

FORM

UPC



0 47700 25716 7

6665861

CAPACITY*
*INCLUDES 1 IN CHAMBER

MODEL 700 TM M24

ORDER NO. 5716

BARREL LENGTH

Remington



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

MODEL 700 TM M24

SERIAL NO.

C6665861

ORDER NO.

5716

20

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



5716 C6665861

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 #

C6665861

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		9/23/91	KR
600	Proof		9/23/91	KR
607	Check Headspace		9/23/91	KR
610	Dis-assemble Gun		9/23/91	KR
612	Magnaflux Barrel Action		SEP 30 1991	KR
	Magnaflux Bolt		SEP 30 1991	KR
615	Rollmark Caliber		SEP 30 1991	GL
617	Drill and Tap Sight Holes		SEP 30 1991	LB
618	Polish Barrel		OCT 2 1991	WB
620	Apply Coatings (Barrel Action)		9/29/91	JK
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/8/91	KR
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/8/91	KR
	C) Inspect Ejector Hole for Chamfer		10/8/91	KR
	D) Oil Firing Pin Ass'y		10/8/91	KR
	E) Adjust Trigger Pull to Min Setting and Stake		10-9-91	DH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	5	5			10-9-91	AC
	G) Safety Off Force	4	4	4			10-9-91	AC
	H) Trigger Pull Test & Retainability						10-9-91	DH
	I) Firing Pin Indent	.021	.020	.021			10-9-91	AC
	J) Assemble Stock						10/10/91	RW
	K) Assemble Swivel Studs						10-17-91	AC
	L) Attach Front and Rear Sight Assemblies						10/10/91	RW
	M) Iron Sight Alignment						10/10/91	RW
	N) Detach Front & Rear Sights & place in numbered container						10/10/91	RW
	O) Attach Scope to Rifle						10/10/91	RW
	P) Detach & Attach Scope 20 Times						10/10/91	RW
640	Gallery Target & Test						10/11/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						10/11/91	KT
655	Final Inspection							
	A) Headspace						10-17-91	AC
	B) Trigger Pull	2.31	2.28	2.56	2.53	2.29	10/14/91	RW
	C) Function						10-17-91	AC
660	Pack						12-18-91	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. 56665861

DATE 10-9-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.57	2.35	2.72	2.31	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.54	2.31	2.77	2.28	
PULL #3	2.55	2.36	2.44	2.56	
PULL #4	2.54	2.32	2.76	2.53	
PULL #5	2.54	2.20	2.70	2.29	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.50	3.57		
PULL #2	3.57	3.57		
PULL #3	3.64	3.68		
PULL #4	3.49	3.55		
PULL #5	3.63	3.56		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.27	4.07		4.13
PULL #2	4.39	4.09		4.04
PULL #3	4.35	4.55		4.07
PULL #4	4.28	4.57		4.08
PULL #5	4.07	4.50		3.99
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06665861
11 Oct 1991

CENTROIDAL DISTANCES

0 TO	1	.168618
1 TO	2	.246789
1 TO	3	.172012
1 TO	4	.393081
1 TO	5	.401966

4.3 (----)POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0262
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0448
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0518987
THE AMR FOR THIS RIFLE IS: .9266

11 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8685861

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 6

2 in = 8

3 in = 9

HS= 1.086

VS= 2.810

GS= 2.868

CENTROID *

PATTERN #

SHOTS (BEST OF)

MAXIMUM X

MINIMUM X

MAXIMUM Y

MINIMUM Y

CENTROID X

CENTROID Y

POA TO CENTROID in.

MIN RADIUS

MEAN RADIUS

MAX RADIUS

HORIZONTAL SPREAD

VERTICAL SPREAD

EXTREME SPREAD

NUMBER IN ONE INCH CIRCLE

NUMBER IN TWO INCH CIRCLE

NUMBER IN THREE INCH CIRCLE

11

10

.372

-.714

1.798

-1.012

.064

.156

.168

.114

.627

1.818

1.086

2.810

2.868

=

=

=

9

.343

-.743

.467

-.812

.093

-.044

.103

.090

.500

.858

1.086

1.279

1.430

=

=

=

8

.377

-.709

.365

-.728

.059

.058

.092

.037

.427

.808

1.086

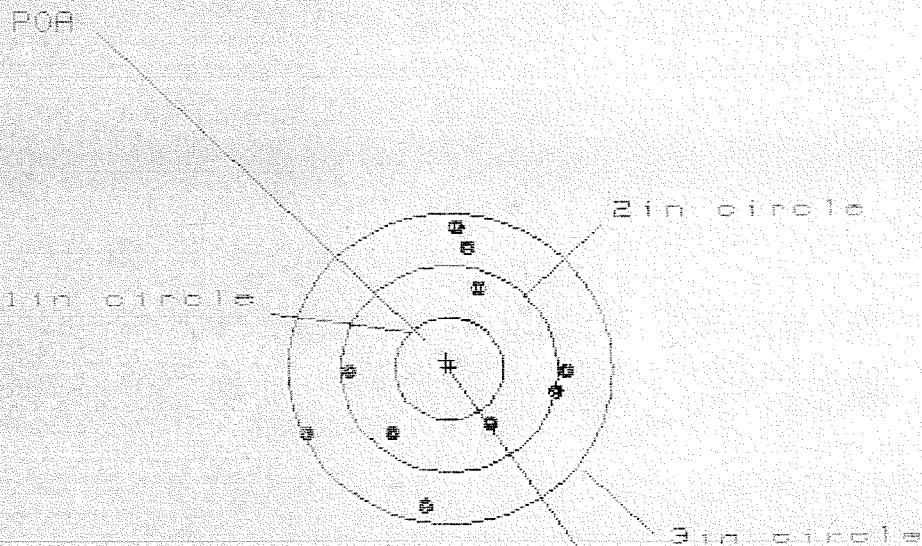
1.093

1.287

13 Oct 1981

FILE:/PATTERNING/CENTERFIRE_PATT/CS665861

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 0

2in = 5

3in = 10

HS= 2.363

VS= 2.719

GS= 2.733

PATTERN #

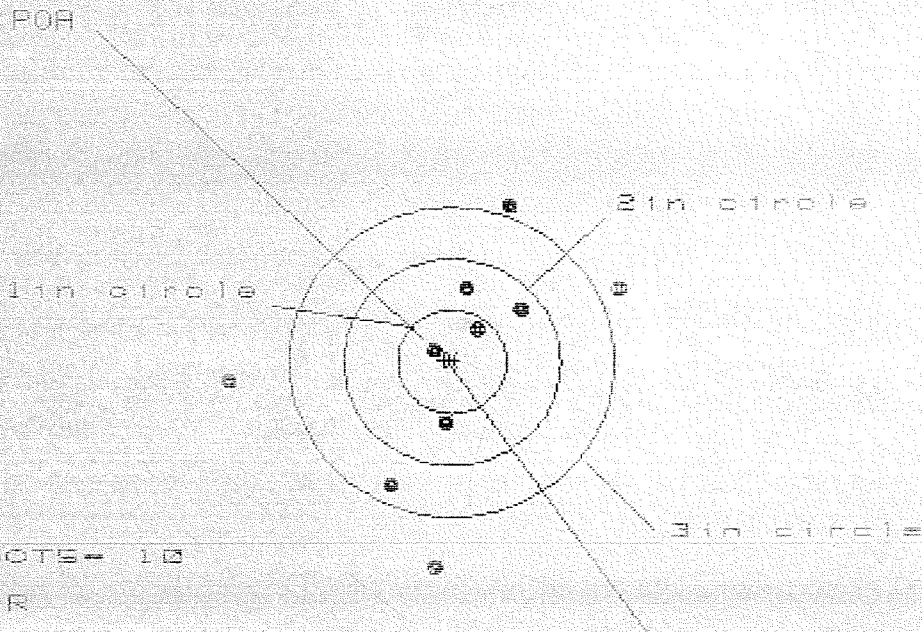
2

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.063	.919	.911
MINIMUM X	-1.300	-1.105	-1.113
MAXIMUM Y	1.394	1.328	1.274
MINIMUM Y	-1.325	-1.391	-1.225
CENTROID X	.027	.171	.179
CENTROID Y	-.080	-.014	-.180
POA TO CENTROID in.	.084	.172	.253
MIN RADIUS	.664	.648	.496
MEAN RADIUS	1.066	1.010	.952
MAX RADIUS	1.431	1.433	1.275
HORIZONTAL SPREAD	2.363	2.024	2.024
VERTICAL SPREAD	2.719	2.719	2.499
EXTREME SPREAD	2.733	2.733	2.534
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		10	

11 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8565851

CENTERFIRE PATTERNS # 3



OF SHOTS = 10
 # IN CIR
 1in = 2
 2in = 5
 3in = 6
 HS = 3.620
 VS = 3.465
 GS = 3.729

CENTROID *

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.579	1.352	1.307
MINIMUM X	-2.041	-1.801	-1.846
MAXIMUM Y	1.479	1.454	1.203
MINIMUM Y	-1.986	-2.011	-1.427
CENTROID X	.062	.289	.334
CENTROID Y	-.016	.009	.250
POA TO CENTROID in.	.064	.289	.423
MIN RADIUS	.227	.333	.105
MEAN RADIUS	1.133	1.021	.827
MAX RADIUS	2.053	2.043	1.659
HORIZONTAL SPREAD	3.620	2.153	2.153
VERTICAL SPREAD	3.465	3.465	2.630
EXTREME SPREAD	3.729	3.531	2.850
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		6	

11 Oct 1991

FILE: \PATTERNING\CENTERFIRE_PATT\06065801

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 8

3 in = 9

HS = 2.072

VS = 2.146

GS = 2.387

CENTROID #

PATTERN #

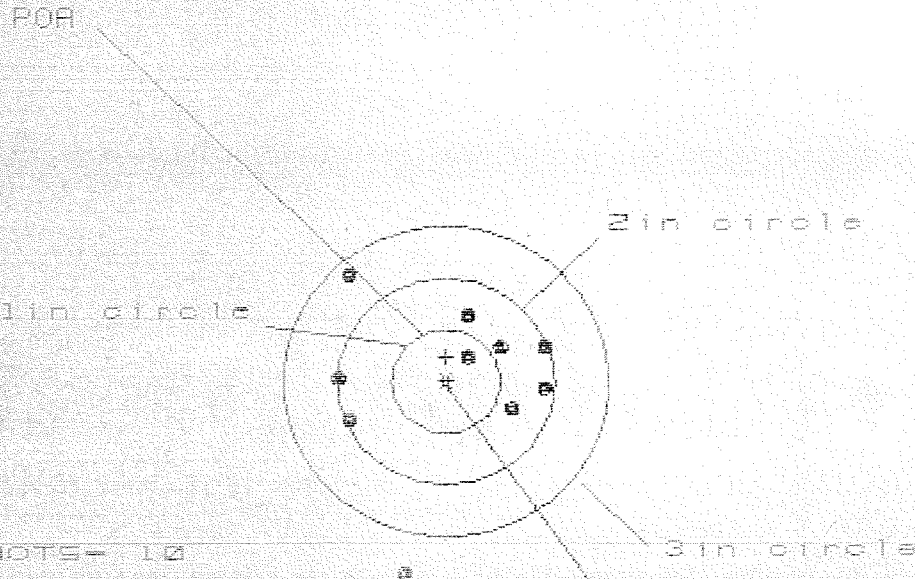
4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.063	.950	.787
MINIMUM X	-1.010	-.811	-.692
MAXIMUM Y	.965	.834	.779
MINIMUM Y	-1.181	-.972	-1.027
CENTROID X	-.279	-.167	-.286
CENTROID Y	-.036	.095	.150
POA TO CENTROID in.	.282	.192	.323
MIN RADIUS	.439	.438	.519
MEAN RADIUS	.882	.790	.752
MAX RADIUS	1.553	1.048	1.045
HORIZONTAL SPREAD	2.072	1.761	1.479
VERTICAL SPREAD	2.146	1.806	1.806
EXTREME SPREAD	2.387	1.868	1.830
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		9	

11 Oct 1991

FILE: \PATTERNING\CENTERFIRE_PATT\08685861

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 1.904

VS= 2.832

GS= 2.882

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.900	.859	.740
MINIMUM X	:	-1.004	-1.045	-1.164
MAXIMUM Y	:	1.002	.798	.508
MINIMUM Y	:	-1.830	-.581	-.481
CENTROID X	:	-.005	.036	.155
CENTROID Y	:	-.240	-.036	-.136
POA TO CENTROID in.	:	.240	.051	.206
MIN RADIUS	:	.366	.217	.187
MEAN RADIUS	:	.925	.774	.686
MAX RADIUS	:	1.868	1.240	1.188
HORIZONTAL SPREAD	:	1.904	1.904	1.904
VERTICAL SPREAD	:	2.832	1.379	.989
EXTREME SPREAD	:	2.882	2.088	1.464
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			9	