

E 626 1585

**Remington®**VERY IMPORTANT:  
Instruction Book  
enclosed to assure  
safe use of this  
firearm.**MODEL 700™ M24**  
BOLT ACTION CENTERFIRE RIFLE  
24" BARREL 7.62 NATOSERIAL NO. **J**  
**E6761585**ORDER NO.  
**25716**

46

Made in Ilion, NY Reg. U.S. Pat &amp; tm. Off. Marca Registrada Marque Deposee.



5716 E6761585

**17XV**

MODEL 700<sup>TH</sup> M24  
BOLT ACTION CENTERFIRE RIFLE  
24" BARREL 7.62 NATO

DOCUMENT ENVELOPE ASSEMBLY:

- INSTRUCTION BOOK
- PRODUCT OWNER'S CARD
- SAFETY BOOKLET

46 FORM 1444

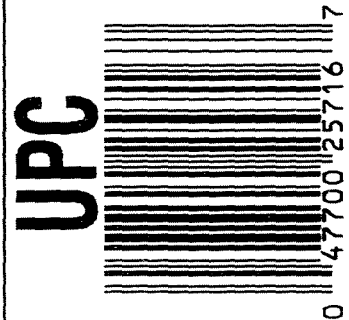


ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

E6761585

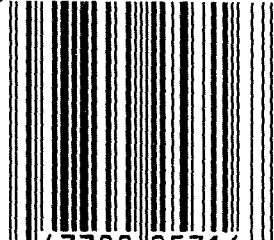


**ORDER**

**25716**

MODEL 700<sup>TH</sup> M24

**UPC**



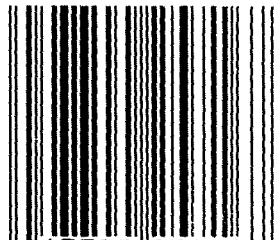
0 47700 25716 7

**ORDER**

**25716**

MODEL 700<sup>TH</sup> M24

**UPC**



0 47700 25716 7

SERIAL NO.



E6761585

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9

CONTRACT #

GUN SERIAL # E6761585

| OP #         | OPERATION NAME                                                                                                                         | READINGS | DATE                    | INITIAL |
|--------------|----------------------------------------------------------------------------------------------------------------------------------------|----------|-------------------------|---------|
| 575 &<br>580 | ASSEMBLE ACTION<br>AND STOCK                                                                                                           |          | 9-27-01                 | AK      |
| 600          | PROOF                                                                                                                                  |          | 9-27-01                 | AC      |
| 607          | CHECK HEADSPACE                                                                                                                        |          | 9-28-01                 | AK      |
| 610          | DIS-ASSEMBLE GUN                                                                                                                       |          | 9-28-01                 | AK      |
| 612          | MAGNAFLUX BBL ACTION<br>MAGNAFLUX BOLT                                                                                                 |          | SEP 29 2001<br>OPERATOR | AC      |
| 615          | ROLLMARK CALIBER                                                                                                                       |          | 9/29                    | (D)     |
| 617          | DRILL AND TAP<br>SIGHT HOLES                                                                                                           |          |                         |         |
| 620          | APPLY COATINGS<br>(BARREL ACTION)                                                                                                      |          | 10/11                   | HP      |
|              | (BOLT)                                                                                                                                 |          | 10/11                   | HP      |
| 625          | FINAL ASSEMBLY<br>A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                                                                                  |          | 10-22-01                | AK      |
|              | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD                                                                         |          | 10-22-01                | AK      |
|              | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                                                                                                 |          | 10-23-01                | AK      |
|              | D) OIL FIRING PIN ASSEMBLY                                                                                                             |          | 10-23-01                | AK      |
|              | E) ADJUST TRIGGER PULL<br>TO MIN. SETTING AND<br>STAKE <span style="border: 1px solid black; padding: 2px;">2.50 LBS +/- .5 LBS</span> |          | 12/13/01                | DA      |

| OP #  | OPERATION NAME                                                        |                                           | READINGS                                                    | DATE     | INITIAL |
|-------|-----------------------------------------------------------------------|-------------------------------------------|-------------------------------------------------------------|----------|---------|
| 625   | F) SAFETY ON FORCE                                                    | 2 LBS MIN<br>10 LBS MAX                   | <u>6.9</u> <u>6.9</u> <u>6.9</u>                            | 11-5-01  | DA      |
| CONT. |                                                                       |                                           |                                                             |          |         |
|       | G) SAFETY OFF FORCE                                                   | 2 LBS MIN                                 | <u>3.9</u> <u>3.9</u> <u>3.9</u>                            | 11-5-01  | DA      |
|       | H) TRIGGER PULL TEST<br>AND RETAINABILITY                             |                                           |                                                             |          |         |
|       | I) FIRING PIN INDENT                                                  | .020 MIN                                  | <u>.023</u> <u>.023</u> <u>.022</u>                         | 11-5-01  | DA      |
|       | J) ASSEMBLE STOCK                                                     |                                           |                                                             |          |         |
|       | K) ASSEMBLE SWIVEL<br>STUDS                                           |                                           |                                                             | 12/13/01 | REP     |
|       | L) ATTACH FRONT AND<br>REAR SIGHT ASSY'S                              |                                           |                                                             | 12/13/01 | REP     |
|       | M) IRON SIGHT<br>ALIGNMENT                                            |                                           |                                                             | 12/13/01 | REP     |
|       | N) DETACH FRONT AND<br>REAR SIGHTS AND PLACE<br>IN NUMBERED CONTAINER |                                           |                                                             | 12/13/01 | REP     |
| 640   | GALLERY TEST AND<br>TARGET                                            |                                           | PASS FAIL                                                   | 10-24-01 | AK      |
|       | A) MALFUNCTIONS                                                       |                                           | PASS FAIL                                                   | 10-24-01 | AK      |
|       | B) PIERCED PRIMERS                                                    |                                           | PASS FAIL                                                   | 10-24-01 | AK      |
| 645   | INSPECT FOR LIVE AMMO                                                 |                                           |                                                             | 10-24-01 | AK      |
| 655   | FINAL INSPECTION<br>A) HEADSPACE                                      |                                           |                                                             | 12/13/01 | REP     |
|       | B) TRIGGER PULL                                                       | +/- .5 LBS<br>MIN 2.50 LBS<br>MAX 4.0 LBS | <u>2.74</u> <u>2.75</u> <u>2.76</u> <u>2.81</u> <u>2.80</u> | 11-5-01  | DA      |
|       | C) FUNCTION                                                           |                                           |                                                             | 12/13/01 | REP     |
| 660   | PACK                                                                  |                                           |                                                             | 12/13/01 | DA      |

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO E6761585DATE 10-10-01TESTER NR

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |       | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|-------|------------------------------------------------------------------------|
| PULL #1 | 2.57             | 2.53                     |                                | 2.52  | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.59             | 2.47                     |                                | 2.50  |                                                                        |
| PULL #3 | 2.51             | 2.51                     |                                | 2.27  |                                                                        |
| PULL #4 | 2.46             | 2.42                     |                                | 2.54  |                                                                        |
| PULL #5 | 2.31             | 2.45                     |                                | 2.35  |                                                                        |
| TOTAL   | 12.44            | 12.38                    |                                | 12.18 |                                                                        |
| AVG.    | 2.48             | 2.47                     |                                | 2.43  |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.02             | 3.06                     |  |          |
| PULL #2 | 3.03             | 3.11                     |  |          |
| PULL #3 | 3.02             | 3.00                     |  |          |
| PULL #4 | 3.19             | 3.08                     |  |          |
| PULL #5 | 3.09             | 3.08                     |  |          |
| TOTAL   | 15.35            | 15.33                    |  |          |
| AVG.    | 3.07             | 3.06                     |  |          |

|         | 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 | 4.01             | 4.24                     |                                | 4.24                                 |
| PULL #2 | 4.04             | 4.03                     |                                | 4.35                                 |
| PULL #3 | 4.08             | 4.03                     |                                | 4.38                                 |
| PULL #4 | 4.05             | 4.05                     |                                | 4.26                                 |
| PULL #5 | 4.03             | 4.03                     |                                | 4.36                                 |
| TOTAL   | 20.21            | 20.38                    |                                | 21.59                                |
| AVG.    | 4.04             | 4.07                     |                                | 4.31                                 |

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # E6761585  
29 Oct 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS:  $-.3242$   
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS:  $.4178$   
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS:  $.528831$

THE AMR FOR THIS RIFLE IS:  $1.148$

### CENTROIDAL DISTANCES

|   |    |   |         |
|---|----|---|---------|
| 0 | TO | 1 | .49768  |
| 1 | TO | 2 | .376431 |
| 1 | TO | 3 | .22404  |
| 1 | TO | 4 | .377243 |
| 1 | TO | 5 | .503016 |

4      2  
3 1      5  
+      <----POA



REMINGTON CENTERFIRE ACCURACY TEST

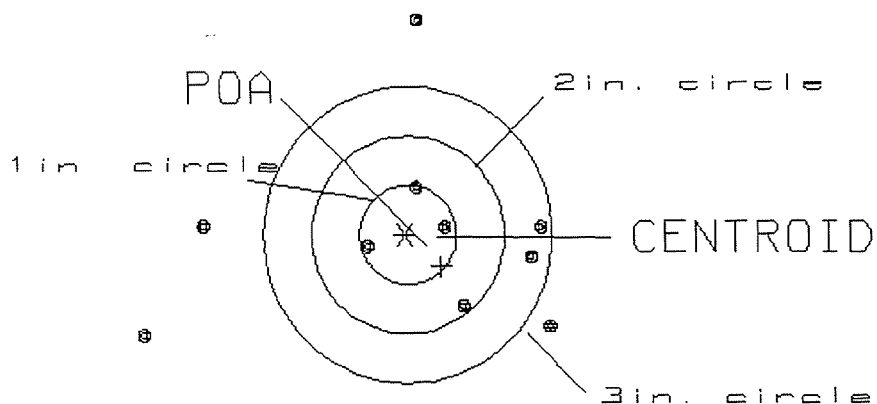
REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 1 ☐  
 POA TO CENTROID: .497  
 MIN RADIUS : .395  
 MEAN RADIUS : 1.380  
 MAX RADIUS : 2.862  
 CENTROID X : -.382  
 CENTROID Y : .319

29 Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire\_Patt/E6761585.1

# CENTERFIRE PATTERN # 1



# OF SHOTS= 10

# IN CIRCLE

HS= 4.15  
 VS= 3.16  
 GS= 4.19

2  
 4  
 6

PATTERN #: ☐ 2 ☐

POA TO CENTROID: .566

MIN RADIUS : .371

MEAN RADIUS : 1.026

MAX RADIUS : 1.646

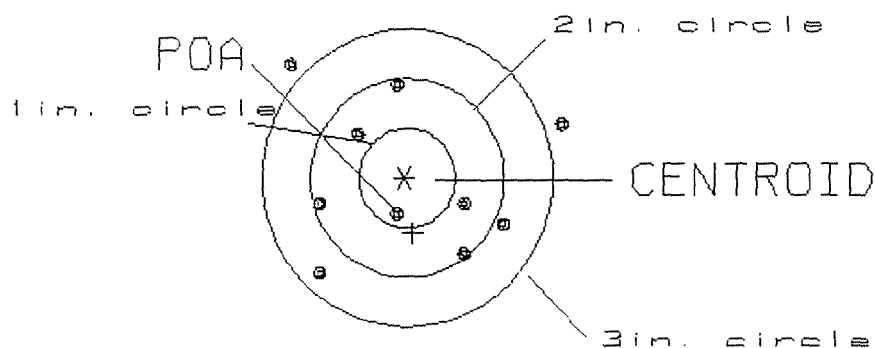
CENTROID X : -.092

CENTROID Y : .559

29 Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire\_Patt/E6761585.1

## CENTERFIRE PATTERN # 2



# OF SHOTS= 10

# IN CIRCLE

HS= 2.76

1

VS= 2.03

6

GS= 2.87

8

## REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 3 ☐

POA TO CENTROID: .709

MIN RADIUS : .271

MEAN RADIUS : 1.010

MAX RADIUS : 2.530

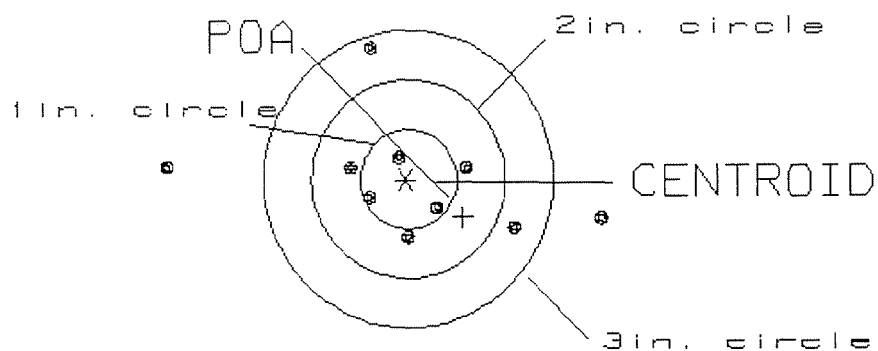
CENTROID X : -.597

CENTROID Y : .382

29 Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire\_Patt/E6761585.1

## CENTERFIRE PATTERN # 3



# OF SHOTS= 10

# IN CIRCLE

HS= 4.48

3

VS= 1.93

6

GS= 4.51

8

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 4 ☐

POA TO CENTROID: .874

MIN RADIUS : .480

MEAN RADIUS : 1.184

MAX RADIUS : 2.061

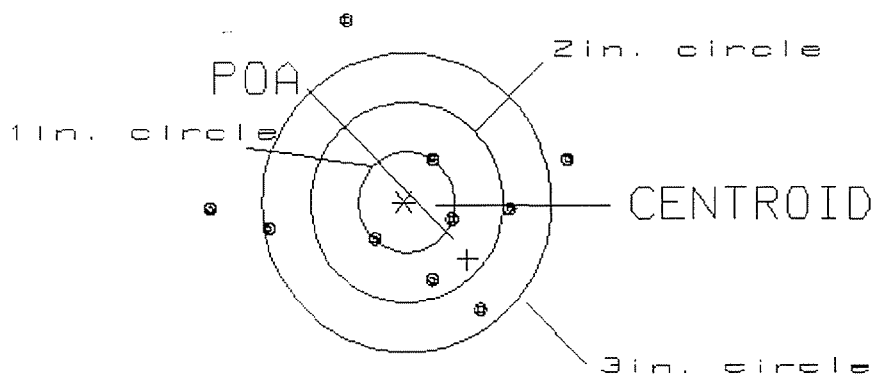
CENTROID X : -.668

CENTROID Y : .565

29 Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire\_Patt/E6761585.1

## CENTERFIRE PATTERN # 4



# OF SHOTS= 10

# IN CIRCLE

HS= 3.73

2

VS= 2.96

4

GS= 3.76

7

## REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 5 ☐

POA TO CENTROID: .289

MIN RADIUS : .343

MEAN RADIUS : 1.138

MAX RADIUS : 1.983

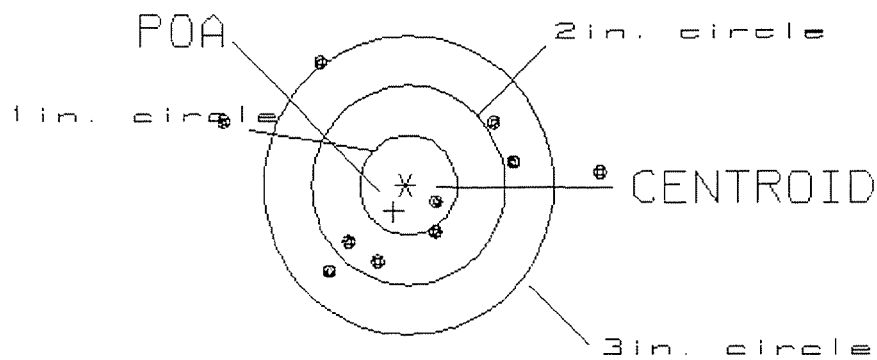
CENTROID X : .118

CENTROID Y : .264

29 Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire\_Patt/E6761585.1

## CENTERFIRE PATTERN # 5



# OF SHOTS= 10

# IN CIRCLE

HS= 3.86

1

VS= 2.06

4

GS= 3.89

7

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # E6761585  
25 Oct 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1292  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0808  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .152385

THE AMR FOR THIS RIFLE IS: 1.438

### CENTROIDAL DISTANCES

|        |         |
|--------|---------|
| 0 TO 1 | .384232 |
| 1 TO 2 | .405178 |
| 1 TO 3 | .791214 |
| 1 TO 4 | .177505 |
| 1 TO 5 | .549426 |

3  
2  
5 + 4 1 <----POA

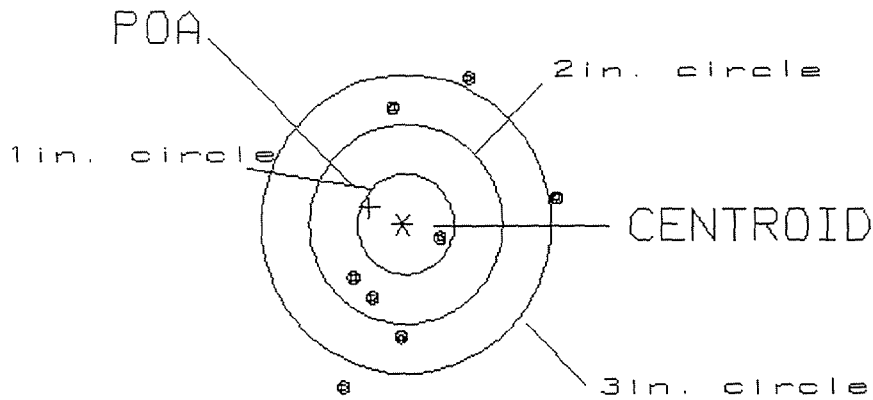
PATTERN #: ☐ 1 ☐

POA TO CENTROID: .384  
 MIN RADIUS : .393  
 MEAN RADIUS : 1.599  
 MAX RADIUS : 4.067  
 CENTROID X : .347  
 CENTROID Y : -.165

25 Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire\_Patt/E6761585

# CENTERFIRE PATTERN # 1



# OF SHOTS= 10

# IN CIRCLE

HS= 2.34

1

VS= 6.76

3

GS= 6.82

5

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 2 ☐

POA TO CENTROID: .517

MIN RADIUS : .302

MEAN RADIUS : 1.344

MAX RADIUS : 2.631

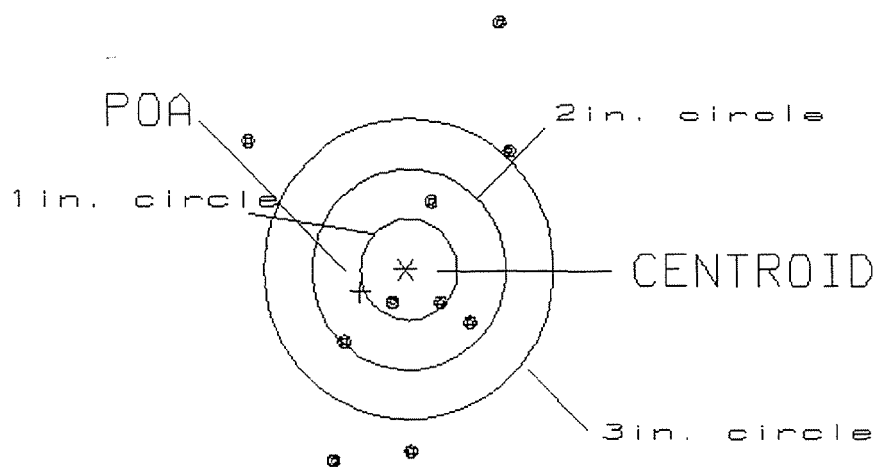
CENTROID X : .467

CENTROID Y : .222

25 Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire\_Patt/E6761505

## CENTERFIRE PATTERN # 2



# OF SHOTS= 10

# IN CIRCLE

HS= 2.69

2

VS= 4.37

5

GS= 4.66

5



PATTERN #: ☐ 3 ☐

POA TO CENTROID: .458

MIN RADIUS : .331

MEAN RADIUS : 1.615

MAX RADIUS : 2.860

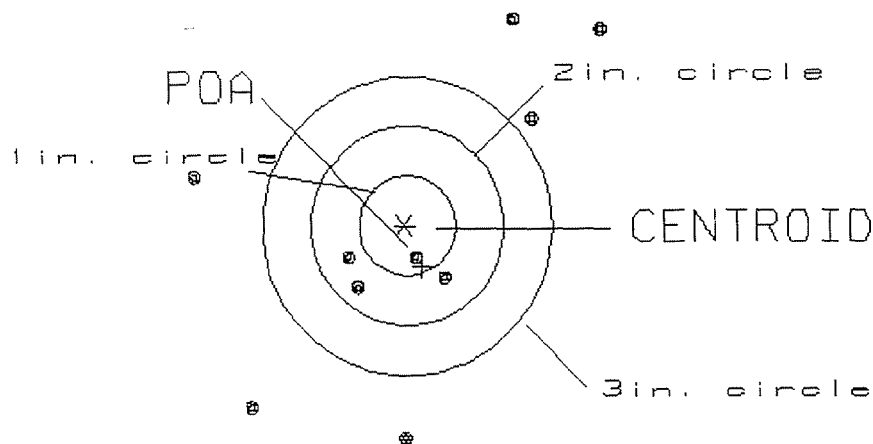
CENTROID X : -.189

CENTROID Y : .417

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FILE:/Hpbasic/Accuracy/Patterning/Centerfire\_Patt/E6761585

## CENTERFIRE PATTERN # 3



# OF SHOTS= 10

# IN CIRCLE

HS= 4.22

1

VS= 4.24

4

GS= 5.27

4

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 4 ☐

POA TO CENTROID: .209

MIN RADIUS : .552

MEAN RADIUS : 1.196

MAX RADIUS : 3.002

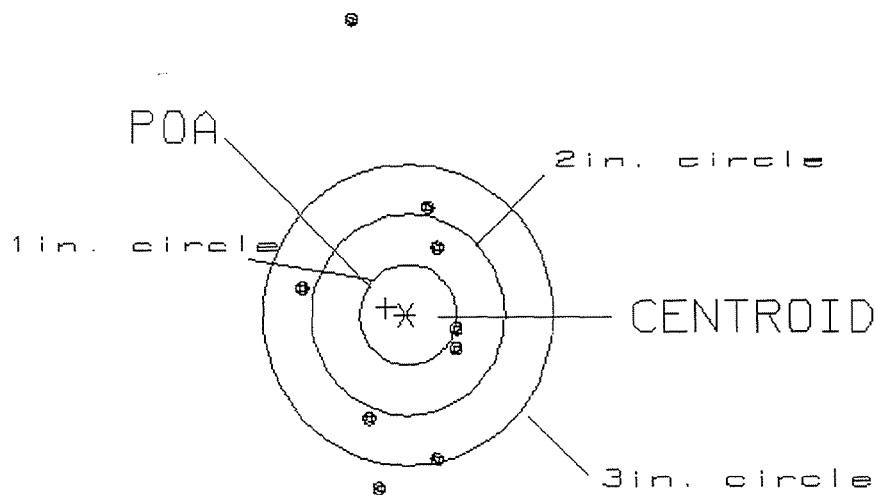
CENTROID X : .199

CENTROID Y : -.067

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FILE:/Hpbasic/Accuracy/Patterning/Centerfire\_Patt/E6761585

## CENTERFIRE PATTERN # 4



# OF SHOTS= 10

# IN CIRCLE

HS= 1.63

0

VS= 4.72

4

GS= 4.73

8

## REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 5 ☐

POA TO CENTROID: .178

MIN RADIUS : .327

MEAN RADIUS : 1.437

MAX RADIUS : 2.766

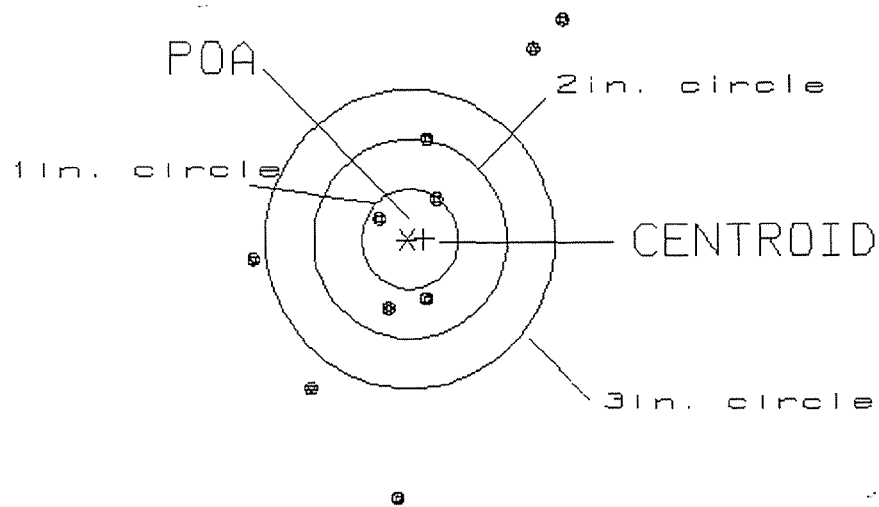
CENTROID X : -.178

CENTROID Y : -.003

25 Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire\_Patt/E6761585

## CENTERFIRE PATTERN # 5



# OF SHOTS= 10

# IN CIRCLE

HS= 3.27

2

VS= 4.86

4

GS= 5.18

5