

FORM

UPC



0 47700 25716 2

C6665685

*INCLUDES 1 IN CHAMBER

MODEL 700 TM M24

5716

ORDER NO.

BARREL LENGTH

CAPACITY*

Remington

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

MODEL 700™ M24**SERIAL NO.****C6665685****ORDER NO.****5716**

20

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



5716 C6665685

ORDER 5716

MODEL 700™ M24

UPC

0 47700 25716 7

ORDER 5716

MODEL 700™ M24

UPC

0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6665685

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10 1	91	RW
600	Proof	10 1	91	RW
607	Check Headspace	1 91		RW
610	Dis-assemble Gun	10 1 91		RW
612	Magnaflux Barrel Action		OCT 4 1991	KR
	Magnaflux Bolt		OCT 4 1991	KR
615	Rollmark Caliber		OCT 4 1991	LS
617	Drill and Tap Sight Holes		OCT 4 1991	LB
618	Polish Barrel		10/8/91	WLB
620	Apply Coatings (Barrel Action)		10-22-91	JS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/22/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/22/91	RW
	C) Inspect Ejector Hole for Chamfer		10/22/91	RW
	D) Oil Firing Pin Ass'y		10/22/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11-1-91	JS

op. #	BARBER - M24 0101300 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			11-1-91	SL
	G) Safety Off Force	3	3	3			11-1-91	SL
	H) Trigger Pull Test & Retainability						11-1-91	SL
	I) Firing Pin Indent	.020	.0205	.0205			11-1-91	SL
	J) Assemble Stock						11/4/91	RW
	K) Assemble Swivel Studs						11-12-91	AC
	L) Attach Front and Rear Sight Assemblies						11/4/91	RW
	M) Iron Sight Alignment						11/4/91	RW
	N) Detach Front & Rear Sights & place in numbered container						11/4/91	RW
	O) Attach Scope to Rifle						11/4/91	RW
	P) Detach & Attach Scope 20 Times						11/4/91	RW
640	Gallery Target & Test						11-5-91	DH
	A) Time						11-5-91	DH
	B) Malfunctions						11-5-91	DH
	C) Pierced Primers						11-5-91	DH
	D) Optical Clarity of Scope						11-5-91	DH
645	Inspect for Live Ammo						11-5-91	DH
655	Final Inspection							
	A) Headspace						11-12-91	AC
	B) Trigger Pull	2.13	2.07	2.03	2.07	2.13	11-6-91	DH
	C) Function						11-12-91	AC
660	Pack						12-18-91	VF

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

SERIAL NO C-6665685DATE 11-1-91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.51	2.57	2.50	2.13	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.44	2.52	2.54	2.07	
PULL #3	2.63	2.66	2.59	2.03	
PULL #4	2.51	2.61	2.57	2.07	
PULL #5	2.31	2.54	2.52	2.13	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.25	3.46		
PULL #2	3.36	3.27		
PULL #3	3.57	3.36		
PULL #4	3.42	3.45		
PULL #5	3.42	3.46		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.29	4.18		4.27
PULL #2	4.30	4.18		4.37
PULL #3	4.26	4.24		4.22
PULL #4	4.26	4.27		4.22
PULL #5	4.22	4.19		4.32
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665685
5 Nov 1991

CENTROIDAL DISTANCES

0 TO 1	.321179
1 TO 2	.275775
1 TO 3	.353
1 TO 4	.3272
1 TO 5	.397574

←---POB

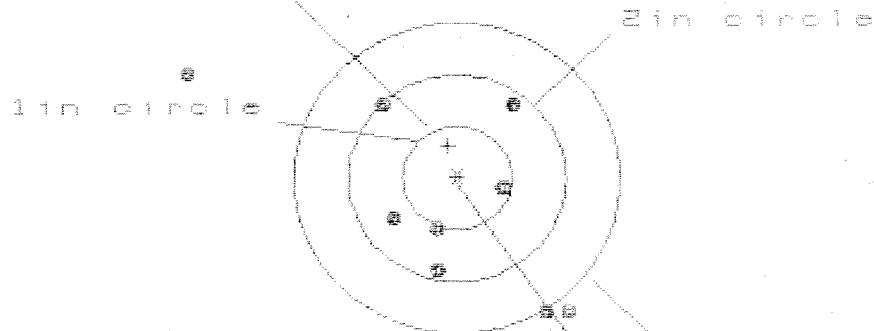
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0634
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.095
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .114213
THE AMR FOR THIS RIFLE IS: 1.107

5 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08685685

CENTERFIRE PATTERNS # 1

POR



OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 6

HS= 3.830

VS= 3.253

GS= 4.161

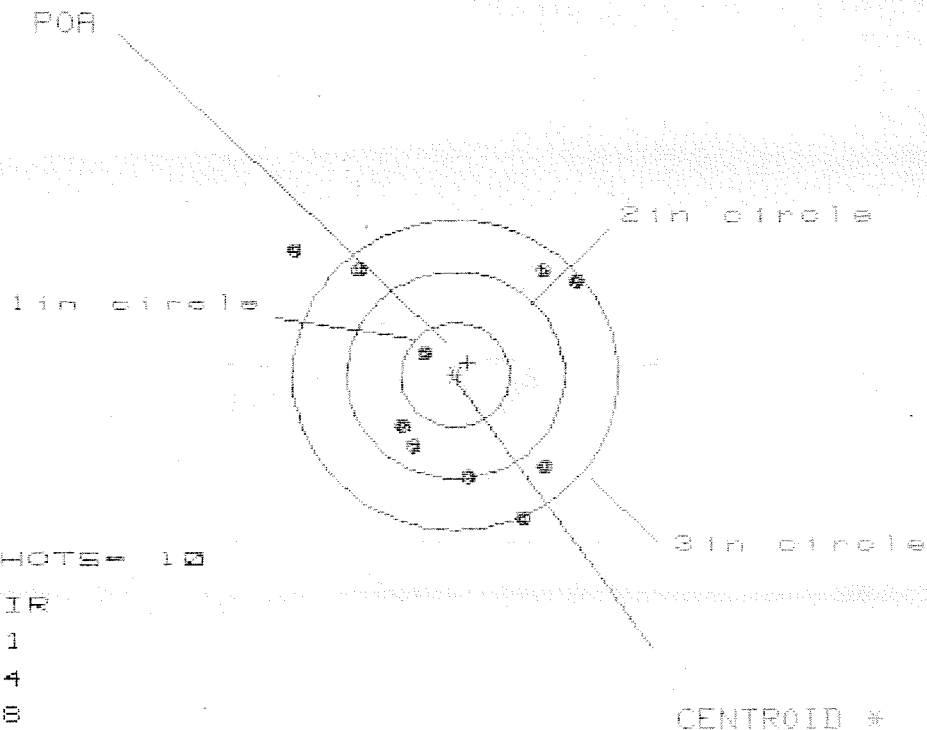
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.361	1.087	.873
MINIMUM X	-2.469	-.913	-.777
MAXIMUM Y	1.925	2.041	1.121
MINIMUM Y	-1.328	-1.212	-.957
CENTROID X	.084	.358	.222
CENTROID Y	-.310	-.426	-.681
POR TO CENTROID in.	.321	.556	.716
MIN RADIUS	.414	.135	.370
MEAN RADIUS	1.263	1.074	.875
MAX RADIUS	2.680	2.312	1.331
HORIZONTAL SPREAD	3.830	2.000	1.650
VERTICAL SPREAD	3.253	3.253	2.078
EXTREME SPREAD	4.161	3.298	2.554
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	6		

5 Nov 1981

FILE:/PATTERNING/CENTERFIRE_PATT/06565665

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 1

2in = 4

3in = 5

HS = 2.603

VS = 2.597

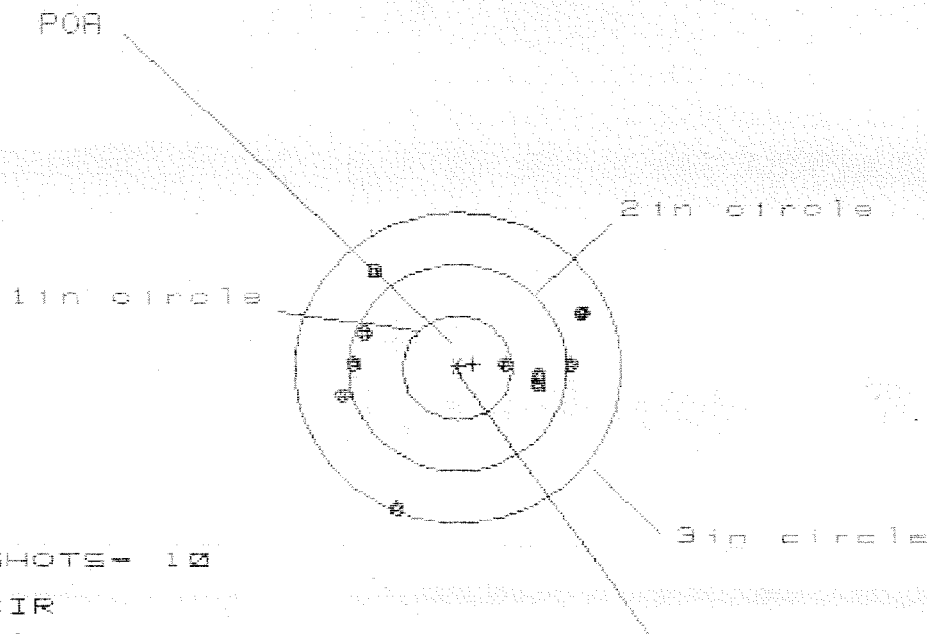
GS = 3.322

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.099	.932	.982
MINIMUM X	:	-1.504	-1.020	-.970
MAXIMUM Y	:	1.185	1.169	1.009
MINIMUM Y	:	-1.412	-1.280	-.984
CENTROID X	:	-.112	.055	.005
CENTROID Y	:	-.116	-.248	-.088
POA TO CENTROID in.	:	.161	.254	.088
MIN RADIUS	:	.305	.518	.391
MEAN RADIUS	:	1.142	1.049	1.010
MAX RADIUS	:	1.915	1.519	1.369
HORIZONTAL SPREAD	:	2.603	1.952	1.952
VERTICAL SPREAD	:	2.597	2.449	1.993
EXTREME SPREAD	:	3.322	2.794	2.500
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		5	

5 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8565685

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 1

2in = 5

3in = 10

HS = 2.167

VS = 2.282

GS = 2.572

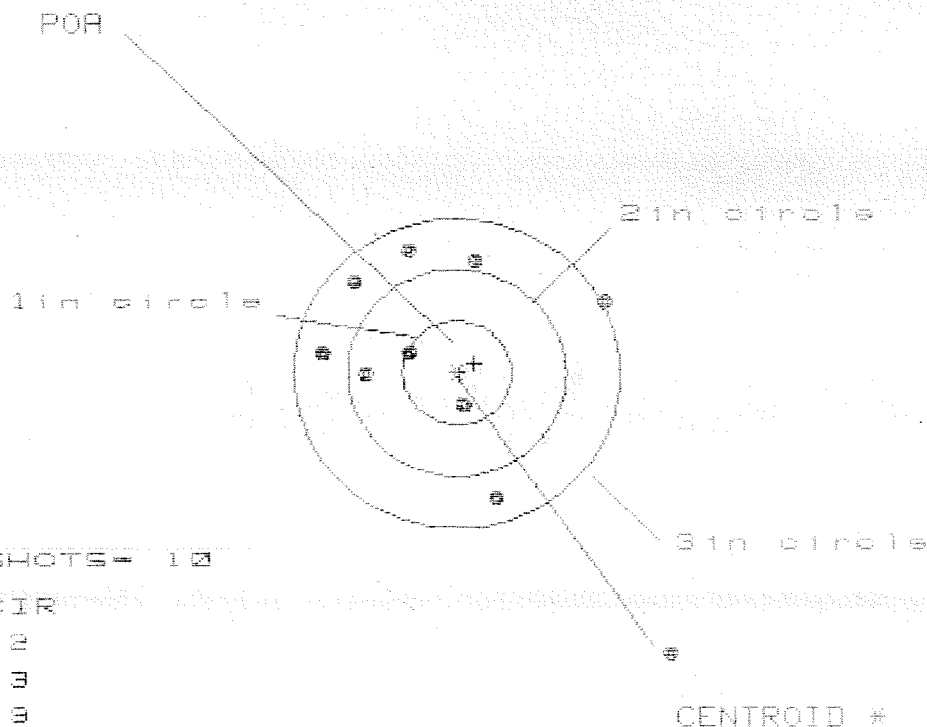
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.120	1.060	1.135
MINIMUM X	:	-1.047	-1.107	-1.975
MAXIMUM Y	:	.892	.737	.790
MINIMUM Y	:	-1.390	-.402	-.349
CENTROID X	:	-.141	-.081	-.213
CENTROID Y	:	-.038	.117	.064
POA TO CENTROID in.	:	.146	.142	.223
MIN RADIUS	:	.445	.399	.519
MEAN RADIUS	:	.989	.918	.892
MAX RADIUS	:	1.491	1.178	1.140
HORIZONTAL SPREAD	:	2.167	2.167	2.110
VERTICAL SPREAD	:	2.282	1.139	1.139
EXTREME SPREAD	:	2.572	2.318	2.125
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

5 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8885885

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 3

3 in = 9

HS = 3.143

VS = 3.939

GS = 4.585

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.915	1.554	.781
MINIMUM X	-1.228	-1.016	-.821
MAXIMUM Y	1.217	.914	.959
MINIMUM Y	-2.723	-1.558	-1.513
CENTROID X	-.160	-.372	-.567
CENTROID Y	-.092	.210	.165
POR TO CENTROID in.	.184	.427	.590
MIN RADIUS	.275	.266	.084
MEAN RADIUS	1.260	.950	.817
MAX RADIUS	3.328	1.665	1.702
HORIZONTAL SPREAD	3.143	2.570	1.602
VERTICAL SPREAD	3.939	2.472	2.472
EXTREME SPREAD	4.585	2.616	2.600
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		9	

5 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06685665

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 2

2in = 6

3in = 10

HS = 3.492

VS = 1.788

GS = 2.607

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.179
MINIMUM X	-1.313
MAXIMUM Y	1.024
MINIMUM Y	-0.764
CENTROID X	.012
CENTROID Y	.081
POA TO CENTROID in.	.082
MIN RADIUS	.121
MEAN RADIUS	.882
MAX RADIUS	1.450
HORIZONTAL SPREAD	2.492
VERTICAL SPREAD	1.788
EXTREME SPREAD	2.607
NUMBER IN ONE INCH CIRCLE	2
NUMBER IN TWO INCH CIRCLE	6
NUMBER IN THREE INCH CIRCLE	10