

FORM

UPC



0 47700 25716 7

06666007

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 700TM M24**SERIAL NO.**

C6666007

ORDER NO.**5716**

20

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



5716 C6666007

ORDER 5716MODEL 700TM M24**UPC**

0 47700 25716 7

ORDER 5716MODEL 700TM M24**UPC**

0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6666007

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		9/25/91	KJ
600	Proof		9/25/91	KJ
607	Check Headspace		9/25/91	KJ
610	Dis-assemble Gun		9/25/91	KJ
612	Magnaflux Barrel Action		OCT 2 1991	KR
	Magnaflux Bolt		OCT 2 1991	KR
615	Rollmark Caliber		OCT 2 1991	LS
617	Drill and Tap Sight Holes		OCT 2 1991	RB
618	Polish Barrel		OCT 4 1991	WB
620	Apply Coatings (Barrel Action)		10-14-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/28/91	KJ
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/28/91	KJ
	C) Inspect Ejector Hole for Chamfer		10/28/91	KJ
	D) Oil Firing Pin Ass'y		10/28/91	KJ
	E) Adjust Trigger Pull to Min Setting and Stake		10/29/91	JA

op. #	BARBER - M24 0104913 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			10/29/91	JH
	G) Safety Off Force	3	3	3			10/29/91	JH
	H) Trigger Pull Test & Retainability						10/29/91	JH
	I) Firing Pin Indent	.021	.020	.020			10/29/91	JH
	J) Assemble Stock						10/29/91	JH
	K) Assemble Swivel Studs						11-8-91	AC
	L) Attach Front and Rear Sight Assemblies						10/29/91	JH
	M) Iron Sight Alignment						10/29/91	JH
	N) Detach Front & Rear Sights & place in numbered container						10/29/91	JH
	O) Attach Scope to Rifle						10/29/91	JH
	P) Detach & Attach Scope 20 Times						10/29/91	JH
640	Gallery Target & Test						10-31-91	DH
	A) Time						10-31-91	DH
	B) Malfunctions						10-31-91	DH
	C) Pierced Primers						10-31-91	DH
	D) Optical Clarity of Scope						10-31-91	DH
645	Inspect for Live Ammo						10-31-91	DH
655	Final Inspection							
	A) Headspace						11-8-91	AC
	B) Trigger Pull	238	226	231	233	244	11-4-91	DH
	C) Function						11-8-91	AC
660	Pack						2-25-92	NC

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

SERIAL NO C-6666007DATE 10/29/91TESTER JG

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.28	2.46	2.50	238	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.57	2.56	2.52	226	
PULL #3	2.47	2.46	2.48	231	
PULL #4	2.47	2.51	2.50	233	
PULL #5	2.54	2.56	2.54	244	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.57	3.39		
PULL #2	3.44	3.38		
PULL #3	3.60	3.33		
PULL #4	3.34	3.47		
PULL #5	3.35	3.47		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.36	4.55		4.43
PULL #2	4.43	4.53		4.49
PULL #3	4.50	4.47		4.53
PULL #4	4.46	4.44		4.50
PULL #5	4.53	4.62		4.29
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 0666007
31 Oct 1991

CENTROIDAL DISTANCES

0 TO	1	.783189
1 TO	2	.753601
1 TO	3	.757038
1 TO	4	.601659
1 TO	5	.910651

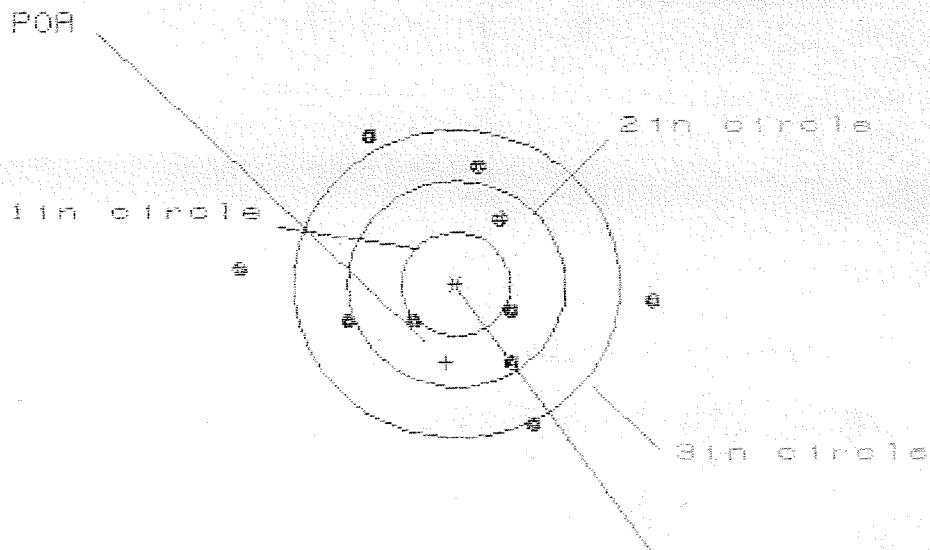
1
5th <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1418
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .169
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .229689
THE AMR FOR THIS RIFLE IS: 1.074

31 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6666007

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 0

2in = 4

3in = 6

HS = 3.767

VS = 2.800

GS = 3.784

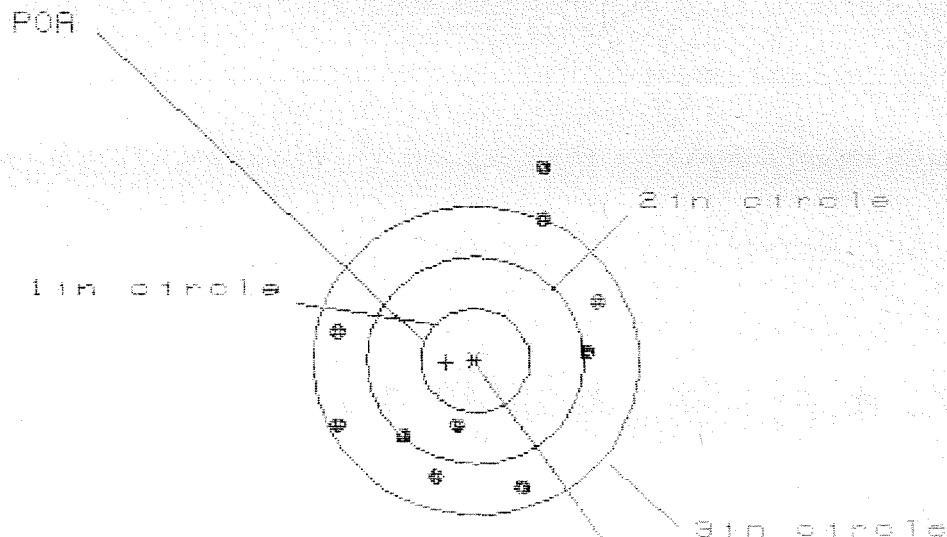
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.820	1.603	.795
MINIMUM X	-1.947	-1.226	-1.025
MAXIMUM Y	1.411	1.429	1.408
MINIMUM Y	-1.389	-1.371	-1.392
CENTROID X	.097	.314	.113
CENTROID Y	.757	.739	.760
FOR TO CENTROID in.	.763	.802	.769
MIN RADIUS	.513	.365	.527
MEAN RADIUS	1.198	1.092	1.024
MAX RADIUS	1.955	1.743	1.618
HORIZONTAL SPREAD	3.767	2.829	1.730
VERTICAL SPREAD	2.800	2.800	2.800
EXTREME SPREAD	3.784	3.177	3.177
NUMBER IN ONE INCH CIRCLE	= 0		
NUMBER IN TWO INCH CIRCLE	= 4		
NUMBER IN THREE INCH CIRCLE	= 6		

31 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06665007

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 2

3 in = 8

HS = 2.477

VS = 3.078

GS = 3.175

CENTROID *

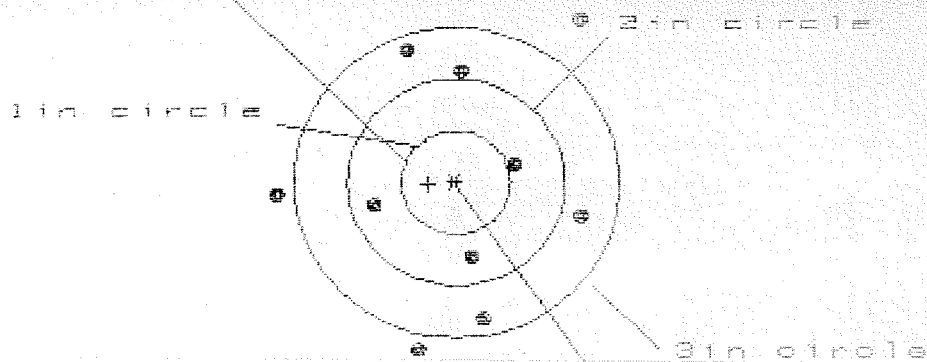
PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.165	1.232	1.314
MINIMUM X	-1.312	-1.245	-1.163
MAXIMUM Y	1.872	1.593	.961
MINIMUM Y	-1.206	-.998	-.798
CENTROID X	.272	.205	.123
CENTROID Y	.024	-.184	-.383
POA TO CENTROID in.	.273	.276	.403
MIN RADIUS	.592	.375	.171
MEAN RADIUS	1.259	1.131	.993
MAX RADIUS	1.965	1.723	1.628
HORIZONTAL SPREAD	2.477	2.477	2.477
VERTICAL SPREAD	3.078	2.591	1.760
EXTREME SPREAD	3.175	2.746	2.731
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		2	
NUMBER IN THREE INCH CIRCLE =		8	

31 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06666007

CENTERFIRE PATTERNS # 3

POA



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 3

3 in = 7

HS = 2.734

VS = 3.117

GS = 3.453

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.129	1.233	1.204
MINIMUM X	:	-1.605	-1.480	-1.509
MAXIMUM Y	:	1.545	1.433	1.258
MINIMUM Y	:	-1.572	-1.401	-1.302
CENTROID X	:	.252	.127	.156
CENTROID Y	:	.016	-.155	.020
POA TO CENTROID in.	:	.253	.200	.157
MIN RADIUS	:	.625	.549	.653
MEAN RADIUS	:	1.204	1.109	1.066
MAX RADIUS	:	1.913	1.483	1.511
HORIZONTAL SPREAD	:	2.734	2.713	2.713
VERTICAL SPREAD	:	3.117	2.834	2.560
EXTREME SPREAD	:	3.453	2.837	2.720
NUMBER IN ONE INCH CIRCLE	=	0	3	7
NUMBER IN TWO INCH CIRCLE	=	0	3	7
NUMBER IN THREE INCH CIRCLE	=	0	3	7

31 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6668007

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.536

VS= 1.824

GS= 2.214

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.951	.428	.403
MINIMUM X	:	-.645	-.539	-.564
MAXIMUM Y	:	.988	.773	.682
MINIMUM Y	:	-.836	-.726	-.575
CENTROID X	:	.229	.123	.148
CENTROID Y	:	.170	.060	.151
POA TO CENTROID in.	:	.285	.137	.212
MIN RADIUS	:	.234	.163	.256
MEAN RADIUS	:	.630	.514	.498
MAX RADIUS	:	1.371	.883	.792
HORIZONTAL SPREAD	:	1.596	.967	.967
VERTICAL SPREAD	:	1.824	1.499	1.257
EXTREME SPREAD	:	2.214	1.624	1.334
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

31 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/0666007

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 9

HS= 2.884

VS= 2.370

GS= 3.161

CENTROID *

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.503	.809	.659
MINIMUM X	-1.361	-1.194	-1.178
MAXIMUM Y	1.256	1.156	1.199
MINIMUM Y	-1.114	-1.214	-1.171
CENTROID X	-.141	-.308	-.158
CENTROID Y	-.122	-.021	-.064
POA TO CENTROID in.	.186	.308	.171
MIN RADIUS	.214	.400	.245
MEAN RADIUS	1.081	1.016	.957
MAX RADIUS	1.752	1.290	1.311
HORIZONTAL SPREAD	2.864	2.003	1.837
VERTICAL SPREAD	2.370	2.370	2.370
EXTREME SPREAD	3.161	2.439	2.439
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		9	

LOT #2

SCOPE

#

1052

**ENDURANCE
GUN**

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6225191

OP.#	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and stock	8	9/88	FB
600	Proof	9	7/88	RW
607	Check Headspace	9	7/88	RW
610	Dis-assemble gun	9	7/88	RW
612	Magnaflux Barrel Action		9-14-88	RW
	Magnaflux Bolt		9-14-88	RW
615	Rollmark Caliber		10/12	WC
617	Drill & Tap Sight Holes		10/12	FB
618	Polish Barrel		10/20	WT
620	Apply Coatings (Barrel Action)		10-31-88	TJA
	Apply Coatings (Bolt)		10-31-88	TJA
625	Final Assembly A) Clean inside of Bolt Assembly		11/2/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/2/88	RW
	C) Inspect Ejector Hole for Chamfer		11/2/88	RW

OVER

OP.#		READINGS	DATE	INITIAL
625	D) Oil Firing Pin Ass'y		11/2/88	RW
cont.	E) Adjust Trigger Pull to Min. Setting and Stake		31 Oct 88	JSJ
	F) Safety on Force	5 5 5	4 Nov 88	JSJ
	G) Safety off Force	3 3 3	4 Nov 88	JSJ
	H) Trigger Pull Test & Retainability		31 Oct 88	JSJ
	I) Firing Pin Indent	.020 .020 .020	4 Nov 88	JSJ
	J) Assemble Stock		11/2/88	RW
	K) Attach Front & Rear Sight Assemblies		11/2/88	RW
	L) Iron Sight Alignment		11/7/88	RW
	M) Detach Front & Rear Sights & place in numbered container		11/2/88	RW
	N) Attach Scope to Rifle		11/7/88	RW
	O) Detach & Attach Scope 20 times		11/7/88	W.B.
640	Gallery Target & Test	66 R 88 L	11/8/88	DH
	A) Optical Clarity of Scope		11/8/88	DH
645	Inspect for Live Ammo		11/8/88	DH
655	Final Inspection			
	A) Headspace		11 Nov 88	JSJ
	B) Trigger Pull			
	C) Function			
	D) Assemble Swivel Studs			
660	Pack			

QP 0041

MAGNETIC PARTICLE INSPECTION

PART NUMBER 96005

PART NAME Final Bolt Assem. MATERIAL Bolt Head-8640, Bolt Body 1140M, Bolt

OPERATION NUMBER 615

METHOD	SINGLE PARTS			MULTIPLE PARTS		
	HEAD SHOT	CENTRAL CONDUCTOR	COIL SHOT	HEAD SHOT CENTRAL CONDUCTOR	COIL SHOT IN BASKET	AMPERES

NON-FLUORESCENT
CONTINUOUS WET

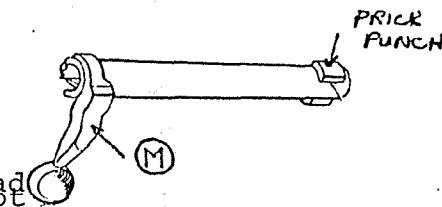
FLUORESCENT
CONTINUOUS WET

NON-FLUORESCENT
RESIDUAL WET

FLUORESCENT
RESIDUAL WET

600-800-Head Shot
900-1100-Coil Shot

SKETCH AND/OR REMARKS



APPROVAL [Signature]
INSP. [Signature] LEV III
DATE: 12-17-88 DATE:

STAMPING

STEEL STAMP ON Prick punch O.D. large locking lug (Left)

OTHER & letter "M" circled on Bolt Handle

ACCEPTANCE STANDARD

PROCEDURE:

1. All parts must be cleaned before testing.
2. All parts shall be satisfactorily demagnetized after all magnetization has been completed.
3. The magnetic substance shall be completely removed from all parts after inspection and demagnetization.
4. All accepted parts must be marked with a mangaflex stamp, acid etch, or ink stamp. (If the part is too small or is a critical part, contact inspection supervisor).
5. Parts having indications not acceptable shall be segregated and identified, and are to be reviewed by Metallurgy and inspection groups.
6. All areas to be inspected 100%.
7. Inspection to be performed by a certified Level I, acceptance or rejection of product will be done by a certified Level II, or Level III.

Bolt Handle is not included
in Magnetic Particle Inspection.
It is checked for strength at
another operation.
No indications on the Bolt Head.
Lug area.

USE BACK SIDE OF THIS CARD TO RECORD EACH LOT INSPECTED.
ALL BLOCKS MUST BE PROPERLY FILLED IN.

1.1 - 1.4
LEV III.
INSP.

FORM QP-0041-1

QP 0041

DATE	MFG. ORDER NO.	QUANTITY	SERIAL #	QUANTITY OF PARTS	
				ACCEPTED	REJECTED
11-17-88	2500 Rds	1	C-6225191	1 - OK	
		ENDURANCE GUN BOLT ASSEM.		P.J. CROSS 11-17-88	
12-5-88	5000 Rds	1		1 - OK	
		ENDURANCE GUN BOLT ASSEM.	SAME	P.J. CROSS 12-5-88	
12-6-88	6000 Rds	1		1 - OK	
		ENDURANCE GUN BOLT ASSEM.	SAME	P.J. CROSS 12-6-88	
12-7-88	7000 Rds	1		1 - OK	
		ENDURANCE GUN BOLT ASSEM.	SAME	P.J. CROSS 12-7-88	
12-8-88	8000 Rds	1		1 - OK	
		ENDURANCE GUN BOLT ASSEM.	SAME	P.J. CROSS 12-8-88	
12-9-88	9000 Rds	1		1 - OK	
		ENDURANCE BOLT ASSEM.	SAME	P.J. CROSS 12-9-88	
12/13/88	10,000 Rds	1			
		Endurance Bolt Assem	Same	Karl C Rice 12/13/88	

PART NUMBER 96002

OPERATION NUMBER 615

OPERATION NUMBER 615

SKETCH AND/OR REMARKS

900-1100-Head Shot
600-800-Coil Shot

900-1100-Head Shot
600-800-Coil Shot

APPROVAL: Pete J. Lwin LEV III
DATE: 6/11/17 DATE:

APPROVAL: Pete J. Lwin LEV III
DATE: 6/11/17 DATE:

ACCEPTANCE STANDARD

No Indications acceptable in the
Locking Lug area of Receiver or
chamber area of Bbl.

Locking Lug area of Receiver or
chamber area of Bbl.

1. All parts must be cleaned before testing.
2. All parts shall be satisfactorily demagnetized after all magnetization has been completed.
3. The magnetic substance shall be completely removed from all parts after inspection and demagnetization.
4. All accepted parts must be marked with a manganflux stamp, acid etch, or ink stamp (If the part is too small or is a critical part, contact inspection supervisor).
5. Parts having indications not acceptable shall be segregated and identified, and are to be reviewed by Metallurgy and inspection groups.
6. All areas to be inspected 100%.
7. Inspection to be performed by a certified Level I, acceptance or rejection of product will be done by a certified Level II, or Level III.

LEV III. _____
INSP.

INSP.

FORM QP-0041-1

BARBER - M24 0104925

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

BARBER - M24 ~~0124923~~ **M2400104964**

QP 0041

DATE	MFG. ORDER NO.	QUANTITY	SERIAL #	QUANTITY OF PARTS	
				ACCEPTED	REJECTED
11-17-88	2500 Rds	1 ENDURANCE GUN BARREL ASSEM.	C-6225191	1 - OK	P.J. CROSS 11-17-88
12-5-88	5000 Rds.	1 ENDURANCE BARREL ASSEM.	SAME	1 - OK	P.J. CROSS 12-5-88
12-6-88	6000 Rds	1 ENDURANCE BARREL ASSEM.	SAME	1 - OK	P.J. CROSS 12-6-88
12-7-88	7000 Rds	1 ENDURANCE BARREL ASSEM.	SAME	1 - OK	P.J. CROSS 12-7-88
12-8-88	8000 Rds	1 ENDURANCE BARREL ASSEM.	SAME	1 - OK	P.J. CROSS 12-8-88
12-9-88	9000 Rds.	1 ENDURANCE BARREL ASSEM.	SAME	1 - OK	P.J. CROSS 12-8-88
12/13/88	10,000 Rds	1 Endurance Barrel Assem.	Same		Karl C Rice 12/13/88

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6225191DATE 3/6/88TESTER JU. + W. S.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.45	2.54	2.32	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.26	2.50	2.32	
PULL #3	2.68	2.50	2.30	
PULL #4	2.25	2.42	2.31	
PULL #5	2.74	2.42	2.29	
TOTAL	12.58	12.38	11.54	
AVG.	2.516	2.476	2.308	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.05	3.14	
PULL #2	2.99	3.24	
PULL #3	2.91	3.21	
PULL #4	2.93	3.22	
PULL #5	2.98	3.25	
TOTAL	14.86	16.06	
AVG.	2.972	3.212	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.25	4.24		4.37
PULL #2	4.29	4.22		4.28
PULL #3	4.31	4.21		4.28
PULL #4	4.20	4.00		4.29
PULL #5	4.24	4.21		4.29
TOTAL	21.29	20.88		21.51
AVG.	4.258	4.176		4.302