

E 676 1497

Remington®

MODEL 700™ M24
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

VERY IMPORTANT!
INSTRUCTIONS, DIS-
CHARGE, AND SAFETY
INSTRUCTIONS MUST BE
READ AND UNDERSTOOD
BEFORE USE OF THIS
RIFLE.

SERIAL NO.
E67614970

ORDER NO.
25716

46

Made in Illinois, NY Reg. U.S. Pat. & tm. Off. Marca Registrada. Marque Deposee.

14XV

5716 E6761497

MODEL 700_{TH} M24

0 47700 25716 7

MODEL 700TH M24

0 47700 25716 7

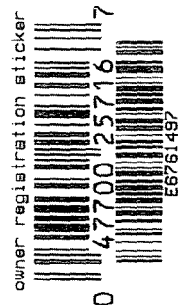
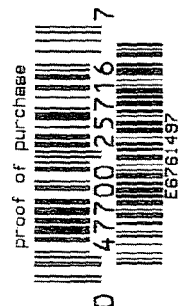
E6761497

MODEL 700TM M24
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

DOCUMENT ENVELOPE ASSEMBLY:

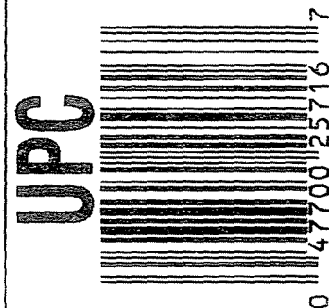
- INSTRUCTION BOOK
- PRODUCT OWNER'S CARD
- SAFETY BOOKLET

46 FORM 1444



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

E6761497



GUN SERIAL # 2676 1497

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		9-25-01	RL
600	PROOF		9/25/01	
607	CHECK HEADSPACE		9-26-01	RL
610	DIS-ASSEMBLE GUN	MAGNA-FLUX INSPECTED	9-26-01	RL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	SEP 26 2001 NRD		
615	ROLLMARK CALIBER	OPERATOR _____	9/27	RL
617	DRILL AND TAP SIGHT HOLES	9/24 BWT SEND TO NEXT OP	9/27	RL
620	APPLY COATINGS (BARREL ACTION)		10/3	HP
	(BOLT)		10/3	HP
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-10-01	RL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-10-01	RL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-10-01	RL
	D) OIL FIRING PIN ASSEMBLY		10-10-01	RL
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

CONTRACT #

GUN SERIAL # _____

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK			
600	PROOF			
607	CHECK HEADSPACE			
610	DIS-ASSEMBLE GUN			
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT			
615	ROLLMARK CALIBER			
617	DRILL AND TAP SIGHT HOLES			
620	APPLY COATINGS (BARREL ACTION)			
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD			
	C) INSPECT EJECTOR HOLE FOR CHAMFER			
	D) OIL FIRING PIN ASSEMBLY			
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

OP #	OPERATION NAME		READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>5.5</u> <u>6.0</u> <u>6.0</u>	10-17-01	DA
CONT.					
	G) SAFETY OFF FORCE	2 LBS MIN	<u>3.0</u> <u>3.0</u> <u>3.0</u>	10-17-01	DA
	H) TRIGGER PULL TEST AND RETAINABILITY				
	I) FIRING PIN INDENT	.020 MIN	<u>.022</u> <u>.021</u> <u>.022</u>	10-17-01	DA
	J) ASSEMBLE STOCK				
	K) ASSEMBLE SWIVEL STUDS			11-6-01	AC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S				
	M) IRON SIGHT ALIGNMENT				
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER				
640	GALLERY TEST AND TARGET		PASS FAIL	10-17-01	AC
	A) MALFUNCTIONS		PASS FAIL	10-17-01	AC
	B) PIERCED PRIMERS		PASS FAIL	10-17-01	AC
645	INSPECT FOR LIVE AMMO			10-17-01	AC
655	FINAL INSPECTION A) HEADSPACE			11-6-01	AC
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.60</u> <u>2.71</u> <u>2.71</u> <u>2.63</u> <u>2.69</u>	10-17-01	DA
	C) FUNCTION			11-6-01	AC
660	PACK			11-3-01	DA

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. E676 1497DATE 10/3/01TESTER NSA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.51	2.37	2.52	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.51	2.29	2.47	
PULL #3	2.50	2.32	2.46	
PULL #4	2.38	2.34	2.42	
PULL #5	2.47	2.30	2.48	
TOTAL	12.37	11.62	12.35	
AVG.	2.47	2.32	2.47	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.22	3.26	
PULL #2	3.16	3.34	
PULL #3	3.16	3.26	
PULL #4	3.15	3.26	
PULL #5	3.22	3.34	
TOTAL	15.91	16.46	
AVG.	3.18	3.29	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.34	4.32		4.25
PULL #2	4.33	4.34		4.35
PULL #3	4.34	4.28		4.38
PULL #4	4.15	4.34		4.39
PULL #5	4.22	4.30		4.47
TOTAL	21.38	21.58		21.84
AVG.	4.27	4.31		4.36

BARBER - M24 0112606

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # E6761497
17 Oct 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0142
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0828
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0840088
THE AVERAGE POI RADIUS FOR THIS RIFLE IS: .848

CENTROIDAL DISTANCES

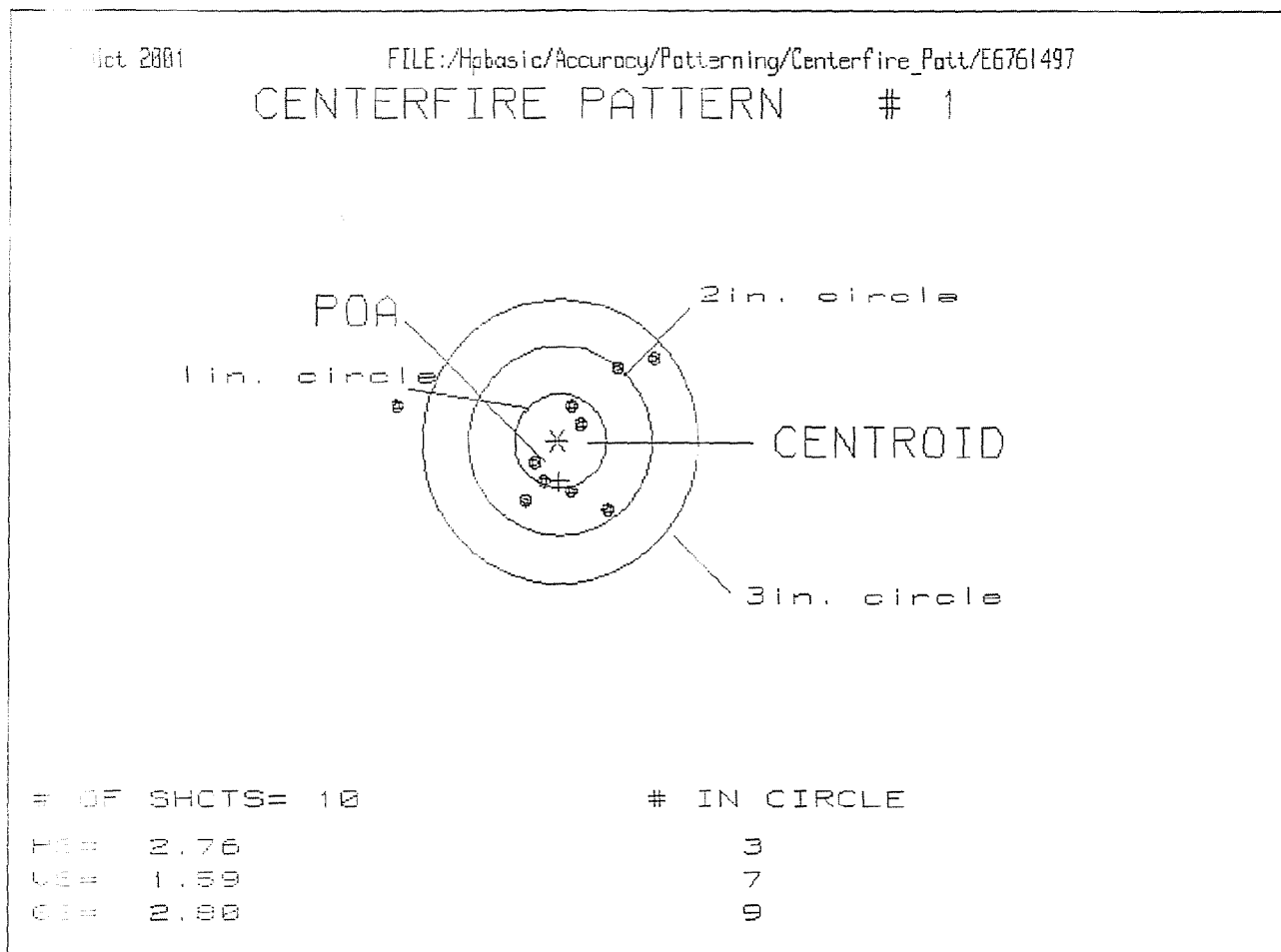
0	TL	1	.428517
1	TL	2	.285313
1	TL	3	.447
1	TL	4	.742172
1	TL	5	.474499

1 2
5 3 <----POA
4

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 1 ☐
 POA TO CENTROID: .427
 MIN RADIUS : .285
 MEAN RADIUS : .779
 MAX RADIUS : 1.795
 CENTROID X : -.021
 CENTROID Y : .426



REMINGTON CENTERFIRE ACCURACY TEST

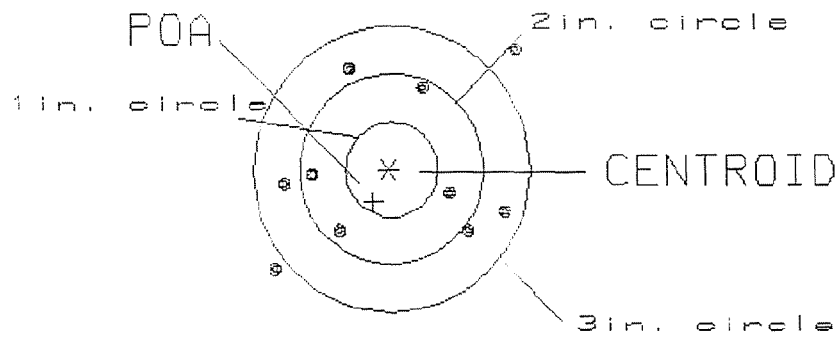
REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 2 ☐
 POA TO CENTROID: .380
 MIN RADIUS : .621
 MEAN RADIUS : 1.137
 MAX RADIUS : 1.832
 CENTROID X : .167
 CENTROID Y : .342

Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6761497

CENTERFIRE PATTERN # 2



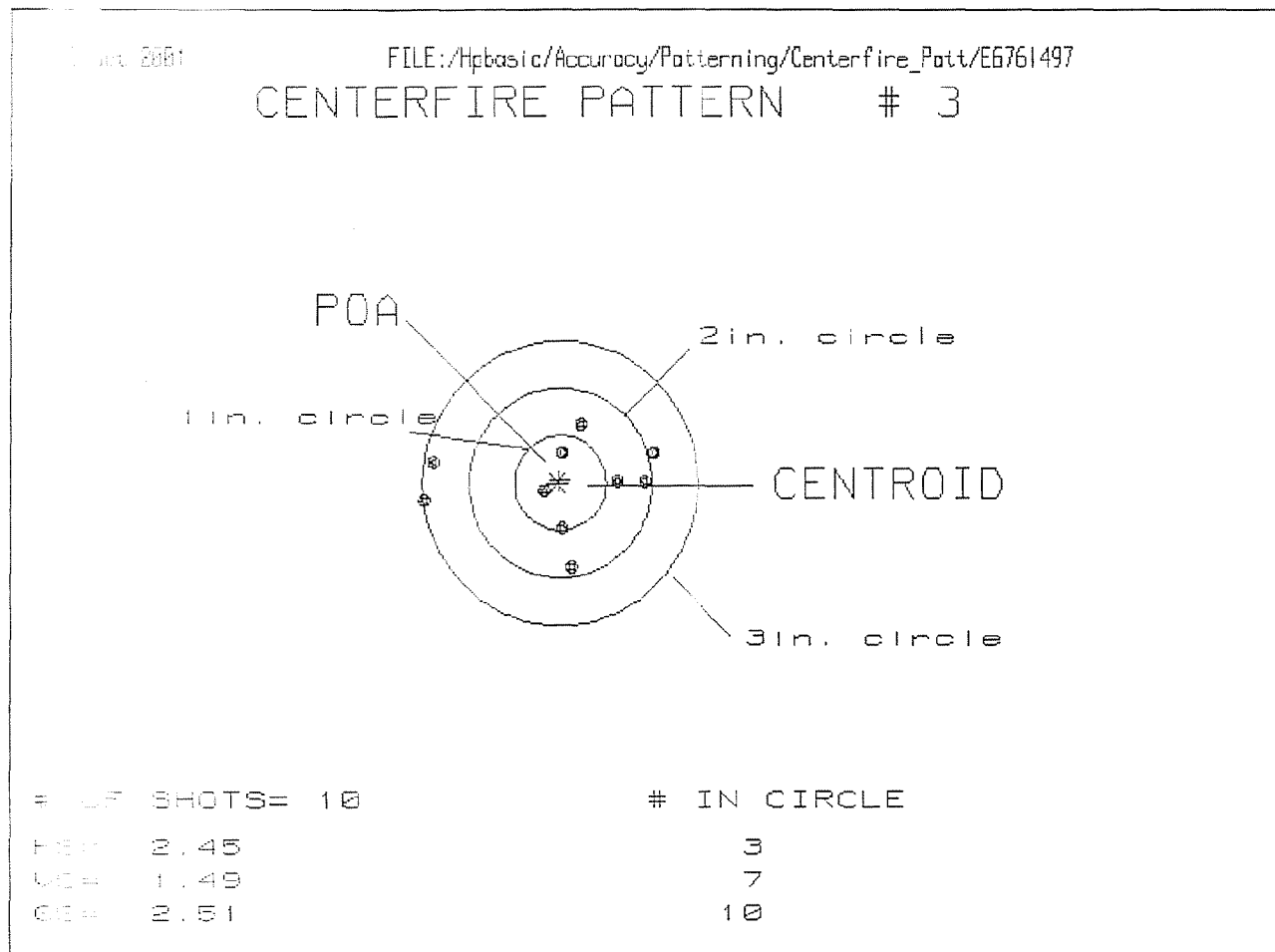
OF SHOTS= 10

IN CIRCLE

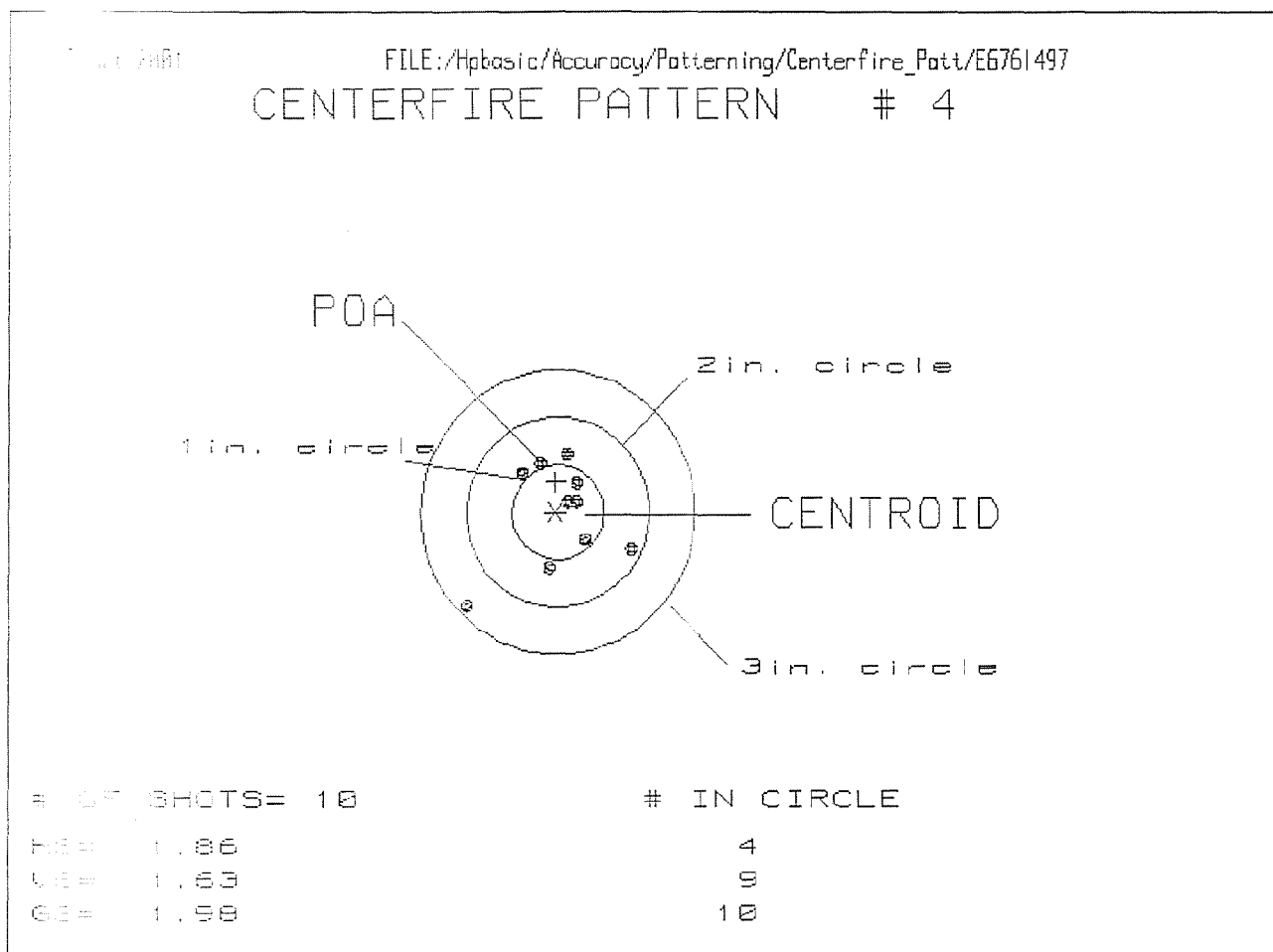
POA 2.53
 CE 2.39
 GE 3.48

0
 5
 8

PATTERN #: 3
 POA TO CENTROID: .030
 MIN RADIUS : .159
 MEAN RADIUS : .797
 MAX RADIUS : 1.452
 CENTROID X : -.021
 CENTROID Y : -.021



PATTERN #: 4
 POA CENTROID: .316
 MIN RADIUS : .125
 MEAN RADIUS : .592
 MAX RADIUS : 1.428
 CENTROID X : -.005
 CENTROID Y : -.316



PATTERN #: 5
 POP. CENTROID: .192
 MIN. RADIUS : .256
 MEAN RADIUS : .935
 MAX. RADIUS : 1.683
 CENTROID X : -.191
 CENTROID Y : -.017

