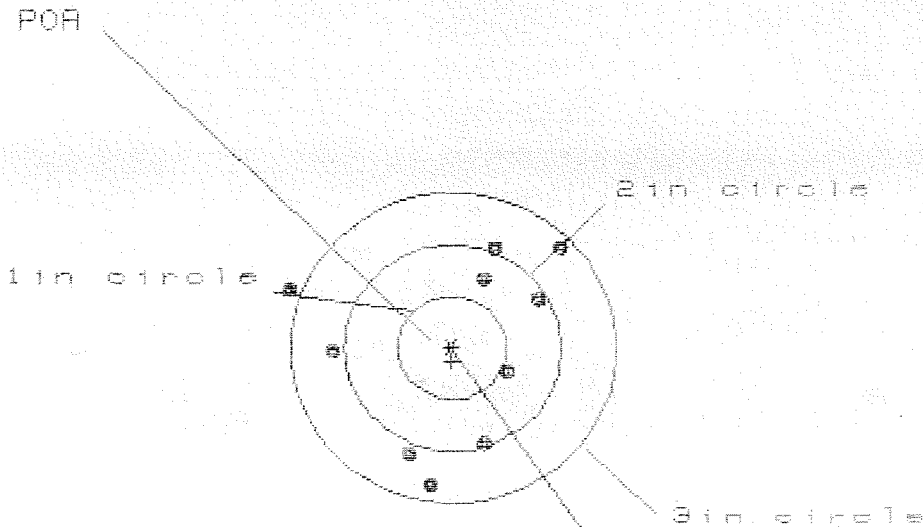
GS= 3.458

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.584	1.483	.693
MINIMUM X	:	-1.185	-1.286	-1.101
MAXIMUM Y	:	.982	.742	.602
MINIMUM Y	:	-2.163	-1.118	-.791
CENTROID X	:	-.002	.099	-.086
CENTROID Y	:	-.383	-.143	-.003
POA TO CENTROID in.	:	.383	.174	.086
MIN RADIUS	:	.177	.087	.251
MEAN RADIUS	:	.987	.763	.609
MAX RADIUS	:	2.346	1.857	1.355
HORIZONTAL SPREAD	:	2.769	2.769	1.734
VERTICAL SPREAD	:	3.145	1.860	1.393
EXTREME SPREAD	:	3.458	2.808	2.209
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

4 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6865836

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 0

2in = 3

3in = 9

HS= 2.492

VS= 2.230

GS= 2.522

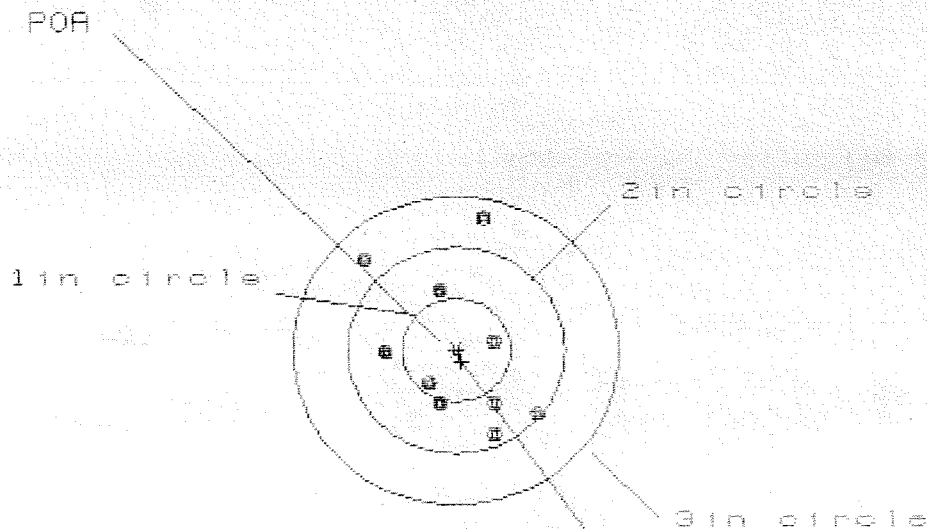
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.956	.785	.679
MINIMUM X	:	-1.536	-1.286	-1.188
MAXIMUM Y	:	.937	.997	1.126
MINIMUM Y	:	-1.293	-1.233	-1.110
CENTROID X	:	.007	.178	.080
CENTROID Y	:	.126	.066	-.057
POA TO CENTROID in.	:	.126	.190	.098
MIN RADIUS	:	.567	.387	.450
MEAN RADIUS	:	1.074	.983	.950
MAX RADIUS	:	1.627	1.297	1.197
HORIZONTAL SPREAD	:	2.492	2.071	1.867
VERTICAL SPREAD	:	2.230	2.230	2.230
EXTREME SPREAD	:	2.522	2.517	2.320
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		9	

4 Nov 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.571

VS= 2.079

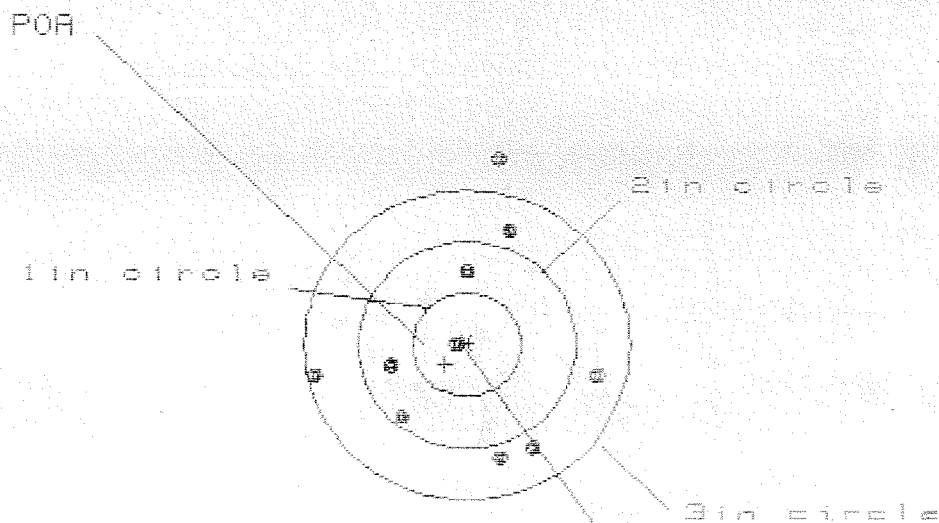
GS= 2.174

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.766	.790	.692
MINIMUM X	:	-.804	-.781	-.757
MAXIMUM Y	:	1.245	1.020	.821
MINIMUM Y	:	-.834	-.696	-.568
CENTROID X	:	-.049	-.072	.026
CENTROID Y	:	.116	-.022	-.150
POA TO CENTROID in.	:	.126	.075	.152
MIN RADIUS	:	.348	.274	.275
MEAN RADIUS	:	.742	.657	.551
MAX RADIUS	:	1.263	1.285	.851
HORIZONTAL SPREAD	:	1.571	1.571	1.449
VERTICAL SPREAD	:	2.079	1.716	1.389
EXTREME SPREAD	:	2.174	2.174	1.559
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

4 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/00605036

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 9

HS= 2.536

VS= 2.912

GS= 2.913

CENTROID *

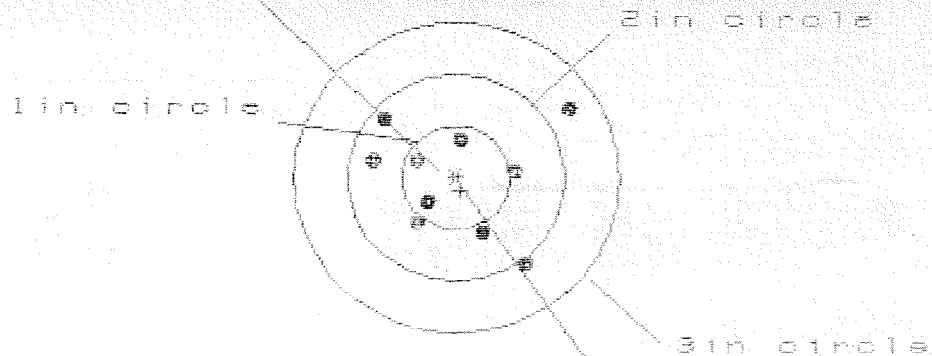
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.170	1.205	1.038
MINIMUM X	:	-1.366	-1.331	-1.788
MAXIMUM Y	:	1.799	1.287	1.274
MINIMUM Y	:	-1.113	-1.913	-1.926
CENTROID X	:	.200	.165	.332
CENTROID Y	:	.192	-.003	.005
POA TO CENTROID in.	:	.277	.166	.332
MIN RADIUS	:	.052	.208	.268
MEAN RADIUS	:	1.032	.937	.892
MAX RADIUS	:	1.826	1.344	1.293
HORIZONTAL SPREAD	:	2.536	2.536	1.826
VERTICAL SPREAD	:	2.912	2.200	2.200
EXTREME SPREAD	:	2.913	2.536	2.202
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			4	
NUMBER IN THREE INCH CIRCLE =			9	

4 Nov 1991

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CENTERFIRE PATTERNS # 5

POA



OF SHOTS= 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.843

VS= 1.426

GS= 1.910

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.085	.735	.778
MINIMUM X	:	-.758	-.637	-.545
MAXIMUM Y	:	.627	.650	.559
MINIMUM Y	:	-.799	-.730	-.563
CENTROID X	:	-.041	-.161	-.253
CENTROID Y	:	.127	.058	.149
POA TO CENTROID in.	:	.134	.171	.294
MIN RADIUS	:	.388	.246	.234
MEAN RADIUS	:	.682	.594	.522
MAX RADIUS	:	1.253	1.036	.778
HORIZONTAL SPREAD	:	1.843	1.372	1.323
VERTICAL SPREAD	:	1.426	1.380	1.122
EXTREME SPREAD	:	1.910	1.910	1.437
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	