

C6611804

MODEL 700TM M24

Model S&S TM

Action

Barrel Length

Capacity

Order No. 5716

* Includes 1 in chamber.

Remington



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

MODEL 700TM M24

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

SERIAL NO.
C6611804

ORDER NO.
5716

46



GUN SERIAL # C6611804

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 28	9 1	RW
600	Proof	3 28	9 1	RW
607	Check Headspace	3 28	9 1	RW
610	Dis-assemble Gun	3 28	9 1	RW
612	Magnaflux Barrel Action	APR	2 1991	K.B.
	Magnaflux Bolt	APR	2 1991	11
615	Rollmark Caliber	APR	2 1991	11
617	Drill and Tap Sight Holes	APR	5 1991	LB
618	Polish Barrel	APR	5 1991	WB
620	Apply Coatings (Barrel Action)		4-9-91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/10/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/10/91	RW
	C) Inspect Ejector Hole for Chamfer		4/10/91	RW
	D) Oil Firing Pin Ass'y		4/10/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4/12/91	RM

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	5			4-15-91	DH
	G) Safety Off Force	3	3 $\frac{3}{4}$	3			4-15-91	DH
	H) Trigger Pull Test & Retainability						4/12/91	JL
	I) Firing Pin Indent	.021	.022	.020			4-15-91	DH
	J) Assemble Stock						4/16/91	RW
	K) Assemble Swivel Studs						4-17-91	A
	L) Attach Front and Rear Sight Assemblies						4/16/91	RW
	M) Iron Sight Alignment						4/16/91	RW
	N) Detach Front & Rear Sights & place in numbered container						4/16/91	RW
	O) Attach Scope to Rifle						4/16/91	RW
	P) Detach & Attach Scope 20 Times						4/16/91	RW
640	Gallery Target & Test						4-16-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						4-16-91	NF
655	Final Inspection							
	A) Headspace						4-17-91	A
	B) Trigger Pull	2.42	2.50	2.34	2.56	2.28	4/17/91	JL
	C) Function						4-17-91	AC
660	Pack						6-17-91	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6611804

DATE 4/12/91

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.57	2.36	2.34	2.42	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.19	2.36	2.38	2.50	
PULL #3	2.39	2.35	2.44	2.34	
PULL #4	2.33	2.23	2.41	2.56	
PULL #5	2.33	2.38	2.37	2.28	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.41	3.45		
PULL #2	3.43	3.39		
PULL #3	3.36	3.45		
PULL #4	3.55	3.43		
PULL #5	3.52	3.43		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.44	4.33		4.23
PULL #2	4.43	4.37		4.45
PULL #3	4.18	4.22		4.45
PULL #4	4.37	4.23		4.42
PULL #5	4.40	4.25		4.26
TOTAL				
AVG.				

MOD. _____		GA. CAL. _____	GUN # <u>1804</u>
# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st		
<i>NF</i>	<i>4/16</i>	<i>Safe Binds</i>	<i>RW</i>
	2nd		
	<i>4/17/91</i>	<i>file Stock Bench Check OK</i>	<i>RW</i>
	3rd		
	4th		

FUNCTION _____

RD 6654 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611884
16 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.39462
1 TO	2	.334432
1 TO	3	.279728
1 TO	4	.182387
1 TO	5	.0451221

50
4

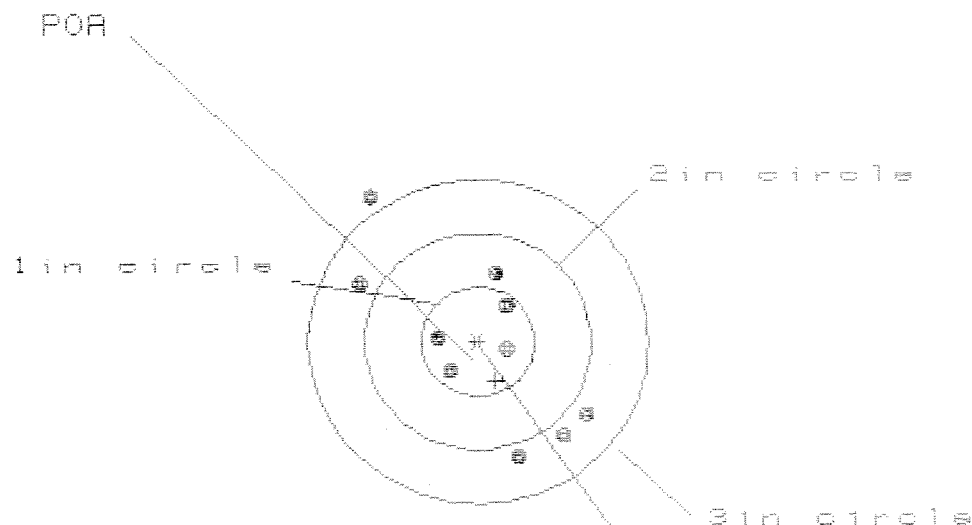
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0712
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .243
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .1253216
THE AMR FOR THIS RIFLE IS: .7254

16 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611884

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 4

2in = 5

3in = 9

HS = 1.981

VS = 2.349

GS = 2.676

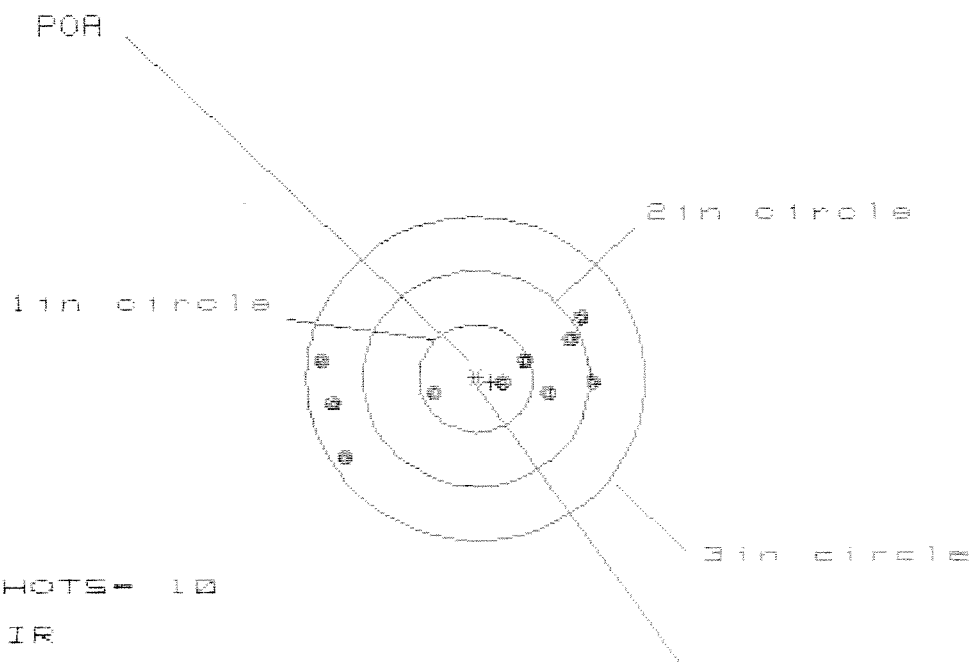
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.919	.818	.672
MINIMUM X	-1.062	-1.163	-.627
MAXIMUM Y	1.293	.771	.860
MINIMUM Y	-1.056	-.912	-.823
CENTROID X	-.150	-.049	.097
CENTROID Y	.365	.221	.132
POA TO CENTROID in.	.394	.226	.164
MIN RADIUS	.240	.174	.198
MEAN RADIUS	.808	.713	.637
MAX RADIUS	1.585	1.365	.865
HORIZONTAL SPREAD	1.981	1.981	1.299
VERTICAL SPREAD	2.349	1.683	1.683
EXTREME SPREAD	2.676	2.315	1.691
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

16 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611884

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 2.365

VS= 1.245

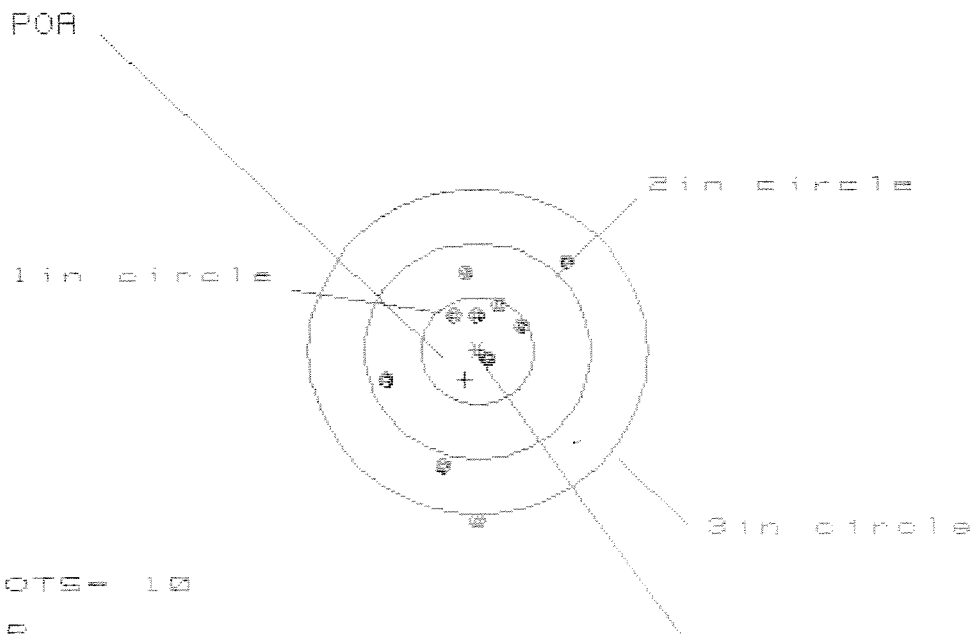
GS= 2.481

PATTERN #	2	2	2
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.043	.909	.728
MINIMUM X	-1.322	-1.456	-1.548
MAXIMUM Y	.546	.469	.477
MINIMUM Y	-.699	-.338	-.330
CENTROID X	-.133	.001	.182
CENTROID Y	.031	.108	.100
POA TO CENTROID in.	.136	.108	.208
MIN RADIUS	.214	.102	.116
MEAN RADIUS	.872	.774	.634
MAX RADIUS	1.388	1.457	1.583
HORIZONTAL SPREAD	2.365	2.365	2.276
VERTICAL SPREAD	1.245	.807	.807
EXTREME SPREAD	2.481	2.371	2.325
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

16 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611884

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 5

2 in = 7

3 in = 9

HS= 1.563

VS= 2.359

GS= 2.476

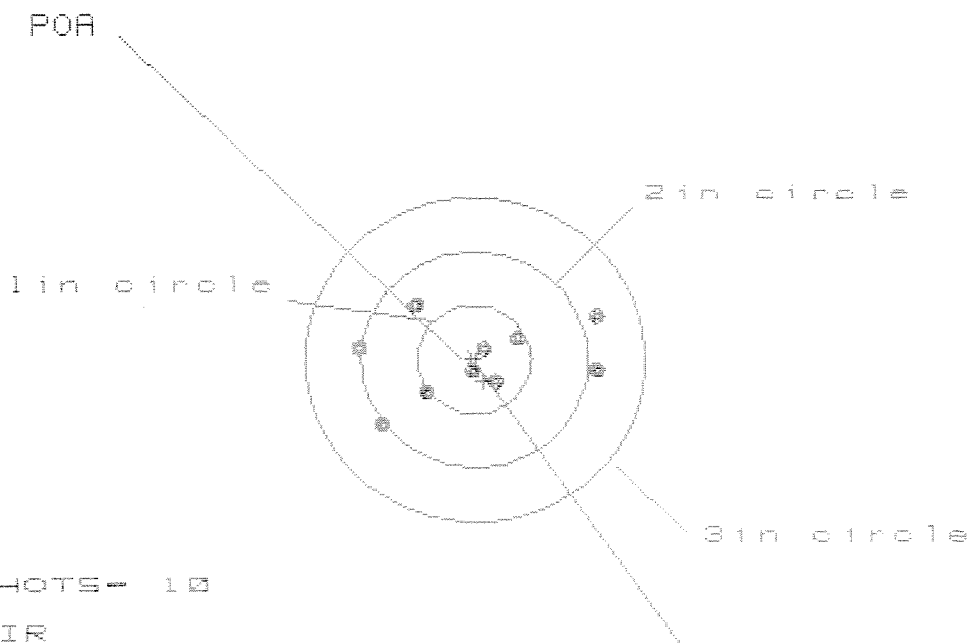
CENTROID *

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.769	.771	.446
MINIMUM X	-.794	-.792	-.696
MAXIMUM Y	.842	.673	.697
MINIMUM Y	-1.518	-1.227	-1.143
CENTROID X	.112	.110	.014
CENTROID Y	.267	.436	.352
POA TO CENTROID in.	.290	.450	.352
MIN RADIUS	.171	.149	.245
MEAN RADIUS	.721	.586	.553
MAX RADIUS	1.518	1.259	1.158
HORIZONTAL SPREAD	1.563	1.563	1.142
VERTICAL SPREAD	2.359	1.900	1.840
EXTREME SPREAD	2.476	2.172	1.847
NUMBER IN ONE INCH CIRCLE =		5	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

16 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611804

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 4

2in = 7

3in = 10

HS = 2.075

VS = 1.029

GS = 2.082

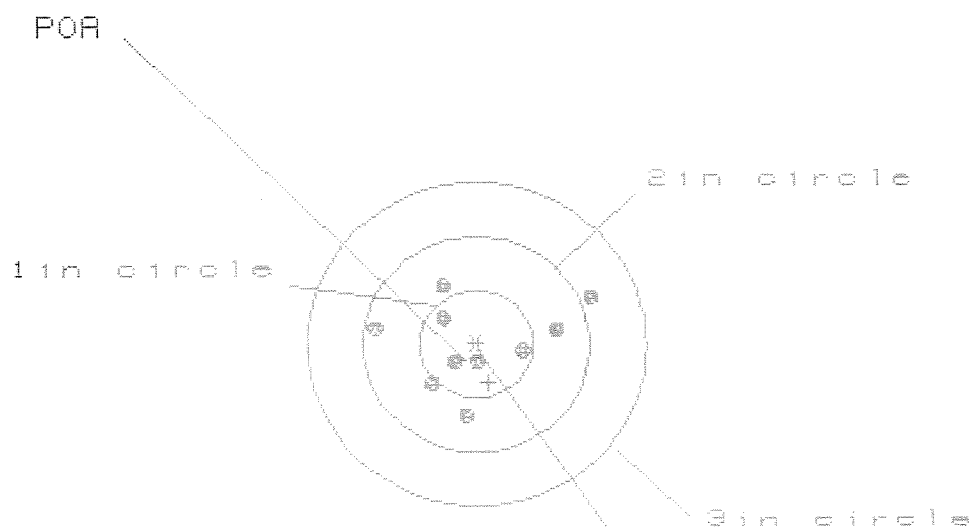
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.066	1.180	.659
MINIMUM X	:	-1.009	-.895	-.747
MAXIMUM Y	:	.463	.504	.500
MINIMUM Y	:	-.566	-.525	-.529
CENTROID X	:	-.079	-.193	-.341
CENTROID Y	:	.197	.156	.160
POA TO CENTROID in.	:	.213	.248	.376
MIN RADIUS	:	.144	.170	.303
MEAN RADIUS	:	.644	.598	.536
MAX RADIUS	:	1.097	1.181	.760
HORIZONTAL SPREAD	:	2.075	2.075	1.406
VERTICAL SPREAD	:	1.029	1.029	1.029
EXTREME SPREAD	:	2.082	2.082	1.430
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

16 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611864

CENTERFIRE PATTERNS : # 5



OF SHOTS- 10

IN CIR

1in = 4

2in = 9

3in = 10

HS= 1.916

VS= 1.177

GS= 1.938

PATTERN #

5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.040	.807	.712
MINIMUM X	-.876	-.761	-.324
MAXIMUM Y	.499	.551	.581
MINIMUM Y	-.678	-.626	-.596
CENTROID X	-.106	-.221	-.126
CENTROID Y	.355	.303	.273
POA TO CENTROID in.	.370	.375	.301
MIN RADIUS	.198	.147	.114
MEAN RADIUS	.582	.495	.454
MAX RADIUS	1.142	.831	.747
HORIZONTAL SPREAD	1.916	1.568	1.036
VERTICAL SPREAD	1.177	1.177	1.177
EXTREME SPREAD	1.938	1.568	1.184
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	

R 94-18758

FROM:	SHIP TO:
COMMANDER (W52H094138H226) DEFENSE DIST DEPOT ANNISTON ATTN DDAA-UR BLDG 112 ANNISTON AL 36201-5025	COMMANDER (W52H094138H226) DEFENSE DIST DEPOT ANNISTON ATTN DDAA-UR BLDG 112 ANNISTON AL 36201-5025

CUSTOMER CONCERN	AMMO	FUNCTION	FINISH	ACCURACY	FIT	INSPECT
CYCLE	A1	B1				
TRIGGER GROUP		B2			E1	F1
BOLT ASSY.		B3			E2	F2
BARREL ASSY.		B4		D1	E3	F3
REC. ASSY.		B5		D2	E4	F4
WOOD			C1	D3	E5	F5
METAL			C2			

MAIN FAULT

[illegible]

OFFICE COPY

RD6925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

BARBER - M24 M2400036334

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6611804DATE 2-12-96TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.71	2.61	2.75		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.69	2.76	2.88		
PULL #3	2.66	2.79	2.87		
PULL #4	2.76	2.68	2.89		
PULL #5	2.75	2.58	2.83		
TOTAL	13.57	13.42	14.22		
AVG.	2.71	2.68	2.84		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.15	3.28		
PULL #2	3.25	3.30		
PULL #3	3.14	3.33		
PULL #4	3.23	3.21		
PULL #5	3.29	3.25		
TOTAL	16.06	16.37		
AVG.	3.21	3.27		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.35	4.07		4.13
PULL #2	4.05	4.01		4.19
PULL #3	4.27	4.24		4.15
PULL #4	4.27	4.12		4.15
PULL #5	4.21	4.29		4.28
TOTAL	21.15	20.73		20.90
AVG.	4.23	4.14		4.18

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611804

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock			
600	Proof			
607	Check Headspace			
610	Dis-assemble Gun			
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (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 Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			3/7	A
	G) Safety Off Force	2 $\frac{1}{2}$	2 $\frac{1}{2}$	2 $\frac{1}{2}$			3/7	A
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent							
	J) Assemble Stock							
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies							
	M) Iron Sight Alignment							
	N) Detach Front & Rear Sights & place in numbered container							
	O) Attach Scope to Rifle							
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test							
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection A) Headspace							
	B) Trigger Pull	2.54	2.49	2.51	2.60	2.61	3/7/96	WB
	C) Function							
660	Pack							