

FORM

UPC



0 47700 25716 7

66665859

CAPACITY*
*INCLUDES 1 IN CHAMBER

Remington



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

MODEL 700TM M24

SERIAL NO.

C6665859

ORDER NO.

5716

20

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



5716 C6665859

ORDER 5716

MODEL 700TM M24

UPC

ORDER 5716

MODEL 700TM M24

UPC



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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6665859

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		9/26/91	KH
600	Proof		9/26/91	KH
607	Check Headspace		9/26/91	KH
610	Dis-assemble Gun		9/26/91	KH
612	Magnaflux Barrel Action	OCT	4 1991	KCH
	Magnaflux Bolt	OCT	4 1991	KCH
615	Rollmark Caliber	OCT	4 1991	CS
617	Drill and Tap Sight Holes	OCT	4 1991	FB
618	Polish Barrel	OCT	4 1991	CSB
620	Apply Coatings (Barrel Action)		10-18-91	DA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/7/91	KH
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/7/91	KH
	C) Inspect Ejector Hole for Chamfer		11/7/91	KH
	D) Oil Firing Pin Ass'y		11/7/91	KH
	E) Adjust Trigger Pull to Min Setting and Stake		11-8-91	KH

Op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5 1/4			11/8/91	KS
	G) Safety Off Force	2 1/2	2 3/4	2 1/2			11/8/91	KS
	H) Trigger Pull Test & Retainability						11-8-91	SL
	I) Firing Pin Indent	.021	.0215	.0205			11-8-91	KS
	J) Assemble Stock						11/8/91	KS
	K) Assemble Swivel Studs						11-8-91	D/H
	L) Attach Front and Rear Sight Assemblies						11/8/91	KS
	M) Iron Sight Alignment						11/8/91	KS
	N) Detach Front & Rear Sights & place in numbered container						11/8/91	KS
	O) Attach Scope to Rifle						11/8/91	KS
	P) Detach & Attach Scope 20 Times						11/8/91	KS
640	Gallery Target & Test						11/13/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						11/13/91	KT
655	Final Inspection							
	A) Headspace						11-18-91	D/H
	B) Trigger Pull	260	256	258	261	262	11-18-91	D/H
	C) Function						11-18-91	D/H
660	Pack						12-19-91	N

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6665859

DATE 11-8-91

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.39	2.40	260	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.30	2.25	2.44	256	
PULL #3	2.38	2.30	2.39	258	
PULL #4	2.38	2.39	2.35	261	
PULL #5	2.27	2.37	2.37	262	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.48	3.23		
PULL #2	3.68	3.55		
PULL #3	3.60	3.56		
PULL #4	3.28	3.30		
PULL #5	3.64	3.30		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.34	4.55		4.57
PULL #2	4.53	4.59		4.37
PULL #3	4.32	4.61		4.60
PULL #4	4.56	4.30		4.59
PULL #5	4.55	4.60		4.61
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665859
13 Nov 1991

CENTROIDAL DISTANCES

0 TO	1	.104307
1 TO	2	.114039
1 TO	3	.119331
1 TO	4	.276355
1 TO	5	.399531

1000

<----POR

.0472

.0472

.0473984

13 Nov 1991

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CENTERFIRE PATTERNS # 1

FOR

1 in circle

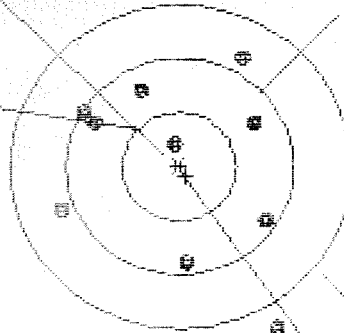
2 in circle

3 in circle

OF SHOTS- 10

IN CIR

CENTROID #



CENTROID #

12

9

8

1.011

.849

.924

1.011

-.932

-.851

1.007

.642

.627

1.007

-1.010

-.905

1.011

-.182

-.233

1.011

.258

.150

1.011

.236

.277

1.011

.182

.221

1.011

.731

.770

1.011

1.089

1.081

1.011

1.775

1.775

1.011

1.852

1.531

1.011

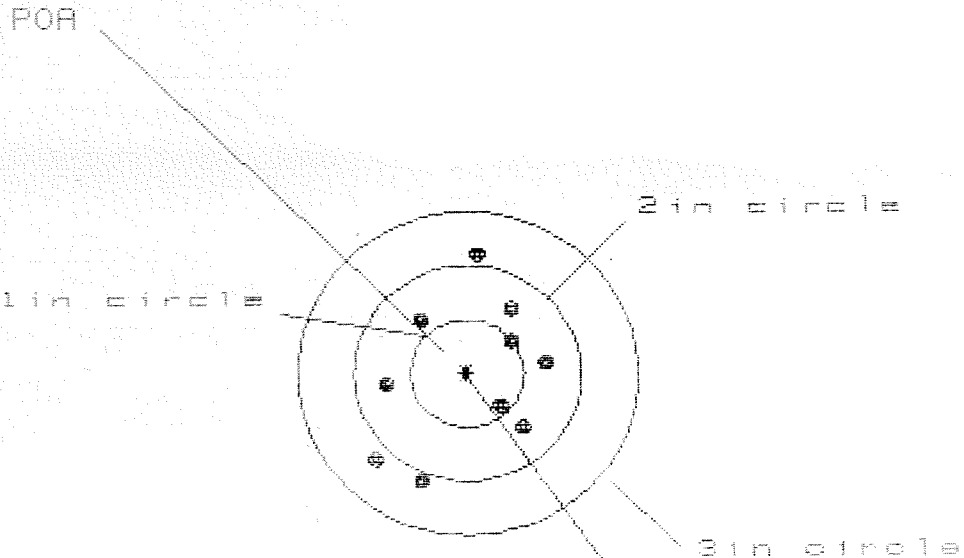
1.115

1.868

13 Nov 1991

FILE: PATTERNING/CENTERFIRE_PATT/C8885353.1

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 10

MEAN = 0.458

STD = 0.114

ERR = 0.160

CENTROID #

PATTERN #

2

SHOTS - 300 OF 300	10	9	8
MAXIMUM	.699	.696	.599
MINIMUM	-.786	-.779	-.761
MAXIMUM	.143	.764	.682
MINIMUM	-.872	-.845	-.927
CENTROID	.619	.603	.100
CENTROID	.006	-.132	-.050
POA (CL) (AVG)	.011	.132	.112
410 (AVG)	.360	.280	.267
MEAN RADIAL	.780	.712	.652
MAX RADIAL	1.144	1.016	1.042
HORIZONTAL (AVG)	1.475	1.475	1.360
VERTICAL (AVG)	2.114	1.609	1.609
EXTREMES (SPREAD)	2.160	1.832	1.780
NUMBER OF SHOTS IN 1IN CIRCLE =		1	
NUMBER OF SHOTS IN 2IN CIRCLE =		7	
NUMBER OF SHOTS IN 3IN CIRCLE =		10	

13 Nov 1991

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CENTERFIRE PATTERNS # 3

POR

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 3

2in = 6

3in = 9

HS= 1.974

VS= 2.600

CS= 2.037

CENTROID *

PATTERN #

3

SHOTS (BEST OF)	10	9	8
MAXIMUM	.626	.476	.485
MINIMUM	-1.349	-.394	-.385
MAXIMUM	1.161	1.001	.975
MINIMUM	-1.439	-1.168	-1.043
CENTROID	.060	.289	.200
CENTROID	.116	.276	.151
POR TO CENTROID	.130	.346	.251
MIN RADIUS	.103	.251	.289
MEAN RADIUS	.816	.660	.622
MAX RADIUS	1.972	1.233	1.112
HORIZONTAL SPREAD	1.974	.870	.870
VERTICAL SPREAD	2.600	2.169	2.018
EXTREME SPREAD	3.037	2.218	2.029
NUMBER IN ONE INCH CIRCLE	=	3	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	9	

13 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06685959.1

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 8

MEAN = .423

VG = 2.183

CS = 2.615

CENTROID *

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM

.981

.732

.634

MINIMUM

-1.524

-.956

-1.054

MAXIMUM

.344

1.003

.865

MINIMUM

1.159

-1.100

-1.074

CENTROID

.218

.387

.485

CENTROID

.124

.065

.203

POA TO CENTROID

.251

.393

.525

MIN RADII

.397

.247

.351

MEAN RADII

.933

.819

.729

MAX RADII

1.614

1.349

1.218

HORIZONTAL SPREAD

2.425

1.688

1.688

VERTICAL SPREAD

2.183

2.183

1.939

EXTREME SPREAD

2.615

2.187

2.161

NUMBER OF SHOTS IN 1IN CIRCLE =

1

NUMBER OF SHOTS IN 2IN CIRCLE =

7

NUMBER OF SHOTS IN 3IN CIRCLE =

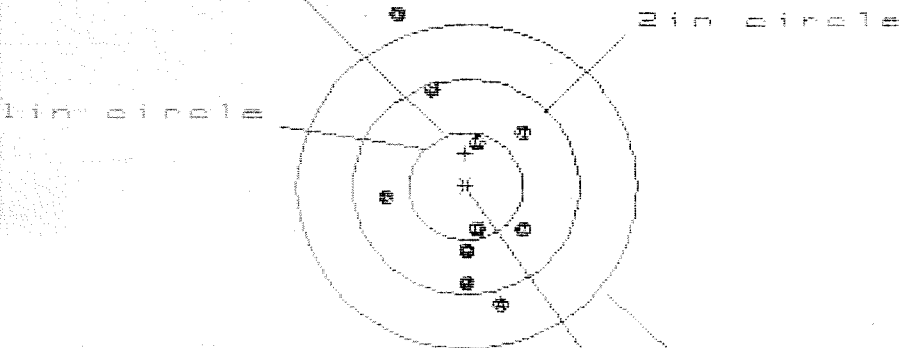
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13 Nov 1991

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CENTERFIRE PATTERNS # 5

POB



OF SHOTS- 10

IN CIR

1in = 2

2in = 8

3in = 9

MEAN = 1.184

SE = 2.720

GE = 1.655

CENTROID *

PATTERN #

5

SHOTS - BEST OF	10	9	8
MAXIMUM	.513	.446	.471
MINIMUM	-.671	-.738	-.713
MAXIMUM	1.638	1.881	.968
MINIMUM	-1.082	-.900	-.844
CENTROID	.084	.071	.046
CENTROID	-.387	-.489	-.376
POB TO CENTROID	.387	.494	.379
ALL PATTERN	.428	.236	.351
MEAN PATTERN	.829	.676	.655
MEAN PATTERN	1.745	1.127	1.012
HORIZONTAL SPREAD	1.184	1.184	1.184
VERTICAL SPREAD	2.720	1.981	1.812
EXTREMITY SPREAD	2.955	2.048	1.830
NUMBER OF SHOTS IN 1IN CIRCLE	2	2	2
NUMBER OF SHOTS IN 2IN CIRCLE	8	8	8
NUMBER OF SHOTS IN 3IN CIRCLE	9	9	9