

FORM

UPC



0 47700 25716 7

C6665985

*INCLUDES 1 IN CHAMBER

CAPACITY*

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.
C6665985

20

ORDER NO.
5716

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



5716 C6665985

ORDER **5716**
MODEL 700TM M24

UPC



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ORDER **5716**
MODEL 700TM M24

UPC



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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6665985

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		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	SL
617	Drill and Tap Sight Holes	OCT	8 1991	LB
618	Polish Barrel		10/14/91	WLB
620	Apply Coatings (Barrel Action)		11/1/91	WLB
	Apply Coating (Bolt)		11/1/91	WLB
625	Final Assembly A) Clean inside of Bolt Assembly		11/6/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/6/91	KL
	C) Inspect Ejector Hole for Chamfer		11/6/91	KL
	D) Oil Firing Pin Ass'y		11/6/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		11/7/91	KL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			11-7-91	JK
	G) Safety Off Force	3	3	3			11-7-91	JK
	H) Trigger Pull Test & Retainability						11/7/91	JK
	I) Firing Pin Indent	.0215	.0215	.0215			11-7-91	JK
	J) Assemble Stock						11/7/91	JK
	K) Assemble Swivel Studs						11-18-91	DH
	L) Attach Front and Rear Sight Assemblies						11/7/91	JK
	M) Iron Sight Alignment						11/7/91	JK
	N) Detach Front & Rear Sights & place in numbered container						11/7/91	JK
	O) Attach Scope to Rifle						11/7/91	JK
	P) Detach & Attach Scope 20 Times						11/7/91	JK
640	Gallery Target & Test						11-14-91	N
	A) Time						"	N
	B) Malfunctions						"	N
	C) Pierced Primers						"	N
	D) Optical Clarity of Scope						"	N
645	Inspect for Live Ammo						11-14-91	N
655	Final Inspection							
	A) Headspace						11-18-91	DH
	B) Trigger Pull	280	285	285	285	251	11-18-91	DH
	C) Function						11-18-91	DH
660	Pack						12-17-91	N

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. C-6665985DATE 11-7-91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.32	2.43	2.50	2.80	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.24	2.41	2.52	2.85	
PULL #3	2.37	2.38	2.49	2.85	
PULL #4	2.39	2.40	2.53	2.85	
PULL #5	2.34	2.48	2.50	2.51	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.62	3.47		
PULL #2	3.60	3.48		
PULL #3	3.54	3.55		
PULL #4	3.56	3.56		
PULL #5	3.42	3.53		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.26	4.46		4.40
PULL #2	4.23	4.49		4.50
PULL #3	4.41	4.48		4.57
PULL #4	4.46	4.53		4.53
PULL #5	4.44	4.52		4.53
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665985
15 Nov 1991

CENTROIDAL DISTANCES

0 TO 1	.237508
1 TO 2	.588903
1 TO 3	.419698
1 TO 4	.263797
1 TO 5	.570215

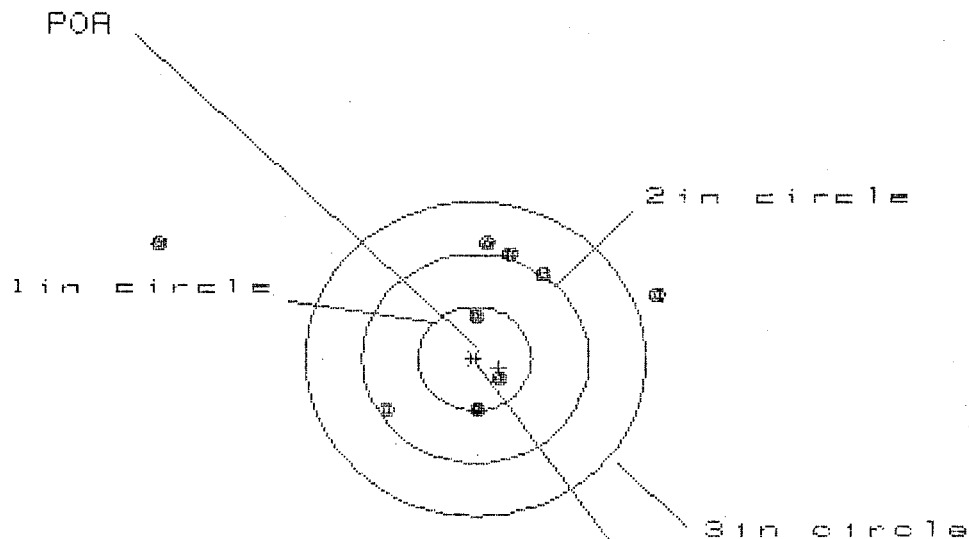
1st <----POA

COORDINATE FOR THIS RIFLE IS: .098
COORDINATE FOR THIS RIFLE IS: -.0984
POI RADIUS FOR THIS RIFLE IS: .137466
RIFLE IS: 1.049

15 NOV 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66859B5

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 4

3 in = 7

HS= 4.456

VS= 5.005

GS= 6.021

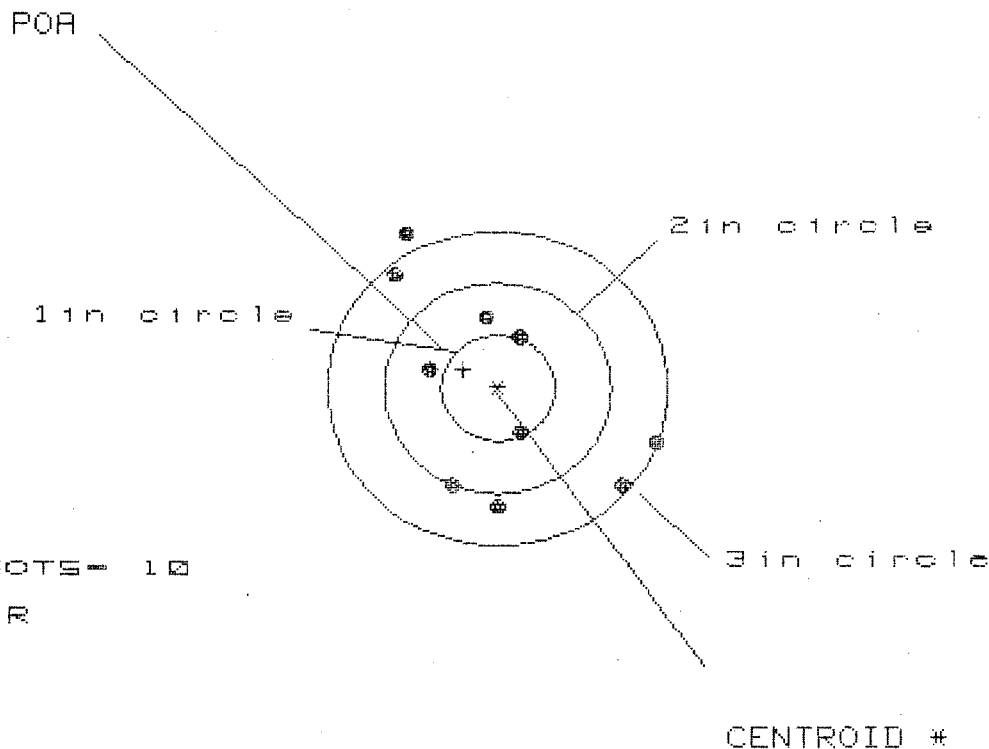
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.645	1.714	1.371
MINIMUM X	-2.811	-2.742	-1.073
MAXIMUM Y	1.142	.713	.795
MINIMUM Y	-3.863	-.962	-.880
CENTROID X	-.211	-.280	.063
CENTROID Y	.087	.516	.434
TO CENTROID in.	.228	.587	.439
RADIUS	.306	.122	.230
IN RADIUS	1.410	1.080	.814
RADIUS	3.912	2.819	1.401
HORIZONTAL SPREAD	4.456	4.456	2.444
VERTICAL SPREAD	5.005	1.675	1.675
EXTREME SPREAD	6.021	4.479	2.690
NUMBER IN ONE INCH CIRCLE	= 2		
NUMBER IN TWO INCH CIRCLE	= 4		
NUMBER IN THREE INCH CIRCLE	= 7		

15 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665985

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.293

VS= 2.605

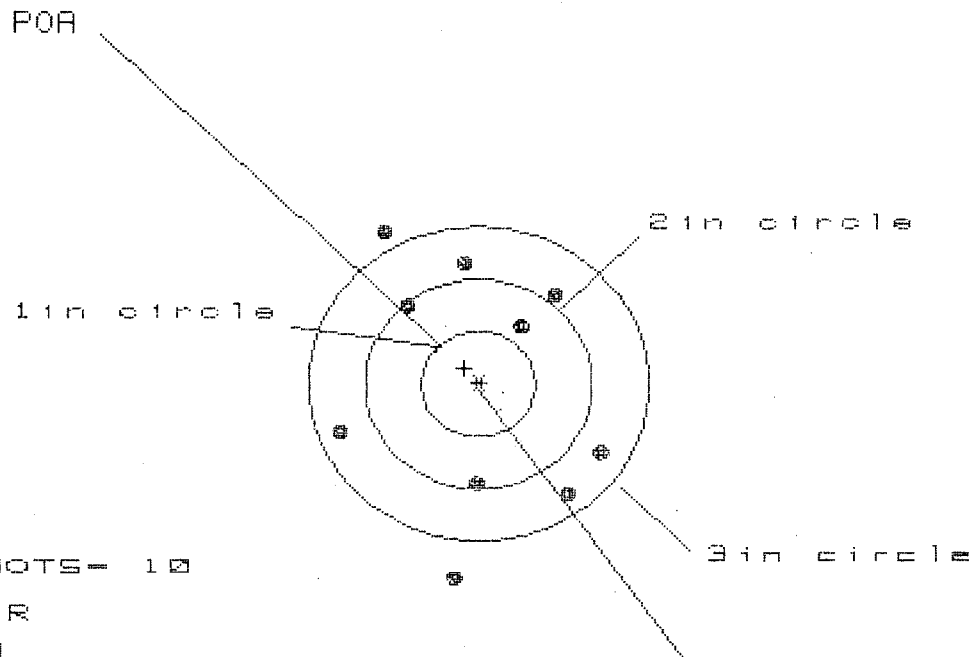
GS= 3.063

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.377	1.283	1.190
MINIMUM X	:	-.916	-1.010	-.850
MAXIMUM Y	:	1.472	1.239	1.192
MINIMUM Y	:	-1.133	-.970	-1.017
CENTROID X	:	.304	.398	.238
CENTROID Y	:	-.182	-.345	-.298
POA TO CENTROID in.	:	.354	.527	.381
MIN RADIUS	:	.460	.274	.392
MEAN RADIUS	:	1.038	.952	.894
MAX RADIUS	:	1.698	1.599	1.464
HORIZONTAL SPREAD	:	2.293	2.293	2.040
VERTICAL SPREAD	:	2.605	2.209	2.209
EXTREME SPREAD	:	3.063	2.821	2.821
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

15 Nov 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 0

2in = 3

3in = 8

HS= 2.324

VS= 3.225

GS= 3.280

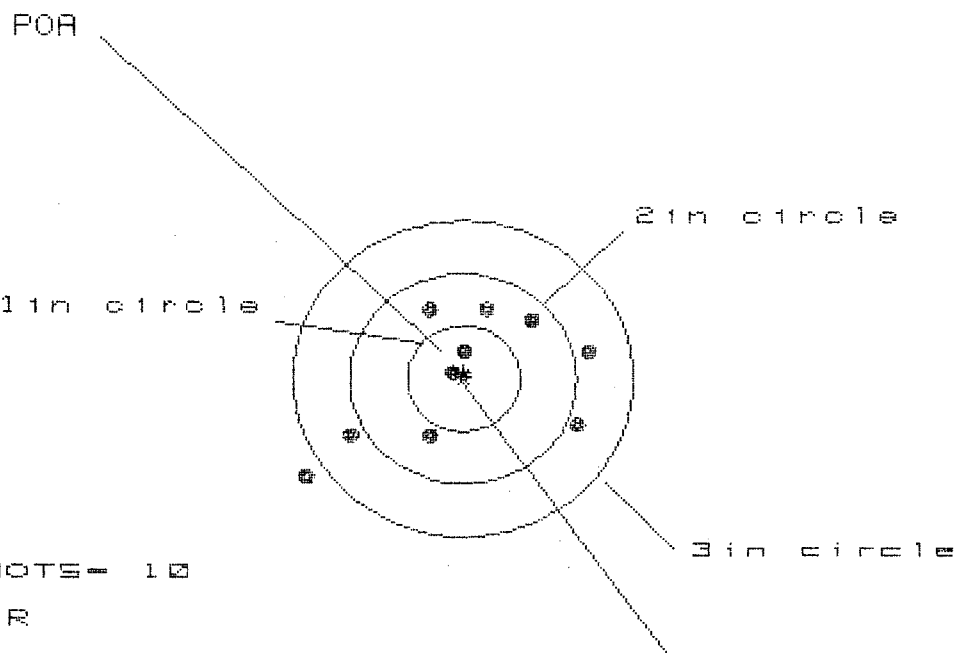
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.115	1.091	.987
MINIMUM X	:	-1.209	-1.233	-1.337
MAXIMUM Y	:	1.425	1.225	1.130
MINIMUM Y	:	-1.800	-1.219	-1.066
CENTROID X	:	.124	.148	.252
CENTROID Y	:	-.152	.048	-.105
POA TO CENTROID in.	:	.196	.155	.273
MIN RADIUS	:	.680	.516	.571
MEAN RADIUS	:	1.214	1.117	1.071
MAX RADIUS	:	1.813	1.482	1.416
HORIZONTAL SPREAD	:	2.324	2.324	2.324
VERTICAL SPREAD	:	3.225	2.444	2.196
EXTREME SPREAD	:	3.280	2.936	2.377
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

15 Nov 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.486

VS= 1.631

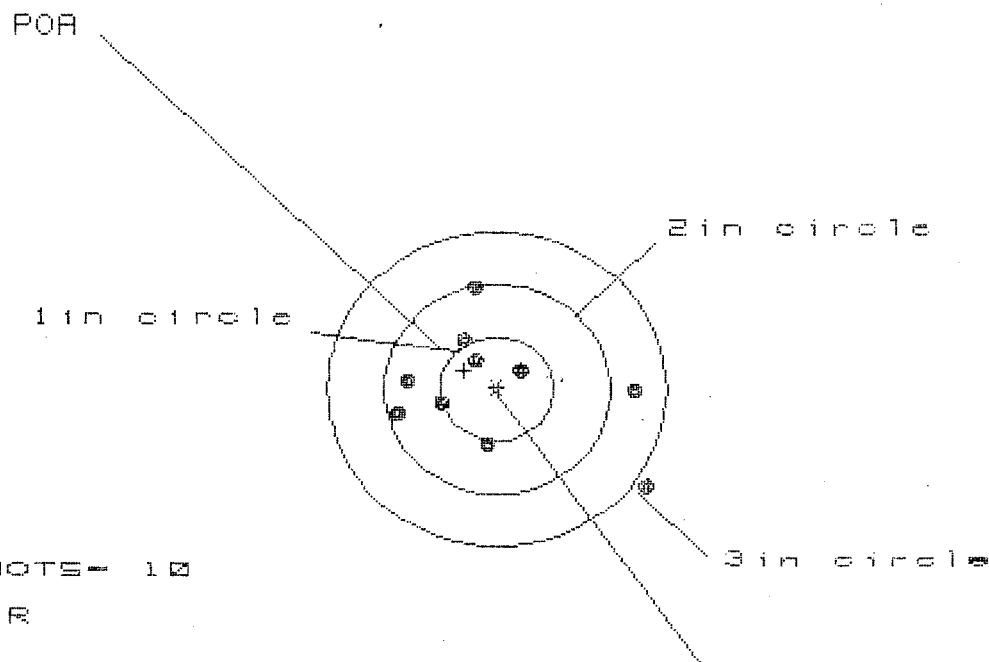
GS= 2.748

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.120	.968	.988
MINIMUM X	:	-1.366	-1.123	-1.002
MAXIMUM Y	:	.686	.581	.596
MINIMUM Y	:	-.945	-.652	-.637
CENTROID X	:	-.004	.148	.026
CENTROID Y	:	-.063	.042	.027
POA TO CENTROID in.	:	.063	.154	.038
MIN RADIUS	:	.058	.172	.097
MEAN RADIUS	:	.819	.710	.657
MAX RADIUS	:	1.661	1.298	1.187
HORIZONTAL SPREAD	:	2.486	2.091	1.990
VERTICAL SPREAD	:	1.631	1.233	1.233
EXTREME SPREAD	:	2.748	2.229	1.994
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 9

HS= 2.192

VS= 1.916

GS= 2.431

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.344
MINIMUM X	-.848
MAXIMUM Y	.987
MINIMUM Y	-.929
CENTROID X	.287
CENTROID Y	-.172
POA TO CENTROID in.	.334
MIN RADIUS	.280
MEAN RADIUS	.766
MAJ. RADIUS	1.634
HORIZONTAL SPREAD	2.192
VERTICAL SPREAD	1.916
EXTREME SPREAD	2.431
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	8
NUMBER IN THREE INCH CIRCLE =	9

