

[illegible]

UPC

[illegible]

MODEL 700 TM M24

ORDER NO.

5716

Remington



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

MODEL 700 TM M24

SERIAL NO.

C6665893

ORDER NO.

5716

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

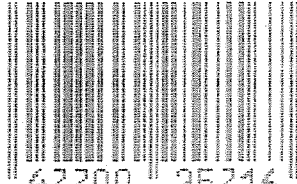


5716 C6665893

ORDER 5716

MODEL 700 TM M24

UPC

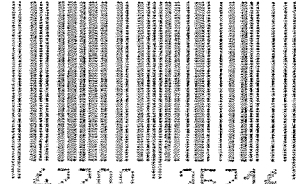


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ORDER 5716

MODEL 700 TM M24

UPC



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6665893

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		OCT 2 1991	WB
620	Apply Coatings (Barrel Action)		9/25/91	KL
	Apply Coating (Bolt)		9/25/91	KL
625	Final Assembly A) Clean inside of Bolt Assembly		10/8/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/8/91	KL
	C) Inspect Ejector Hole for Chamfer		10/8/91	KL
	D) Oil Firing Pin Ass'y		10/8/91	KL
	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	5	6	6			10-9-91	K
	G) Safety Off Force	4	4	4			10-9-91	K
	H) Trigger Pull Test & Retainability						10-9-91	DH
	I) Firing Pin Indent	.020	.020	.020			10-9-91	AC
	J) Assemble Stock						10/11/91	RW
	K) Assemble Swivel Studs						10-17-91	AC
	L) Attach Front and Rear Sight Assemblies						10/11/91	RW
	M) Iron Sight Alignment						10/11/91	RW
	N) Detach Front & Rear Sights & place in numbered container						10/11/91	RW
	O) Attach Scope to Rifle						10/11/91	RW
	P) Detach & Attach Scope 20 Times						10/11/91	RW
640	Gallery Target & Test						10-14-91	DH
	A) Time						10-14-91	DH
	B) Malfunctions						10-14-91	DH
	C) Pierced Primers						10-14-91	DH
	D) Optical Clarity of Scope						10-14-91	DH
645	Inspect for Live Ammo						10-14-91	DH
655	Final Inspection							
	A) Headspace						10-17-91	K
	B) Trigger Pull	272	273	275	272	272	10-14-91	DH
	C) Function						10-17-91	K
660	Pack						12-17-91	VF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO C-6665893

DATE 10-9-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.61	2.63	2.68	2.72	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.58	2.56	2.21	2.73	
PULL #3	2.52	2.43	2.57	2.75	
PULL #4	2.54	2.56	2.57	2.72	
PULL #5	2.62	2.69	2.45	2.72	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.38	3.25		
PULL #2	3.38	3.44		
PULL #3	3.37	3.40		
PULL #4	3.37	3.33		
PULL #5	3.48	3.26		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.38	4.24		4.02
PULL #2	4.00	4.04		4.60
PULL #3	4.34	4.20		4.50
PULL #4	4.18	4.00		4.06
PULL #5	4.12	4.20		4.31
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665893
14 Oct 1991

CENTROIDAL DISTANCES

0 TO 1	.341422
1 TO 2	.36309
1 TO 3	.337717
1 TO 4	.423458
1 TO 5	.323484

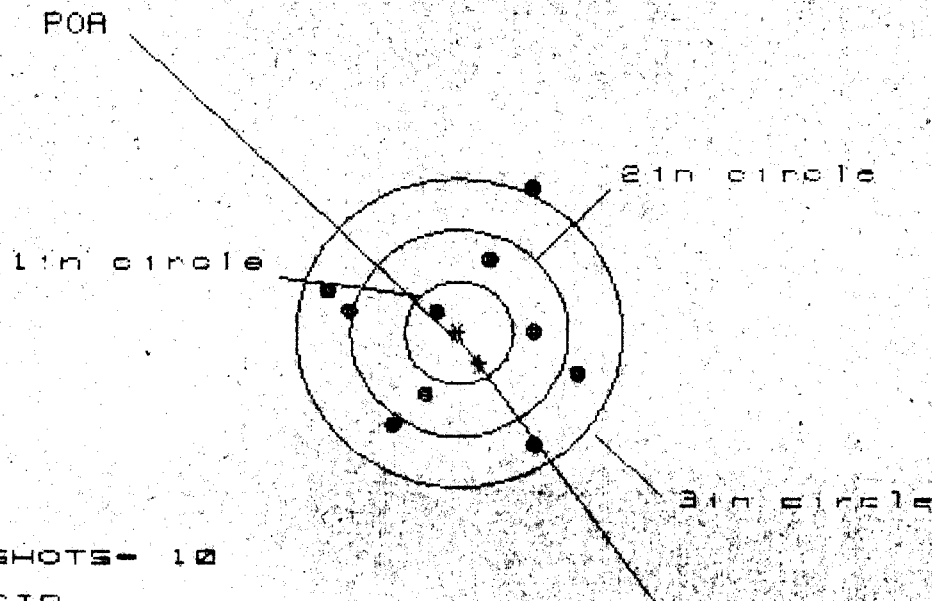
3* (---)POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0392
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2022
THE RESULTING AVERAGE FOI RADIUS FOR THIS RIFLE IS: .205965
THE AMR FOR THIS RIFLE IS: .9288

14 Oct 1991

FILE: PATTERNING/CENTERFIRE_PATT/66063893

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS= 2.243

VS= 2.503

GS= 2.601

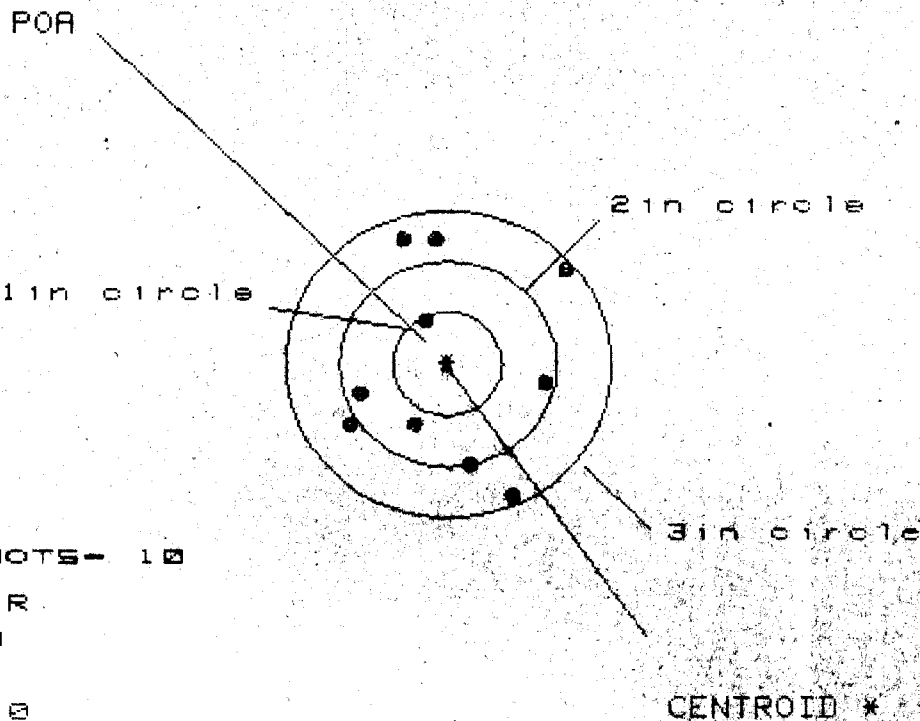
CENTROID *

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.042	1.118	1.211
MINIMUM X	:	-1.201	-1.125	-1.032
MAXIMUM Y	:	1.378	.913	.791
MINIMUM Y	:	-1.125	-.971	-.827
CENTROID X	:	-.188	-.264	-.357
CENTROID Y	:	.285	.131	.253
POA TO CENTROID in.	:	.341	.295	.437
MIN RADIUS	:	.292	.359	.210
MEAN RADIUS	:	.979	.905	.847
MAX RADIUS	:	1.539	1.258	1.267
HORIZONTAL SPREAD	:	2.243	2.243	2.243
VERTICAL SPREAD	:	2.503	1.984	1.618
EXTREME SPREAD	:	2.601	2.418	2.386
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

14 Oct 1991

FILE: PATTERNING/CENTERFIRE_PATT/CS885893

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR.

1in - 0

2in - 5

3in - 10

HS- 2.021

VS- 2.560

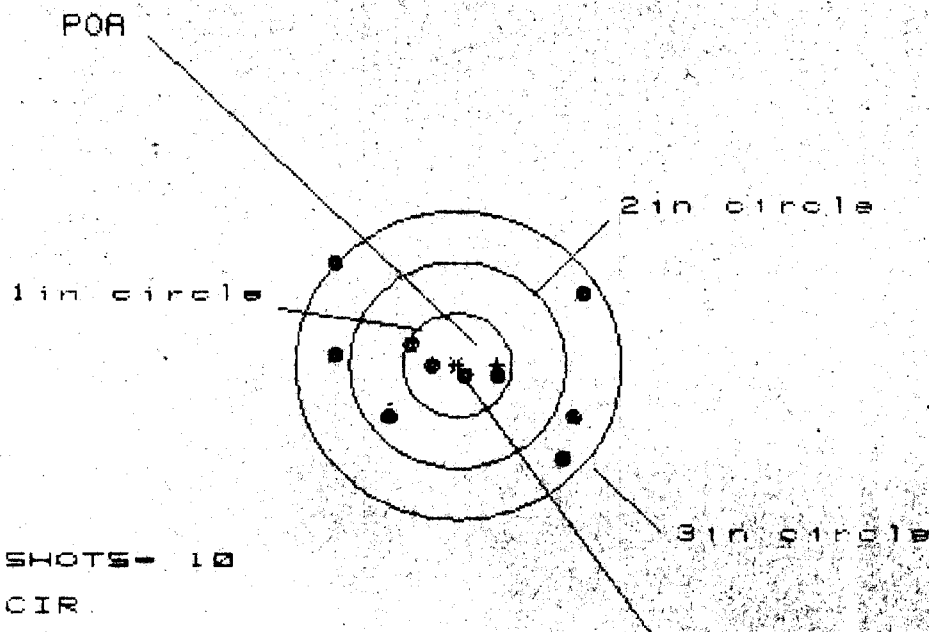
GS- 2.743

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.081	1.144	1.112
MINIMUM X	:	-.940	-.877	-.734
MAXIMUM Y	:	1.250	1.105	1.198
MINIMUM Y	:	-1.310	-1.092	-.999
CENTROID X	:	.009	-.054	-.197
CENTROID Y	:	-.020	.125	.032
POA TO CENTROID in.	:	.022	.136	.199
MIN RADIUS	:	.508	.350	.399
MEAN RADIUS	:	1.040	.986	.916
MAX RADIUS	:	1.427	1.365	1.217
HORIZONTAL SPREAD	:	2.021	2.021	1.846
VERTICAL SPREAD	:	2.560	2.197	2.197
EXTREME SPREAD	:	2.743	2.513	2.285
NUMBER IN ONE INCH CIRCLE =			0	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			10	

14 Oct 1991

FILE: PATTERNING/CENTERFIRE PATT/C8605893

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR.

1 in - 4

2 in - 5

3 in - 10

HS - 2.298

VS - 1.864

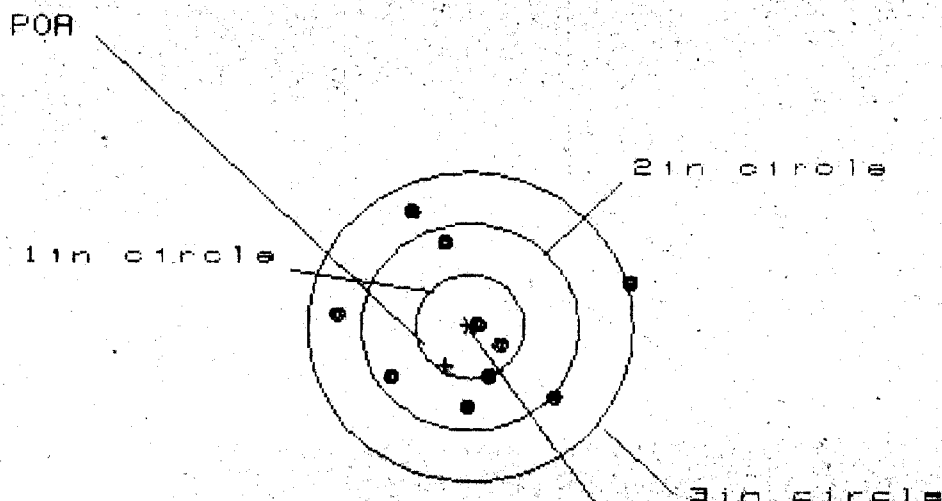
GS - 2.818

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.134	1.008	1.089
MINIMUM X	-1.164	-1.290	-1.164
MAXIMUM Y	.956	.846	.434
MINIMUM Y	-.908	-.802	-.697
CENTROID X	-.366	-.240	-.366
CENTROID Y	-.002	-.108	-.213
POA TO CENTROID	.366	.263	.424
MIN RADIUS	.072	.096	.161
MEAN RADIUS	.845	.777	.708
MAX RADIUS	1.485	1.316	1.219
HORIZONTAL SPREAD	2.298	2.298	2.253
VERTICAL SPREAD	1.864	1.648	1.131
EXTREME SPREAD	2.818	2.389	2.389
NUMBER IN ONE INCH CIRCLE	4		
NUMBER IN TWO INCH CIRCLE	5		
NUMBER IN THREE INCH CIRCLE	10		

14 Oct 1991

FILE: PATTERNING/CENTERFIRE PATT/C8665893

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in - 3

2in - 6

3in - 9

HS- 2.719

VS- 1.919

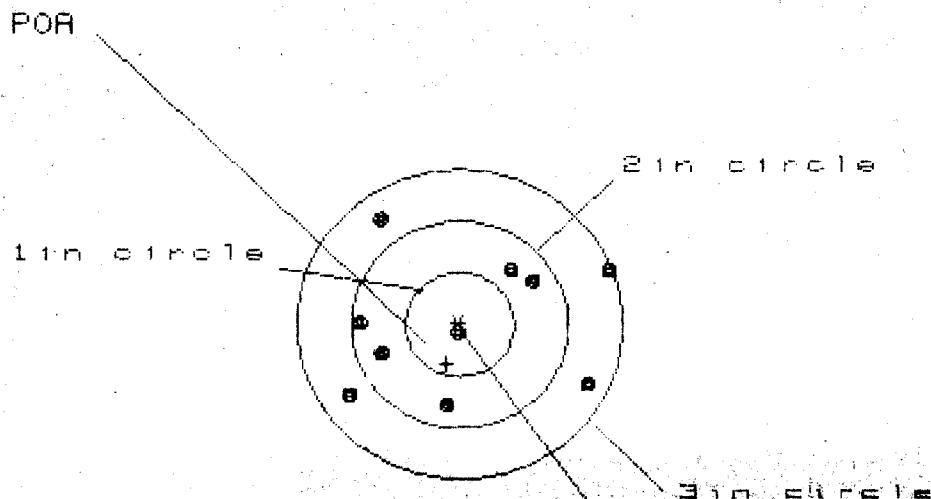
GS- 2.742

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.483	.954	.908
MINIMUM X	-1.236	-1.071	-1.117
MAXIMUM Y	1.166	1.219	1.012
MINIMUM Y	-.752	-.700	-.548
CENTROID X	.226	.061	.107
CENTROID Y	.374	.321	.169
POA TO CENTROID (in)	.437	.327	.200
MIN RADIUS	.041	.212	.257
MEAN RADIUS	.842	.771	.677
MAX RADIUS	1.557	1.274	1.165
HORIZONTAL SPREAD	2.719	2.025	2.025
VERTICAL SPREAD	1.919	1.919	1.560
EXTREME SPREAD	2.742	2.267	2.176
NUMBER IN ONE INCH CIRCLE	3	6	9
NUMBER IN TWO INCH CIRCLE	6	9	9
NUMBER IN THREE INCH CIRCLE	9	9	9

14 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8665893

CENTERFIRE PATTERNS # 5



* OF SHOTS - 10

IN CIR

1in - 1

2in - 6

3in - 10

HS - 2.401

VS - 1.831

GS - 3.875

CENTROID *

PATTERN #

SHOTS	10	9	8
MAXIMUM	1.358	1.283	.961
MINIMUM	1.041	.890	-.730
MAXIMUM	1.336	1.082	1.017
MINIMUM	-.388	.749	-.814
CENTROID	.123	-.029	-.188
CENTROID	.204	.318	.383
POA TO CENTROID	.377	.319	.427
MIN RADIUS	.63	.892	.264
MEAN RADIUS	.63	.866	.799
MAX RADIUS	.63	1.384	1.102
HORIZONTAL SPREAD	.171	.173	1.191
VERTICAL SPREAD	.171	1.331	1.331
EXTREME SPREAD	.171	1.467	1.413
NUMBER ONE	1	1	1
NUMBER TWO	2	2	2
NUMBER THREE	3	3	3