

FORM

UPC



0 47700 25716 7

C6665687

\*INCLUDES 1 IN CHAMBER

MODEL 700 TM M24

5716

ORDER NO.

BARREL LENGTH

CAPACITY

|                                                                                      |  |                                             |                                                                                           |
|--------------------------------------------------------------------------------------|--|---------------------------------------------|-------------------------------------------------------------------------------------------|
| <b>Remington</b>                                                                     |  | <b>DU PONT</b><br>REG. U.S. PAT. & TM. OFF. | VERY IMPORTANT:<br>Instruction Book<br>enclosed to assure<br>safe use of this<br>firearm. |
| <b>MODEL 700™ M24</b>                                                                |  | <b>SERIAL NO.</b><br>C6665687               |                                                                                           |
|                                                                                      |  | <b>ORDER NO.</b><br><b>5716</b>             |                                                                                           |
| MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee. |  |                                             |                                                                                           |



5716 C6665687

**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 #

C6665687

| OP. #     | OP. NAME                                                 | READINGS                                                                                                            | DATE       | INIT |
|-----------|----------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------|------------|------|
| 575 & 580 | Assemble Action and Stock                                | <div style="border: 1px solid black; padding: 5px; display: inline-block;"> <b>QUALITY</b><br/> <b>AUDIT</b> </div> | 10 1 91    | RW   |
| 600       | Proof                                                    |                                                                                                                     | 10 1 91    | RW   |
| 607       | Check Headspace                                          |                                                                                                                     | 10 1 91    | RW   |
| 610       | Dis-assemble Gun                                         |                                                                                                                     | 10 1 91    | RW   |
| 612       | Magnaflux Barrel Action                                  |                                                                                                                     | OCT 4 1991 | KR   |
|           | Magnaflux Bolt                                           |                                                                                                                     | OCT 4 1991 | KR   |
| 615       | Rollmark Caliber                                         |                                                                                                                     | OCT 4 1991 | LL   |
| 617       | Drill and Tap Sight Holes                                |                                                                                                                     | OCT 4 1991 | LB   |
| 618       | Polish Barrel                                            |                                                                                                                     | 10/8/91    | WB   |
| 620       | Apply Coatings (Barrel Action)                           |                                                                                                                     | 10-22-91   | BA   |
|           | Apply Coating (Bolt)                                     |                                                                                                                     | 10-22-91   | BA   |
| 625       | Final Assembly                                           |                                                                                                                     |            |      |
|           | A) Clean inside of Bolt Assembly                         |                                                                                                                     | 10/22/91   | RW   |
|           | B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head |                                                                                                                     | 10/22/91   | RW   |
|           | C) Inspect Ejector Hole for Chamfer                      |                                                                                                                     | 10/22/91   | RW   |
|           | D) Oil Firing Pin Ass'y                                  |                                                                                                                     | 10/22/91   | RW   |
|           | E) Adjust Trigger Pull to Min Setting and Stake          |                                                                                                                     | 10/28/91   | JP   |

| op. #        | BARBER - M24 0101326                                        | READINGS |       |       |     |     | DATE     | INIT |
|--------------|-------------------------------------------------------------|----------|-------|-------|-----|-----|----------|------|
|              | OP. NAME                                                    |          |       |       |     |     |          |      |
| 625<br>cont. | F) Safety On Force                                          | 4 1/4    | 4 1/4 | 4 1/4 |     |     | 10/28/91 | WB   |
|              | G) Safety Off Force                                         | 2        | 2     | 2     |     |     | 10/28/91 | WB   |
|              | H) Trigger Pull Test & Retainability                        |          |       |       |     |     | 10/28/91 | JB   |
|              | I) Firing Pin Indent                                        | .0205    | .020  | .020  |     |     | 10/28/91 | WB   |
|              | J) Assemble Stock                                           |          |       |       |     |     | 10/29/91 | RW   |
|              | K) Assemble Swivel Studs                                    |          |       |       |     |     | 11-12-91 | AC   |
|              | L) Attach Front and Rear Sight Assemblies                   |          |       |       |     |     | 10/29/91 | RW   |
|              | M) Iron Sight Alignment                                     |          |       |       |     |     | 10/29/91 | RW   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |       |       |     |     | 10/29/91 | RW   |
|              | O) Attach Scope to Rifle                                    |          |       |       |     |     | 10/29/91 | RW   |
|              | P) Detach & Attach Scope 20 Times                           |          |       |       |     |     | 10/29/91 | RW   |
| 640          | Gallery Target & Test                                       |          |       |       |     |     | 10/29/91 | KT   |
|              | A) Time                                                     |          |       |       |     |     |          | KT   |
|              | B) Malfunctions                                             |          |       |       |     |     |          | KT   |
|              | C) Pierced Primers                                          |          |       |       |     |     |          | KT   |
|              | D) Optical Clarity of Scope                                 |          |       |       |     |     |          | KT   |
| 645          | Inspect for Live Ammo                                       |          |       |       |     |     | 10/29/91 | KT   |
| 655          | Final Inspection                                            |          |       |       |     |     |          |      |
|              | A) Headspace                                                |          |       |       |     |     | 11-12-91 | AC   |
|              | B) Trigger Pull                                             | 239      | 240   | 240   | 235 | 240 | 10-30-91 | D/H  |
|              | C) Function                                                 |          |       |       |     |     | 11-12-91 | AC   |
| 660          | Pack                                                        |          |       |       |     |     | 12-17-91 | N    |

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO 66665687

DATE 10/28/91

TESTER JY

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.33             | 2.28                     | 2.19                           | 2.39 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.35             | 2.27                     | 2.22                           | 2.40 |                                                                        |
| PULL #3 | 2.28             | 2.28                     | 2.20                           | 2.40 |                                                                        |
| PULL #4 | 2.32             | 2.30                     | 2.29                           | 2.35 |                                                                        |
| PULL #5 | 2.31             | 2.23                     | 2.38                           | 2.40 |                                                                        |
| TOTAL   |                  |                          |                                |      |                                                                        |
| AVG.    |                  |                          |                                |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.35             | 3.56                     |  |          |
| PULL #2 | 3.32             | 3.40                     |  |          |
| PULL #3 | 3.26             | 3.46                     |  |          |
| PULL #4 | 3.28             | 3.60                     |  |          |
| 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 | 4.47             | 4.21                     |                                | 4.41                                 |
| PULL #2 | 4.33             | 4.58                     |                                | 4.34                                 |
| PULL #3 | 4.37             | 4.43                     |                                | 4.43                                 |
| PULL #4 | 4.15             | 4.41                     |                                | 4.33                                 |
| PULL #5 | 4.26             | 4.50                     |                                | 4.42                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # 06665687  
29 Oct 1991

CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| 0 TO | 1 | .179324 |
| 1 TO | 2 | .229819 |
| 1 TO | 3 | .155641 |
| 1 TO | 4 | .251748 |
| 1 TO | 5 | .729449 |

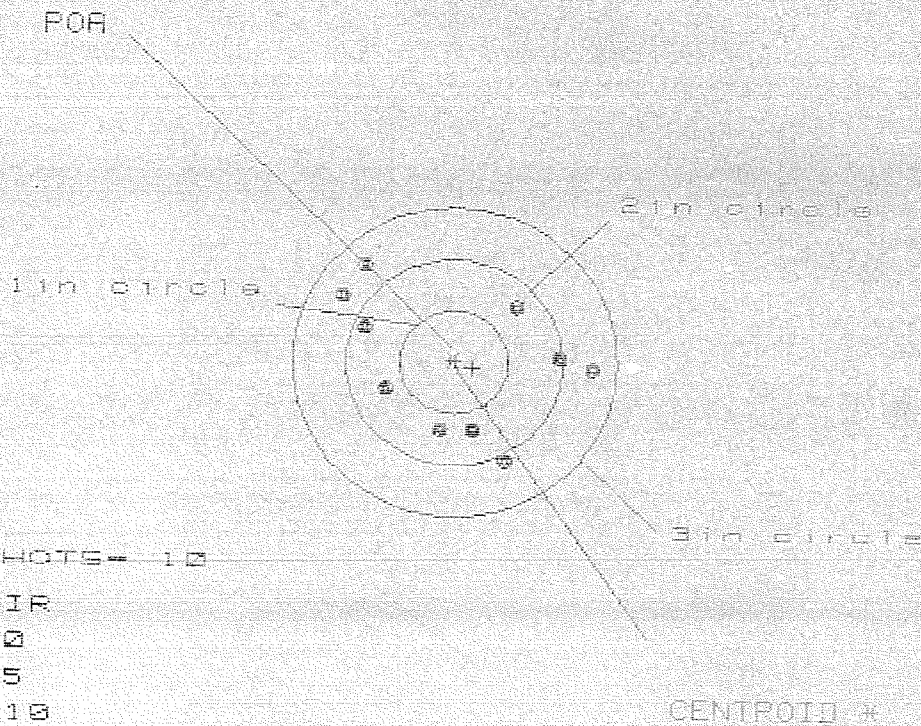
45 ← POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0634  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0124  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0646012  
THE AMR FOR THIS RIFLE IS: .0578

29 Oct 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6565667

## CENTERFIRE PATTERNS # 1



# OF SHOTS = 10

# IN CIR

1 in = 0

2 in = 5

3 in = 10

HS = 2.348

VS = 1.835

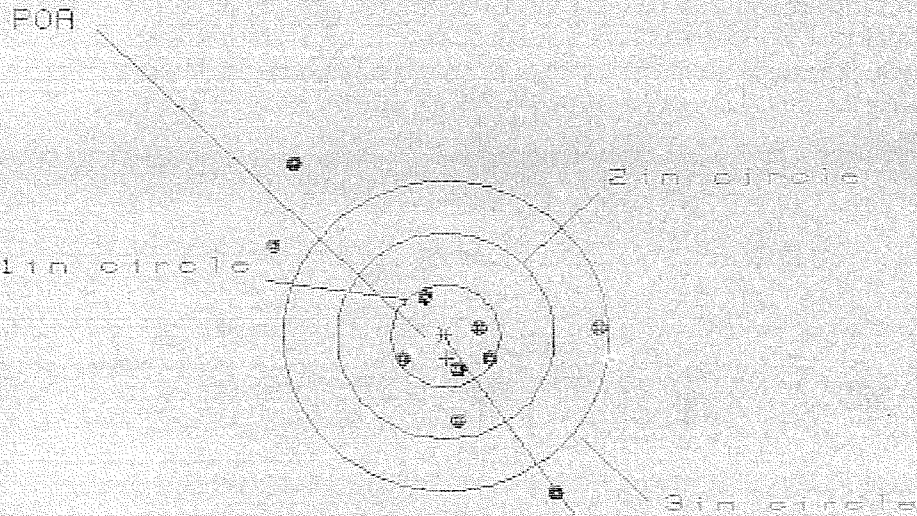
GS = 2.452

| PATTERN #                     | 1      | 2      | 3      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.300  | 1.159  | 1.071  |
| MINIMUM X                     | -1.043 | -0.984 | -0.992 |
| MAXIMUM Y                     | .904   | .894   | .714   |
| MINIMUM Y                     | -0.930 | -0.941 | -0.829 |
| CENTROID X                    | -0.171 | -0.315 | -0.227 |
| CENTROID Y                    | .054   | .064   | -0.048 |
| POA TO CENTROID in.           | .179   | .321   | .232   |
| MIN RADIUS                    | .665   | .534   | .572   |
| MEAN RADIUS                   | .956   | .905   | .859   |
| MAX RADIUS                    | 1.303  | 1.162  | 1.223  |
| HORIZONTAL SPREAD             | 2.348  | 2.063  | 2.063  |
| VERTICAL SPREAD               | 1.835  | 1.835  | 1.543  |
| EXTREME SPREAD                | 2.452  | 2.245  | 2.146  |
| NUMBER IN ONE INCH CIRCLE =   | 0      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 5      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 10     |        |        |

25 Oct 1991

FILE://PATTERNING/CENTERFIRE\_PATT/C6605007

## CENTERFIRE PATTERNS # 2



# OF SHOTS = 10

# IN CIR

1 in = 5

2 in = 6

3 in = 7

HS = 2.994

VS = 3.168

GS = 3.941

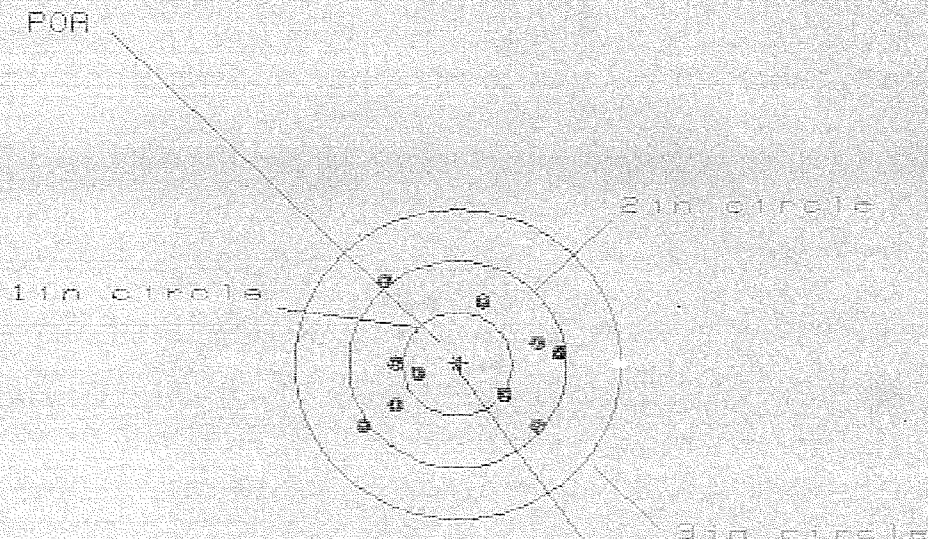
CENTROID \*

| PATTERN #                     | : | 2      |        |        |
|-------------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)               | : | 10     | 9      | 8      |
| MAXIMUM X                     | : | 1.449  | 1.298  | 1.403  |
| MINIMUM X                     | : | -1.545 | -1.696 | -1.591 |
| MAXIMUM Y                     | : | 1.676  | 1.061  | .898   |
| MINIMUM Y                     | : | -1.492 | -1.306 | -.816  |
| CENTROID X                    | : | -.010  | .141   | .036   |
| CENTROID Y                    | : | .218   | .032   | .195   |
| POA TO CENTROID in.           | : | .218   | .144   | .198   |
| MIN RADIUS                    | : | .312   | .109   | .225   |
| MEAN RADIUS                   | : | .997   | .818   | .743   |
| MAX RADIUS                    | : | 2.155  | 2.000  | 1.826  |
| HORIZONTAL SPREAD             | : | 2.994  | 2.994  | 2.994  |
| VERTICAL SPREAD               | : | 3.168  | 2.367  | 1.714  |
| EXTREME SPREAD                | : | 3.941  | 3.469  | 3.087  |
| NUMBER IN ONE INCH CIRCLE =   |   |        | 5      |        |
| NUMBER IN TWO INCH CIRCLE =   |   |        | 6      |        |
| NUMBER IN THREE INCH CIRCLE = |   |        | 7      |        |

29 Oct 1991

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## CENTERFIRE PATTERNS # 3



# OF SHOTS= 10

# IN CIR

1in = 1

2in = 8

3in = 10

HS= 1.810

VS= 1.449

GS= 1.992

CENTROID #

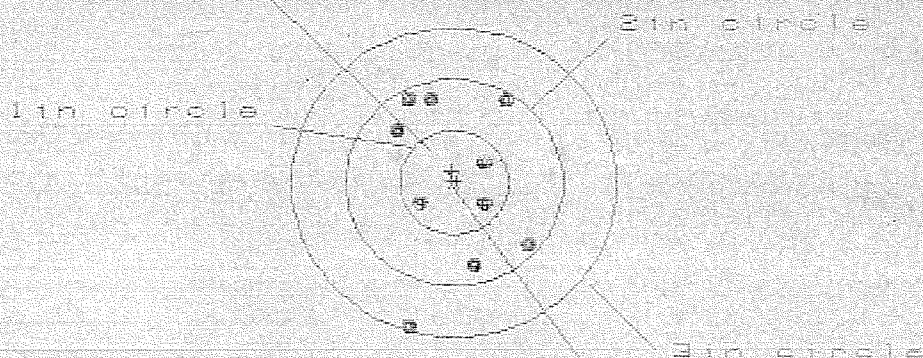
| PATTERN #                   | : | 3     |       |       |
|-----------------------------|---|-------|-------|-------|
| SHOTS (BEST OF)             | : | 10    | 9     | 8     |
| MAXIMUM X                   | : | .962  | .887  | .771  |
| MINIMUM X                   | : | -.848 | -.923 | -.734 |
| MAXIMUM Y                   | : | .814  | .738  | .675  |
| MINIMUM Y                   | : | -.635 | -.545 | -.608 |
| CENTROID X                  | : | -.031 | .044  | .160  |
| CENTROID Y                  | : | -.014 | -.104 | -.042 |
| POA TO CENTROID in.         | : | .034  | .113  | .165  |
| MIN RADIUS                  | : | .423  | .393  | .330  |
| MEAN RADIUS                 | : | .755  | .716  | .665  |
| MAX RADIUS                  | : | 1.059 | 1.051 | .788  |
| HORIZONTAL SPREAD           | : | 1.810 | 1.810 | 1.505 |
| VERTICAL SPREAD             | : | 1.449 | 1.283 | 1.283 |
| EXTREME SPREAD              | : | 1.992 | 1.950 | 1.562 |
| NUMBER IN ONE INCH CIRCLE   | = |       | 1     |       |
| NUMBER IN TWO INCH CIRCLE   | = |       | 8     |       |
| NUMBER IN THREE INCH CIRCLE | = |       | 10    |       |

29 Oct 1991

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## CENTERFIRE PATTERNS # 4

POB



# OF SHOTS- 10

# IN CIR

1in = 3

2in = 9

3in = 10

HS= 1.133

VS= 2.263

GS= 2.444

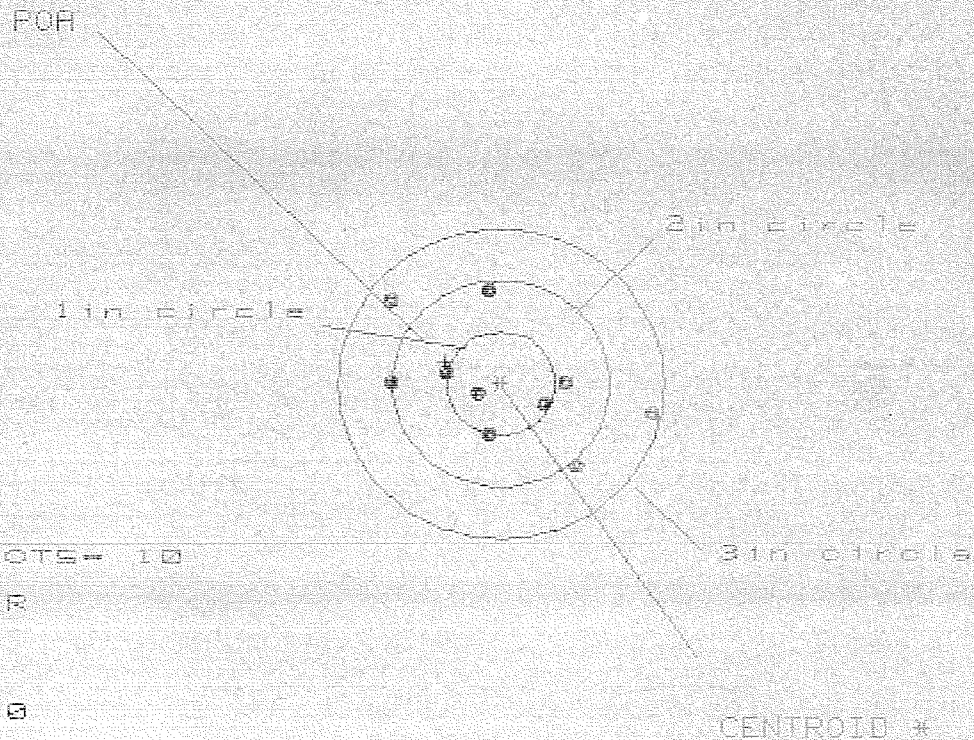
CENTROID \*

| PATTERN #                     | 4      |       |       |
|-------------------------------|--------|-------|-------|
| SHOTS (BEST OF)               | 10     | 9     | 8     |
| MAXIMUM X                     | .641   | .594  | .651  |
| MINIMUM X                     | -.492  | -.539 | -.482 |
| MAXIMUM Y                     | .927   | .668  | .740  |
| MINIMUM Y                     | -1.436 | -.920 | -.837 |
| CENTROID X                    | .020   | .067  | .010  |
| CENTROID Y                    | -.110  | .049  | -.024 |
| POB TO CENTROID in.           | .112   | .083  | .036  |
| MIN RADIUS                    | .362   | .288  | .372  |
| MEAN RADIUS                   | .774   | .677  | .657  |
| MAX RADIUS                    | 1.497  | .989  | .961  |
| HORIZONTAL SPREAD             | 1.133  | 1.133 | 1.133 |
| VERTICAL SPREAD               | 2.263  | 1.598 | 1.577 |
| EXTREME SPREAD                | 2.444  | 1.792 | 1.792 |
| NUMBER IN ONE INCH CIRCLE =   |        | 3     |       |
| NUMBER IN TWO INCH CIRCLE =   |        | 9     |       |
| NUMBER IN THREE INCH CIRCLE = |        | 10    |       |

29 Oct 1991

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## CENTERFIRE PATTERNS # 5



# OF SHOTS= 10

# IN CIR

1 in = 2

2 in = 6

3 in = 10

HS= 2.414

VS= 1.738

GS= 2.594

| PATTERN #                     | 5      | 9     | 8      |
|-------------------------------|--------|-------|--------|
| SHOTS (BEST OF)               | 10     | 9     | 8      |
| MAXIMUM X                     | 1.358  | .962  | .761   |
| MINIMUM X                     | -1.054 | -.903 | -1.004 |
| MAXIMUM Y                     | .926   | .891  | .990   |
| MINIMUM Y                     | -.812  | -.847 | -.748  |
| CENTROID X                    | .509   | .358  | .459   |
| CENTROID Y                    | -.210  | -.175 | -.274  |
| FOR TO CENTROID in.           | .551   | .398  | .535   |
| MIN RADIUS                    | .255   | .170  | .185   |
| MEAN RADIUS                   | .807   | .727  | .663   |
| MAX RADIUS                    | 1.398  | 1.209 | 1.067  |
| HORIZONTAL SPREAD             | 2.414  | 1.765 | 1.765  |
| VERTICAL SPREAD               | 1.738  | 1.738 | 1.738  |
| EXTREME SPREAD                | 2.594  | 2.346 | 1.961  |
| NUMBER IN ONE INCH CIRCLE =   |        | 2     |        |
| NUMBER IN TWO INCH CIRCLE =   |        | 6     |        |
| NUMBER IN THREE INCH CIRCLE = |        | 10    |        |