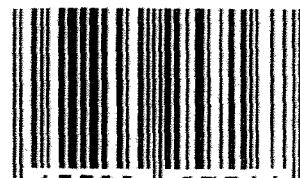


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FORM

UPC



47700 25716

BARREL LENGTH  
CAPACITY\*  
\*INCLUDES 1 IN CHAMBER  
C6649056

MODEL 700<sup>TM</sup> M24

ORDER NO.

5715

# Remington



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

**MODEL 700<sup>TM</sup> M24**

SERIAL NO.

**C6649056**

ORDER NO.

**5716**

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

20



5716 C6649056

**ORDER 5716**

MODEL 700<sup>TM</sup> M24

**UPC**



0 47700 25716 7

**ORDER 5716**

MODEL 700<sup>TM</sup> M24

**UPC**



0 47700 25716 7

**GFM**

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649056

| OP. #        | OP. NAME                                                       | READINGS | DATE     | INIT |
|--------------|----------------------------------------------------------------|----------|----------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   | 9 26 91  | 9 26 91  | RW   |
| 600          | Proof                                                          | 9 26 91  | 9 26 91  | RW   |
| 607          | Check Headspace                                                | 9 26 91  | 9 26 91  | RW   |
| 610          | Dis-assemble Gun                                               | 9 26 91  | 9 26 91  | RW   |
| 612          | Magnaflux Barrel<br>Action                                     | OCT      | 3 1991   | Ked  |
|              | Magnaflux Bolt                                                 | OCT      | 3 1991   | Ked  |
| 615          | Rollmark Caliber                                               | OCT      | 3 1991   | GS   |
| 617          | Drill and Tap Sight Holes                                      | OCT      | 4 1991   | LB   |
| 618          | Polish Barrel                                                  | OCT      | 4 1991   | WB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 10-18-91 | JH   |
|              | Apply Coating (Bolt)                                           |          | 10-18-91 | JH   |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 10/18/91 | RW   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 10/18/91 | RW   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 10/18/91 | RW   |
|              | D) Oil Firing Pin Ass'y                                        |          | 10/18/91 | RW   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 11-19-91 | JH   |

| op. #        | OP. NAME                                                    | READINGS                      |                               |                               |      |      | DATE     | INIT |
|--------------|-------------------------------------------------------------|-------------------------------|-------------------------------|-------------------------------|------|------|----------|------|
| 625<br>cont. | F) Safety On Force                                          | 3 <sup>3</sup> / <sub>4</sub> | 3 <sup>1</sup> / <sub>2</sub> | 3 <sup>3</sup> / <sub>4</sub> |      |      | 11/14/91 | W/B  |
|              | G) Safety Off Force                                         | 2 <sup>1</sup> / <sub>2</sub> | 2 <sup>1</sup> / <sub>2</sub> | 2 <sup>1</sup> / <sub>2</sub> |      |      | 11/19/91 | W/B  |
|              | H) Trigger Pull Test & Retainability                        |                               |                               |                               |      |      | 11-19-91 | JH   |
|              | I) Firing Pin Indent                                        | .020                          | .020                          | .020                          |      |      | 11/19/91 | W/B  |
|              | J) Assemble Stock                                           |                               |                               |                               |      |      | 11/20/91 | RW   |
|              | K) Assemble Swivel Studs                                    |                               |                               |                               |      |      | 11-26-91 | JH   |
|              | L) Attach Front and Rear Sight Assemblies                   |                               |                               |                               |      |      | 11/20/91 | RW   |
|              | M) Iron Sight Alignment                                     |                               |                               |                               |      |      | 11/20/91 | RW   |
|              | N) Detach Front & Rear Sights & place in numbered container |                               |                               |                               |      |      | 11/20/91 | RW   |
|              | O) Attach Scope to Rifle                                    |                               |                               |                               |      |      | 11/20/91 | RW   |
|              | P) Detach & Attach Scope 20 Times                           |                               |                               |                               |      |      | 11/20/91 | RW   |
| 640          | Gallery Target & Test                                       |                               |                               |                               |      |      | 11-22-91 | AC   |
|              | A) Time                                                     |                               |                               |                               |      |      | 11-22-91 | AC   |
|              | B) Malfunctions                                             |                               |                               |                               |      |      | 11-22-91 | AC   |
|              | C) Pierced Primers                                          |                               |                               |                               |      |      | 11-22-91 | AC   |
|              | D) Optical Clarity of Scope                                 |                               |                               |                               |      |      | 11-22-91 | AC   |
| 645          | Inspect for Live Ammo                                       |                               |                               |                               |      |      | 11-22-91 | AC   |
| 655          | Final Inspection                                            |                               |                               |                               |      |      |          |      |
|              | A) Headspace                                                | 2.53                          | 2.68                          | 2.66                          | 2.67 | 2.35 | 11-26-91 | JH   |
|              | B) Trigger Pull                                             | 286                           | 286                           | 291                           | 294  | 295  | 11-22-91 | D/H  |
|              | C) Function                                                 |                               |                               |                               |      |      | 11-26-91 | JH   |
| 660          | Pack                                                        |                               |                               |                               |      |      | 12-19-91 | NF   |

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6649656

DATE 11-19-91

TESTER JLL

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |                      | COMMENTS          |
|---------|------------------|--------------------------|--------------------------------|----------------------|-------------------|
| PULL #1 | 2.69             | 2.53                     | 2.55                           | <del>2.86</del> 2.53 | MIN. SETTING,     |
| PULL #2 | 2.49             | 2.60                     | 2.58                           | <del>2.86</del> 2.68 | NO AVG. OF 5      |
| PULL #3 | 2.56             | 2.55                     | 2.50                           | <del>2.91</del> 2.66 | READINGS ACCEPT-  |
| PULL #4 | 2.55             | 2.59                     | 2.59                           | <del>2.94</del> 2.67 | ABLE LESS THAN 2# |
| PULL #5 | 2.60             | 2.59                     | 2.60                           | <del>2.95</del> 2.35 |                   |
| TOTAL   |                  |                          |                                |                      |                   |
| AVG.    |                  |                          |                                |                      |                   |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.39             | 3.51                     |  |          |
| PULL #2 | 3.51             | 3.55                     |  |          |
| PULL #3 | 3.55             | 3.43                     |  |          |
| PULL #4 | 3.48             | 3.51                     |  |          |
| PULL #5 | 3.50             | 3.43                     |  |          |
| 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 | 4.52             | 4.40                     |                                | 4.52                                 |
| PULL #2 | 4.44             | 4.42                     |                                | 4.42                                 |
| PULL #3 | 4.46             | 4.44                     |                                | 4.48                                 |
| PULL #4 | 4.30             | 4.45                     |                                | 4.45                                 |
| PULL #5 | 4.45             | 4.47                     |                                | 4.21                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # 06649056  
22 Nov 1991

CENTROIDAL DISTANCES

|        |         |
|--------|---------|
| 0 TO 1 | .201316 |
| 1 TO 2 | .447725 |
| 1 TO 3 | .500402 |
| 1 TO 4 | .534575 |
| 1 TO 5 | .686571 |

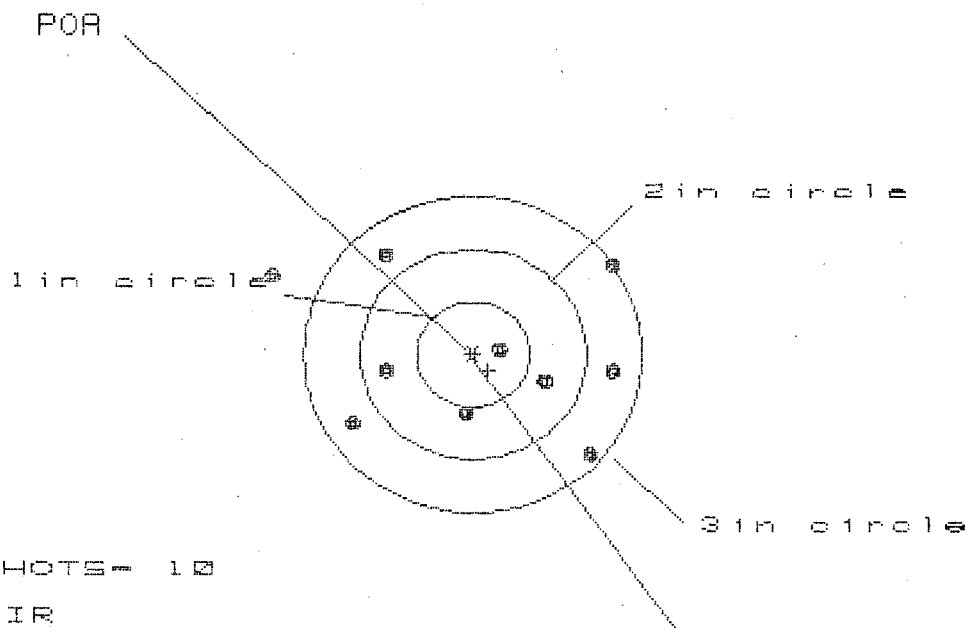
$1^2$   
4.25 <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .271  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0758  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .281401  
THE AMR FOR THIS RIFLE IS: .8478

22 Nov 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C8649056

# CENTERFIRE PATTERNS # 1



# OF SHOTS - 10

# IN CIR

1 in = 1

2 in = 4

3 in = 5

HS = 3.018

VS = 1.886

GS = 3.197

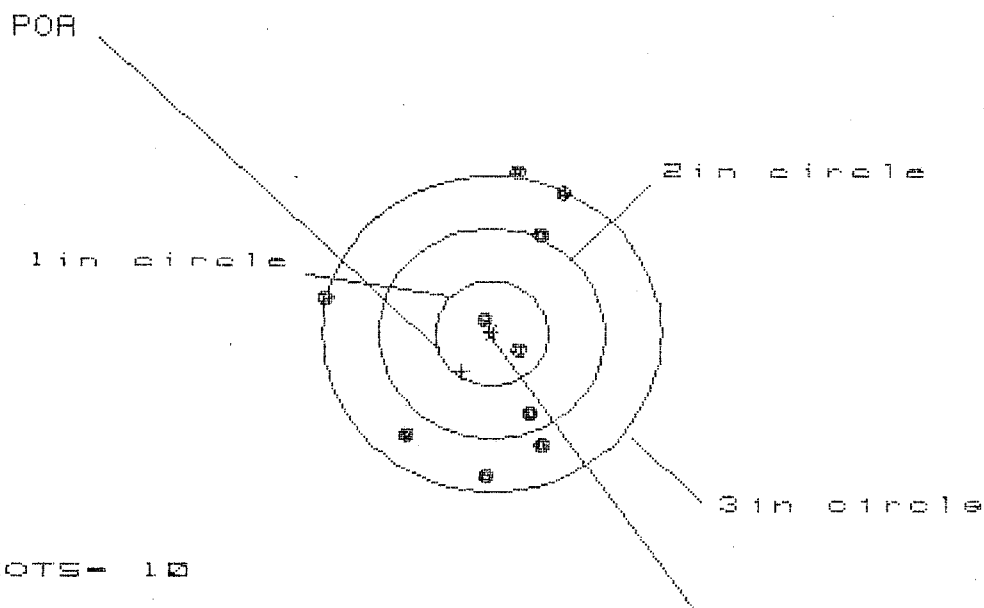
CENTROID #

| PATTERN #                     | 1      | 2      | 3      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.278  | 1.085  | 1.144  |
| MINIMUM X                     | -1.740 | -1.268 | -1.132 |
| MAXIMUM Y                     | .963   | 1.041  | 1.159  |
| MINIMUM Y                     | -.923  | -.845  | -.727  |
| CENTROID X                    | -.132  | .061   | -.075  |
| CENTROID Y                    | .152   | .074   | -.044  |
| POA TO CENTROID in.           | .202   | .096   | .087   |
| MIN RADIUS                    | .281   | .148   | .325   |
| MEAN RADIUS                   | 1.078  | .951   | .888   |
| MAX RADIUS                    | 1.878  | 1.437  | 1.419  |
| HORIZONTAL SPREAD             | 3.018  | 2.353  | 2.276  |
| VERTICAL SPREAD               | 1.886  | 1.886  | 1.886  |
| EXTREME SPREAD                | 3.197  | 2.775  | 2.586  |
| NUMBER IN ONE INCH CIRCLE =   | 1      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 4      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 8      |        |        |

22 Nov 1991

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# CENTERFIRE PATTERNS # 2



# OF SHOTS- 10

# IN CIR

1 in = 2

2 in = 3

3 in = 8

HS= 2.135

VS= 2.849

GS= 2.860

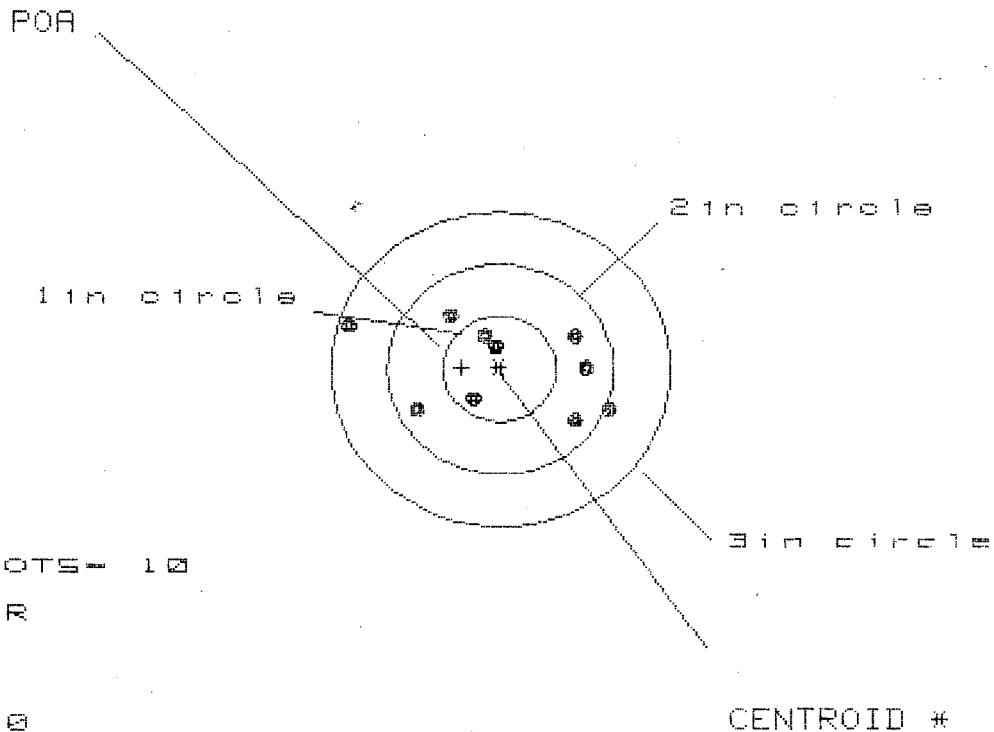
CENTROID #

|                             |   |        |        |        |
|-----------------------------|---|--------|--------|--------|
| PATTERN #                   | : | 2      |        |        |
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | .672   | .509   | .516   |
| MINIMUM X                   | : | -1.463 | -.983  | -.876  |
| MAXIMUM Y                   | : | 1.495  | 1.538  | 1.572  |
| MINIMUM Y                   | : | -1.354 | -1.311 | -1.119 |
| CENTROID X                  | : | .265   | .428   | .421   |
| CENTROID Y                  | : | .359   | .316   | .124   |
| POR TO CENTROID in.         | : | .446   | .532   | .439   |
| MIN RADIUS                  | : | .170   | .128   | .122   |
| MEAN RADIUS                 | : | 1.053  | .982   | .891   |
| MAX RADIUS                  | : | 1.513  | 1.539  | 1.654  |
| HORIZONTAL SPREAD           | : | 2.135  | 1.392  | 1.392  |
| VERTICAL SPREAD             | : | 2.849  | 2.849  | 2.691  |
| EXTREME SPREAD              | : | 2.860  | 2.860  | 2.782  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 3      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 8      |        |

22 Nov 1991

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# CENTERFIRE PATTERNS # 3



# OF SHOTS- 10

# IN CIR

1in = 3

2in = 8

3in = 10

HS= 2.228

VS= 1.019

GS= 2.363

| PATTERN #                     | : | 3      | 9     | 8     |
|-------------------------------|---|--------|-------|-------|
| SHOTS (BEST OF)               | : | 10     | 9     | 8     |
| MAXIMUM X                     | : | .917   | .771  | .686  |
| MINIMUM X                     | : | -1.311 | -.867 | -.770 |
| MAXIMUM Y                     | : | .488   | .530  | .485  |
| MINIMUM Y                     | : | -.531  | -.489 | -.534 |
| CENTROID X                    | : | .339   | .485  | .388  |
| CENTROID Y                    | : | -.017  | -.059 | -.014 |
| POA TO CENTROID in.           | : | .340   | .488  | .389  |
| MIN RADIUS                    | : | .218   | .330  | .236  |
| MEAN RADIUS                   | : | .704   | .632  | .587  |
| MAX RADIUS                    | : | 1.366  | .947  | .880  |
| HORIZONTAL SPREAD             | : | 2.228  | 1.638 | 1.456 |
| VERTICAL SPREAD               | : | 1.019  | 1.019 | 1.019 |
| EXTREME SPREAD                | : | 2.363  | 1.638 | 1.534 |
| NUMBER IN ONE INCH CIRCLE =   | : | 3      |       |       |
| NUMBER IN TWO INCH CIRCLE =   | : | 8      |       |       |
| NUMBER IN THREE INCH CIRCLE = | : | 10     |       |       |

22 Nov 1991

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# CENTERFIRE PATTERNS

# 4

POA

1 in circle

2 in circle

3 in circle

# OF SHOTS- 10

# IN CIR

1 in = 6

2 in = 9

3 in = 10

HSI = 1.596

VS= 1.147

GS= 1.621

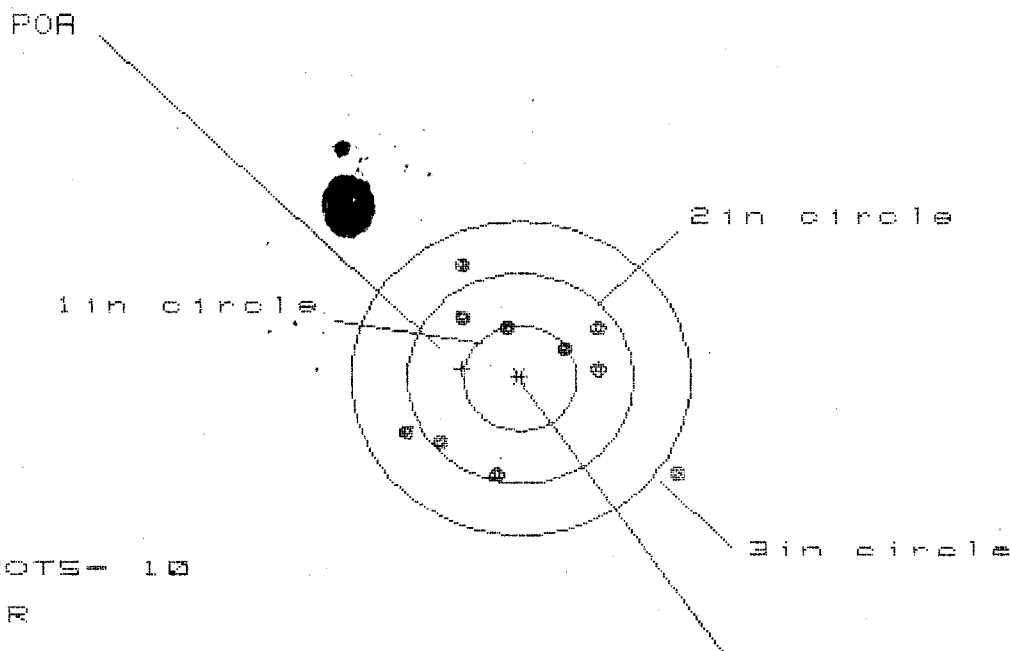
CENTROID \*

| PATTERN #                   | : | 4      |       |       |
|-----------------------------|---|--------|-------|-------|
| SHOTS (BEST OF)             | : | 10     | 9     | 8     |
| MAXIMUM X                   | : | .472   | .347  | .349  |
| MINIMUM X                   | : | -1.124 | -.631 | -.629 |
| MAXIMUM Y                   | : | .731   | .701  | .457  |
| MINIMUM Y                   | : | -.416  | -.446 | -.359 |
| CENTROID X                  | : | .371   | .496  | .493  |
| CENTROID Y                  | : | -.029  | .001  | -.086 |
| POA TO CENTROID in.         | : | .373   | .496  | .501  |
| MIN RADIUS                  | : | .162   | .041  | .079  |
| MEAN RADIUS                 | : | .491   | .378  | .337  |
| MAX RADIUS                  | : | 1.157  | .701  | .642  |
| HORIZONTAL SPREAD           | : | 1.596  | .978  | .978  |
| VERTICAL SPREAD             | : | 1.147  | 1.147 | .815  |
| EXTREME SPREAD              | : | 1.621  | 1.166 | .999  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 6     |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 9     |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 10    |       |

02 Nov 1991

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# CENTERFIRE PATTERNS # 5



# OF SHOTS - 10

# IN CIR

1 in = 1

2 in = 7

3 in = 9

HS = 2.344

VS = 2.073

GS = 2.767

|                               |   |       |        |       |
|-------------------------------|---|-------|--------|-------|
| PATTERN #                     | : | 5     |        |       |
| SHOTS (BEST OF)               | : | 10    | 9      | 8     |
| MAXIMUM X                     | : | 1.449 | .851   | .888  |
| MINIMUM X                     | : | -.995 | -.846  | -.889 |
| MAXIMUM Y                     | : | 1.122 | 1.018  | .592  |
| MINIMUM Y                     | : | -.951 | -1.055 | -.928 |
| CENTROID X                    | : | .512  | .363   | .406  |
| CENTROID Y                    | : | -.086 | .018   | -.109 |
| POA TO CENTROID in.           | : | .520  | .363   | .420  |
| MIN RADIUS                    | : | .431  | .393   | .517  |
| MEAN RADIUS                   | : | .913  | .816   | .787  |
| MAX RADIUS                    | : | 1.644 | 1.075  | .998  |
| HORIZONTAL SPREAD             | : | 2.344 | 1.697  | 1.697 |
| VERTICAL SPREAD               | : | 2.073 | 2.073  | 1.520 |
| EXTREME SPREAD                | : | 2.767 | 2.090  | 1.971 |
| NUMBER IN ONE INCH CIRCLE =   |   |       | 1      |       |
| NUMBER IN TWO INCH CIRCLE =   |   |       | 7      |       |
| NUMBER IN THREE INCH CIRCLE = |   |       | 9      |       |