

FORM

UPC



0 47700 25716 7

06665942

BARREL LENGTH
CAPACITY*
*INCLUDES 1 IN CHAMBER

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.

C6665942

ORDER NO.

5716

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

20



5716 C6665942

ORDER 5716

MODEL 700 TM M24

UPC

ORDER 5716

MODEL 700 TM M24

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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6665942

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		9/24/91	KL
600	Proof		9/24/91	KL
607	Check Headspace		9/24/91	KL
610	Dis-assemble Gun		9/24/91	KL
612	Magnaflux Barrel Action	OCT 2 1991		KR
	Magnaflux Bolt	OCT 2 1991		KR
615	Rollmark Caliber	OCT 2 1991		GS
617	Drill and Tap Sight Holes	OCT 2 1991		LB
618	Polish Barrel	OCT 4 1991		WB
620	Apply Coatings (Barrel Action)		10-14-91	JA
	Apply Coating (Bolt)		10-14-91	JA
625	Final Assembly A) Clean inside of Bolt Assembly		10/16/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/16/91	KL
	C) Inspect Ejector Hole for Chamfer		10/16/91	KL
	D) Oil Firing Pin Ass'y		10/16/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		10/24/91	KL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			10/24/91	QU
	G) Safety Off Force	3	3	3			10/24/91	QU
	H) Trigger Pull Test & Retainability						10/24/91	QU
	I) Firing Pin Indent	.020	.020	.020			10/24/91	QU
	J) Assemble Stock						10/25/91	QU
	K) Assemble Swivel Studs						10-30-91	QU
	L) Attach Front and Rear Sight Assemblies						10/25/91	QU
	M) Iron Sight Alignment						10/25/91	QU
	N) Detach Front & Rear Sights & place in numbered container						10/25/91	QU
	O) Attach Scope to Rifle						10/25/91	QU
	P) Detach & Attach Scope 20 Times						10/25/91	QU
640	Gallery Target & Test						10-28-91	AC
	A) Time						10-28-91	AC
	B) Malfunctions						10-28-91	AC
	C) Pierced Primers						10-28-91	AC
	D) Optical Clarity of Scope						10-28-91	AC
645	Inspect for Live Ammo						10-28-91	AC
655	Final Inspection							
	A) Headspace						10-30-91	AC
	B) Trigger Pull	263	266	270	265	270	10-29-91	QU
	C) Function						10-30-91	AC
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-6665942
DATE 10/24/91
TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.49	2.47	2.40	2.63	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.30	2.41	2.49	2.66	
PULL #3	2.41	2.39	2.36	2.70	
PULL #4	2.48	2.48	2.48	2.65	
PULL #5	2.51	2.46	2.45	2.70	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.55	3.60		
PULL #2	3.40	3.51		
PULL #3	3.60	3.65		
PULL #4	3.61	3.52		
PULL #5	3.58	3.65		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.23	4.45		4.47
PULL #2	4.29	4.41		4.58
PULL #3	4.21	4.54		4.54
PULL #4	4.29	4.29		4.48
PULL #5	4.20	4.58		4.46
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665942
28 Oct 1991

CENTROIDAL DISTANCES

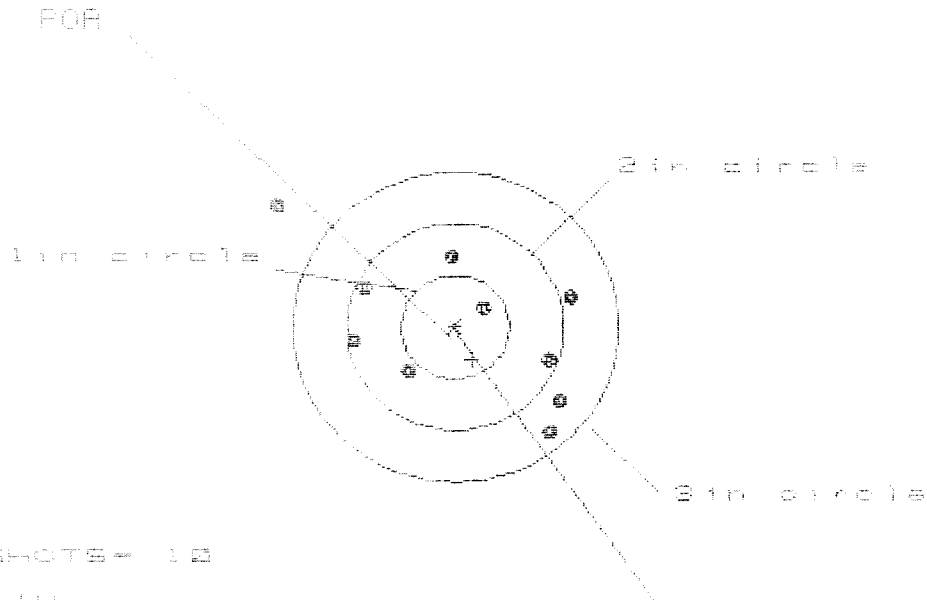
0 TO 1	.355563
1 TO 2	.492264
1 TO 3	.7206
1 TO 4	1.03106
1 TO 5	.813211

1 2
+
4 5
-----POR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .001
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1594
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .169400
THE AMR FOR THIS RIFLE IS: 1.046

FILE:/PATTERNING/CENTERFIRE_PATT/05665842

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN 1 IN

1 in = 1

2 in = 6

3 in = 9

HE= 3.734

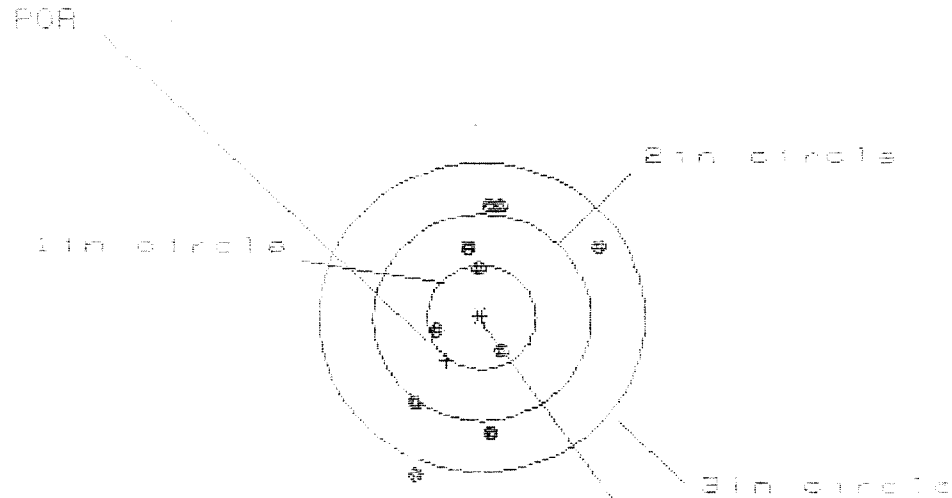
VE= 2.188

GE= 3.298

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.074	.809	.568
MINIMUM X	-1.680	-1.105	-1.026
MAXIMUM Y	1.144	.790	.676
MINIMUM Y	-1.036	-.905	-.737
CENTROID X	-.163	.032	-.057
CENTROID Y	.316	.189	.303
POB TO CENTROID in.	.355	.190	.308
MIN RADIUS	.319	.304	.244
MEAN RADIUS	.994	.865	.820
MAX RADIUS	2.016	1.118	1.115
HORIZONTAL SPREAD	2.734	1.934	1.994
VERTICAL SPREAD	2.188	1.699	1.413
EXTREME SPREAD	3.298	2.146	2.092
SHOTS IN ONE INCH CIRCLE =	1		
SHOTS IN TWO INCH CIRCLE =	6		
SHOTS IN THREE INCH CIRCLE =	9		

FILE:/PATTERNING/CENTERFIRE_PATT/C8865842

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 3

2in = 4

3in = 9

HS= 1.695

VS= 2.626

GS= 2.822

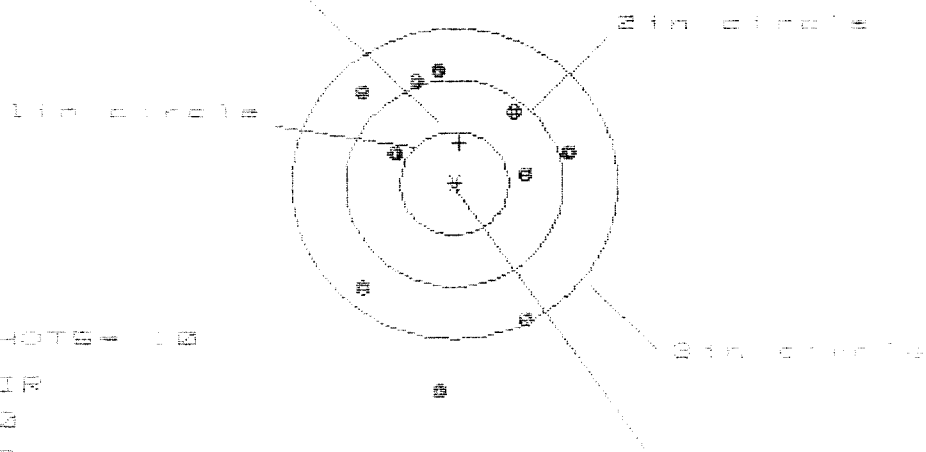
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.100	1.034	.289
MINIMUM X	:	-.595	-.659	-.529
MAXIMUM Y	:	1.072	.899	.966
MINIMUM Y	:	-1.554	-1.262	-1.196
CENTROID X	:	.319	.385	.255
CENTROID Y	:	.416	.589	.522
FOR TO CENTROID in.	:	.534	.703	.582
MIN RADIUS	:	.403	.289	.350
MEAN RADIUS	:	.914	.808	.757
MAX. RADIUS	:	1.664	1.262	1.200
HORIZONTAL SPREAD	:	1.695	1.693	.813
VERTICAL SPREAD	:	2.626	2.161	2.161
EXTREME SPREAD	:	2.822	2.273	2.163
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

10

FILE:/PATTERNING/CENTERFIRE_PATT/08685942

CENTERFIRE PATTERNS # 3

POB



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 3

3 in = 6

HS = 1.877

VS = 3.140

GS = 3.141

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.010	.991	1.074
MINIMUM X	-.867	-.886	-.800
MAXIMUM Y	1.139	.917	.721
MINIMUM Y	-2.001	-1.566	-1.410
CENTROID X	-.052	-.033	-.116
CENTROID Y	-.396	-.174	.020
POB TO CENTROID in.	.399	.177	.118
MIN RADIUS	.659	.618	.549
MEAN RADIUS	1.146	.999	.866
GR. RADIUS	2.009	1.704	1.623
HORIZONTAL SPREAD	1.877	1.877	1.877
VERTICAL SPREAD	3.140	2.483	2.131
EXTREME SPREAD	3.141	2.656	2.264
NUMBER IN ONE INCH CIRCLE =	1	0	0
NUMBER IN TWO INCH CIRCLE =	3	3	3
NUMBER IN THREE INCH CIRCLE =	6	6	6

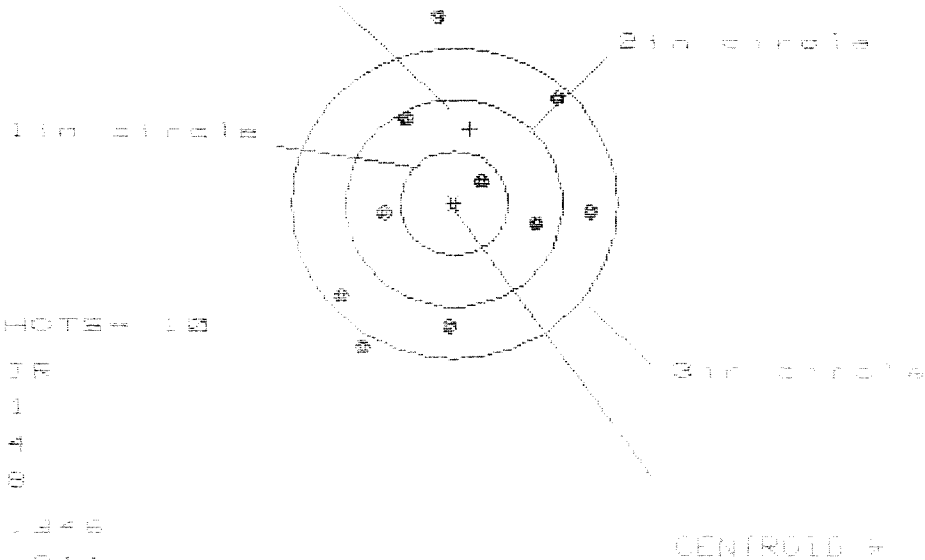
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CENTERFIRE PATTERNS

4

FOR



OF SHOTS = 10

IN CIR

1in = 1

2in = 4

3in = 5

HS = 2.246

VS = 3.211

GS = 3.291

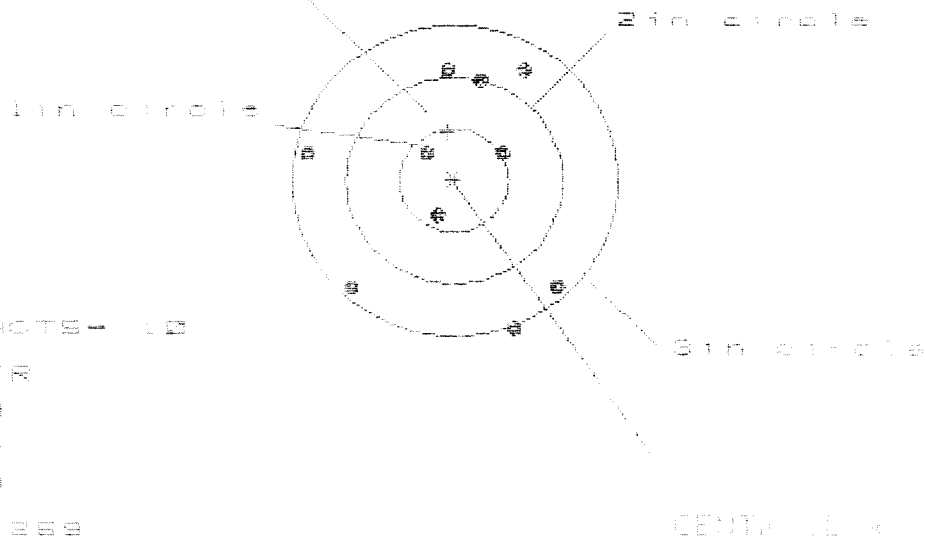
CENTROID +

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.264	1.249	1.198
MINIMUM X	:	-1.082	-1.098	-1.208
MAXIMUM Y	:	1.812	1.219	1.070
MINIMUM Y	:	-1.399	-1.198	-1.171
CENTROID X	:	-1.152	-1.136	-1.026
CENTROID Y	:	-1.715	-1.916	-1.787
FOR TO CENTROID in.	:	.731	.926	.767
1IN RADIUS	:	.290	.432	.248
2IN RADIUS	:	1.147	1.072	.990
3IN RADIUS	:	1.818	1.566	1.466
HORIZONTAL SPREAD	:	2.346	2.346	2.346
VERTICAL SPREAD	:	3.211	2.417	2.241
EXTREME SPREAD	:	3.291	3.053	2.852
NUMBER IN ONE INCH CIRCLE =		1		
NUMBER IN TWO INCH CIRCLE =		4		
NUMBER IN THREE INCH CIRCLE =		5		

CENTERFIRE PATTERNS

5

POB



PATTERN #	5		
SHOTS (EILT OF)	10	9	8
MAXIMUM X	1.951	1.008	1.045
MINIMUM X	-1.312	-1.261	-1.135
MAXIMUM Y	1.092	1.932	1.781
MINIMUM Y	-1.447	-1.210	-1.361
CENTROID X	1.050	-1.004	-1.100
CENTROID Y	-1.460	-1.008	-1.107
XY TO CENTROID In.	1.471	1.000	1.204
1st RADIUS	1.367	1.252	1.118
2nd RADIUS	1.027	1.945	1.844
3rd RADIUS	1.536	1.571	1.557
1st RADIUS SPREAD	2.289	2.269	1.980
2nd RADIUS SPREAD	2.539	2.142	2.142
3rd RADIUS SPREAD	2.675	2.675	2.675
1st RADIUS ONE INCH CIRCLE	=	3	
2nd RADIUS ONE INCH CIRCLE	=	4	
3rd RADIUS ONE INCH CIRCLE	=	9	