

FORM

CAPACITY*

*INCLUDES 1 IN CHAMBER

C6665965

UPC



0 47700 25716 7

MODEL 700 TM M24

ORDER NO. 5716

BARREL LENGTH

Remington



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

MODEL 700TM M24

SERIAL NO.

C6665965

ORDER NO.

5716

20

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



5716 C6665965

ORDER 5716

MODEL 700TM M24

UPC

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MODEL 700TM M24

UPC



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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6665965

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	9/30/91	KL
600	Proof		9/30/91	KL
607	Check Headspace		9/30/91	KL
610	Dis-assemble Gun		9/30/91	KL
612	Magnaflux Barrel Action	OCT	8 1991	KR
	Magnaflux Bolt	OCT	8 1991	KR
615	Rollmark Caliber	OCT	8 1991	LS
617	Drill and Tap Sight Holes	OCT	8 1991	LS
618	Polish Barrel		10/14/91	WB
620	Apply Coatings (Barrel Action)		11-51	KL
	Apply Coating (Bolt)			KL
625	Final Assembly A) Clean inside of Bolt Assembly		11/26/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/26/91	KL
	C) Inspect Ejector Hole for Chamfer		11/26/91	KL
	D) Oil Firing Pin Ass'y		11/26/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		12-2-91	KL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			12-2-91	JK
	G) Safety Off Force	3	3	3			12-2-91	JK
	H) Trigger Pull Test & Retainability						12-2-91	JK
	I) Firing Pin Indent	10205	10205	10205			12-2-91	JK
	J) Assemble Stock						12-2-91	JK
	K) Assemble Swivel Studs						12-7-91	AC
	L) Attach Front and Rear Sight Assemblies						12-2-91	JK
	M) Iron Sight Alignment						12-2-91	JK
	N) Detach Front & Rear Sights & place in numbered container						12-2-91	JK
	O) Attach Scope to Rifle						12-2-91	JK
	P) Detach & Attach Scope 20 Times						12-2-91	JK
640	Gallery Target & Test						12-3-91	N
	A) Time						"	N
	B) Malfunctions						"	N
	C) Pierced Primers						"	N
	D) Optical Clarity of Scope						"	N
645	Inspect for Live Ammo						12-3-91	N
655	Final Inspection							
	A) Headspace						12-7-91	AC
	B) Trigger Pull	2.80	2.78	2.77	2.80	2.73	12-5-91	AC
	C) Function						12-7-91	AC
660	Pack						12-19-91	N

SWS TRIGGER PULL TEST

ETAQ

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. 06665965

DATE 12-2-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.22	2.36	2.40	2.80	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.39	2.44	2.78	
PULL #3	2.33	2.34	2.39	2.77	
PULL #4	2.36	2.37	2.30	2.80	
PULL #5	2.36	2.38	2.48	2.73	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.30	3.52		
PULL #2	3.28	3.32		
PULL #3	3.38	3.53		
PULL #4	3.51	3.57		
PULL #5	3.34	3.51		
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	4.42		4.40
PULL #2	4.44	4.42		4.37
PULL #3	4.43	4.32		4.37
PULL #4	4.33	4.29		4.31
PULL #5	4.42	4.44		4.44
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06665965
3 Dec 1991

CENTROIDAL DISTANCES

0 TO	1	.543007
1 TO	2	.0601664
1 TO	3	.305792
1 TO	4	.482296
1 TO	5	.553507

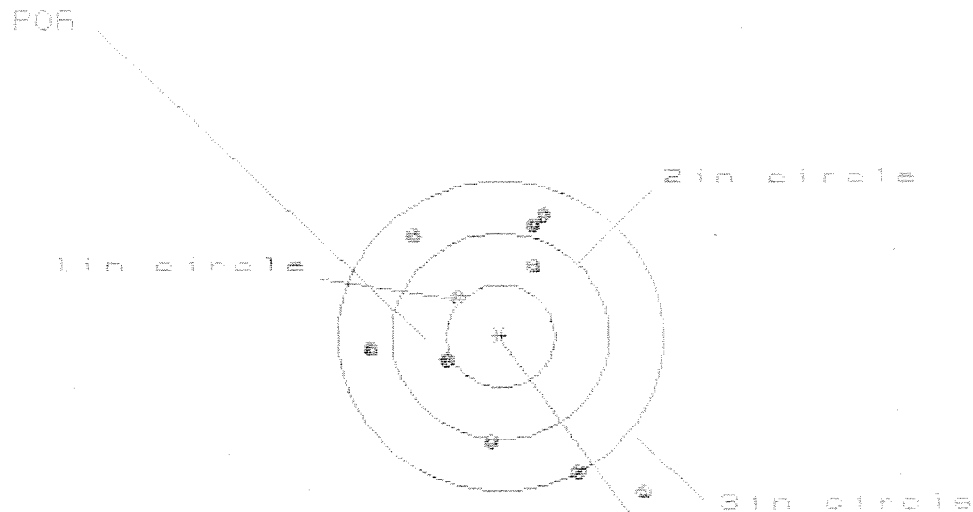
$\frac{5}{4}x^2$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2654
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1688
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .14500
THE AVE FOR THIS RIFLE IS: .9854

08/1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8685965

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 9

3 in = 9

HS= 2.554

VS= 2.789

GS= 3.258

CENTROID #

PATTERN #

SHOTS (BEST OF)

MAXIMUM X

MINIMUM X

MAXIMUM Y

MINIMUM Y

CENTROID X

CENTROID Y

POB TO CENTROID (in)

1 in radius

2 in radius

3 in radius

1 in spread

2 in spread

3 in spread

100% - ONE INCH CIRCLE =

100% - TWO INCH CIRCLE =

100% - THREE INCH CIRCLE =

10

9

8

1.349

.848

.666

-1.205

-1.055

-.958

1.222

1.048

.866

1.567

-1.453

-1.349

.496

.346

.241

.221

.395

.577

.543

.526

.625

.552

.325

.156

1.115

.957

.824

2.068

1.682

1.354

2.554

1.903

1.616

2.789

2.501

2.215

3.258

2.647

2.282

6

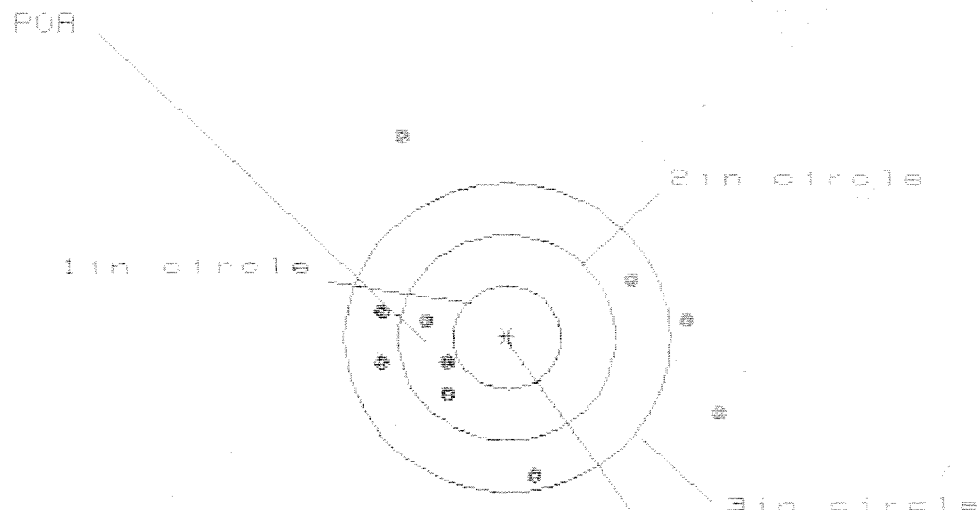
2

9

3 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8665965

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 0

2in = 3

3in = 7

HS= 3.162

VS= 3.254

GS= 3.996

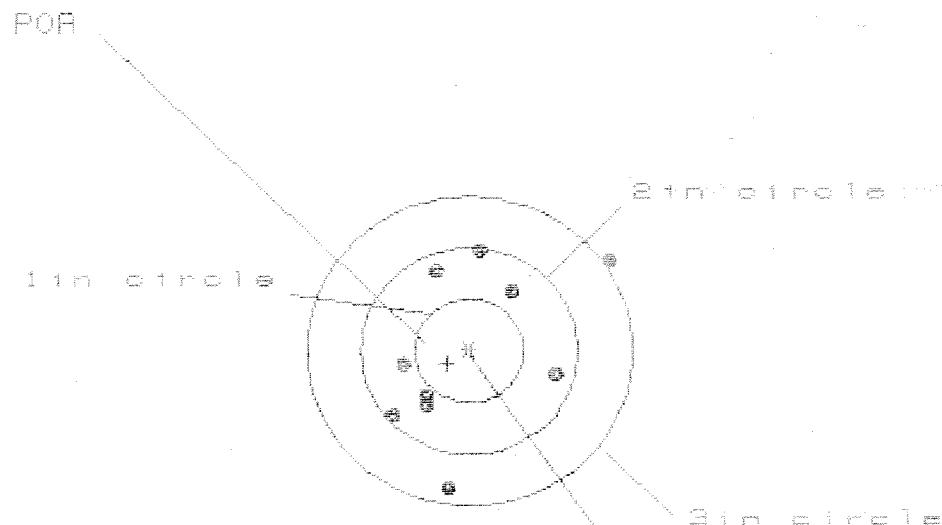
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.983	1.875	1.887
MINIMUM X	:	-1.179	-1.287	-1.053
MAXIMUM Y	:	1.948	.786	.720
MINIMUM Y	:	-1.306	-1.089	-1.155
CENTROID X	:	.554	.652	.428
CENTROID Y	:	.237	.020	.086
POR TO CENTROID in.	:	.603	.663	.437
MIN RADIUS	:	.601	.657	.432
MEAN RADIUS	:	1.305	1.206	1.039
MAX RADIUS	:	2.177	1.947	1.830
HORIZONTAL SPREAD	:	3.162	3.162	2.868
VERTICAL SPREAD	:	3.254	1.875	1.875
EXTREME SPREAD	:	3.996	3.319	2.863
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		7	

3 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06665965

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 0

2in = 8

3in = 9

HS= 2.045

VS= 2.241

GS= 2.636

CENTROID #

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.301
MINIMUM X	-.744
MAXIMUM Y	.956
MINIMUM Y	-1.285
CENTROID X	.206
CENTROID Y	.124
POR TO CENTROID in.	.241
MIN RADIUS	.574
MEAN RADIUS	.904
MAX RADIUS	1.559
HORIZONTAL SPREAD	2.045
VERTICAL SPREAD	2.241
EXTREME SPREAD	2.636
NUMBER IN ONE INCH CIRCLE	0
NUMBER IN TWO INCH CIRCLE	8
NUMBER IN THREE INCH CIRCLE	9

3 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08665985

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 1.455

VS= 2.420

GS= 2.475

CENTROID #

PATTERN #

4

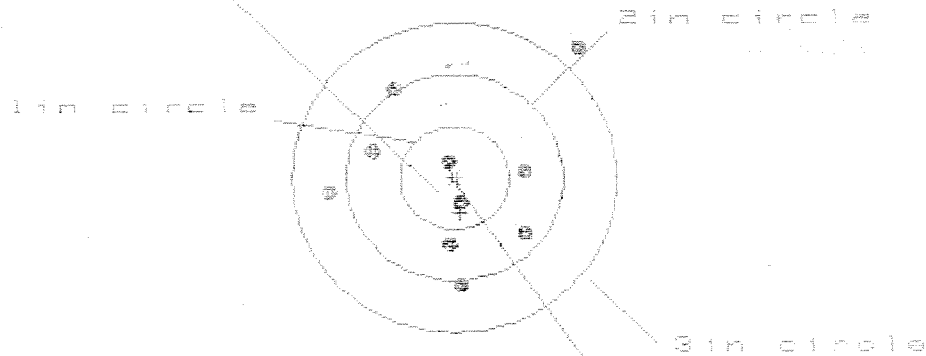
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.845	.778	.770
MINIMUM X	-.611	-.638	-.646
MAXIMUM Y	1.054	.902	.714
MINIMUM Y	-1.366	-1.504	-.695
CENTROID X	.116	.183	.191
CENTROID Y	-.076	.076	.264
POA TO CENTROID in.	.138	.199	.326
MIN RADII	.119	.151	.199
MEAN RADIUS	.788	.686	.571
MAX RADII	1.497	1.505	.963
HORIZONTAL SPREAD	1.456	1.416	1.416
VERTICAL SPREAD	2.420	2.406	1.409
EXTREME SPREAD	2.475	2.475	1.691
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

13 Dec 1991

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CENTERFIRE PATTERNS # 5

POA



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 7

3 in = 8

HS= 2.254

VS= 2.252

GS= 2.620

CENTROID #

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.146	.763	.640
MINIMUM X	-1.108	-.980	-.712
MAXIMUM Y	1.226	.949	.952
MINIMUM Y	-1.026	-.890	-.887
CENTROID X	-.045	-.173	-.050
CENTROID Y	.038	.202	.139
POA TO CENTROID in.	.341	.266	.205
MIN RADIUS	.223	.220	.135
MEAN RADIUS	.815	.705	.651
MAX RADIUS	1.678	1.023	1.077
HORIZONTAL SPREAD	2.254	1.743	1.352
VERTICAL SPREAD	2.252	1.839	1.839
EXTREME SPREAD	2.620	1.916	1.916
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	