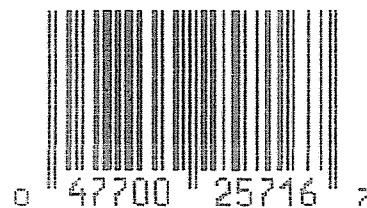


Speed®

FORM

UPC



06665883

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.

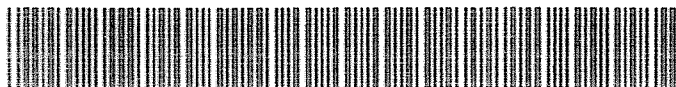
C6665883

ORDER NO.

5716

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

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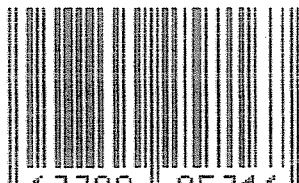


5716 C6665883

ORDER 5716

MODEL 700 <sup>TM</sup> M24

UPC

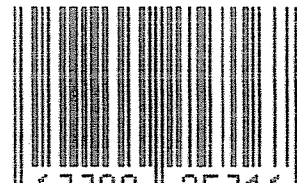


0 47700 25716 7

ORDER 5716

MODEL 700 <sup>TM</sup> M24

UPC



0 47700 25716 7

**GFM**

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

**CCCC5883**

| OP. #        | OP. NAME                                                       | READINGS | DATE       | INIT |
|--------------|----------------------------------------------------------------|----------|------------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   |          | 9/26/91    | KK   |
| 600          | Proof                                                          |          | 9/26/91    | KK   |
| 607          | Check Headspace                                                |          | 9/26/91    | KK   |
| 610          | Dis-assemble Gun                                               |          | 9/26/91    | KK   |
| 612          | Magnaflux Barrel<br>Action                                     |          | OCT 4 1991 | KCD  |
|              | Magnaflux Bolt                                                 |          | OCT 4 1991 | KCD  |
| 615          | Rollmark Caliber                                               |          | OCT 4 1991 | CS   |
| 617          | Drill and Tap Sight Holes                                      |          | OCT 4 1991 | LB   |
| 618          | Polish Barrel                                                  |          | OCT 4 1991 | WB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 10-18-91   | JA   |
|              | Apply Coating (Bolt)                                           |          | 10-18-91   | JA   |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 11/11/91   | KK   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 11/11/91   | KK   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 11/11/91   | KK   |
|              | D) Oil Firing Pin Ass'y                                        |          | 11/11/91   | KK   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 11-12-91   | JK   |

| op. #        | OP. NAME                                                    | READINGS |      |      |     |     | DATE     | INIT |
|--------------|-------------------------------------------------------------|----------|------|------|-----|-----|----------|------|
| 625<br>cont. | F) Safety On Force                                          | 6        | 5    | 5    |     |     | 11-12-91 | JK   |
|              | G) Safety Off Force                                         | 4        | 4    |      |     |     | 11-12-91 | JK   |
|              | H) Trigger Pull Test & Retainability                        |          |      |      |     |     | 11-12-91 | JK   |
|              | I) Firing Pin Indent                                        | .021     | .021 | .021 |     |     | 11-12-91 | JK   |
|              | J) Assemble Stock                                           |          |      |      |     |     | 11/12/91 | JK   |
|              | K) Assemble Swivel Studs                                    |          |      |      |     |     | 11-24-91 | JK   |
|              | L) Attach Front and Rear Sight Assemblies                   |          |      |      |     |     | 11/12/91 | JK   |
|              | M) Iron Sight Alignment                                     |          |      |      |     |     | 11/12/91 | JK   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |      |      |     |     | 11/12/91 | JK   |
|              | O) Attach Scope to Rifle                                    |          |      |      |     |     | 11/12/91 | JK   |
|              | P) Detach & Attach Scope 20 Times                           |          |      |      |     |     | 11/12/91 | JK   |
| 640          | Gallery Target & Test                                       |          |      |      |     |     | 11-21-91 | NF   |
|              | A) Time                                                     |          |      |      |     |     | "        | NF   |
|              | B) Malfunctions                                             |          |      |      |     |     | "        | NF   |
|              | C) Pierced Primers                                          |          |      |      |     |     | "        | NF   |
|              | D) Optical Clarity of Scope                                 |          |      |      |     |     | "        | NF   |
| 645          | Inspect for Live Ammo                                       |          |      |      |     |     | 11-21-91 | NF   |
| 655          | Final Inspection                                            |          |      |      |     |     |          |      |
|              | A) Headspace                                                |          |      |      |     |     | 11-26-91 | JK   |
|              | B) Trigger Pull                                             | 288      | 288  | 278  | 277 | 277 | 11-22-91 | D/H  |
|              | C) Function                                                 |          |      |      |     |     | 11-26-91 | JK   |
| 660          | Pack                                                        |          |      |      |     |     |          |      |

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

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

SERIAL NO. C-6665883

DATE 11-12-91

TESTER GU.

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |     | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|-----|------------------------------------------------------------------------|
| PULL #1 | 2.55             | 2.57                     | 2.55                           | 288 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.44             | 2.55                     | 2.53                           | 288 |                                                                        |
| PULL #3 | 2.54             | 2.63                     | 2.50                           | 278 |                                                                        |
| PULL #4 | 2.56             | 2.61                     | 2.58                           | 277 |                                                                        |
| PULL #5 | 2.66             | 2.53                     | 2.56                           | 277 |                                                                        |
| TOTAL   |                  |                          |                                |     |                                                                        |
| AVG.    |                  |                          |                                |     |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.40             | 3.20                     |  |          |
| PULL #2 | 3.44             | 3.35                     |  |          |
| PULL #3 | 3.47             | 3.45                     |  |          |
| PULL #4 | 3.49             | 3.52                     |  |          |
| PULL #5 | 3.24             | 3.47                     |  |          |
| 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 | 4.40             | 4.38                     |                                | 4.30                                 |
| PULL #2 | 4.39             | 4.21                     |                                | 4.30                                 |
| PULL #3 | 4.23             | 4.36                     |                                | 4.46                                 |
| PULL #4 | 4.27             | 4.40                     |                                | 4.31                                 |
| PULL #5 | 4.33             | 4.30                     |                                | 4.45                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6665883  
22 Nov 1991

CENTROIDAL DISTANCES

|        |         |
|--------|---------|
| 0 TO 1 | .121696 |
| 1 TO 2 | .209898 |
| 1 TO 3 | .202675 |
| 1 TO 4 | .230098 |
| 1 TO 5 | .123102 |

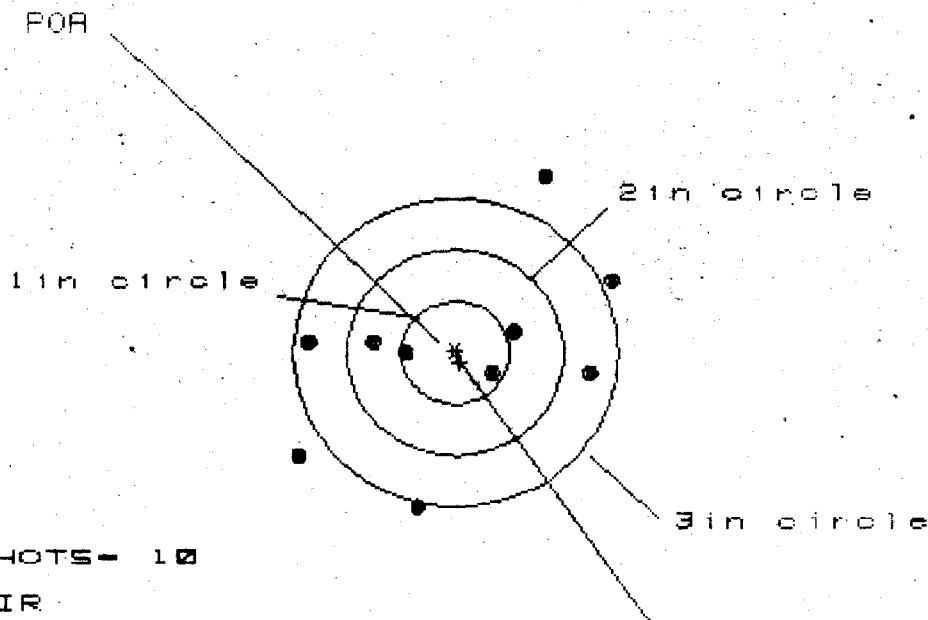
<----POA

THE CENTROIDAL DISTANCE FOR THIS RIFLE IS: .0442  
THE CENTROIDAL DISTANCE FOR THIS RIFLE IS: .0888  
THE CENTROIDAL DISTANCE FOR THIS RIFLE IS: .0991921  
THE CENTROIDAL DISTANCE FOR THIS RIFLE IS: 1.088

0 0 1001

FILE:/PATTERNING/CENTERFIRE\_PATT/C6665883

# CENTERFIRE PATTERNS \* 1



\* OF SHOTS - 10

# IN CIR

1 in = 2

2 in = 4

3 in = 6

HS = 2.989

VS = 3.200

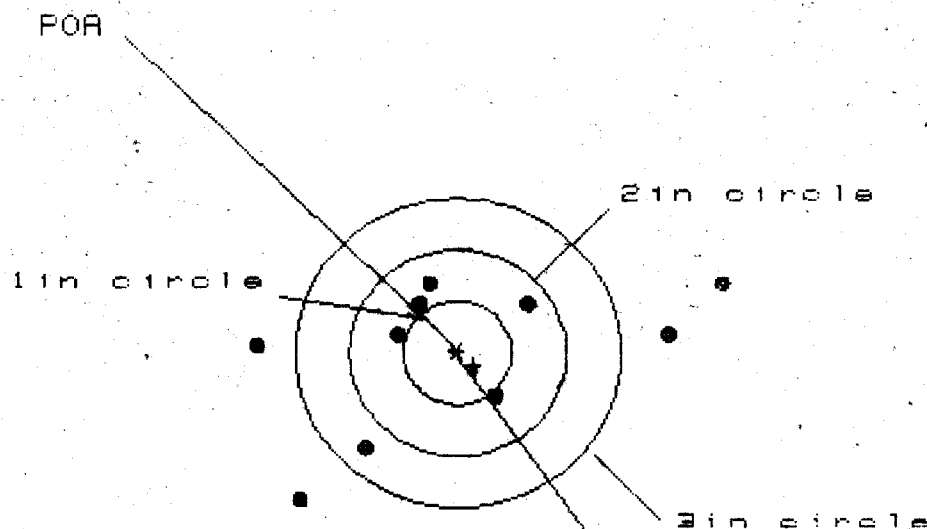
GS = 3.577

| PATTERN #                     | : | 10     | 9      | 8      |
|-------------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)               | : | 10     | 9      | 8      |
| MAXIMUM X                     | : | 1.482  | 1.576  | 1.399  |
| MINIMUM X                     | : | -1.507 | -1.413 | -1.464 |
| MAXIMUM Y                     | : | 1.733  | .894   | .797   |
| MINIMUM Y                     | : | -1.467 | -1.274 | -1.371 |
| CENTROID X                    | : | -.040  | -.134  | .043   |
| CENTROID Y                    | : | .094   | -.099  | -.002  |
| POS TO CENTROID in.           | : | .102   | .166   | .043   |
| MIN RADIUS                    | : | .437   | .427   | .322   |
| MEAN RADIUS                   | : | 1.174  | 1.084  | .997   |
| MR RADIUS                     | : | 1.927  | 1.812  | 1.611  |
| HORIZONTAL SPREAD             | : | 2.989  | 2.989  | 2.863  |
| VERTICAL SPREAD               | : | 3.200  | 2.168  | 2.168  |
| EXTREME SPREAD                | : | 3.577  | 3.421  | 2.933  |
| NUMBER IN ONE INCH CIRCLE =   | : | 2      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | : | 4      |        |        |
| NUMBER IN THREE INCH CIRCLE = | : | 6      |        |        |

22 Nov 1991

FILE:/PATTERNS/CENTERFIRE\_PAT/C66656B3

# CENTERFIRE PATTERNS # 2



# OF SHOTS = 10

# IN CIR

1in = 0

2in = 5

3in = 6

HS = 4.322

VS = 2.165

GS = 4.504

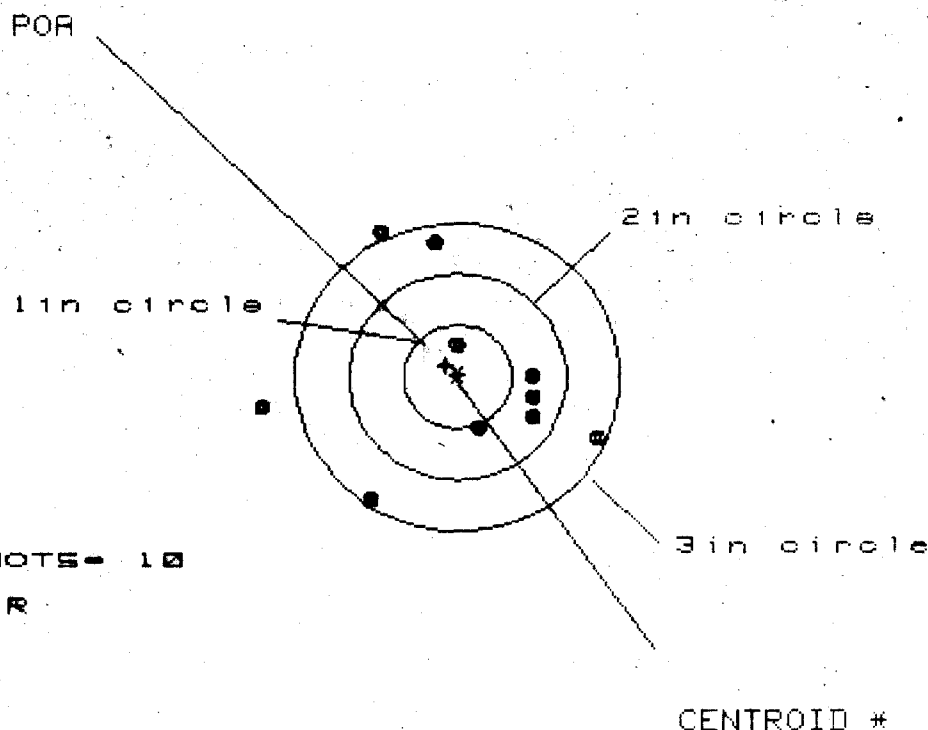
CENTROID \*

|                             |   |        |        |        |
|-----------------------------|---|--------|--------|--------|
| PATTERN #                   | : |        |        |        |
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 2.476  | 2.182  | 2.032  |
| MINIMUM X                   | : | -1.846 | -1.570 | -1.720 |
| MAXIMUM Y                   | : | .712   | .789   | .617   |
| MINIMUM Y                   | : | -1.453 | -1.374 | -1.026 |
| CENTROID X                  | : | -.145  | -.421  | -.271  |
| CENTROID Y                  | : | .120   | .041   | .213   |
| POA TO CENTROID in.         | : | .189   | .423   | .344   |
| MIN RADIUS                  | : | .535   | .328   | .394   |
| MEAN RADIUS                 | : | 1.291  | 1.121  | 1.004  |
| MAX RADIUS                  | : | 2.577  | 2.194  | 2.033  |
| HORIZONTAL SPREAD           | : | 4.322  | 3.752  | 3.752  |
| VERTICAL SPREAD             | : | 2.165  | 2.163  | 1.643  |
| EXTREME SPREAD              | : | 4.504  | 3.752  | 3.752  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 0      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 5      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 6      |        |

22 Nov 1991

FILE:/PATTERNS/CENTERFIRE\_PATT/C6665883

# CENTERFIRE PATTERNS # 3



# OF SHOTS = 10

# IN CIR

1in = 2

2in = 5

3in = 8

HS = 3.123

VS = 2.618

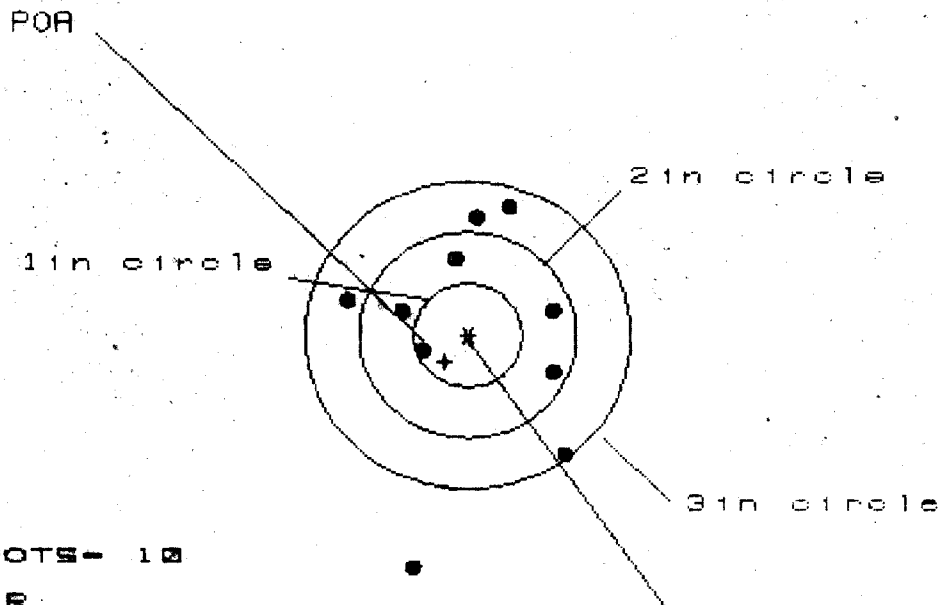
GS = 3.130

|                               |   |        |        |        |
|-------------------------------|---|--------|--------|--------|
| PATTERN #                     | : |        |        |        |
| SHOTS (BEST OF)               | : | 10     | 9      | 8      |
| MAXIMUM X                     | : | 1.265  | 1.059  | .947   |
| MINIMUM X                     | : | -1.858 | -.984  | -1.096 |
| MAXIMUM Y                     | : | 1.419  | 1.383  | 1.489  |
| MINIMUM Y                     | : | -1.199 | -1.235 | -1.062 |
| CENTROID X                    | : | .109   | .315   | .427   |
| CENTROID Y                    | : | -.112  | -.076  | -.249  |
| POA TO CENTROID in.           | : | .156   | .324   | .494   |
| MIN RADIUS                    | : | .356   | .391   | .353   |
| MEAN RADIUS                   | : | 1.071  | .933   | .791   |
| MAX RADIUS                    | : | 1.887  | 1.648  | 1.574  |
| HORIZONTAL SPREAD             | : | 3.123  | 2.043  | 2.043  |
| VERTICAL SPREAD               | : | 2.618  | 2.618  | 2.551  |
| EXTREME SPREAD                | : | 3.130  | 2.770  | 2.617  |
| NUMBER IN ONE INCH CIRCLE =   |   |        | 2      |        |
| NUMBER IN TWO INCH CIRCLE =   |   |        | 5      |        |
| NUMBER IN THREE INCH CIRCLE = |   |        | 8      |        |

22 Nov 1991

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# CENTERFIRE PATTERNS # 4



# OF SHOTS- 10

# IN CIR

1in = 1

2in = 5

3in = 9

HS= 1.961

VS= 3.578

GS= 3.679

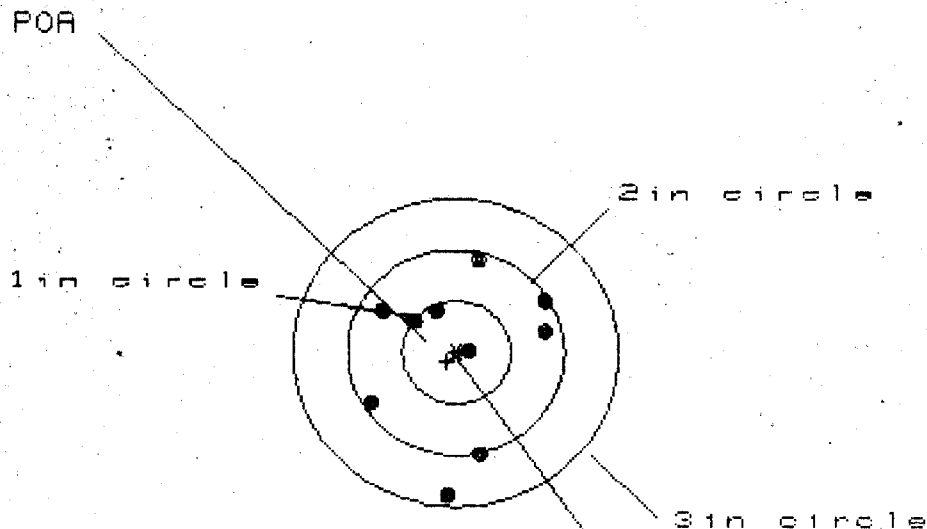
CENTROID \*

|                             |   |        |        |        |
|-----------------------------|---|--------|--------|--------|
| PATTERN #                   | : |        |        |        |
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | .850   | .794   | .801   |
| MINIMUM X                   | : | -1.111 | -1.167 | -1.068 |
| MAXIMUM Y                   | : | 1.285  | 1.031  | .849   |
| MINIMUM Y                   | : | -2.292 | -1.452 | -.839  |
| CENTROID X                  | : | .214   | .270   | .171   |
| CENTROID Y                  | : | .253   | .508   | .690   |
| POA TO CENTROID in.         | : | .332   | .575   | .711   |
| MIN RADIUS                  | : | .380   | .526   | .320   |
| MEAN RADIUS                 | : | 1.091  | .910   | .780   |
| MAX RADIUS                  | : | 2.348  | 1.655  | 1.160  |
| HORIZONTAL SPREAD           | : | 1.961  | 1.961  | 1.869  |
| VERTICAL SPREAD             | : | 3.578  | 2.483  | 1.688  |
| EXTREME SPREAD              | : | 3.679  | 2.533  | 2.000  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 1      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 5      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |        |

22 Nov 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6665683

# CENTERFIRE PATTERNS # 5



# OF SHOTS- 10

# IN CIR

1in = 2

2in = 8

3in = 10

HS= 1.618

VS= 2.368

GS= 2.380

CENTROID #

| PATTERN #                     | 10     | 9      | 8     |
|-------------------------------|--------|--------|-------|
| SHOTS (BEST OF)               | 10     | 9      | 8     |
| MAXIMUM X                     | .806   | .800   | .828  |
| MINIMUM X                     | -.812  | -.818  | -.790 |
| MAXIMUM Y                     | .960   | .803   | .661  |
| MINIMUM Y                     | -1.403 | -1.139 | -.807 |
| CENTROID X                    | .083   | .089   | .062  |
| CENTROID Y                    | .089   | .246   | .388  |
| POA TO CENTROID in.           | .122   | .261   | .393  |
| MIN RADIUS                    | .168   | .189   | .238  |
| MEAN RADIUS                   | .808   | .711   | .635  |
| MAX RADIUS                    | 1.409  | 1.159  | 1.130 |
| HORIZONTAL SPREAD             | 1.618  | 1.618  | 1.618 |
| VERTICAL SPREAD               | 2.368  | 1.942  | 1.468 |
| EXTREME SPREAD                | 2.380  | 1.942  | 1.905 |
| NUMBER IN ONE INCH CIRCLE =   | 2      |        |       |
| NUMBER IN TWO INCH CIRCLE =   | 8      |        |       |
| NUMBER IN THREE INCH CIRCLE = | 10     |        |       |