

FORM

UPC



0 47700 25716 7

C6665990

*INCLUDES 1 IN CHAMBER

CAPACITY*

MODEL 700 TM M24

ORDER NO. 572

BARREL LENGTH

Remington



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

MODEL 700TM M24

SERIAL NO.
C6665990

20

ORDER NO.
5716

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



5716 C6665990

ORDER 5716
MODEL 700TM M24
UPC



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ORDER 5716
MODEL 700TM M24
UPC



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6665990

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	GL
617	Drill and Tap Sight Holes		OCT 8 1991	LB
618	Polish Barrel		10/14/91	WB
620	Apply Coatings (Barrel Action)		11/1/91	KL
	Apply Coating (Bolt)		11/1/91	KL
625	Final Assembly A) Clean inside of Bolt Assembly		11/21/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/21/91	KL
	C) Inspect Ejector Hole for Chamfer		11/21/91	KL
	D) Oil Firing Pin Ass'y		11/21/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		11-22-91	KL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	6	6			11/25/91	JK
	G) Safety Off Force	4	4	4			11/25/91	JK
	H) Trigger Pull Test & Retainability						11-22-91	JK
	I) Firing Pin Indent	.0205	.0205	.0205			11-25-91	JK
	J) Assemble Stock						11/25/91	JK
	K) Assemble Swivel Studs						11-27-91	D/H
	L) Attach Front and Rear Sight Assemblies						11/25/91	JK
	M) Iron Sight Alignment						11/25/91	JK
	N) Detach Front & Rear Sights & place in numbered container						11/25/91	JK
	O) Attach Scope to Rifle						11/25/91	JK
	P) Detach & Attach Scope 20 Times						11/25/91	JK
640	Gallery Target & Test						11-26-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						11-26-91	NF
655	Final Inspection						11-27-91	D/H
	A) Headspace						11-27-91	D/H
	B) Trigger Pull	237	237	229	238	239	11-27-91	D/H
	C) Function						11-27-91	D/H
660	Pack						12-19-91	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS2.50# + .50#
3.00# + .75#
4.00# + 1.00#SERIAL NO. C-6665990DATE 11-22-91TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.62	2.54	2.55	2.37	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.53	2.68	2.25	2.37	
PULL #3	2.51	2.69	2.48	2.29	
PULL #4	2.54	2.68	2.60	2.38	
PULL #5	2.59	2.68	2.61	2.39	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.31	3.42		
PULL #2	3.19	3.46		
PULL #3	3.45	3.46		
PULL #4	3.34	3.34		
PULL #5	3.35	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	4.47	4.48		4.36
PULL #2	4.53	4.39		4.42
PULL #3	4.25	4.36		4.41
PULL #4	4.31	4.19		4.37
PULL #5	4.27	4.22		4.43
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06668990
28 Nov 1991

CENTROIDAL DISTANCES

0 TO	1	.21285
1 TO	2	.288196
1 TO	3	.195243
1 TO	4	.180942
1 TO	5	.332862

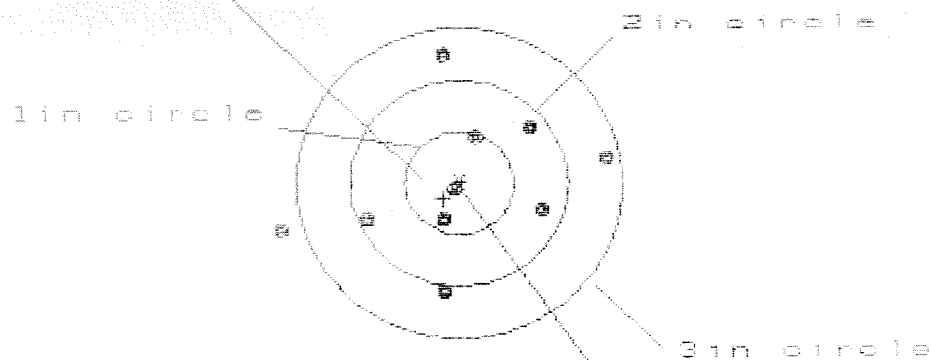
32 <----POA

COORDINATE FOR THIS RIFLE IS: .0656
COORDINATE FOR THIS RIFLE IS: -.0146
LARGE POI RADIUS FOR THIS RIFLE IS: .0572051
LARGE IS: .0656

CENTERFIRE PATTERNS

1

FOR



OF SHOTS= 10

IN CIR

1in = 3

2in = 6

3in = 9

HS= 3.028

VS= 2.365

GS= 3.108

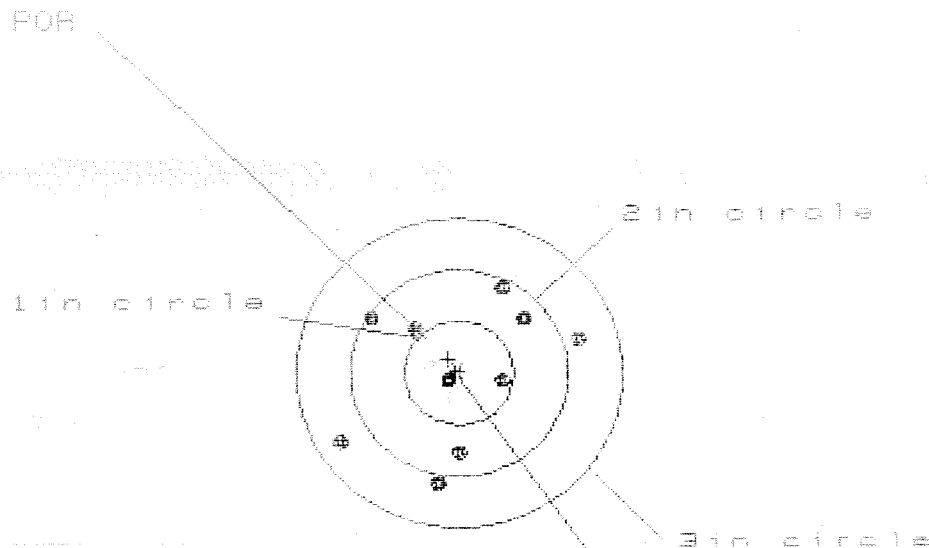
CENTROID *

PATTERN #		1	9	8
SHOTS BEST OF		10	9	8
MAXIMUM X		1.352	1.166	.673
MINIMUM X		-1.676	-1.040	-.894
MAXIMUM Y		1.282	1.227	1.246
MINIMUM Y		-1.083	-1.138	-1.119
CENTROID X		.149	.335	.189
CENTROID Y		.152	.207	.188
FOR THE CENTROID (in.)		.212	.394	.267
1st PHASE		.024	.210	.077
2nd PHASE		.890	.794	.720
3rd PHASE		1.748	1.261	1.254
HORIZONTAL SPREAD		3.028	2.206	1.567
VERTICAL SPREAD		2.365	2.365	2.365
ELLIPSE SPREAD		3.108	2.365	2.365
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

26 Nov 1981

FILE:/PATTERNING/CENTERFIRE PAIT/C8605390

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 2.251

VS= 1.936

GS= 2.469

CENTROID #

PATTERN #

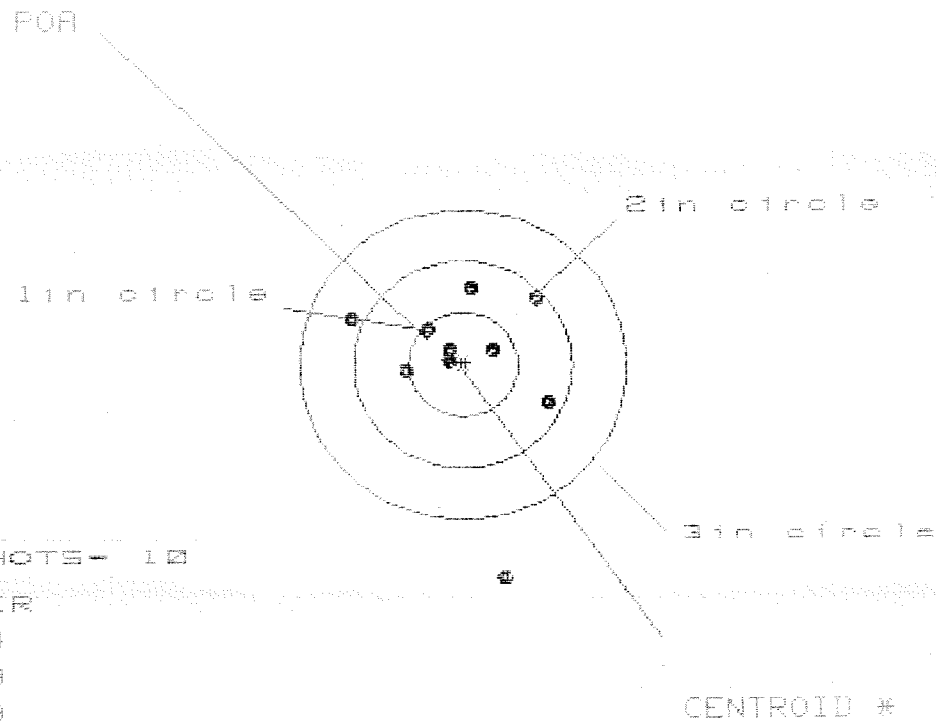
2

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.105	.978	.585
MINIMUM X	-1.145	-.899	-.777
MAXIMUM Y	.832	.755	.785
MINIMUM Y	-1.104	-1.181	-1.151
CENTROID X	.100	.228	.105
CENTROID Y	-.132	-.055	-.085
POR TO CENTROID in.	.166	.234	.136
MIN RADIUS	.081	.230	.113
MEAN RADIUS	.805	.738	.695
MAX RADIUS	1.339	1.222	1.167
HORIZONTAL SPREAD	2.251	1.877	1.363
VERTICAL SPREAD	1.936	1.936	1.936
EXTREME SPREAD	2.469	2.022	2.022
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

23 NOV 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06685990

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 4

2in = 6

3in = 8

HS= 1.774

VS= 2.722

GS= 2.851

PATTERN #

3

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.783

.825

.787

MINIMUM X

-.991

-.949

-.643

MAXIMUM Y

.795

.488

.513

MINIMUM Y

-2.018

-.688

-.575

CENTROID X

.127

.085

.283

CENTROID Y

-.042

.183

.150

POR TO CENTROID in.

.133

.201

.253

MIN RADIUS

.124

.139

.217

MEAN RADIUS

.737

.547

.500

MAX RADIUS

2.053

1.025

.911

HORIZONTAL SPREAD

1.774

1.774

1.350

VERTICAL SPREAD

2.722

1.088

1.088

EXTREME SPREAD

2.851

1.975

1.391

NUMBER IN ONE INCH CIRCLE =

4

NUMBER IN TWO INCH CIRCLE =

6

NUMBER IN THREE INCH CIRCLE =

9

20 Nov 1931

FILE:/PATTERNING/CENTERFIRE_PATT/C6685990

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 10

HS= 1.991

VS= 2.198

GS= 2.356

CENTROID *

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.066

1.118

1.009

MINIMUM X

-.925

-.873

-.886

MAXIMUM Y

1.231

.756

.611

MINIMUM Y

-.967

-.931

-.736

CENTROID X

.077

.025

.134

CENTROID Y

-.014

-.150

-.245

POA TO CENTROID in.

.078

.153

.279

MIN RADIUS

.424

.568

.445

MEAN RADIUS

.850

.792

.730

MAX RADIUS

1.316

1.155

1.017

HORIZONTAL SPREAD

1.991

1.991

1.895

VERTICAL SPREAD

2.198

1.587

1.347

EXTREME SPREAD

2.356

2.181

1.957

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

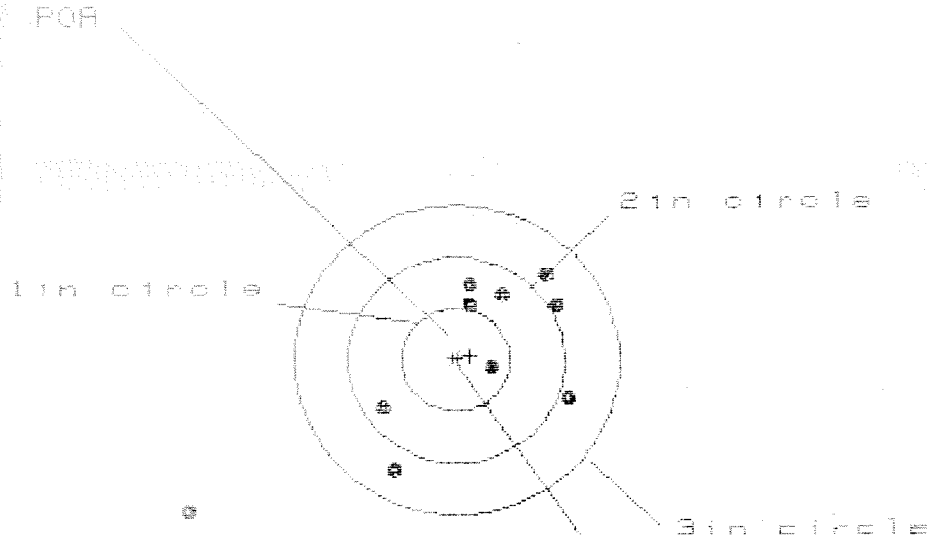
6

NUMBER IN THREE INCH CIRCLE =

10

FILE:/PATTERNING/CENTERFIRE_PATT/C6685990

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 3.533

VS= 2.270

GS= 4.044

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.011
MINIMUM X	-2.522
MAXIMUM Y	.845
MINIMUM Y	-1.425
CENTROID X	-.125
CENTROID Y	-.037
POA TO CENTROID IN.	.131
MIN RADIUS	.294
MEAN RADIUS	1.052
MAX RADIUS	2.896
HORIZONTAL SPREAD	3.533
VERTICAL SPREAD	2.270
EXTREME SPREAD	4.044
NUMBER IN ONE INCH CIRCLE	1
NUMBER IN TWO INCH CIRCLE	5
NUMBER IN THREE INCH CIRCLE	9