

E 679 0140

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

DOCUMENT ENVELOPE ASSEMBLY:

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

46 FORM 1444

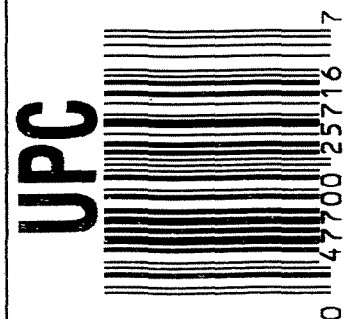


ORDER NO. 25716

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**

SERIAL NO. J
E6790140

ORDER NO.
25716

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



5716 E6790140

ORDER

25716

MODEL 700™ M24

UPC



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25716

MODEL 700™ M24

UPC



SERIAL NO.



E6790140

CONTRACT #

GUN SERIAL # E6790140

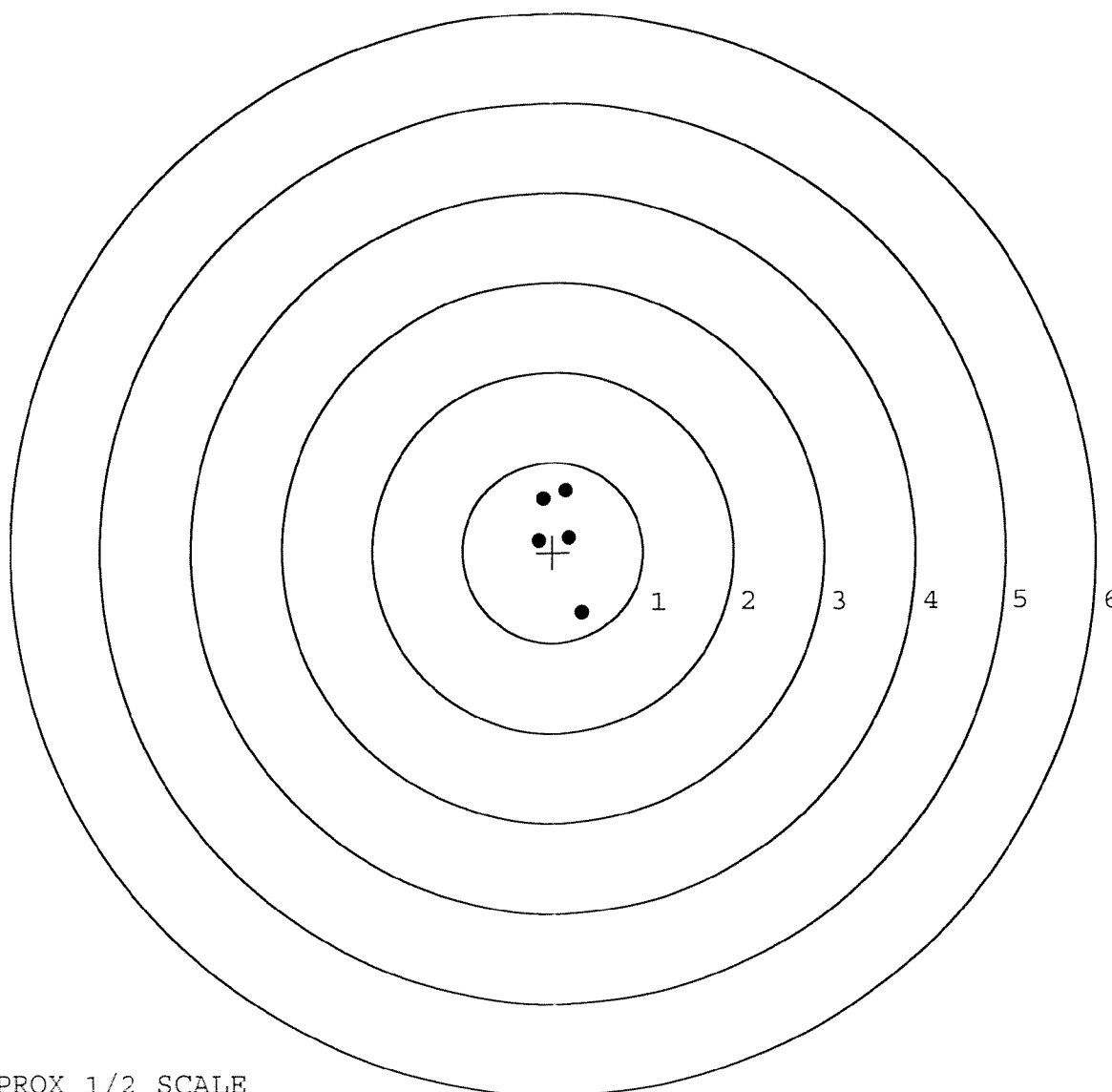
OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		11/15/01	DK
600	PROOF		11/15/01	DK
607	CHECK HEADSPACE	MAGNA - FLUX	11/15/01	DK
610	DIS-ASSEMBLE GUN	INSPECTED	11/15/01	DK
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	NOV 29 2001 OPERATOR <u>DRS</u>		
615	ROLLMARK CALIBER		11/30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

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5.5</u> <u>5.0</u> <u>5.25</u>	12/16/01	D.M.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2.75</u> <u>2.75</u>	12/16/01	D.M.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.022</u> <u>.022</u>	12/16/01	D.M.
	J) ASSEMBLE STOCK		12-13-01	EW
	K) ASSEMBLE SWIVEL STUDS		12/17/01	Rep
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		12/17/01	Rep
	M) IRON SIGHT ALIGNMENT		12/17/01	Rep
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		12/17/01	Rep
640	GALLERY TEST AND TARGET	PASS FAIL	12/15/01	RH
	A) MALFUNCTIONS	PASS FAIL	12/15/01	RH
	B) PIERCED PRIMERS	PASS FAIL	12/15/01	RH
645	INSPECT FOR LIVE AMMO		12/15/01	RH
655	FINAL INSPECTION A) HEADSPACE		12/17/01	Rep
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.89</u> <u>2.87</u> <u>2.96</u> <u>2.79</u> <u>2.71</u>	12/14/01	D.M.
	C) FUNCTION		12/17/01	Rep
660	PACK		12/17/01	D.A.

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

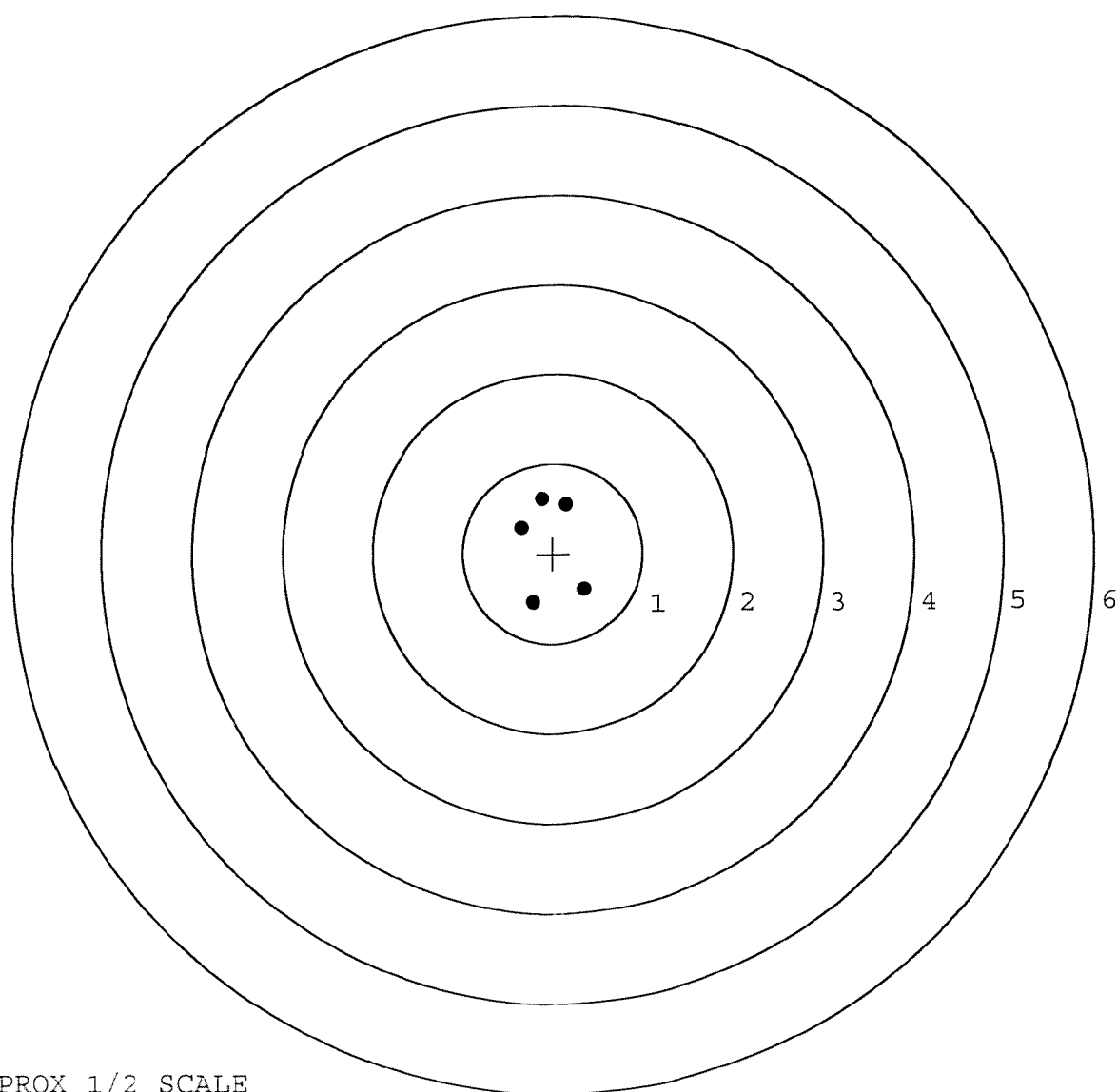


TARGET APPROX 1/2 SCALE

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. F6796140

DATE 11/16/01

TESTER B.K.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.64	2.45		2.51	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- 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# INITIAL	3.00# AFTER 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# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR 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

M-24

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

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

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. E6790638

DATE 11/12/01

TESTER DN

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.57	2.11		2.34	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- 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	

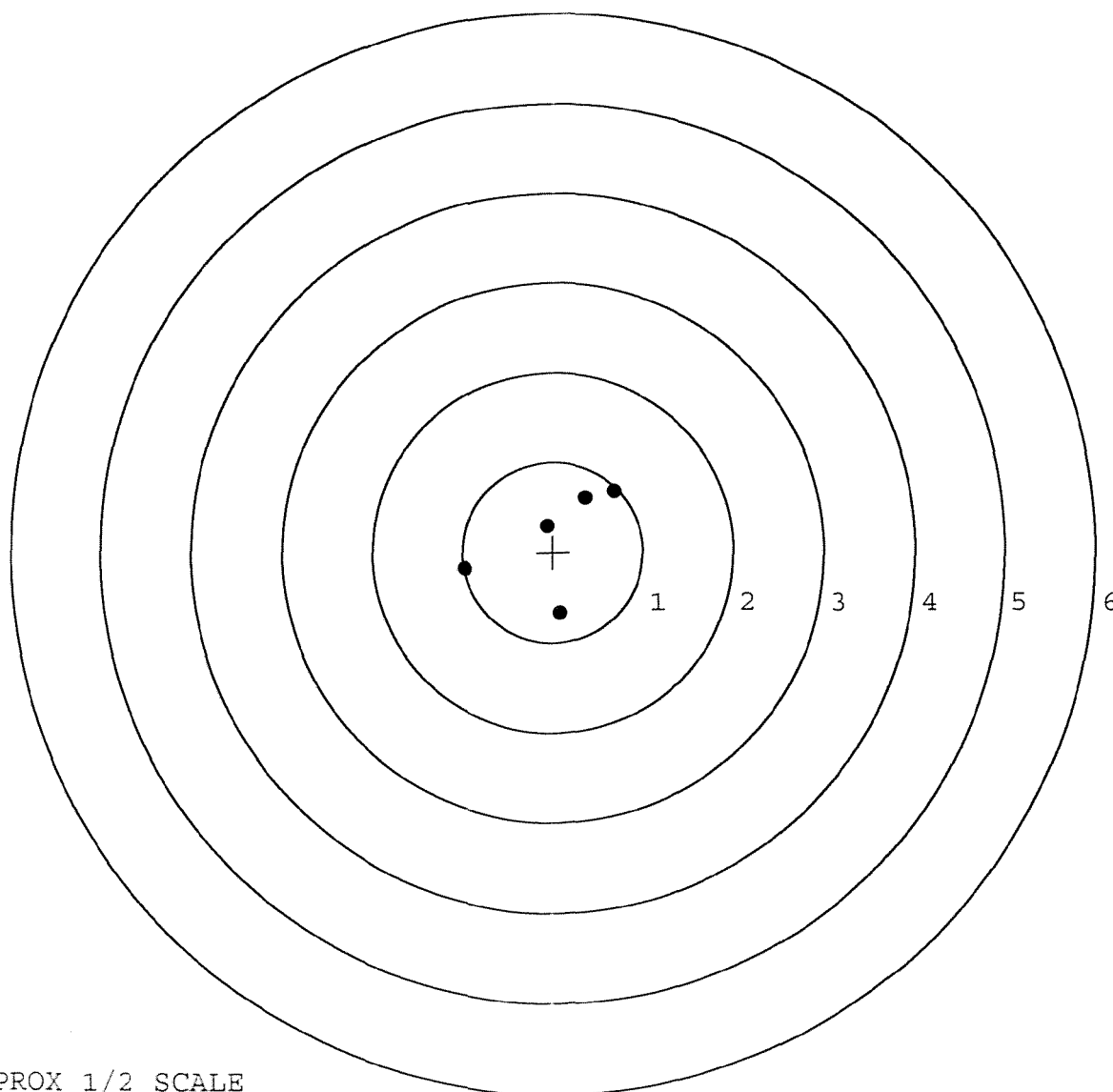
	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.26	3.17		
PULL #2	3.12	3.10		
PULL #3	3.28	3.19		
PULL #4	3.29	3.15		
PULL #5	3.24	3.14		
TOTAL	16.19	15.75		
AVG.	3.24	3.15		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.09	4.07		4.03 4.32
PULL #2	4.05	4.03		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

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

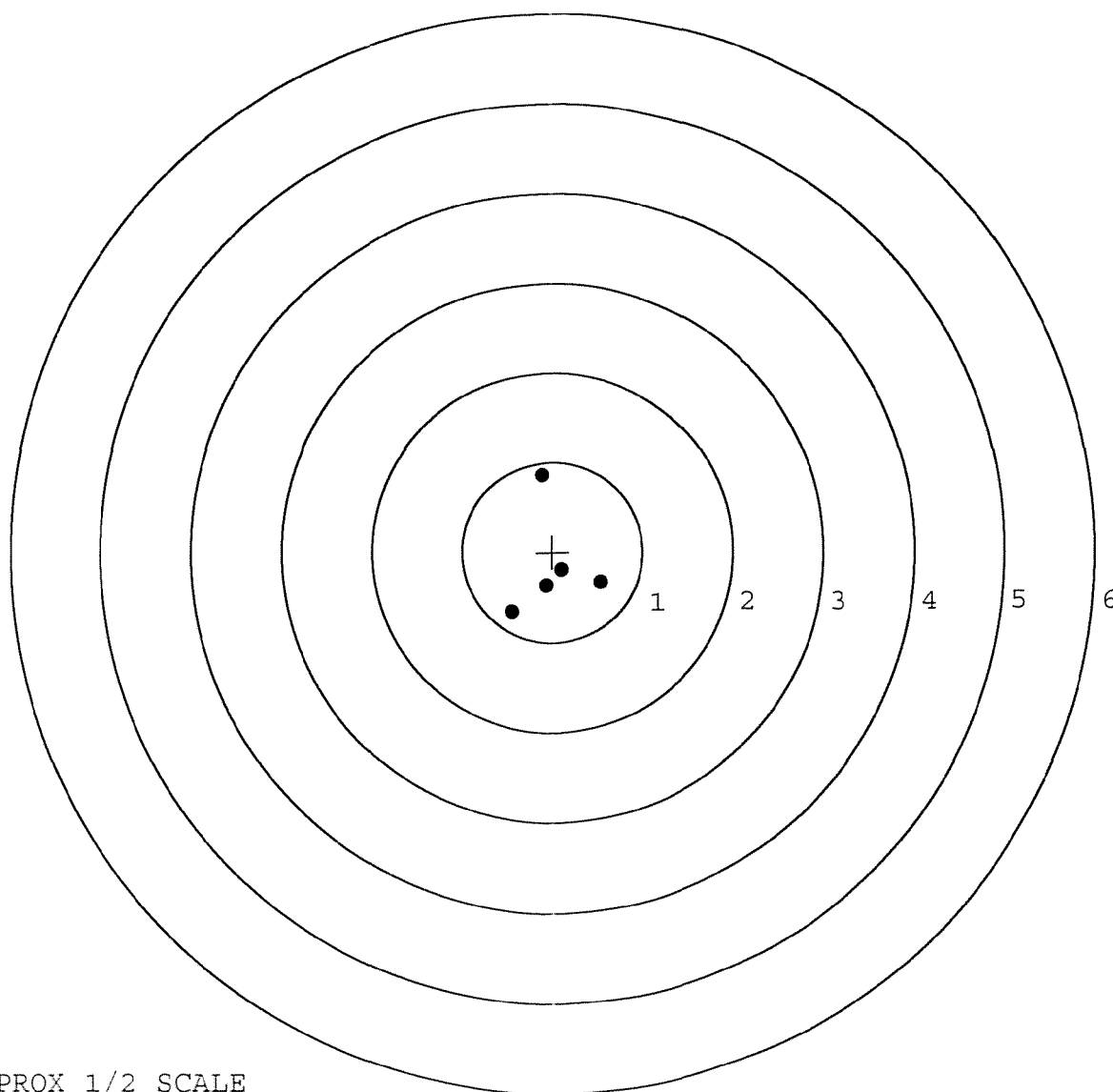


TARGET APPROX 1/2 SCALE

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