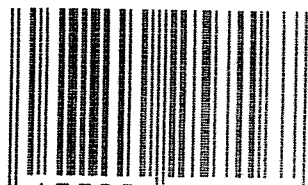


F102H

UPC



0 47700 25716 7

BARREL LENGTH

CAPACITY*

*INCLUDES 1 IN CHAMBER

06665934

MODEL 700 TM M24

ORDER NO.

5715

Remington



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

MODEL 700 TM M24

SERIAL NO.

C6665934

ORDER NO.

5716

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

20



5716 C6665934

ORDER 5716

MODEL 700 TM M24

UPC

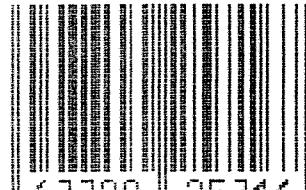
ORDER 5716

MODEL 700 TM M24

UPC



0 47700 25716 7



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6665934

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10 1	97	RW
600	Proof	10 1	91	RW
607	Check Headspace	10 1	91	RW
610	Dis-assemble Gun	10 1	91	RW
612	Magnaflux Barrel Action		OCT 4 1991	KR
	Magnaflux Bolt		OCT 4 1991	KR
615	Rollmark Caliber		OCT 4 1991	GL
617	Drill and Tap Sight Holes		OCT 4 1991	LB
618	Polish Barrel		10/8/91	LB
620	Apply Coatings (Barrel Action)		10-22-91	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/22/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/22/91	RW
	C) Inspect Ejector Hole for Chamfer		10/22/91	RW
	D) Oil Firing Pin Ass'y		10/22/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/23/91	JL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			10/24/91	JH
	G) Safety Off Force	3	3	3			10/24/91	JH
	H) Trigger Pull Test & Retainability						10/23/91	JH
	I) Firing Pin Indent	.020	.020	.020			10/24/91	JH
	J) Assemble Stock						10/25/91	RW
	K) Assemble Swivel Studs						10-30-91	AC
	L) Attach Front and Rear Sight Assemblies						10/25/91	RW
	M) Iron Sight Alignment						10/25/91	RW
	N) Detach Front & Rear Sights & place in numbered container						10/25/91	RW
	O) Attach Scope to Rifle						10/25/91	RW
	P) Detach & Attach Scope 20 Times						10/25/91	RW
640	Gallery Target & Test						10-28-91	DH
	A) Time						10-28-91	DH
	B) Malfunctions						10-28-91	DH
	C) Pierced Primers						10-28-91	DH
	D) Optical Clarity of Scope						10-28-91	DH
645	Inspect for Live Ammo						10-28-91	DH
655	Final Inspection							
	A) Headspace						10-30-91	AC
	B) Trigger Pull	248	248	244	245	244	10-29-91	DH
	C) Function						10-30-91	AC
660	Pack						12-19-91	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-6665934

DATE 10/23/91

TESTER JEL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.52	2.50	2.49	248	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.54	2.50	2.46	248	
PULL #3	2.52	2.47	2.50	244	
PULL #4	2.47	2.51	2.55	245	
PULL #5	2.50	2.50	2.51	244	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.48	3.46		
PULL #2	3.47	3.52		
PULL #3	3.46	3.50		
PULL #4	3.41	3.41		
PULL #5	3.43	3.57		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.28	4.38		4.35
PULL #2	4.43	4.32		4.32
PULL #3	4.36	4.34		4.32
PULL #4	4.38	4.35		4.35
PULL #5	4.24	4.29		4.27
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665934
28 Oct 1991

CENTROIDAL DISTANCES

0 TO	1	.295203
1 TO	2	.234361
1 TO	3	.322605
1 TO	4	.148489
1 TO	5	.116829

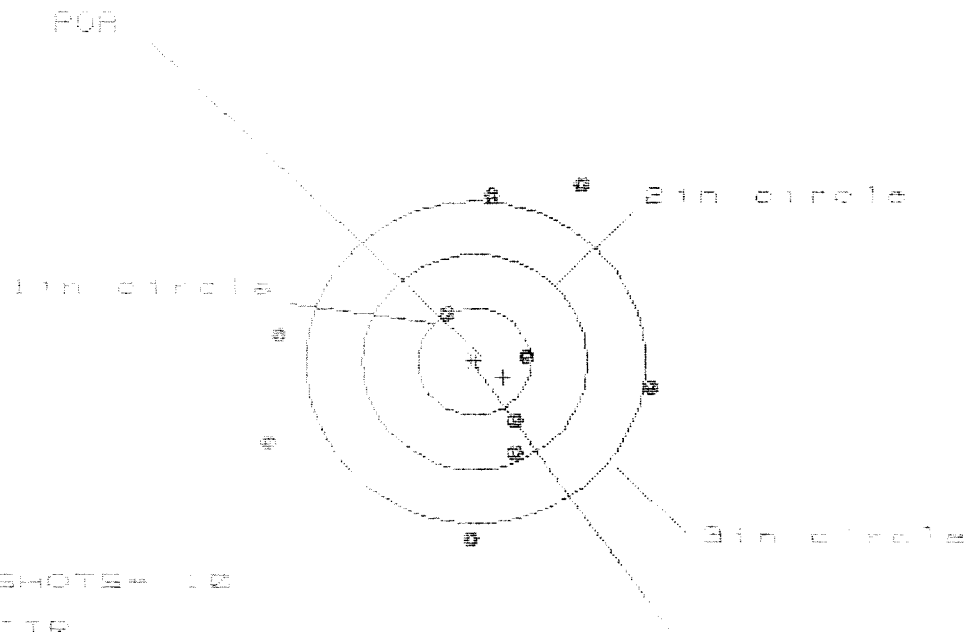
5.20 (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1074
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0662
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .198749
THE AMP FOR THIS RIFLE IS: 1.043

28 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08865934

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 2

2in = 4

3in = 4

AS = 3.317

BS = 3.312

CS = 3.326

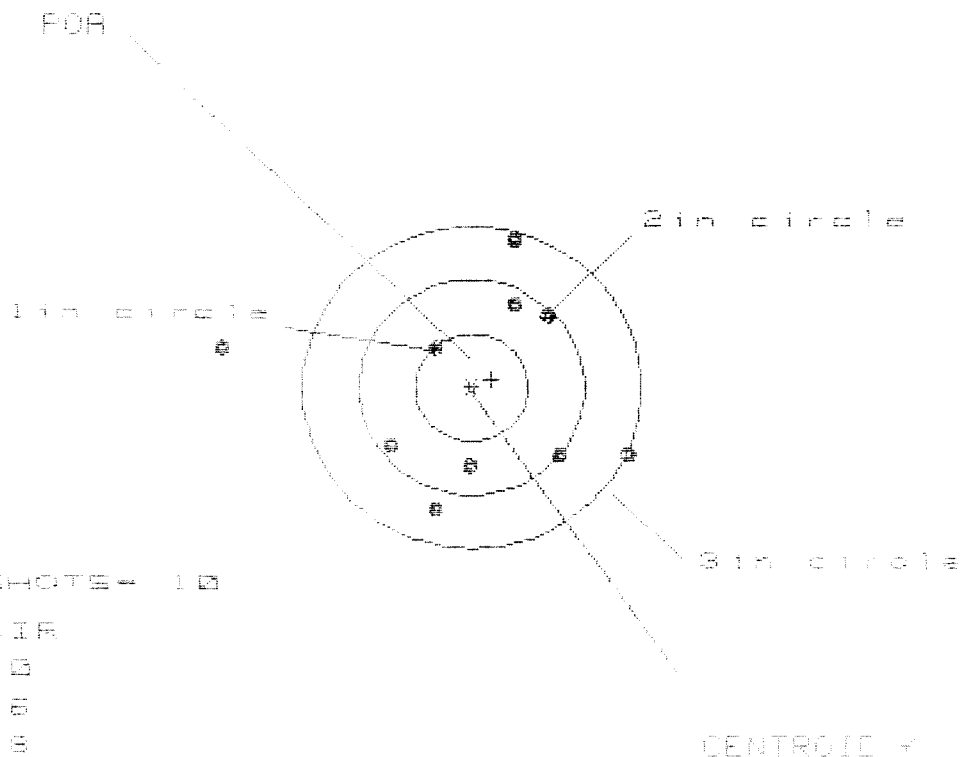
CENTROID +

PATTERN #		1	2	3
CH 13 (BEST OF)	:	10	9	8
MINIMUM X	:	1.520	1.627	1.416
MINIMUM Y	:	-1.797	-1.690	-1.369
MINIMUM X	:	1.685	1.743	1.675
MINIMUM Y	:	-1.627	-1.440	-1.568
CENTROID X	:	-1.256	-1.363	-1.152
CENTROID Y	:	1.147	1.040	1.028
CH 13 CENTROID X	:	1.295	1.366	1.155
CH 13 CENTROID Y	:	1.460	1.597	1.406
CH 13 X	:	1.291	1.217	1.101
CH 13 Y	:	1.943	1.777	1.915
CH 13 SPREAD	:	3.317	3.317	3.265
CH 13 SPREAD	:	3.312	3.183	3.183
CH 13 SPREAD	:	3.376	3.359	3.324
CH 13 ONE INCH CIRCLE	=	2		
CH 13 TWO INCH CIRCLE	=	4		
CH 13 THREE INCH CIRCLE	=	4		

28 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8665334

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 6

2in = 5

3in = 5

MS- 2.600

MS- 2.503

MS- 2.726

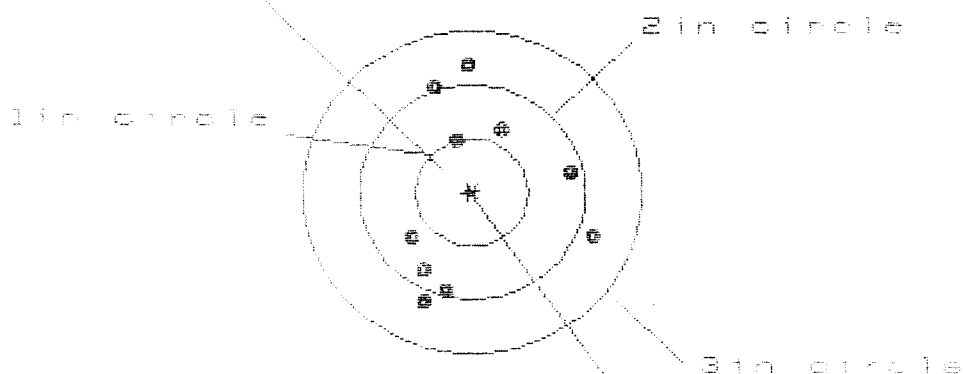
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.384	1.138	.651
MINIMUM X	:	-2.216	-.983	-.843
MAXIMUM Y	:	1.371	1.412	1.344
MINIMUM Y	:	-1.132	-1.091	-1.159
CENTROID X	:	-.178	.068	-.074
CENTROID Y	:	-.074	-.115	-.047
GROUP CENTROID IN.	:	.193	.134	.087
GROUP RELIUS	:	.533	.693	.586
GROUP RELIUS	:	1.125	.981	.935
GROUP RELIUS	:	2.247	1.417	1.368
GROUP RELIUS SPREAD	:	3.600	2.123	1.494
GROUP RELIUS SPREAD	:	2.503	2.503	2.503
GROUP RELIUS SPREAD	:	3.726	2.592	2.392
GROUP RELIUS ONE INCH CIRCLE	=	0		
GROUP RELIUS TWO INCH CIRCLE	=	6		
GROUP RELIUS THREE INCH CIRCLE	=	8		

26 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665934

CENTERFIRE PATTERNS # 3

FOR



OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 10

HS = 1.591

VS = 2.216

GS = 2.249

CENTROID *

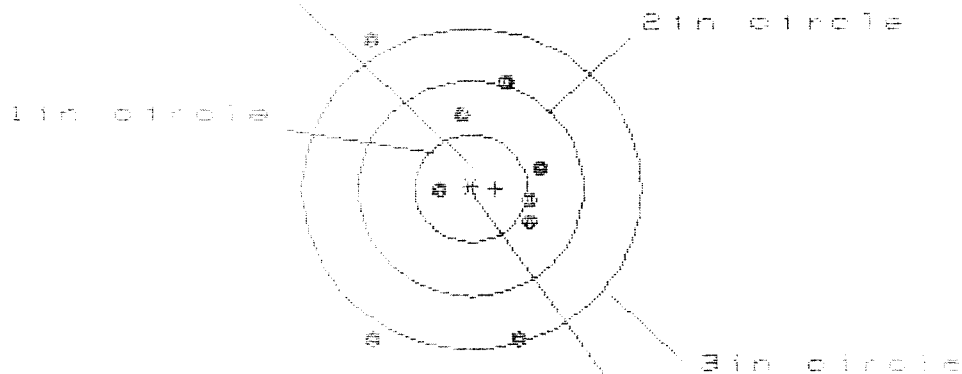
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MINIMUM X	:	1.090	1.082	1.958
MINIMUM Y	:	-1.501	-1.509	-1.373
MAXIMUM X	:	1.218	1.089	1.051
MAXIMUM Y	:	-1.998	-1.863	-1.981
CENTROID X	:	.037	.045	-1.091
CENTROID Y	:	.012	-1.123	-1.085
1 INCH RADIUS	:	.039	.131	.124
2 INCH RADIUS	:	.494	.574	.482
3 INCH RADIUS	:	.903	.862	.812
4 INCH RADIUS	:	1.220	1.157	1.081
5 INCH RADIUS	:	1.591	1.591	1.331
6 INCH RADIUS	:	2.216	1.952	1.952
7 INCH RADIUS	:	2.249	2.028	1.953
1 INCH ONE INCH CIRCLE	=		1	
2 INCH TWO INCH CIRCLE	=		6	
3 INCH THREE INCH CIRCLE	=		10	

06 04 1993

FILE:/PATTERNING/CENTERFIRE_PATT/C8665934

CENTERFIRE PATTERNS # 4

FOR



OF SHOTS = 10

IN CIR

1in = 2

2in = 6

3in = 8

ME = 1.495

MS = 2.872

SS = 3.877

CENTROID

PATTERN #

4

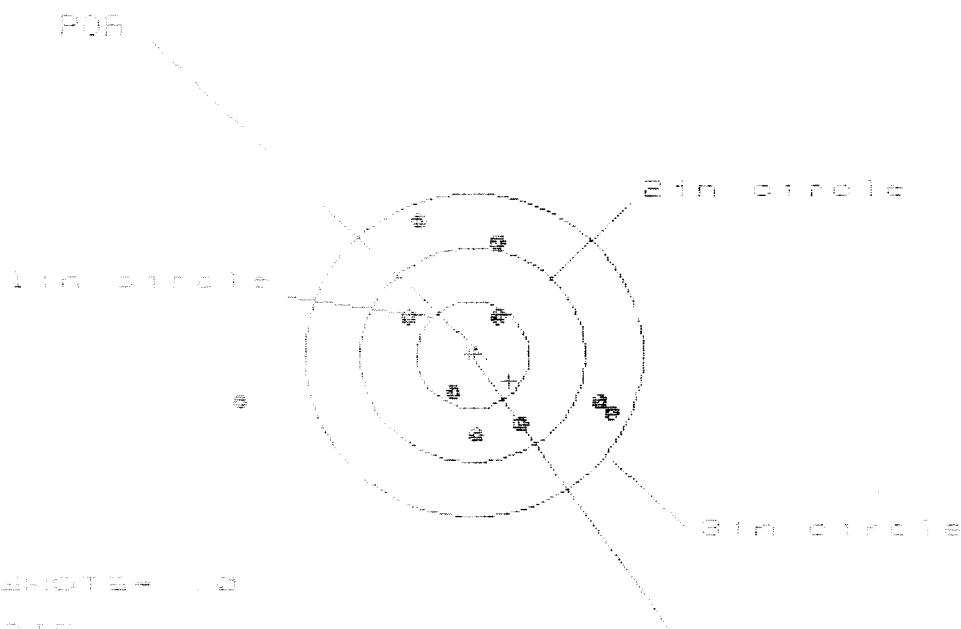
SHOTS (TEST OF)	:	10	9	8
MAXIMUM X	:	.595	.495	.376
MINIMUM X	:	-.901	-.948	-.545
MAXIMUM Y	:	1.420	1.130	.968
MINIMUM Y	:	-1.452	-1.294	-1.363
CENTROID X	:	-.216	-.116	.000
CENTROID Y	:	.004	-.154	.008
TEST - CENTROID INCH	:	.216	.193	.008
SPREAD X	:	.257	.398	.351
SPREAD Y	:	.884	.798	.662
SPREAD Z	:	1.682	1.604	1.378
SPREAD X,Y	:	1.495	1.443	.921
SPREAD X,Z	:	2.872	2.424	2.331
SPREAD Y,Z	:	3.877	2.690	2.833
INCH INCH CIRCLE	=	2		
INCH INCH CIRCLE	=	6		
INCH INCH CIRCLE	=	8		

08-001 (53)

FILE:/PATTERNING/CENTERFIRE_PATT/C8685934

CENTERFIRE PATTERNS

5



OF SHOTS = 10

1in CIR = 5

2in CIR = 5

3in CIR = 0

MEAN = 2.645

STDEV = 1.962

SEMEAN = 0.3947

INDEX #

:

13

INDEX #	:	10	9	8
MEAN	:	1.256	1.024	1.025
STDEV	:	-2.089	-1.304	-1.678
SEMEAN	:	1.239	1.188	1.111
STDEV	:	-1.723	-1.774	-1.051
SEMEAN	:	-1.324	-1.092	-1.220
STDEV	:	1.242	1.258	1.370
SEMEAN	:	1.405	1.387	1.430
STDEV	:	1.358	1.355	1.366
SEMEAN	:	1.011	1.072	1.020
STDEV	:	2.136	1.388	1.258
MEAN	:	3.045	1.928	1.701
STDEV	:	1.962	1.962	1.962
SEMEAN	:	3.347	2.367	2.313
MEAN	:	2	5	9
STDEV	:	2	5	9
SEMEAN	:	2	5	9