

Call
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C6636070

MODEL 700™ M24

Model **515**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

6070

MOD. _____ GA. CAL. _____ GUN # ~~440~~

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
KT	1st	R.C.	AW
	5/31	Bolt won't open after fired.	
	2nd	Now ABT Reprocessed	
	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		

Remington®
 REG. U.S. PAT. & TM. OFF.

DUPONT
 REG. U.S. PAT. & TM. OFF.

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

MODEL 700™ M24

SERIAL NO.
 C6636070

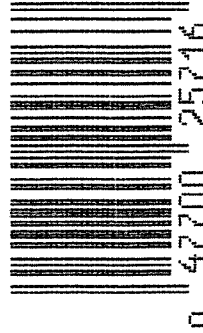
ORDER NO.
5716

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

20



LPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636070

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 8 9 1		RW
600	Proof	4 8 9 1		RW
607	Check Headspace	4 8 9 1		RW
610	Dis-assemble Gun	4 8 9 1		RW
612	Magnaflux Barrel Action	APR 9 1991		KR
	Magnaflux Bolt	APR 9 1991		11
615	Rollmark Caliber	APR 9 1991		GL
617	Drill and Tap Sight Holes	APR 9 1991		LB
618	Polish Barrel	APR 9 1991		WB
620	Apply Coatings (Barrel Action)		5-10-91	DA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/14/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/14/91	RW
	C) Inspect Ejector Hole for Chamfer		5/14/91	RW
	D) Oil Firing Pin Ass'y		5/14/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/29/91	JL

op. #	OP. NAME	READINGS			DATE	INIT
625 cont.	F) Safety On Force	7	7	7	5/30/91	JL
	G) Safety Off Force	4	4	4	5/30/91	JL
	H) Trigger Pull Test & Retainability				5/29/91	JL
	I) Firing Pin Indent	.020	.0205	.0205	5/30/91	JL
	J) Assemble Stock				5/30/91	RW
	K) Assemble Swivel Studs					
	L) Attach Front and Rear Sight Assemblies				5/30/91	RW
	M) Iron Sight Alignment				5/30/91	RW
	N) Detach Front & Rear Sights & place in numbered container				5/30/91	RW
	O) Attach Scope to Rifle				5/30/91	RW
	P) Detach & Attach Scope 20 Times				5/30/91	RW
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					
	C) Function					
660	Pack					

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636070

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		8/2/91	KH
600	Proof		8/2/91	KH
607	Check Headspace		8/2/91	KH
610	Dis-assemble Gun		8/2/91	KH
612	Magnaflux Barrel Action		AUG 7 1991	KR
	Magnaflux Bolt		AUG 7 1991	KR
615	Rollmark Caliber		AUG 7 1991	SS
617	Drill and Tap Sight Holes		AUG 7 1991	LB
618	Polish Barrel		AUG 13 1991	WB
620	Apply Coatings (Barrel Action)		8-27-91	AD
	Apply Coating (Bolt)		8-27-91	AD
625	Final Assembly A) Clean inside of Bolt Assembly		8/29/91	KH
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/29/91	KH
	C) Inspect Ejector Hole for Chamfer		8/29/91	KH
	D) Oil Firing Pin Ass'y		8/29/91	KH
	E) Adjust Trigger Pull to Min Setting and Stake		8/30/91	ML

D"

BARBER - M24 0037348

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			8/30/91	JK
	G) Safety Off Force	2	2	2			8/30/91	JK
	H) Trigger Pull Test & Retainability						8/30/91	JK
	I) Firing Pin Indent	.021	.021	.021			8/30/91	JK
	J) Assemble Stock						8/30/91	JK
	K) Assemble Swivel Studs						9-10-91	D/H
	L) Attach Front and Rear Sight Assemblies						8/30/91	JK
	M) Iron Sight Alignment						8/30/91	JK
	N) Detach Front & Rear Sights & place in numbered container						8/30/91	JK
	O) Attach Scope to Rifle						8/30/91	JK
	P) Detach & Attach Scope 20 Times						8/30/91	JK
640	Gallery Target & Test						9-5-91	N
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						9-5-91	NF
655	Final Inspection							
	A) Headspace						9-10-91	D/H
	B) Trigger Pull	2.22	2.20	2.28	2.25	2.34	9-6-91	JK
	C) Function						9-10-91	D/H
660	Pack						9-18-91	N

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6636070

DATE 8/30/91

TESTER JLL.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.19	2.33	2.35	2.22	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.29	2.30	2.38	2.20	
PULL #3	2.33	2.31	2.30	2.28	
PULL #4	2.17	2.34	2.36	2.25	
PULL #5	2.37	2.27	2.29	2.34	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.47	3.47		
PULL #2	3.20	3.45		
PULL #3	3.43	3.45		
PULL #4	3.46	3.51		
PULL #5	3.47	3.49		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.20	4.35		4.19
PULL #2	4.30	4.31		4.23
PULL #3	4.20	4.30		4.27
PULL #4	4.29	4.36		4.36
PULL #5	4.27	4.36		4.36
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636070
5 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.312605
1 TO	2	.436981
1 TO	3	.327686
1 TO	4	.609548
1 TO	5	.49148

$\frac{S_1}{a_1} z$ <----POA

COORDINATE FOR THIS RIFLE IS: .0544
COORDINATE FOR THIS RIFLE IS: -.0596
AVERAGE POI RADIUS FOR THIS RIFLE IS: .080694

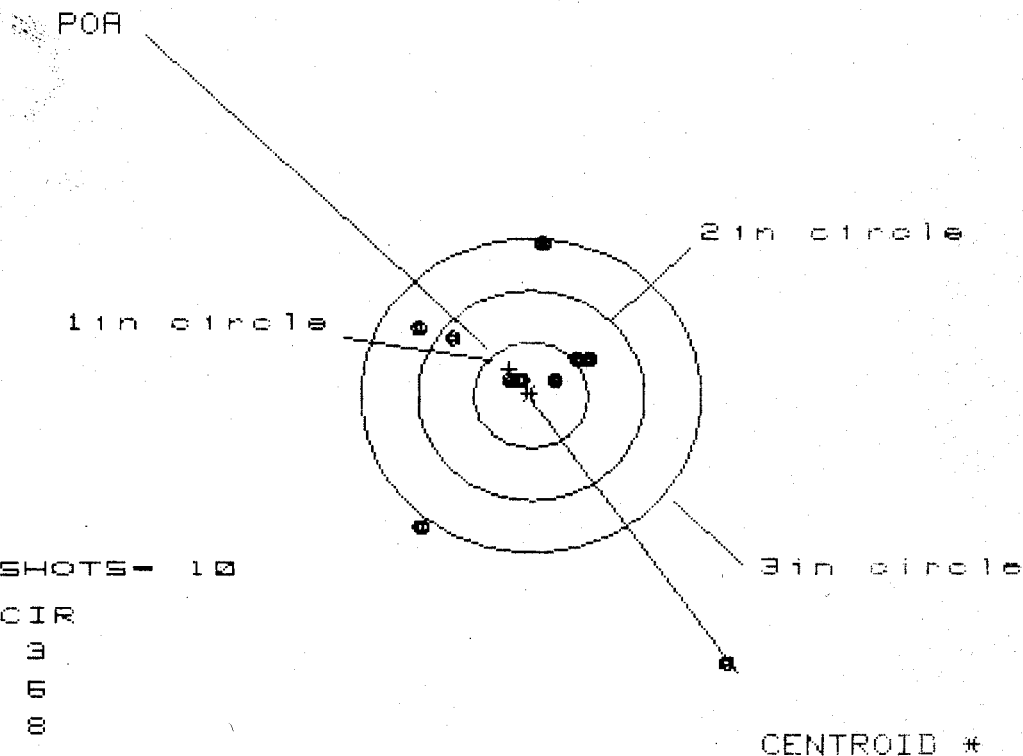
.9124

5 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/ C6636070

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 8

HS= 2.710

VS= 4.017

GS= 4.330

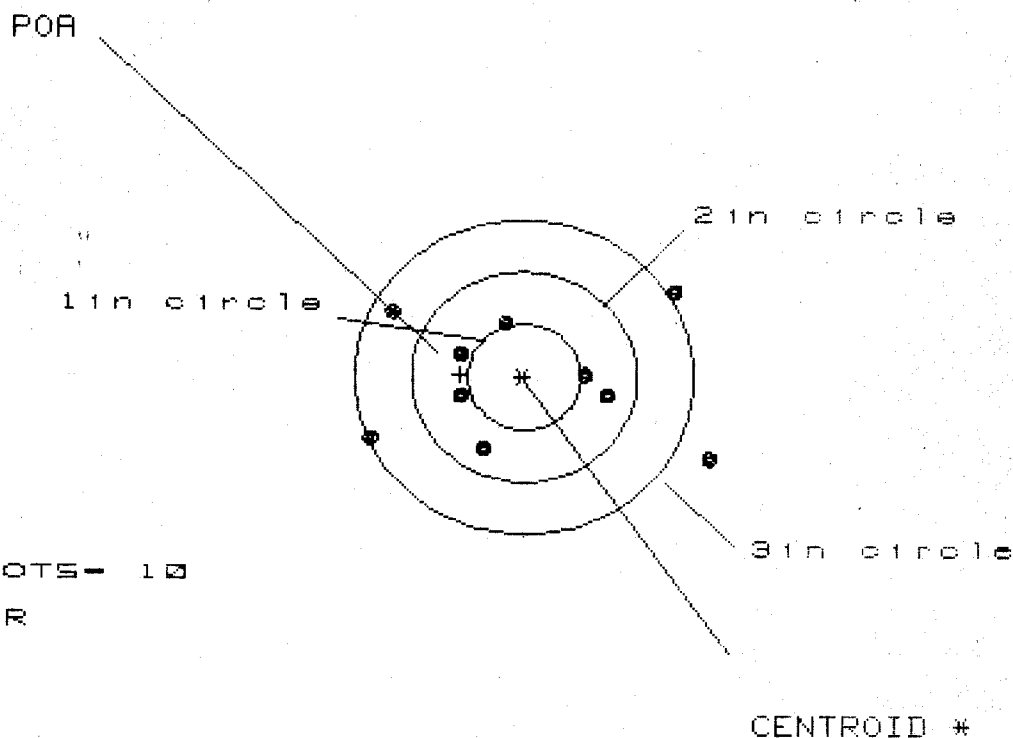
CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.695	.655	.552
MINIMUM X	:	-1.015	-.827	-.861
MAXIMUM Y	:	1.447	1.162	.971
MINIMUM Y	:	-2.570	-1.530	-.302
CENTROID X	:	.189	.001	.104
CENTROID Y	:	-.249	.036	.227
RAD TO CENTROID IN.	:	.313	.036	.250
MIN RADIAL	:	.211	.105	.294
MAX RADIAL	:	.994	.691	.570
TRD RADIAL	:	3.078	1.739	.984
HORIZONTAL SPREAD	:	2.710	1.482	1.413
VERTICAL SPREAD	:	4.017	2.692	1.273
EXTREME SPREAD	:	4.330	2.905	1.446
NUMBER IN ONE INCH CIRCLE =	:	3		
NUMBER IN TWO INCH CIRCLE =	:	6		
NUMBER IN THREE INCH CIRCLE =	:	8		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in - 0

2in - 6

3in - 7

HS- 3.040

VS- 1.589

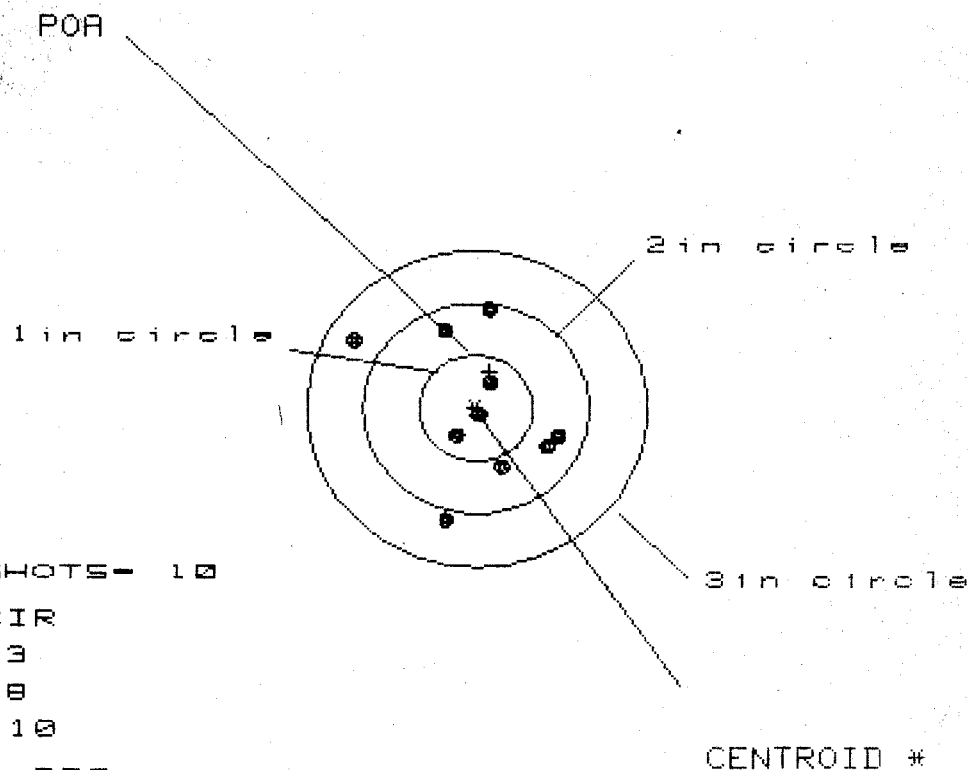
GS- 3.144

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.661	1.514	1.109
MINIMUM X	-1.379	-1.194	-1.005
MAXIMUM Y	.837	.753	.621
MINIMUM Y	-.752	-.747	-.653
CENTROID X	.563	.378	.189
CENTROID Y	-.023	.061	-.034
POA TO CENTROID in.	.563	.383	.192
MIN RADIUS	.502	.437	.250
MEAN RADIUS	1.002	.881	.750
MAX RADIUS	1.824	1.691	1.161
HORIZONTAL SPREAD	3.040	2.708	2.114
VERTICAL SPREAD	1.589	1.500	1.274
EXTREME SPREAD	3.144	3.062	2.162
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	7		

5 Sep 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in - 3

2 in - 8

3 in = 10

HS= 1.829

VS= 1.989

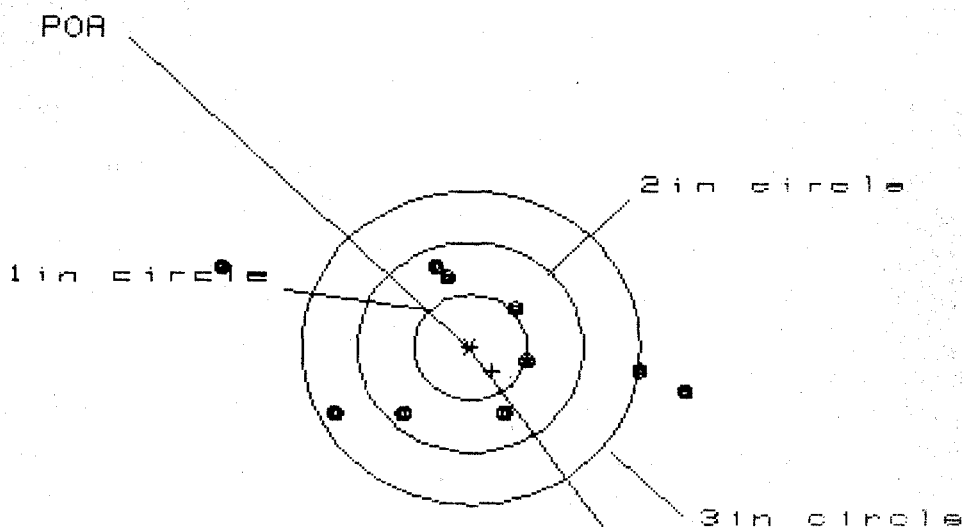
GS= 2.031

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.718	.595	.550
MINIMUM X	:	-1.111	-.430	-.475
MAXIMUM Y	:	.957	1.023	.903
MINIMUM Y	:	-1.032	-.966	-.642
CENTROID X	:	-.124	-.001	.044
CENTROID Y	:	-.346	-.412	-.292
POA TO CENTROID in.	:	.368	.412	.295
MIN RADIUS	:	.064	.108	.171
MEAN RADIUS	:	.666	.588	.539
MAX RADIUS	:	1.261	1.031	.903
HORIZONTAL SPREAD	:	1.829	1.025	1.025
VERTICAL SPREAD	:	1.989	1.989	1.545
EXTREME SPREAD	:	2.031	2.031	1.545
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	8		
NUMBER IN THREE INCH CIRCLE	=	10		

5 Sep 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 6

3 in = 7

HS= 4.107

VS= 1.447

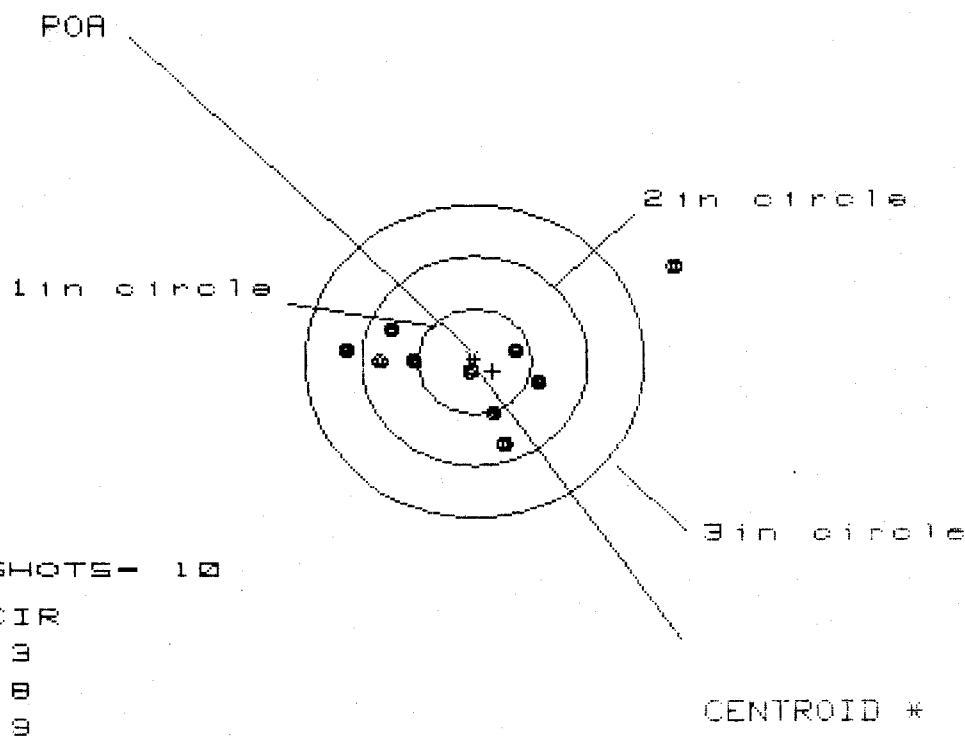
GS= 4.304

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.867	1.619	1.486
MINIMUM X	:	-2.240	-1.501	-1.299
MAXIMUM Y	:	.814	.829	.781
MINIMUM Y	:	-.633	-.543	-.591
CENTROID X	:	-.193	.055	-.147
CENTROID Y	:	.226	.136	.183
POA TO CENTROID in.	:	.298	.147	.235
MIN RADIUS	:	.472	.212	.419
MEAN RADIUS	:	1.134	.963	.876
MAX RADIUS	:	2.383	1.663	1.495
HORIZONTAL SPREAD	:	4.107	3.120	2.785
VERTICAL SPREAD	:	1.447	1.372	1.372
EXTREME SPREAD	:	4.304	3.124	2.818
NUMBER IN ONE INCH CIRCLE	:	=	1	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in - 3

2in - 8

3in = 9

HS- 2.946

VS= 1.662

GS= 3.050

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.784	.720	.600
MINIMUM X	:	-1.162	-.964	-.760
MAXIMUM Y	:	.856	.431	.451
MINIMUM Y	:	-.805	-.710	-.690
CENTROID X	:	-.163	-.361	-.241
CENTROID Y	:	.094	-.001	-.021
POA TO CENTROID in.	:	.188	.361	.242
MIN RADIUS	:	.078	.206	.093
MEAN RADIUS	:	.766	.621	.556
MAX RADIUS	:	1.979	.977	.782
HORIZONTAL SPREAD	:	2.946	1.684	1.360

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VERTICAL SPREAD :	1.662	1.141	1.141
EXTREME SPREAD :	3.050	1.698	1.510
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		9	