

FORM

UPC



0 47700 25716 7

C6665781

INCLUDED IN CHAIRMAN

MODEL 700 TM M24

ORDER NO. 5716

BARREL LENGTH

CAPACITY*

Remington



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

MODEL 700 TM M24

SERIAL NO.
C6665781

20

ORDER NO.
5716

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



5716 C6665781

ORDER 5716

MODEL 700 TM M24

UPC

ORDER 5716

MODEL 700 TM M24

UPC



0 47700 25716 7



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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

6665781

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/1/91	KH
600	Proof		10/1/91	KH
607	Check Headspace		10/1/91	KH
610	Dis-assemble Gun		10/1/91	KH
612	Magnaflux Barrel Action		OCT 8 1991	KR
	Magnaflux Bolt		OCT 8 1991	KR
615	Rollmark Caliber		OCT 8 1991	GB
617	Drill and Tap Sight Holes		OCT 8 1991	FB
618	Polish Barrel		10/14/91	WB
620	Apply Coatings (Barrel Action)		11-1-91	11-1-91
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/26/91	KH
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/26/91	KH
	C) Inspect Ejector Hole for Chamfer		11/26/91	KH
	D) Oil Firing Pin Ass'y		11/26/91	KH
	E) Adjust Trigger Pull to Min Setting and Stake		12-2-91	JK

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			12-2-91	SL
	G) Safety Off Force	3	3	3			12-2-91	SL
	H) Trigger Pull Test & Retainability						12-2-91	SL
	I) Firing Pin Indent	.0205	.0205	.0205			12-2-91	SL
	J) Assemble Stock						12/2/91	SL
	K) Assemble Swivel Studs						12-7-91	AC
	L) Attach Front and Rear Sight Assemblies						12/2/91	SL
	M) Iron Sight Alignment						12/2/91	SL
	N) Detach Front & Rear Sights & place in numbered container						12/2/91	SL
	O) Attach Scope to Rifle						12/2/91	SL
	P) Detach & Attach Scope 20 Times						12/2/91	SL
640	Gallery Target & Test						12-3-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						12-3-91	AF
655	Final Inspection							
	A) Headspace						12-4-91	AC
	B) Trigger Pull	268	249	249	242	219	12-4-91	DH
	C) Function						12-7-91	AC
660	Pack						12-19-91	AF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6665781

DATE 12-2-91

TESTER X

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.29	2.38	2.44	2.68	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.28	2.38	2.32	2.49	
PULL #3	2.37	2.42	2.39	2.49	
PULL #4	2.37	2.37	2.40	2.42	
PULL #5	2.46	2.33	2.44	2.19	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.43	3.41		
PULL #2	3.42	3.45		
PULL #3	3.47	3.48		
PULL #4	3.47	3.40		
PULL #5	3.35	3.48		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.69	4.38		4.39
PULL #2	4.14	4.42		4.20
PULL #3	4.36	4.39		4.35
PULL #4	4.20	4.45		4.43
PULL #5	4.47	4.41		4.38
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665781
3 Dec 1991

CENTROIDAL DISTANCES

0 TO	1	.605486
1 TO	2	.991561
1 TO	3	.528366
1 TO	4	.146349
1 TO	5	.400078

2 to 4 <----POA

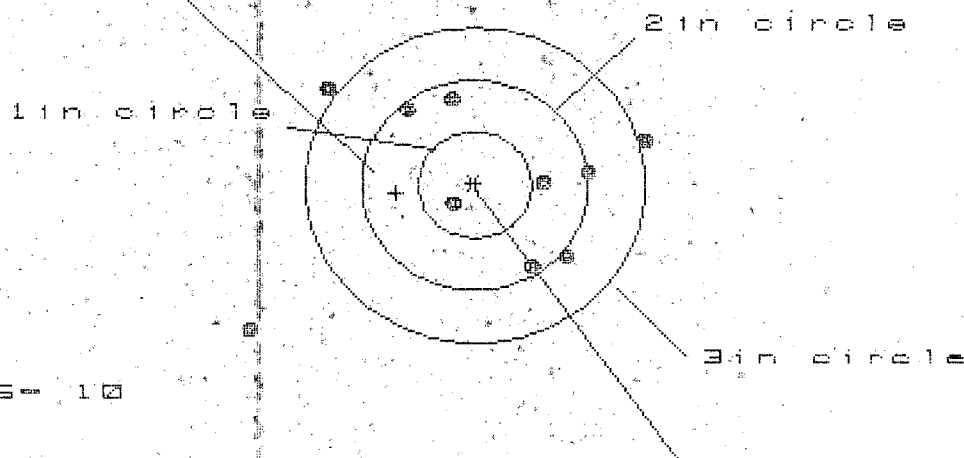
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2278
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0828
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .242381
THE AMR FOR THIS RIFLE IS: 1.07

3 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665781

CENTERFIRE PATTERNS # 4

POA



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 6

3 in = 7

HS = 3.5007

VS = 2.284

GS = 0.059

CENTROID *

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.547

1.329

1.134

MINIMUM X

-1.960

-1.558

-1.027

MAXIMUM Y

.907

.754

.737

MINIMUM Y

-1.377

-.916

-.821

CENTROID X

.695

.913

1.108

CENTROID Y

.074

.227

.132

POA TO CENTROID in.

.699

.941

1.116

MIN RADIUS

.284

.368

.156

MEAN RADIUS

1.119

.949

.809

MAX RADIUS

2.395

1.731

1.216

HORIZONTAL SPREAD

3.507

2.887

2.161

VERTICAL SPREAD

2.284

1.670

1.558

EXTREME SPREAD

3.959

2.922

2.175

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

6

NUMBER IN THREE INCH CIRCLE =

7

3 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6865781

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIRC

1 in = 3

2 in = 8

3 in = 9

HS = 1.471

VS = 2.514

GS = 2.851

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.651

.710

.614

MINIMUM X

-.820

-.761

-.590

MAXIMUM Y

.834

.648

.573

MINIMUM Y

-1.680

-.833

-.752

CENTROID X

.191

.132

.228

CENTROID Y

.079

.265

.184

POA TO CENTROID in.

.206

.297

.293

MIN RADIUS

.218

.305

.208

MEAN RADIUS

.752

.617

.566

MAX RADIUS

1.760

1.049

.927

HORIZONTAL SPREAD

1.471

1.471

1.204

VERTICAL SPREAD

2.514

1.481

1.325

EXTREME SPREAD

2.851

2.037

1.642

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

8

NUMBER IN THREE INCH CIRCLE =

9

3 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66657B1

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS - 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS = 2.556

VS = 1.750

GS = 2.056

PATTERN #

3

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.249

1.092

.539

MINIMUM X

-1.417

-.935

-.798

MAXIMUM Y

.758

.817

.762

MINIMUM Y

-.992

-.933

-.988

CENTROID X

.076

.233

.097

CENTROID Y

.022

-.037

.019

POA TO CENTROID in.

.079

.236

.098

MIN RADIUS

.249

.240

.261

MEAN RADIUS

.795

.717

.638

MAX RADIUS

1.511

1.178

.999

HORIZONTAL SPREAD

2.666

2.027

1.338

VERTICAL SPREAD

1.750

1.750

1.750

EXTREME SPREAD

2.856

2.038

1.770

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

7

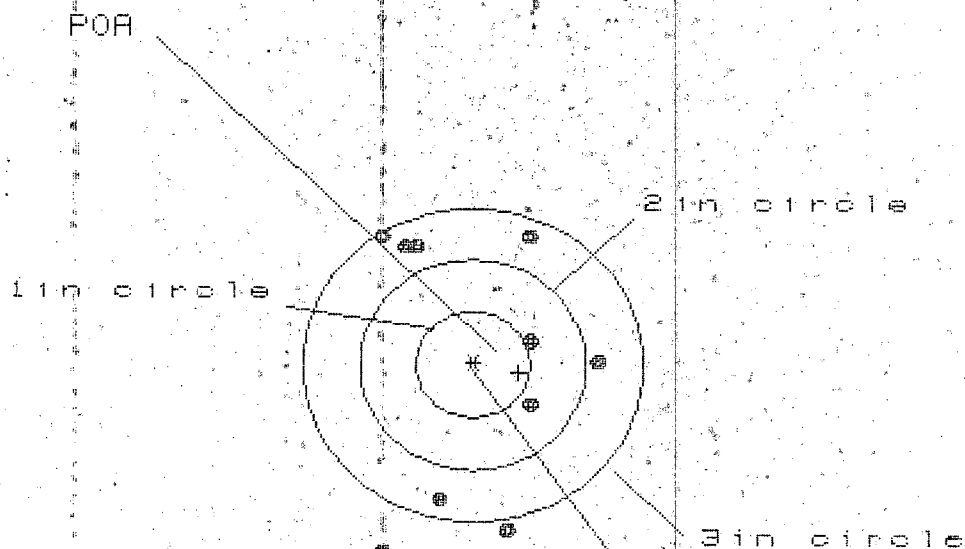
NUMBER IN THREE INCH CIRCLE =

9

3 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66657B1

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 0

2 in = 2

3 in = 8

10 = 1.062

V0 = 3.039

G0 = 3.314

CENTROID #

PATTERN #

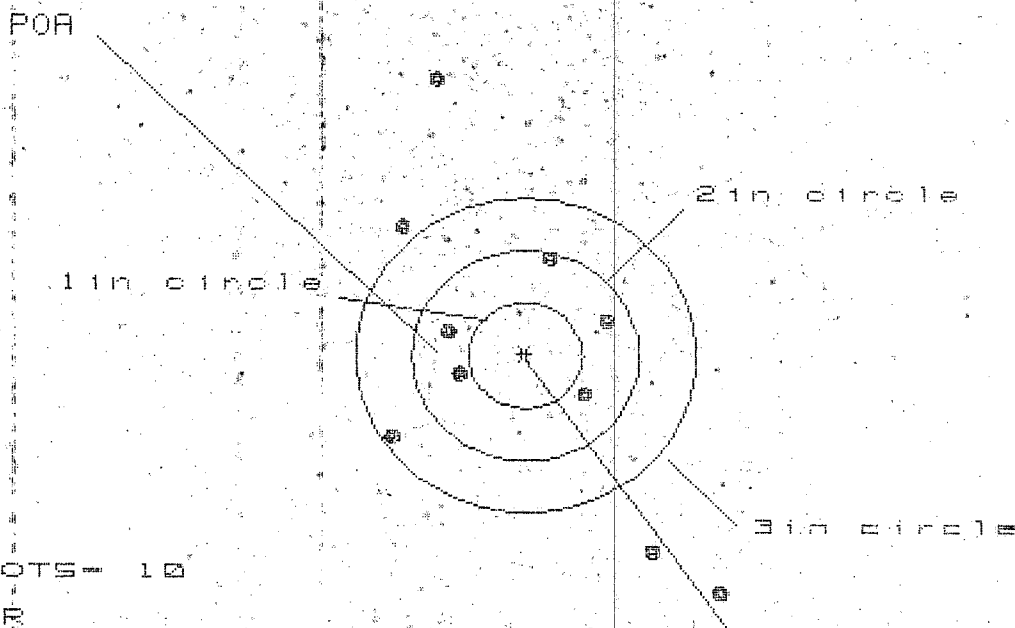
2

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.138	1.051	1.077
MINIMUM X	-.824	-.911	-.885
MAXIMUM Y	1.268	1.071	.851
MINIMUM Y	-1.771	-1.756	-1.666
CENTROID X	-.405	-.318	-.344
CENTROID Y	.072	.269	.489
POA TO CENTROID in.	.411	.417	.598
MIN RADIUS	.552	.417	.481
MEAN RADIUS	1.238	1.127	1.024
MAX RADIUS	1.934	1.768	1.697
HORIZONTAL SPREAD	1.962	1.962	1.962
VERTICAL SPREAD	3.039	2.827	2.517
EXTREME SPREAD	3.314	3.021	2.644
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	8		

3 Dec 1991

FILE: PATTERNING/CENTERFIRE_PATT/C66657B1

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 0

2in = 5

3in = 6

HS= 2.960

VS= 4.927

GS= 5.540

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.764	1.286	1.215
MINIMUM X	-1.196	-1.000	-1.071
MAXIMUM Y	2.671	2.421	1.242
MINIMUM Y	-2.256	-2.067	-1.765
CENTROID X	.582	.386	.457
CENTROID Y	.167	.417	.115
POA TO CENTROID in.	.605	.568	.471
MIN RADIUS	.584	.470	.526
MEAN RADIUS	1.447	1.260	1.094
MAX RADIUS	2.864	2.487	2.142
HORIZONTAL SPREAD	2.960	2.286	2.286
VERTICAL SPREAD	4.927	4.488	3.007
EXTREME SPREAD	5.540	4.857	3.694
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	6		