

FORM

UPC



0 47700 25716 7

C6665804

INCLUDES 1 IN CHAMBER

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<sup>TM</sup> M24**

**SERIAL NO.**

**C6665804**

**ORDER NO.**

**5716**

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

20



5716 C6665804

**ORDER 5716**

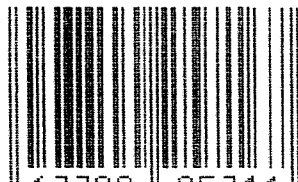
MODEL 700<sup>TM</sup> M24

**UPC**

**ORDER 5716**

MODEL 700<sup>TM</sup> M24

**UPC**



0 47700 25716 7



0 47700 25716 7

**GFM**

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

**C6665804**

| OP. #     | OP. NAME                                                 | READINGS                                                                                                  | DATE        | INIT |
|-----------|----------------------------------------------------------|-----------------------------------------------------------------------------------------------------------|-------------|------|
| 575 & 580 | Assemble Action and Stock                                | <div style="border: 1px solid black; padding: 10px; text-align: center;"> <b>QUALITY<br/>AUDIT</b> </div> | 9/23/91     | KH   |
| 600       | Proof                                                    |                                                                                                           | 9/23/91     | KH   |
| 607       | Check Headspace                                          |                                                                                                           | 9/23/91     | KH   |
| 610       | Dis-assemble Gun                                         |                                                                                                           | 9/23/91     | KH   |
| 612       | Magnaflux Barrel Action                                  |                                                                                                           | SEP 30 1991 | KR   |
|           | Magnaflux Bolt                                           |                                                                                                           | SEP 30 1991 | KR   |
| 615       | Rollmark Caliber                                         |                                                                                                           | SEP 30 1991 | LS   |
| 617       | Drill and Tap Sight Holes                                |                                                                                                           | SEP 30 1991 | FB   |
| 618       | Polish Barrel                                            |                                                                                                           | OCT 2 1991  | WB   |
| 620       | Apply Coatings (Barrel Action)                           |                                                                                                           | 10/8/91     | KH   |
|           | Apply Coating (Bolt)                                     |                                                                                                           |             | KH   |
| 625       | Final Assembly                                           |                                                                                                           | 10/8/91     | KH   |
|           | A) Clean inside of Bolt Assembly                         |                                                                                                           | 10/8/91     | KH   |
|           | B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head |                                                                                                           | 10/8/91     | KH   |
|           | C) Inspect Ejector Hole for Chamfer                      |                                                                                                           | 10/8/91     | KH   |
|           | D) Oil Firing Pin Ass'y                                  |                                                                                                           | 10/8/91     | KH   |
|           | E) Adjust Trigger Pull to Min Setting and Stake          |                                                                                                           | 10/9/91     | DH   |

| op. #        | BARBER - M24 0102790<br>OP. NAME                            | READINGS |      |      |      |      | DATE     | INIT |
|--------------|-------------------------------------------------------------|----------|------|------|------|------|----------|------|
| 625<br>cont. | F) Safety On Force                                          | 6        | 7    | 6    |      |      | 10-9-91  | AC   |
|              | G) Safety Off Force                                         | 4        | 4    | 4    |      |      | 10-9-91  | AC   |
|              | H) Trigger Pull Test & Retainability                        |          |      |      |      |      | 10-9-91  | D/H  |
|              | I) Firing Pin Indent                                        | .021     | .021 | .021 |      |      | 10-9-91  | AC   |
|              | J) Assemble Stock                                           |          |      |      |      |      | 10/11/91 | RW   |
|              | K) Assemble Swivel Studs                                    |          |      |      |      |      | 10-17-91 | AC   |
|              | L) Attach Front and Rear Sight Assemblies                   |          |      |      |      |      | 10/11/91 | RW   |
|              | M) Iron Sight Alignment                                     |          |      |      |      |      | 10/11/91 | RW   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |      |      |      |      | 10/11/91 | RW   |
|              | O) Attach Scope to Rifle                                    |          |      |      |      |      | 10/11/91 | RW   |
|              | P) Detach & Attach Scope 20 Times                           |          |      |      |      |      | 10/11/91 | RW   |
| 640          | Gallery Target & Test                                       |          |      |      |      |      | 10-14-91 | D/H  |
|              | A) Time                                                     |          |      |      |      |      | 10-14-91 | D/H  |
|              | B) Malfunctions                                             |          |      |      |      |      | 10-14-91 | D/H  |
|              | C) Pierced Primers                                          |          |      |      |      |      | 10-14-91 | D/H  |
|              | D) Optical Clarity of Scope                                 |          |      |      |      |      | 10-14-91 | D/H  |
| 645          | Inspect for Live Ammo                                       |          |      |      |      |      | 10-14-91 | D/H  |
| 655          | Final Inspection                                            |          |      |      |      |      |          |      |
|              | A) Headspace                                                |          |      |      |      |      | 10-17-91 | AC   |
|              | B) Trigger Pull                                             | 2.51     | 2.34 | 2.40 | 2.32 | 2.42 | 10-14-91 | D/H  |
|              | C) Function                                                 |          |      |      |      |      | 10-17-91 | AC   |
| 660          | Pack                                                        |          |      |      |      |      | 12-17-91 | R    |

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

SERIAL NO. C6665804DATE 10-9-91TESTER D/H

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.48             | 2.65                     | 2.71                           | 2.51 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.37             | 2.57                     | 2.77                           | 2.34 |                                                                        |
| PULL #3 | 2.39             | 2.70                     | 2.80                           | 2.40 |                                                                        |
| PULL #4 | 2.37             | 2.69                     | 2.61                           | 2.32 |                                                                        |
| PULL #5 | 2.42             | 2.74                     | 2.78                           | 2.42 |                                                                        |
| TOTAL   |                  |                          |                                |      |                                                                        |
| AVG.    |                  |                          |                                |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.11             | 3.06                     |  |          |
| PULL #2 | 3.05             | 3.00                     |  |          |
| PULL #3 | 3.00             | 3.16                     |  |          |
| PULL #4 | 3.07             | 2.98                     |  |          |
| PULL #5 | 3.00             | 3.09                     |  |          |
| TOTAL   |                  |                          |  |          |
| AVG.    |                  |                          |  |          |

|         | 4.00#<br>INITIAL | 4.00# AFTER<br>20 CYCLES | MAX SETTING<br>GREATER THAN 4# | RESET TO 4# FOR<br>TARGET & ACCURACY |
|---------|------------------|--------------------------|--------------------------------|--------------------------------------|
| PULL #1 | 4.14             | 4.43                     |                                | 4.35                                 |
| PULL #2 | 4.19             | 4.40                     |                                | 4.27                                 |
| PULL #3 | 4.19             | 4.43                     |                                | 4.34                                 |
| PULL #4 | 4.23             | 4.30                     |                                | 4.38                                 |
| PULL #5 | 4.13             | 4.47                     |                                | 4.20                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6665804  
14 Oct 1991

CENTROIDAL DISTANCES

|      |   |          |
|------|---|----------|
| 0 TO | 1 | .318077  |
| 1 TO | 2 | .0620725 |
| 1 TO | 3 | .111364  |
| 1 TO | 4 | .115378  |
| 1 TO | 5 | .346244  |

5  
0+ <----POI

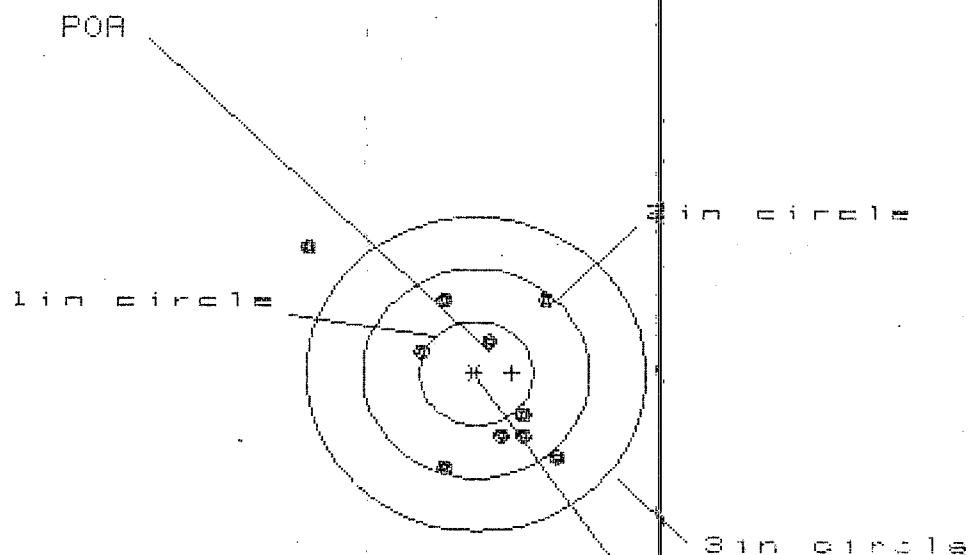
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.3038  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0468  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .007384

THE AMR FOR THIS RIFLE IS: .892

14 Oct 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/06665804

## CENTERFIRE PATTERNS # 1



# OF SHOTS- 10

# IN CIR

1 in = 2

2 in = 8

3 in = 9

HS= 2.246

VS= 2.108

GS= 3.021

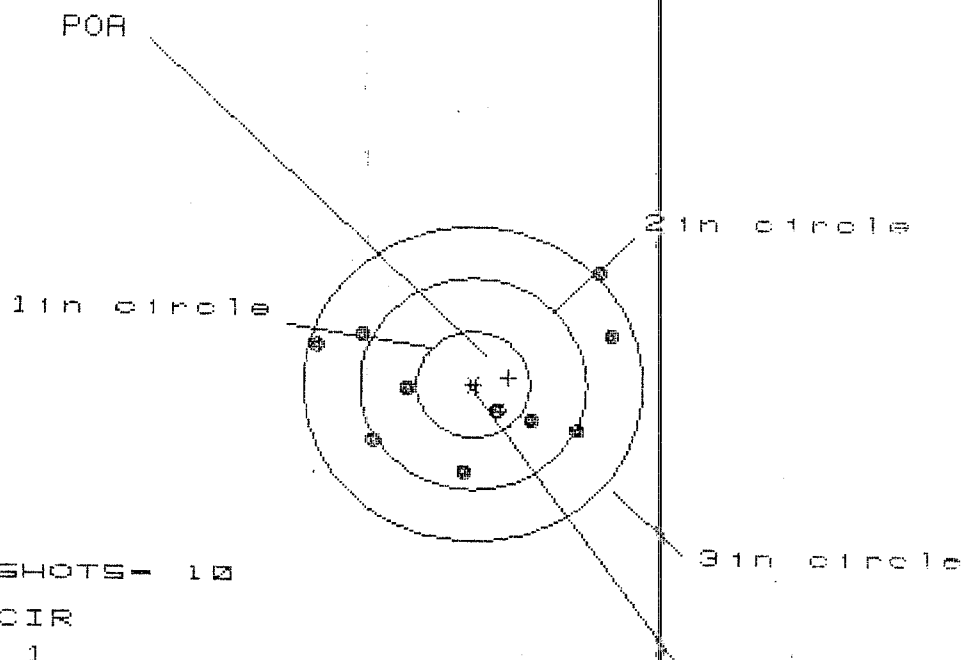
CENTROID \*

| PATTERN #                     | 1      | 2     | 3     |
|-------------------------------|--------|-------|-------|
| SHOTS (BEST OF)               | 10     | 9     | 8     |
| MAXIMUM X                     | .752   | .586  | .548  |
| MINIMUM X                     | -1.494 | -.601 | -.528 |
| MAXIMUM Y                     | 1.252  | .862  | .783  |
| MINIMUM Y                     | -.855  | -.716 | -.795 |
| CENTROID X                    | -.318  | -.152 | -.225 |
| CENTROID Y                    | -.007  | -.146 | -.067 |
| POA TO CENTROID in.           | .318   | .211  | .235  |
| MIN RADIUS                    | .351   | .347  | .402  |
| MEAN RADIUS                   | .839   | .683  | .662  |
| MAX RADIUS                    | 1.950  | .984  | .956  |
| HORIZONTAL SPREAD             | 2.246  | 1.187 | 1.076 |
| VERTICAL SPREAD               | 2.108  | 1.578 | 1.578 |
| EXTREME SPREAD                | 3.021  | 1.839 | 1.839 |
| NUMBER IN ONE INCH CIRCLE =   | 2      |       |       |
| NUMBER IN TWO INCH CIRCLE =   | 8      |       |       |
| NUMBER IN THREE INCH CIRCLE = | 9      |       |       |

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FILE: PATTERNING/CENTERFIRE\_PATT/C66658B4

## CENTERFIRE PATTERNS # 2



# OF SHOTS - 10

# IN CIR

1in - 1

2in - 5

3in - 9

HS = 2.676

VS = 1.956

GS = 2.681

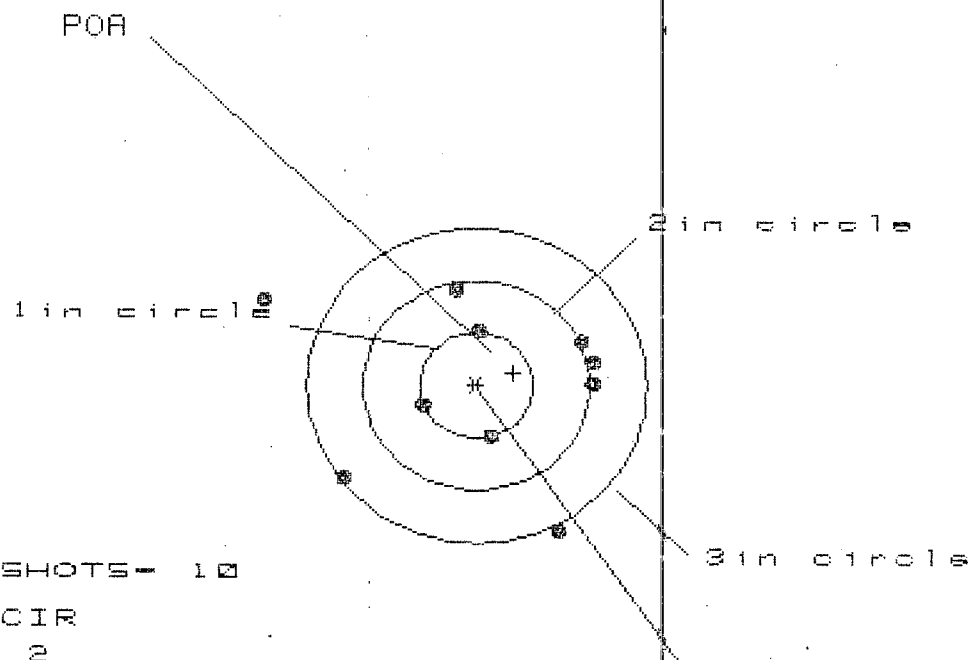
CENTROID \*

| PATTERN #                     | 2      | 3      | 8     |
|-------------------------------|--------|--------|-------|
| SHOTS (BEST OF)               | 10     | 9      | 8     |
| MAXIMUM X                     | 1.247  | 1.367  | 1.203 |
| MINIMUM X                     | -1.429 | -1.309 | -.988 |
| MAXIMUM Y                     | 1.093  | .600   | .655  |
| MINIMUM Y                     | -.863  | -.742  | -.686 |
| CENTROID X                    | -.315  | -.435  | -.271 |
| CENTROID Y                    | -.069  | -.190  | -.246 |
| POA TO CENTROID in.           | .322   | .475   | .366  |
| MIN RADIUS                    | .331   | .380   | .208  |
| MEAN RADIUS                   | .978   | .896   | .808  |
| MAX RADIUS                    | 1.536  | 1.492  | 1.370 |
| HORIZONTAL SPREAD             | 2.676  | 2.676  | 2.191 |
| VERTICAL SPREAD               | 1.956  | 1.342  | 1.342 |
| EXTREME SPREAD                | 2.681  | 2.681  | 2.695 |
| NUMBER IN ONE INCH CIRCLE =   | 1      |        |       |
| NUMBER IN TWO INCH CIRCLE =   | 5      |        |       |
| NUMBER IN THREE INCH CIRCLE = | 9      |        |       |

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## CENTERFIRE PATTERNS # 3



# OF SHOTS- 10

# IN CIR

1 in = 2

2 in = 6

3 in = 8

HS= 2.846

VS= 2.306

GS= 3.356

CENTROID \*

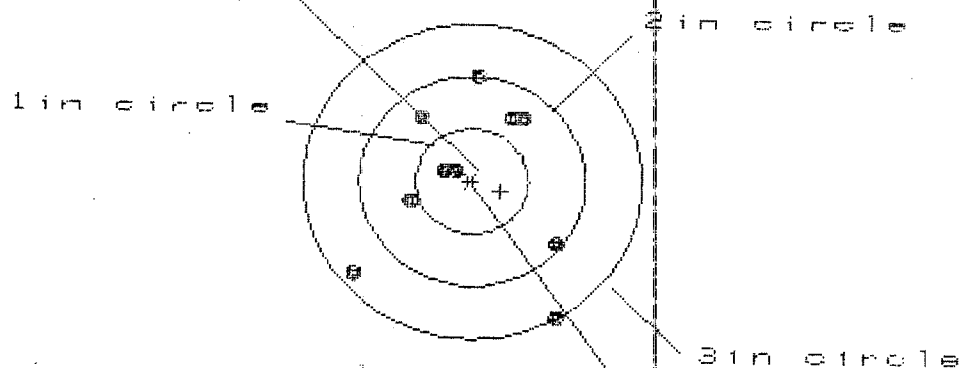
| PATTERN #                     | 3      | 3      | 3      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.010  | .806   | .866   |
| MINIMUM X                     | -1.836 | -1.412 | -1.352 |
| MAXIMUM Y                     | .914   | 1.006  | .843   |
| MINIMUM Y                     | -1.392 | -1.300 | -.924  |
| CENTROID X                    | -.327  | -.123  | -.183  |
| CENTROID Y                    | -.118  | -.210  | -.047  |
| POA TO CENTROID in.           | .348   | .243   | .189   |
| MIN RADIUS                    | .476   | .385   | .431   |
| MEAN RADIUS                   | 1.045  | .918   | .841   |
| MAX RADIUS                    | 2.013  | 1.604  | 1.637  |
| HORIZONTAL SPREAD             | 2.846  | 2.218  | 2.218  |
| VERTICAL SPREAD               | 2.306  | 2.306  | 1.767  |
| EXTREME SPREAD                | 3.356  | 2.467  | 2.467  |
| NUMBER IN ONE INCH CIRCLE =   |        | 2      |        |
| NUMBER IN TWO INCH CIRCLE =   |        | 6      |        |
| NUMBER IN THREE INCH CIRCLE = |        | 8      |        |

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FILE: /PATTERNING/CENTERFIRE\_PATT/CG665884

## CENTERFIRE PATTERNS # 4

POA



# OF SHOTS - 10

# IN CIR

1 in - 2

2 in - 8

3 in - 10

HS = 1.785

VS = 2.286

GS = 2.390

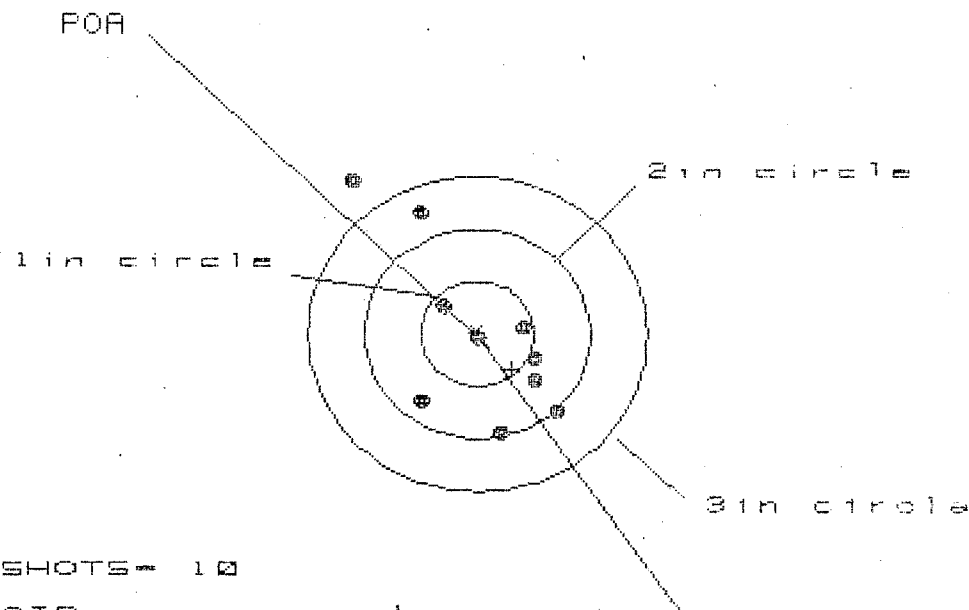
CENTROID #

| PATTERN #                     | 4      | 9      | 8     |
|-------------------------------|--------|--------|-------|
| SHOTS (BEST OF)               | 10     | 9      | 8     |
| MAXIMUM X                     | .789   | .869   | .754  |
| MINIMUM X                     | -1.086 | -.926  | -.623 |
| MAXIMUM Y                     | .990   | .846   | .717  |
| MINIMUM Y                     | -1.296 | -1.028 | -.842 |
| CENTROID X                    | -.254  | -.334  | -.218 |
| CENTROID Y                    | .089   | .233   | .362  |
| POA TO CENTROID in.           | .269   | .408   | .423  |
| MIN RADIUS                    | .135   | .073   | .243  |
| MEAN RADIUS                   | .790   | .670   | .593  |
| MAX RADIUS                    | 1.485  | 1.384  | 1.130 |
| HORIZONTAL SPREAD             | 1.795  | 1.795  | 1.377 |
| VERTICAL SPREAD               | 2.286  | 1.874  | 1.557 |
| EXTREME SPREAD                | 2.390  | 2.139  | 1.777 |
| NUMBER IN ONE INCH CIRCLE =   | 2      |        |       |
| NUMBER IN TWO INCH CIRCLE =   |        | 8      |       |
| NUMBER IN THREE INCH CIRCLE = |        | 10     |       |

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## CENTERFIRE PATTERNS # 5



# OF SHOTS - 10

# IN CIR

1 in - 3

2 in - 8

3 in - 9

HS - 1.731

VS - 2.378

GS - 2.795

| PATTERN #                     | 10     | 9     | 8     |
|-------------------------------|--------|-------|-------|
| SHOTS (BEST OF)               | 10     | 9     | 8     |
| MAXIMUM X                     | .667   | .549  | .472  |
| MINIMUM X                     | -1.064 | -.645 | -.722 |
| MAXIMUM Y                     | 1.474  | 1.350 | .626  |
| MINIMUM Y                     | -.984  | -.740 | -.571 |
| CENTROID X                    | -.385  | -.187 | -.110 |
| CENTROID Y                    | .339   | .175  | .006  |
| POA TO CENTROID in.           | .456   | .256  | .110  |
| MIN RADIUS                    | .050   | .195  | .328  |
| MEAN RADIUS                   | .808   | .665  | .341  |
| MAX RADIUS                    | 1.818  | 1.484 | .795  |
| HORIZONTAL SPREAD             | 1.731  | 1.194 | 1.194 |
| VERTICAL SPREAD               | 2.378  | 2.090 | 1.197 |
| EXTREME SPREAD                | 2.795  | 2.235 | 1.355 |
| NUMBER IN ONE INCH CIRCLE =   | 3      |       |       |
| NUMBER IN TWO INCH CIRCLE =   | 8      |       |       |
| NUMBER IN THREE INCH CIRCLE = | 9      |       |       |