

FORM

UPC



0 47700 25716 7

C6665931

*INCLUDES 1 IN CHAMBER

CAPACITY*

BARREL LENGTH

MODEL 780 TM M24

ORDER NO.

5715

Remington



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

MODEL 700™ M24

SERIAL NO.
C6665931

ORDER NO.
5716

20

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



5716 C6665931

ORDER 5716
MODEL 700™ M24
UPC

ORDER 5716
MODEL 700™ M24
UPC



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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6665931

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	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	YB.
617	Drill and Tap Sight Holes		OCT 4 1991	FB
618	Polish Barrel		10/8/91	WLB
620	Apply Coatings (Barrel Action)		10-22-91	FB
	Apply Coating (Bolt)			
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		11-8-91	JA

op. #	BARBER - M24 0104150 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			11-11-91	JP
	G) Safety Off Force	2	3	2			11-11-91	JP
	H) Trigger Pull Test & Retainability						11-8-91	JP
	I) Firing Pin Indent	.020	.020	.020			11-11-91	JP
	J) Assemble Stock						11/15/91	RW
	K) Assemble Swivel Studs						11-19-91	D/H
	L) Attach Front and Rear Sight Assemblies						11/15/91	RW
	M) Iron Sight Alignment						11/15/91	RW
	N) Detach Front & Rear Sights & place in numbered container						11/15/91	RW
	O) Attach Scope to Rifle						11/15/91	RW
	P) Detach & Attach Scope 20 Times						11/15/91	RW
640	Gallery Target & Test						11-15-91	AC
	A) Time						11-15-91	AC
	B) Malfunctions						11-15-91	AC
	C) Pierced Primers						11-15-91	AC
	D) Optical Clarity of Scope						11-15-91	AC
645	Inspect for Live Ammo						11-15-91	AC
655	Final Inspection A) Headspace						11-15-91	D/H
	B) Trigger Pull	263	252	257	266	264	11-15-91	D/H
	C) Function						11-15-91	D/H
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 C-6665931

DATE 11-8-91

TESTER JF

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.69	2.43	2.44	2.63	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.56	2.56	2.51	2.52	
PULL #3	2.39	2.47	2.55	2.57	
PULL #4	2.50	2.53	2.40	2.66	
PULL #5	2.48	2.53	2.38	2.64	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.69	3.37		
PULL #2	3.41	3.44		
PULL #3	3.27	3.34		
PULL #4	3.38	3.37		
PULL #5	3.44	3.60		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.28	4.32		4.37
PULL #2	4.31	4.32		4.34
PULL #3	4.28	4.34		4.38
PULL #4	4.30	4.39		4.40
PULL #5	4.27	4.38		4.45
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06665931
18 Nov 1991

CENTROIDAL DISTANCES

0 TO 1	.128141
1 TO 2	.112361
1 TO 3	.0935201
1 TO 4	.104661
1 TO 5	.181246

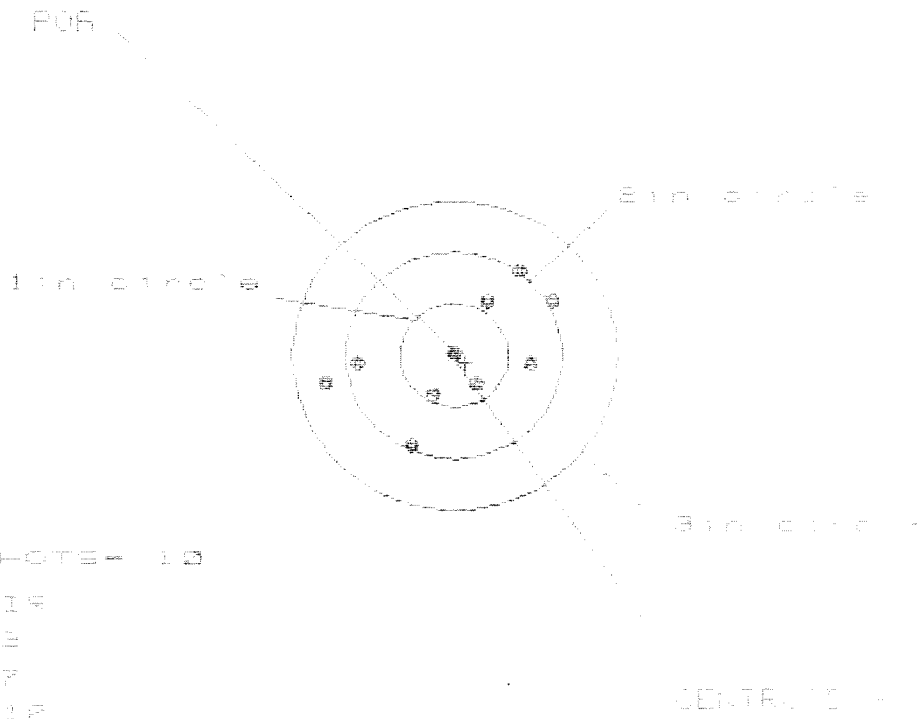
54 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1114
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0844
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .139762
THE AMR FOR THIS RIFLE IS: .8902

15 NOV 1991

FILE: /PATTERNING/CENTERFIRE/0104153

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CH

OF SHOTS

OF SHOTS

OF SHOTS

OF SHOTS

OF SHOTS

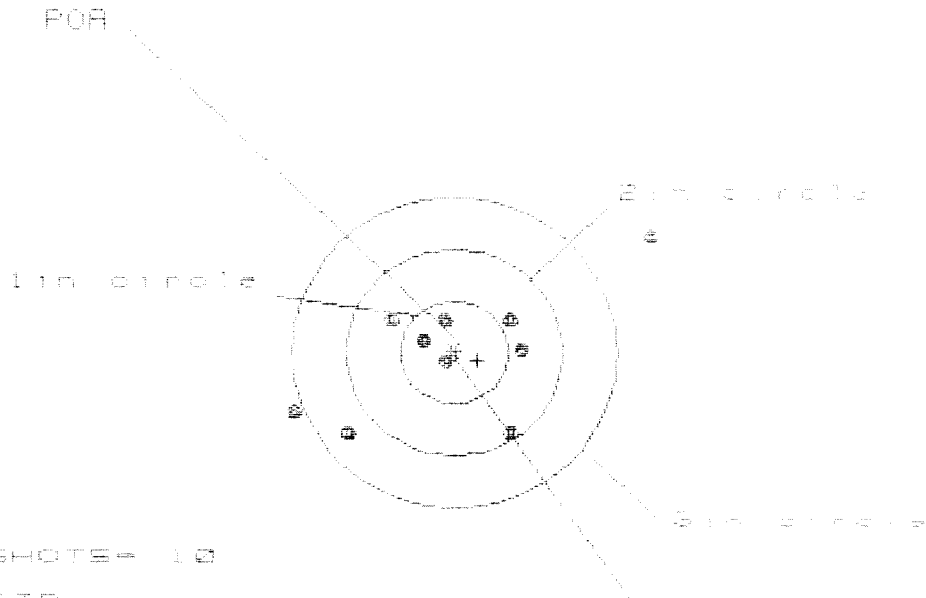
OF SHOTS

SHOTS	1	2	3
10 (BEST OF)	10	9	8
1st INCH	.985	.773	.718
2nd INCH	-1.184	-1.010	-1.010
3rd INCH	.815	.787	.649
4th INCH	-1.889	-1.917	-1.825
5th INCH	-1.106	.025	-1.071
6th INCH	.072	.100	.038
7th INCH	.128	.103	.080
8th INCH	.039	.150	.067
9th INCH	.732	.679	.634
10th INCH	1.210	1.064	1.017
11th INCH	2.089	1.783	1.629
12th INCH	1.704	1.704	1.704
13th INCH	2.225	1.983	1.583
14th INCH	ONE INCH CIRCLE	3	
15th INCH	TWO INCH CIRCLE	7	
16th INCH	THREE INCH CIRCLE	10	

18 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PAT/06665931

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 7

3 in = 8

CENTROID +

SE= 2.318

SE= 1.988

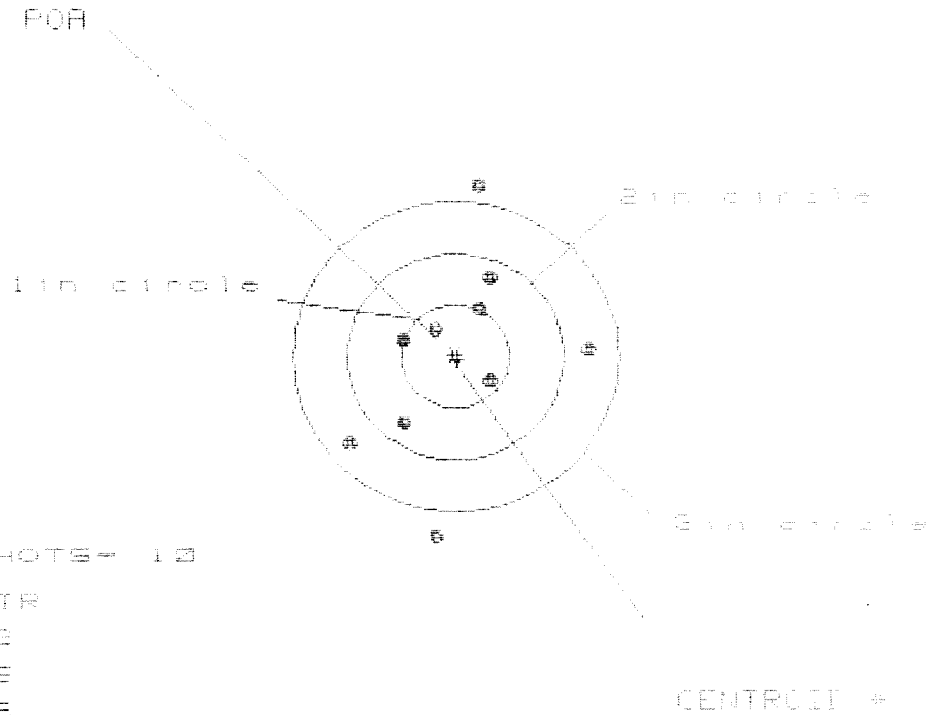
SE= 2.716

PATTERN #	:	2		
POINTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.861	.815	.659
MINIMUM X	:	-1.457	-1.250	-.945
MAXIMUM Y	:	1.125	.467	.414
MINIMUM Y	:	-.781	-.656	-.789
CENTROID X	:	-.218	-.425	-.269
CENTROID Y	:	.081	-.044	.089
STD TO CENTROID (in.)	:	.233	.428	.368
STD DEVIATION	:	.130	.158	.049
MEAN RADIUS	:	.860	.718	.688
GR. RADIUS	:	2.175	1.320	1.181
1 IN. CIRCLE SPREAD	:	3.318	2.865	1.684
2 IN. CIRCLE SPREAD	:	1.986	1.123	1.123
3 IN. CIRCLE SPREAD	:	3.716	2.134	1.822
POINTS IN ONE INCH CIRCLE	=		3	
POINTS IN TWO INCH CIRCLE	=		7	
POINTS IN THREE INCH CIRCLE	=		8	

18 Nov 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CTR

1 in = 2

2 in = 6

3 in = 8

MS= 2.209

S= 3.382

CS= 3.403

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.223	1.202	1.224
MINIMUM X	-1.986	-1.007	-1.985
MAXIMUM Y	1.622	1.427	1.741
MINIMUM Y	-1.760	-1.024	-1.846
CENTROID X	-0.021	-0.000	-0.022
CENTROID Y	.033	.229	.051
POA TO CENTROID IN.	.040	.229	.050
MIN RADIUS	.326	.195	.311
MEAN RADIUS	.928	.803	.732
MAX RADIUS	1.769	1.437	1.298
HORIZONTAL SPREAD	2.209	2.209	2.209
VERTICAL SPREAD	3.382	2.451	1.587
SPHERE SPREAD	3.403	2.719	2.391
SHOTS IN ONE INCH CIRCLE	=	2	
SHOTS IN TWO INCH CIRCLE	=	6	
SHOTS IN THREE INCH CIRCLE	=	8	

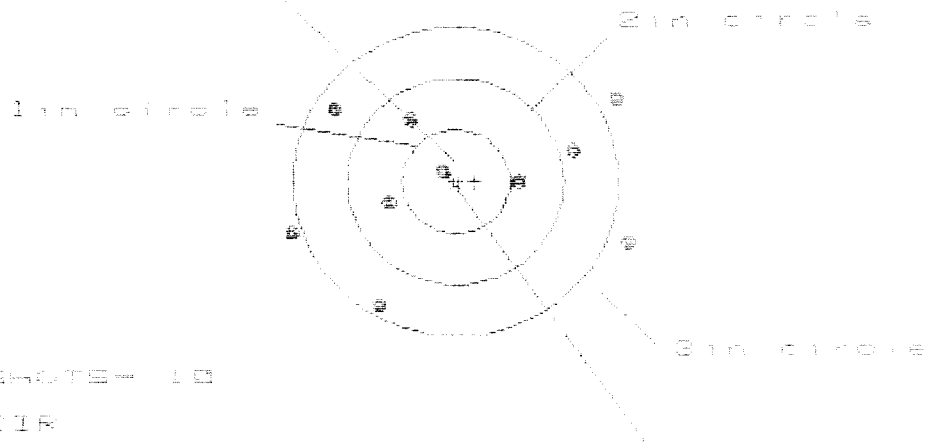
16 MAR 1961

FILE: PATTERNING-CENTERFIRE_PATT-06665931

CENTERFIRE PATTERNS

4

FOR



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 7

CENTROID -

AS= 3.076

S= 2.055

SS= 3.252

PATTERN #

4

SHOTS (BEST OF)	:	10	9	8
AR-MIN	:	1.560	1.631	1.416
AR-MAX	:	-1.516	-1.342	-1.160
AR-MIN	:	.832	.760	.710
AR-MAX	:	-1.223	-1.295	-1.200
CENTROID	:	-.181	-.355	-.558
CENTROID	:	-.001	.071	-.024
OFF TO CENTROID in.	:	.181	.352	.559
OFF PHOTOS	:	.175	.024	.249
OFF PAPER	:	1.098	.996	.893
OFF PAPER	:	1.689	1.799	1.480
HORIZONTAL SPREAD	:	3.076	2.973	2.555
VERTICAL SPREAD	:	2.055	2.055	1.920
SPREAD	:	3.252	3.252	2.683
SPREAD ONE INCH CIRCLE	=		1	
SPREAD TWO INCH CIRCLE	=		4	
SPREAD THREE INCH CIRCLE	=		7	

(S No: 1931)

FILE: \PATTERNING\CENTERFIRE_PAT (05665330)

CENTERFIRE PATTERN

* 5

POA

1 in circle

2 in circle

3 in circle

* OF SHOTS = 10

* IN IN

1 in = 2

2 in = 7

3 in = 6

2 in = 2.12

2 in = 1.556

2 in = 2.124

CENTERFIRE

* OF SHOTS = 10

5

SHOT	1	2	3
1	1.058	1.873	1.712
2	-1.661	-1.291	-1.341
3	1.757	1.624	1.528
4	-1.199	-1.772	-1.416
5	-1.031	1.154	1.315
6	1.237	1.370	1.466
7	1.239	1.401	1.563
8	1.170	1.366	1.241
9	1.813	1.650	1.518
10	2.049	1.504	1.320
11	2.719	2.164	1.155
12	1.956	1.396	1.346
13	2.904	2.213	1.560
14	2.12	2	2
15	1.556	1.556	1.556
16	2.124	2.124	2.124