

FOR

UPC



0 47700 25716 7

C6649033

\*INCLUDES 1 IN CHAMBER

CAPACITY\*

BARREL LENGTH

MODEL 700 TM M24

ORDER NO. 5716

**Remington**VERY IMPORTANT:  
Instruction Book  
enclosed to assure  
safe use of this  
firearm.**MODEL 700™ M24**

SERIAL NO.

C6649033

ORDER NO.

**5716**

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

20



5716 C6649033

**ORDER 5716**

MODEL 700™ M24

**UPC**

0 47700 25716 7

**ORDER 5716**

MODEL 700™ M24

**UPC**

0 47700 25716 7

**GFM**

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649033

| OP. #        | OP. NAME                                                       | READINGS | DATE     | INIT |
|--------------|----------------------------------------------------------------|----------|----------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   | 9 26     | 9 1      | RW   |
| 600          | Proof                                                          | 9 26     | 9 1      | RW   |
| 607          | Check Headspace                                                | 9 26     | 9 1      | RW   |
| 610          | Dis-assemble Gun                                               | 9 26     | 9 1      | RW   |
| 612          | Magnaflux Barrel<br>Action                                     | OCT      | 3 1991   | KCD  |
|              | Magnaflux Bolt                                                 | OCT      | 3 1991   | KCD  |
| 615          | Rollmark Caliber                                               | OCT      | 3 1991   | CS.  |
| 617          | Drill and Tap Sight Holes                                      | OCT      | 4 1991   | FB   |
| 618          | Polish Barrel                                                  | OCT      | 4 1991   | WB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 10/18/91 | JA   |
|              | Apply Coating (Bolt)                                           |          |          |      |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 10/18/91 | RW   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 10/18/91 | RW   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 10/18/91 | RW   |
|              | D) Oil Firing Pin Ass'y                                        |          | 10/18/91 | RW   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 12/3/91  | WB   |

| op. NAME<br>BARBER - M24 0030870 |                                                             | READINGS |       |       |         | DATE | INIT     |    |
|----------------------------------|-------------------------------------------------------------|----------|-------|-------|---------|------|----------|----|
| 625<br>cont.                     | F) Safety On Force                                          | 3 1/2    | 3 1/2 | 3 1/2 | 12/3/91 | WLB  |          |    |
|                                  | G) Safety Off Force                                         | 2        | 2     | 2     | 12/3/91 | WLB  |          |    |
|                                  | H) Trigger Pull Test & Retainability                        |          |       |       | 12/3/91 | WLB  |          |    |
|                                  | I) Firing Pin Indent                                        | .020     | .020  | .020  | 12/3/91 | WLB  |          |    |
|                                  | J) Assemble Stock                                           |          |       |       | 12/4/91 | Rev  |          |    |
|                                  | K) Assemble Swivel Studs                                    |          |       |       | 12-7-91 | Ac   |          |    |
|                                  | L) Attach Front and Rear Sight Assemblies                   |          |       |       | 12/4/91 | Rev  |          |    |
|                                  | M) Iron Sight Alignment                                     |          |       |       | 12/4/91 | Rev  |          |    |
|                                  | N) Detach Front & Rear Sights & place in numbered container |          |       |       | 12/4/91 | Rev  |          |    |
|                                  | O) Attach Scope to Rifle                                    |          |       |       | 12/4/91 | Rev  |          |    |
|                                  | P) Detach & Attach Scope 20 Times                           |          |       |       | 12/4/91 | Rev  |          |    |
| 640                              | Gallery Target & Test                                       |          |       |       | 12-4-91 | DH   |          |    |
|                                  | A) Time                                                     |          |       |       | 12-4-91 | DH   |          |    |
|                                  | B) Malfunctions                                             |          |       |       | 12-4-91 | DH   |          |    |
|                                  | C) Pierced Primers                                          |          |       |       | 12-4-91 | DH   |          |    |
|                                  | D) Optical Clarity of Scope                                 |          |       |       | 12-4-91 | DH   |          |    |
| 645                              | Inspect for Live Ammo                                       |          |       |       | 12-4-91 | DH   |          |    |
| 655                              | Final Inspection                                            |          |       |       |         |      |          |    |
|                                  | A) Headspace                                                |          |       |       | 12-7-91 | Ac   |          |    |
|                                  | B) Trigger Pull                                             | 268      | 259   | 249   | 263     | 264  | 12-5-91  | DH |
|                                  | C) Function                                                 |          |       |       |         |      | 12-7-91  | Ac |
| 660                              | Pack                                                        |          |       |       |         |      | 12-19-91 | NF |

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6649033

DATE 12/3/91

TESTER WB

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.39             | 2.31                     | 2.43                           | 2.68 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.38             | 2.34                     | 2.44                           | 2.59 |                                                                        |
| PULL #3 | 2.33             | 2.36                     | 2.48                           | 2.49 |                                                                        |
| PULL #4 | 2.33             | 2.36                     | 2.50                           | 2.63 |                                                                        |
| PULL #5 | 2.31             | 2.37                     | 2.51                           | 2.64 |                                                                        |
| TOTAL   | 11.74            | 11.74                    | 12.36                          |      |                                                                        |
| AVG.    | 2.35             | 2.35                     | 2.47                           |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.30             | 3.28                     |  |          |
| PULL #2 | 3.27             | 3.27                     |  |          |
| PULL #3 | 3.29             | 3.26                     |  |          |
| PULL #4 | 3.27             | 3.25                     |  |          |
| PULL #5 | 3.18             | 3.27                     |  |          |
| TOTAL   | 16.31            | 16.33                    |  |          |
| AVG.    | 3.26             | 3.27                     |  |          |

|         | 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 | 4.21             | 4.24                     |                                | 4.27                                 |
| PULL #2 | 4.21             | 4.19                     |                                | 4.23                                 |
| PULL #3 | 4.20             | 4.17                     |                                | 4.23                                 |
| PULL #4 | 4.22             | 4.20                     |                                | 4.21                                 |
| PULL #5 | 4.18             | 4.21                     |                                | 4.19                                 |
| TOTAL   | 21.02            | 21.01                    |                                | 21.13                                |
| AVG.    | 4.20             | 4.20                     |                                | 4.22                                 |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6649033  
4 Dec 1991

CENTROIDAL DISTANCES

|        |         |
|--------|---------|
| 0 TO 1 | .268805 |
| 1 TO 2 | .610239 |
| 1 TO 3 | .454843 |
| 1 TO 4 | .493004 |
| 1 TO 5 | .281556 |

2  
+  
5

<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1254  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2176  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .251147  
  
THE AMR FOR THIS RIFLE IS: .9944

4 Dec 1991

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## CENTERFIRE PATTERNS

# 1

POA

1 in circle

2 in circle

3 in circle

CENTROID \*

# OF SHOTS = 10

# IN CIR

1 in = 1

2 in = 5

3 in = 8

HS = 2.411

VS = 3.349

GS = 4.083

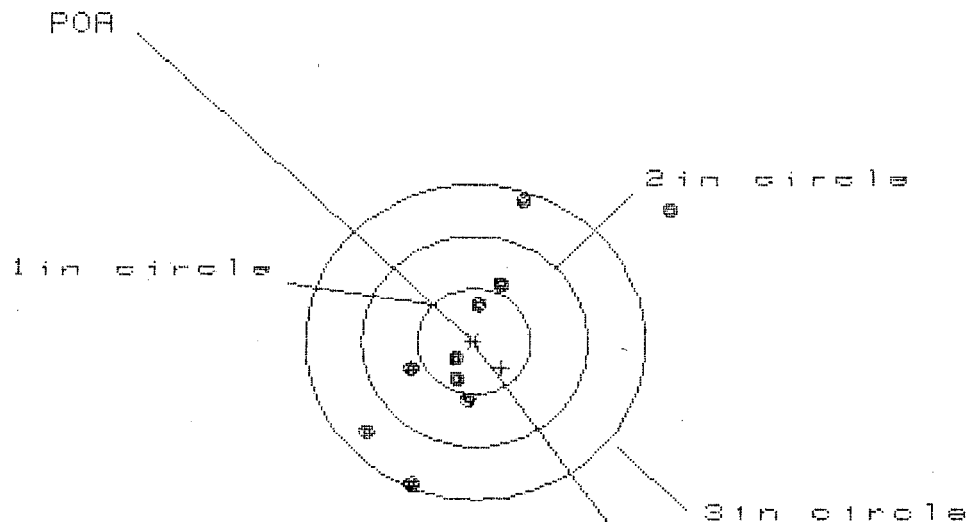
| PATTERN #                   | : | 1      | 9      | 8      |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.015  | 1.119  | .958   |
| MINIMUM X                   | : | -1.396 | -1.292 | -1.074 |
| MAXIMUM Y                   | : | 1.359  | 1.138  | 1.202  |
| MINIMUM Y                   | : | -1.990 | -0.890 | -0.747 |
| CENTROID X                  | : | .160   | .056   | .217   |
| CENTROID Y                  | : | -.216  | .005   | -.138  |
| POA TO CENTROID in.         | : | .269   | .056   | .257   |
| MIN RADIUS                  | : | .275   | .517   | .320   |
| MEAN RADIUS                 | : | 1.098  | .986   | .855   |
| MAX RADIUS                  | : | 2.200  | 1.722  | 1.202  |
| HORIZONTAL SPREAD           | : | 2.411  | 2.411  | 2.032  |
| VERTICAL SPREAD             | : | 3.349  | 2.028  | 1.949  |
| EXTREME SPREAD              | : | 4.083  | 2.878  | 2.167  |
| NUMBER IN ONE INCH CIRCLE   | = | 1      |        |        |
| NUMBER IN TWO INCH CIRCLE   | = | 5      |        |        |
| NUMBER IN THREE INCH CIRCLE | = | 8      |        |        |



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## CENTERFIRE PATTERNS # 2



# OF SHOTS= 10

# IN CIR

1 in = 3

2 in = 6

3 in = 9

HS= 2.666

VS= 2.698

GS= 3.501

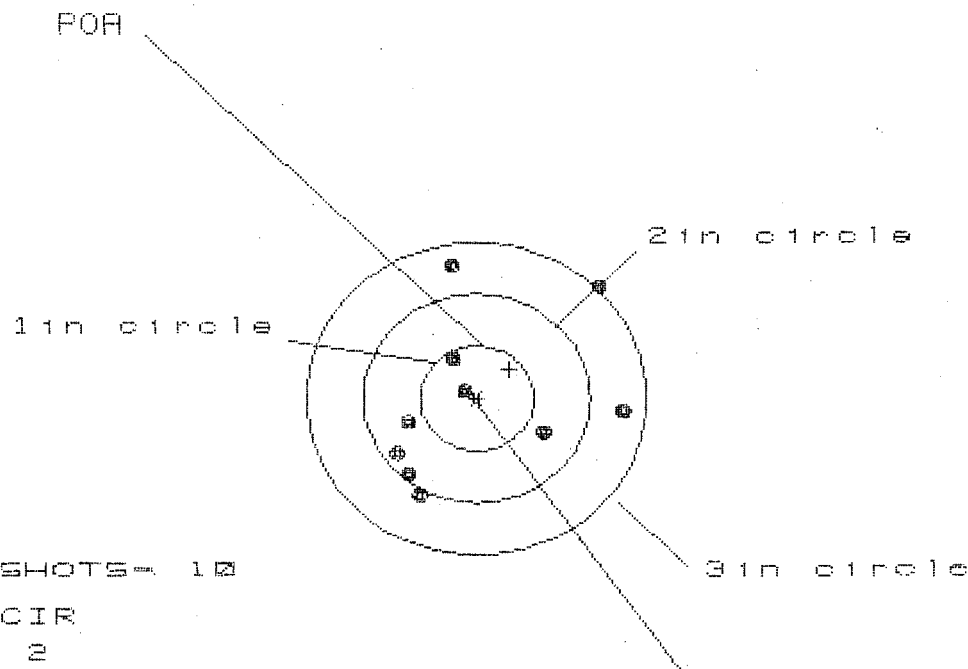
CENTROID #

| PATTERN #                   | : | 2      |        |       |
|-----------------------------|---|--------|--------|-------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | 1.730  | .663   | .614  |
| MINIMUM X                   | : | -.936  | -.743  | -.792 |
| MAXIMUM Y                   | : | 1.341  | 1.482  | 1.330 |
| MINIMUM Y                   | : | -1.357 | -1.216 | -.842 |
| CENTROID X                  | : | -.234  | -.427  | -.378 |
| CENTROID Y                  | : | .250   | .109   | .261  |
| POR TO CENTROID in.         | : | .343   | .440   | .459  |
| MIN RADIUS                  | : | .175   | .069   | .134  |
| MEAN RADIUS                 | : | .885   | .689   | .633  |
| MAX RADIUS                  | : | 2.149  | 1.624  | 1.465 |
| HORIZONTAL SPREAD           | : | 2.666  | 1.406  | 1.406 |
| VERTICAL SPREAD             | : | 2.698  | 2.698  | 2.172 |
| EXTREME SPREAD              | : | 3.501  | 2.895  | 2.587 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 3      |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 6      |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |       |

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## CENTERFIRE PATTERNS # 3



# OF SHOTS- 10

# IN CIR

1 in = 2

2 in = 6

3 in = 9

HS= 1.995

VS= 2.226

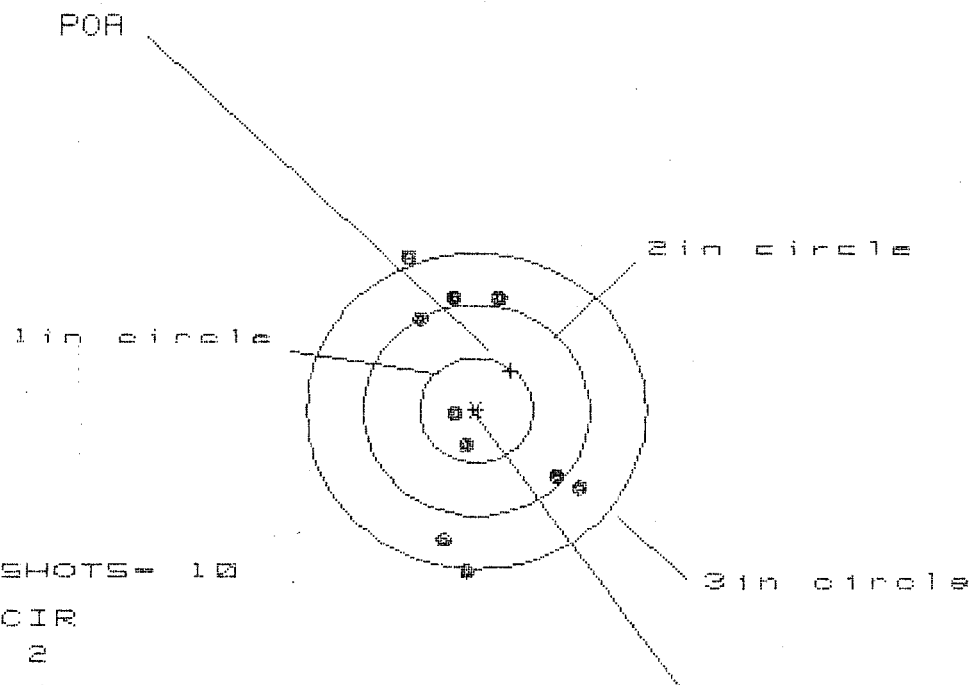
GS= 2.555

| PATTERN #                   | 3     |
|-----------------------------|-------|
| SHOTS (BEST OF)             | 10    |
| MAXIMUM X                   | 1.270 |
| MINIMUM X                   | -.725 |
| MAXIMUM Y                   | 1.291 |
| MINIMUM Y                   | -.935 |
| CENTROID X                  | -.291 |
| CENTROID Y                  | -.275 |
| POA TO CENTROID in.         | .400  |
| MIN RADIUS                  | .124  |
| MEAN RADIUS                 | .891  |
| MAX RADIUS                  | 1.536 |
| HORIZONTAL SPREAD           | 1.995 |
| VERTICAL SPREAD             | 2.226 |
| EXTREME SPREAD              | 2.555 |
| NUMBER IN ONE INCH CIRCLE   | 2     |
| NUMBER IN TWO INCH CIRCLE   | 6     |
| NUMBER IN THREE INCH CIRCLE | 9     |

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## CENTERFIRE PATTERNS # 4



# OF SHOTS = 10

# IN CIR

1 in = 2

2 in = 4

3 in = 9

HS = 1.492

VS = 2.938

GS = 2.995

CENTROID #

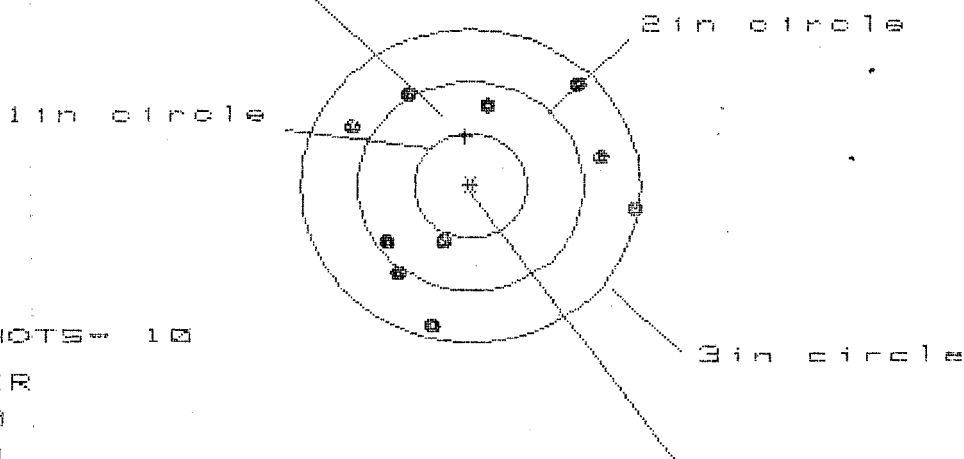
| PATTERN #                   | : | 4      |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | .866   | .796   | .782   |
| MINIMUM X                   | : | -.626  | -.544  | -.558  |
| MAXIMUM Y                   | : | 1.456  | 1.262  | 1.097  |
| MINIMUM Y                   | : | -1.482 | -1.320 | -1.264 |
| CENTROID X                  | : | -.307  | -.237  | -.223  |
| CENTROID Y                  | : | -.374  | -.536  | -.371  |
| POA TO CENTROID in.         | : | .484   | .586   | .432   |
| MIN RADIUS                  | : | .170   | .205   | .254   |
| MEAN RADIUS                 | : | 1.009  | .930   | .884   |
| MAX RADIUS                  | : | 1.585  | 1.325  | 1.322  |
| HORIZONTAL SPREAD           | : | 1.492  | 1.340  | 1.340  |
| VERTICAL SPREAD             | : | 2.938  | 2.582  | 2.361  |
| EXTREME SPREAD              | : | 2.995  | 2.584  | 2.368  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 4      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |        |

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## CENTERFIRE PATTERNS # 5

POA



# OF SHOTS= 10

# IN CIR

1in = 0

2in = 3

3in = 10

HS= 2.456

VS= 2.272

GS= 2.616

CENTROID #

| PATTERN #                     | 5      |
|-------------------------------|--------|
| SHOTS (BEST OF)               | 10     |
| MAXIMUM X                     | 1.431  |
| MINIMUM X                     | -1.025 |
| MAXIMUM Y                     | .973   |
| MINIMUM Y                     | -1.299 |
| CENTROID X                    | .045   |
| CENTROID Y                    | -.473  |
| POA TO CENTROID in.           | .475   |
| MIN RADIUS                    | .635   |
| MEAN RADIUS                   | 1.089  |
| MAX RADIUS                    | 1.449  |
| HORIZONTAL SPREAD             | 2.456  |
| VERTICAL SPREAD               | 2.272  |
| EXTREME SPREAD                | 2.616  |
| NUMBER IN ONE INCH CIRCLE =   | 0      |
| NUMBER IN TWO INCH CIRCLE =   | 3      |
| NUMBER IN THREE INCH CIRCLE = | 10     |