

E 679 0140

**MODEL 700<sup>TM</sup> M24**  
**BOLT ACTION CENTERFIRE RIFLE**  
**24" BARREL 7.62 NATO**

DOCUMENT ENVELOPE ASSEMBLY:

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

46 FORM 1444

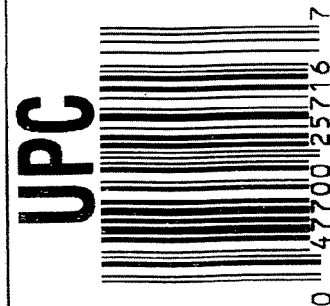


ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

**E6790140**



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

**Remington®**

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

Made in Illion, NY Reg. U.S. Pat. & tm. Off. Marce Registrada Marque Deposee.

|                               |                           |
|-------------------------------|---------------------------|
| SERIAL NO.<br><b>E6790140</b> | ORDER NO.<br><b>25716</b> |
| 46                            |                           |
| 31XV                          |                           |

5716 E6790140

**ORDER 25716**

MODEL 700™ M24

**UPC**



**ORDER 25716**

MODEL 700™ M24

**UPC**



SERIAL NO.



CONTRACT #

GUN SERIAL # E6790140

| OP #      | OPERATION NAME                                                                                                                         | READINGS                           | DATE     | INITIAL |
|-----------|----------------------------------------------------------------------------------------------------------------------------------------|------------------------------------|----------|---------|
| 575 & 580 | ASSEMBLE ACTION AND STOCK                                                                                                              |                                    | 11/15/01 | DK      |
| 600       | PROOF                                                                                                                                  |                                    | 11/15/01 | DK      |
| 607       | CHECK HEADSPACE                                                                                                                        | MAGNA - FLUX                       | 11/15/01 | DK      |
| 610       | DIS-ASSEMBLE GUN                                                                                                                       | INSPECTED                          | 11/15/01 | DK      |
| 612       | MAGNAFLUX BBL ACTION<br>MAGNAFLUX BOLT                                                                                                 | NOV 29 2001<br>OPERATOR <u>DRS</u> |          |         |
| 615       | ROLLMARK CALIBER                                                                                                                       |                                    | 11/30    | LB      |
| 617       | DRILL AND TAP<br>SIGHT HOLES                                                                                                           |                                    | 12/3     | BWT     |
| 620       | APPLY COATINGS<br>(BARREL ACTION)                                                                                                      |                                    | 12-5     | TA      |
|           | (BOLT)                                                                                                                                 |                                    | 12-5     | TA      |
| 625       | FINAL ASSEMBLY                                                                                                                         |                                    | 12-10-01 | DK      |
|           | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                                                                                                    |                                    |          |         |
|           | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD                                                                         |                                    | 12-10-01 | DK      |
|           | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                                                                                                 |                                    | 12-10-01 | DK      |
|           | D) OIL FIRING PIN ASSEMBLY                                                                                                             |                                    | 12-10-01 | DK      |
|           | E) ADJUST TRIGGER PULL<br>TO MIN. SETTING AND<br>STAKE <span style="border: 1px solid black; padding: 2px;">2.50 LBS +/- .5 LBS</span> |                                    | 12-10-01 | GN      |

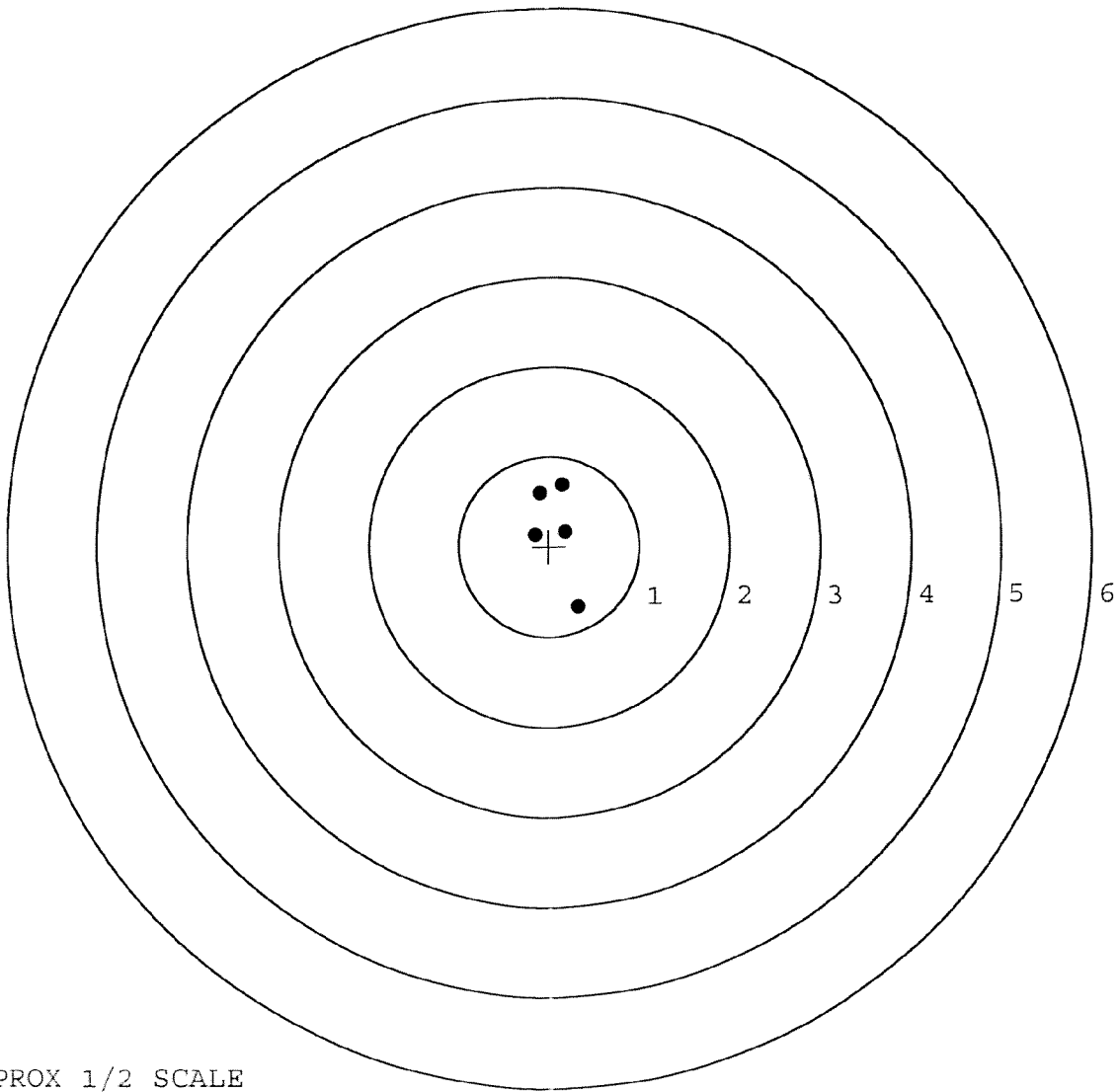
| OP #  | OPERATION NAME                                                           | READINGS                                                    | DATE     | INITIAL |
|-------|--------------------------------------------------------------------------|-------------------------------------------------------------|----------|---------|
| 625   | F) SAFETY ON FORCE <span>2 LBS MIN<br/>10 LBS MAX</span>                 | <u>5.5</u> <u>5.0</u> <u>5.25</u>                           | 12/16/01 | D.N.    |
| CONT. | G) SAFETY OFF FORCE <span>2 LBS MIN</span>                               | <u>2.5</u> <u>2.25</u> <u>2.75</u>                          | 12/16/01 | D.N.    |
|       | H) TRIGGER PULL TEST<br>AND RETAINABILITY                                |                                                             |          |         |
|       | I) FIRING PIN INDENT <span>.020 MIN</span>                               | <u>.022</u> <u>.022</u> <u>.022</u>                         | 12/16/01 | D.N.    |
|       | J) ASSEMBLE STOCK                                                        |                                                             | 12-13-01 | EW      |
|       | K) ASSEMBLE SWIVEL<br>STUDS                                              |                                                             | 12/17/01 | Rep     |
|       | L) ATTACH FRONT AND<br>REAR SIGHT ASSY'S                                 |                                                             | 12/17/01 | Rep     |
|       | M) IRON SIGHT<br>ALIGNMENT                                               |                                                             | 12/17/01 | Rep     |
|       | N) DETACH FRONT AND<br>REAR SIGHTS AND PLACE<br>IN NUMBERED CONTAINER    |                                                             | 12/17/01 | Rep     |
| 640   | GALLERY TEST AND<br>TARGET                                               | PASS FAIL                                                   | 12/15/01 | GRH     |
|       | A) MALFUNCTIONS                                                          | PASS FAIL                                                   | 12/15/01 | GRH     |
|       | B) PIERCED PRIMERS                                                       | PASS FAIL                                                   | 12/15/01 | GRH     |
| 645   | INSPECT FOR LIVE AMMO                                                    |                                                             | 12/15/01 | GRH     |
| 655   | FINAL INSPECTION<br>A) HEADSPACE                                         |                                                             | 12/17/01 | Rep     |
|       | B) TRIGGER PULL <span>+/- .5 LBS<br/>MIN 2.50 LBS<br/>MAX 4.0 LBS</span> | <u>2.89</u> <u>2.87</u> <u>2.96</u> <u>2.79</u> <u>2.71</u> | 12/16/01 | D.N.    |
|       | C) FUNCTION                                                              |                                                             | 12/17/01 | Rep     |
| 660   | PACK                                                                     |                                                             | 12/17/01 | D.A.    |

**BARBER - M24 0114356**

SERIAL NUMBER: *E*6790140. \_\_0  
 TARGET NUMBER: 1  
 FILE DATE: 12/15/2001  
 FILE TIME: 06:26

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.326  | -0.676 |
| 2:     | 0.186  | 0.156  |
| 3:     | -0.157 | 0.130  |
| 4:     | 0.149  | 0.684  |
| 5:     | -0.105 | 0.594  |

X CENTROID: 0.080  
 Y CENTROID: 0.178  
 POA TO CENTROID: 0.195  
 HORZ SPREAD: 0.483  
 VERT SPREAD: 1.360  
 GROUP SPREAD: 1.371  
 MIN RADIUS: 0.108  
 MAX RADIUS: 0.888  
 MEAN RADIUS: 0.441  
 # IN 1 IN DIAMETER: 3  
 # IN 2 IN DIAMETER: 5  
 # in 3 IN DIAMETER: 5



TARGET APPROX 1/2 SCALE

**BARBER - M24 0114357**

SERIAL NUMBER: ~~E~~6790140. \_\_0

TARGET NUMBER: 2

FILE DATE: 12/15/2001

FILE TIME: 06:26

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | -0.223 | -0.546 |
| 2:     | 0.349  | -0.405 |
| 3:     | -0.347 | 0.292  |
| 4:     | -0.120 | 0.611  |
| 5:     | 0.149  | 0.543  |

X CENTROID: -0.038

Y CENTROID: 0.099

POA TO CENTROID: 0.106

HORZ SPREAD: 0.696

VERT SPREAD: 1.157

GROUP SPREAD: 1.162

MIN RADIUS: 0.364

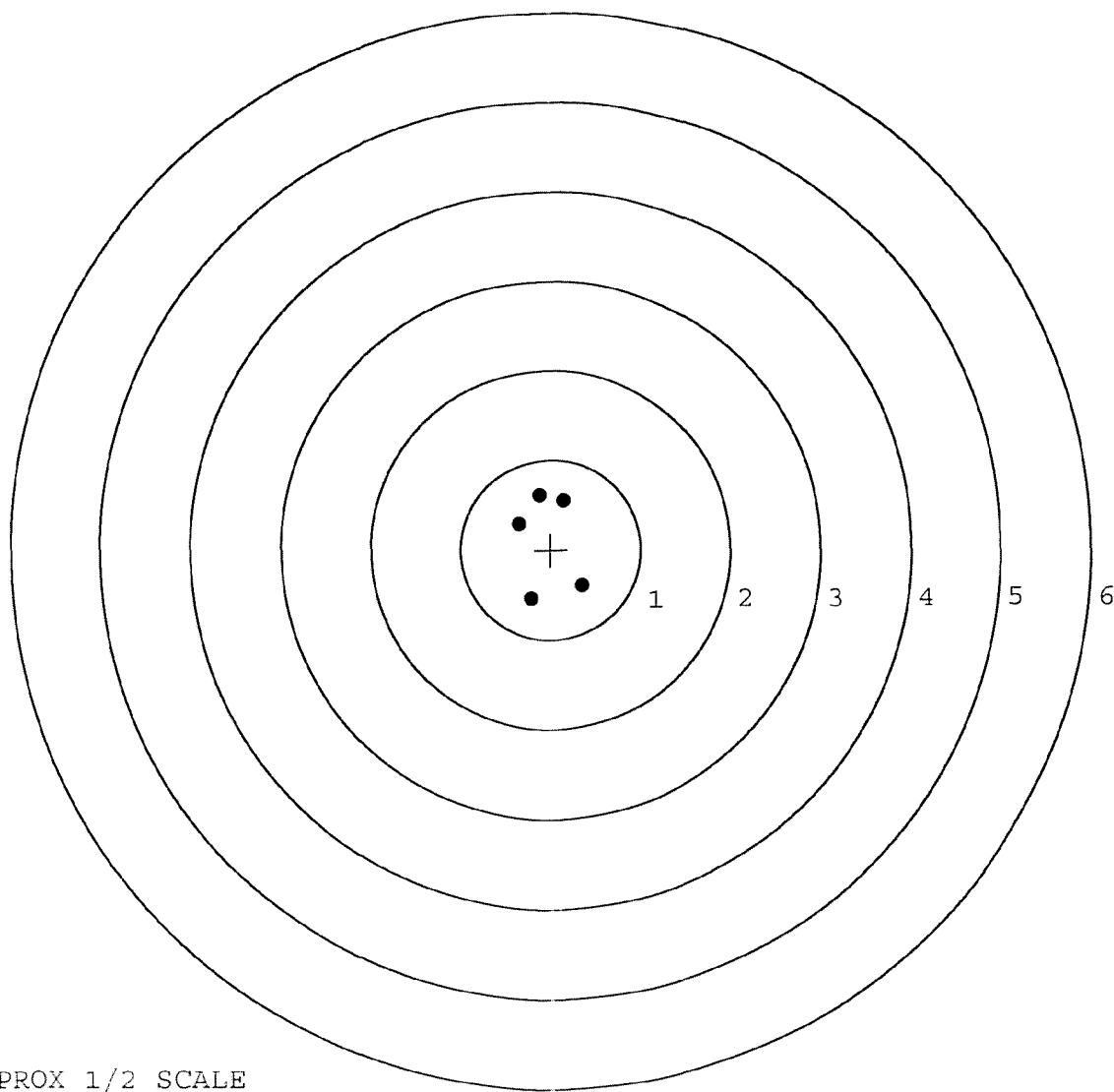
MAX RADIUS: 0.671

MEAN RADIUS: 0.534

# IN 1 IN DIAMETER: 2

# IN 2 IN DIAMETER: 5

# in 3 IN DIAMETER: 5



TARGET APPROX 1/2 SCALE

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50# ± .50#  
3.00# ± .75#  
4.00# ± 1.00#

SERIAL NO. F6790140DATE 11/16/01TESTER B.K.

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.64             | 2.45                     |                                | 2.51 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.29             | 2.37                     |                                | 2.31 |                                                                        |
| PULL #3 | 2.24             | 2.24                     |                                | 2.41 |                                                                        |
| PULL #4 | 2.16             | 2.47                     |                                | 2.56 |                                                                        |
| PULL #5 | 2.21             | 2.53                     |                                | 2.42 |                                                                        |
| TOTAL   | 1154             | 1206                     |                                | 1221 |                                                                        |
| AVG.    | 2.30             | 2.41                     |                                | 2.44 |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.23             | 3.13                     |  |          |
| PULL #2 | 3.49             | 3.26                     |  |          |
| PULL #3 | 3.36             | 3.57                     |  |          |
| PULL #4 | 3.24             | 3.54                     |  |          |
| PULL #5 | 3.20             | 3.36                     |  |          |
| TOTAL   | 1652             | 1686                     |  |          |
| AVG.    | 3.30             | 3.37                     |  |          |

|         | 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 | 4.33             | 4.14                     |                                | 4.19                                 |
| PULL #2 | 4.37             | 4.39                     |                                | 4.05                                 |
| PULL #3 | 4.38             | 4.21                     |                                | 4.44                                 |
| PULL #4 | 4.08             | 4.04                     |                                | 4.20                                 |
| PULL #5 | 4.34             | 4.12                     |                                | 4.41                                 |
| TOTAL   | 2150             | 2090                     |                                | 2129                                 |
| AVG.    | 4.30             | 4.18                     |                                | 4.25                                 |

CONTRACT #

GUN SERIAL # E679 0638

$$\begin{array}{r} 23 \\ 12 \\ \hline 46 \\ 23 \\ \hline 276 \end{array}$$

| OP #      | OPERATION NAME                                                 | READINGS                           | DATE     | INITIAL |
|-----------|----------------------------------------------------------------|------------------------------------|----------|---------|
| 575 & 580 | ASSEMBLE ACTION AND STOCK                                      |                                    | 11/27/01 | RTH     |
| 600       | PROOF                                                          |                                    | 11/27/01 | RTH     |
| 607       | CHECK HEADSPACE                                                | MAGNA - FLUX                       | 11/27/01 | RTH     |
| 610       | DIS-ASSEMBLE GUN                                               | INSPECTED                          | 11/27/01 | RTH     |
| 612       | MAGNAFLUX BBL ACTION<br>MAGNAFLUX BOLT                         | NOV 27 2001<br>OPERATOR <u>NRD</u> |          |         |
| 615       | ROLLMARK CALIBER                                               |                                    | 11/28/01 | SB      |
| 617       | DRILL AND TAP<br>SIGHT HOLES                                   |                                    | 11/29/01 | BWT     |
| 620       | APPLY COATINGS<br>(BARREL ACTION)                              |                                    | 11/30/01 | HP      |
|           | (BOLT)                                                         |                                    | 11/30/01 | HP      |
| 625       | FINAL ASSEMBLY                                                 |                                    |          |         |
|           | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                            |                                    | 12/12/01 | D.M.    |
|           | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD |                                    | 12/12/01 | D.M.    |
|           | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                         |                                    | 12/12/01 | D.M.    |
|           | D) OIL FIRING PIN ASSEMBLY                                     |                                    | 12/12/01 | D.M.    |
|           | E) ADJUST TRIGGER PULL<br>TO MIN. SETTING AND<br>STAKE         | 2.50 LBS +/- .5 LBS                | 12/17/01 | JA      |

| OP #  | OPERATION NAME                                                           | READINGS                                                    | DATE     | INITIAL |
|-------|--------------------------------------------------------------------------|-------------------------------------------------------------|----------|---------|
| 625   | F) SAFETY ON FORCE <span>2 LBS MIN<br/>10 LBS MAX</span>                 | <u>5.5</u> <u>5.75</u> <u>6.0</u>                           | 12/17/01 | D.M.    |
| CONT. |                                                                          |                                                             |          |         |
|       | G) SAFETY OFF FORCE <span>2 LBS MIN</span>                               | <u>2.5</u> <u>3.0</u> <u>2.75</u>                           | 12/17/01 | D.M.    |
|       | H) TRIGGER PULL TEST<br>AND RETAINABILITY                                |                                                             |          |         |
|       | I) FIRING PIN INDENT <span>.020 MIN</span>                               | <u>.022</u> <u>.023</u> <u>.023</u>                         | 12/17/01 | D.M.    |
|       | J) ASSEMBLE STOCK                                                        |                                                             | 12-15-01 | DLH     |
|       | K) ASSEMBLE SWIVEL<br>STUDS                                              |                                                             | 12/17/01 | REP     |
|       | L) ATTACH FRONT AND<br>REAR SIGHT ASSY'S                                 |                                                             | 12/17/01 | REP     |
|       | M) IRON SIGHT<br>ALIGNMENT                                               |                                                             | 12/17/01 | REP     |
|       | N) DETACH FRONT AND<br>REAR SIGHTS AND PLACE<br>IN NUMBERED CONTAINER    |                                                             | 12/17/01 | REP     |
| 640   | GALLERY TEST AND<br>TARGET                                               | PASS FAIL                                                   | 12-16-01 | EK      |
|       | A) MALFUNCTIONS                                                          | <u>PASS</u> FAIL                                            | 12-16-01 | EK      |
|       | B) PIERCED PRIMERS                                                       | <u>PASS</u> FAIL                                            | 12-16-01 | EK      |
| 645   | INSPECT FOR LIVE AMMO                                                    | ✓                                                           | 12-16-01 | EK      |
| 655   | FINAL INSPECTION<br>A) HEADSPACE                                         |                                                             | 12/17/01 | REP     |
|       | B) TRIGGER PULL <span>+/- .5 LBS<br/>MIN 2.50 LBS<br/>MAX 4.0 LBS</span> | <u>2.62</u> <u>2.84</u> <u>2.49</u> <u>2.31</u> <u>2.61</u> | 12/17/01 | D.M.    |
|       | C) FUNCTION                                                              |                                                             | 12/17/01 | REP     |
| 660   | PACK                                                                     |                                                             | 12/17/01 | DA      |

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. E6790638DATE 11/12/01TESTER DM

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------------------------------------------------------------------------|
| PULL #1 | 2.57             | 2.11                     | 2.34                           | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.47             | 2.14                     | 2.30                           |                                                                        |
| PULL #3 | 2.45             | 2.15                     | 2.34                           |                                                                        |
| PULL #4 | 2.42             | 2.20                     | 2.28                           |                                                                        |
| PULL #5 | 2.27             | 2.29                     | 2.30                           |                                                                        |
| TOTAL   | 12.18            | 10.89                    | 11.56                          |                                                                        |
| AVG.    | 2.44             | 2.18                     | 2.31                           |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES | COMMENTS |
|---------|------------------|--------------------------|----------|
| PULL #1 | 3.26             | 3.17                     |          |
| PULL #2 | 3.12             | 3.10                     |          |
| PULL #3 | 3.28             | 3.19                     |          |
| PULL #4 | 3.29             | 3.15                     |          |
| PULL #5 | 3.24             | 3.14                     |          |
| TOTAL   | 16.19            | 15.75                    |          |
| AVG.    | 3.24             | 3.15                     |          |

|         | 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 | 4.09             | 4.07                     |                                | 4.32                                 |
| PULL #2 | 4.05             | 4.03                     |                                | 4.17                                 |
| PULL #3 | 4.03             | 4.05                     |                                | 4.02                                 |
| PULL #4 | 4.06             | 4.08                     |                                | 4.22                                 |
| PULL #5 | 4.05             | 4.11                     |                                | 4.27                                 |
| TOTAL   | 20.28            | 20.34                    |                                | 21.00                                |
| AVG.    | 4.06             | 4.07                     |                                | 4.20                                 |

**BARBER - M24 0114362**

SERIAL NUMBER: E6790638. 0

TARGET NUMBER: 1

FILE DATE: 12/16/2001

FILE TIME: 03:16

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.084  | -0.684 |
| 2:     | -0.973 | -0.198 |
| 3:     | -0.066 | 0.288  |
| 4:     | 0.365  | 0.605  |
| 5:     | 0.683  | 0.678  |

X CENTROID: 0.019

Y CENTROID: 0.138

POA TO CENTROID: 0.139

HORZ SPREAD: 1.656

VERT SPREAD: 1.362

GROUP SPREAD: 1.873

MIN RADIUS: 0.172

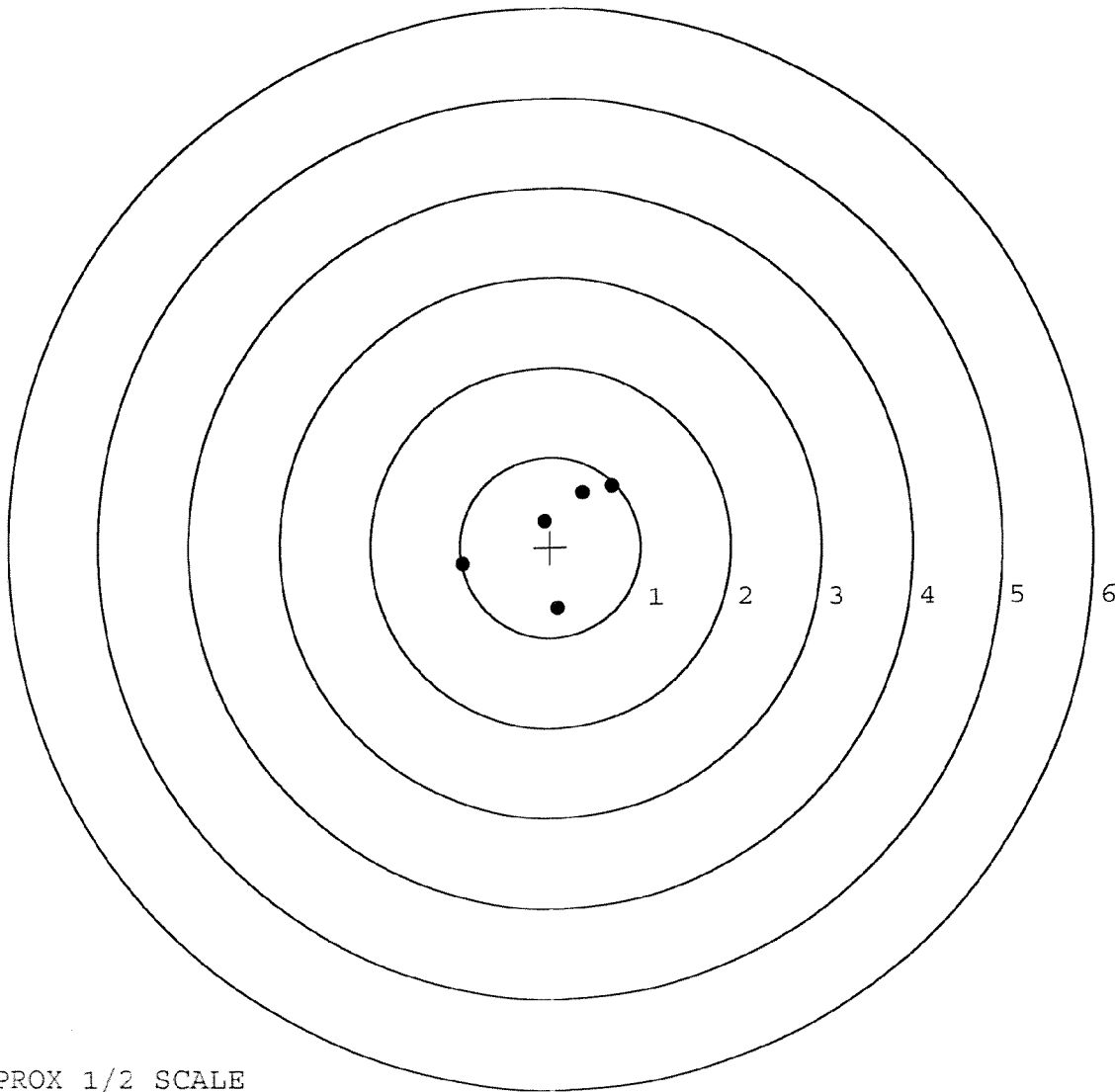
MAX RADIUS: 1.047

MEAN RADIUS: 0.696

# IN 1 IN DIAMETER: 1

# IN 2 IN DIAMETER: 4

# in 3 IN DIAMETER: 5



TARGET APPROX 1/2 SCALE

**BARBER - M24 0114363**

SERIAL NUMBER: ~~E~~6790638. 0

TARGET NUMBER: 2

FILE DATE: 12/16/2001

FILE TIME: 03:16

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | -0.452 | -0.665 |
| 2:     | -0.067 | -0.379 |
| 3:     | 0.103  | -0.200 |
| 4:     | 0.536  | -0.343 |
| 5:     | -0.118 | 0.859  |

X CENTROID: 0.000

Y CENTROID: -0.146

POA TO CENTROID: 0.146

HORZ SPREAD: 0.988

VERT SPREAD: 1.524

GROUP SPREAD: 1.560

MIN RADIUS: 0.116

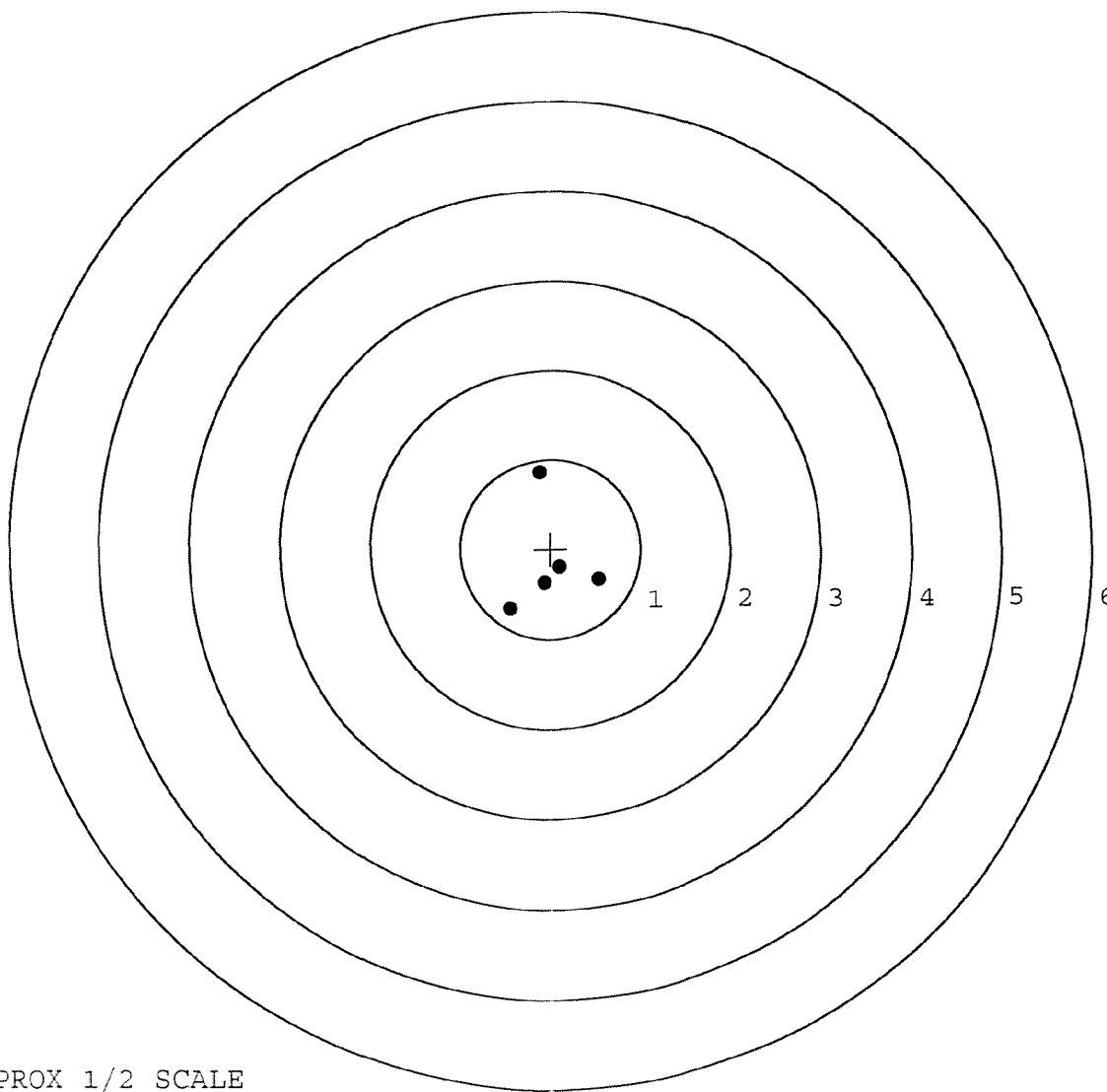
MAX RADIUS: 1.012

MEAN RADIUS: 0.526

# IN 1 IN DIAMETER: 2

# IN 2 IN DIAMETER: 4

# in 3 IN DIAMETER: 5



TARGET APPROX 1/2 SCALE