

FORM

UPC



0 47700 25716 7

BARREL LENGTH

CAPACITY\*

\*INCLUDES 1 IN CHAMBER

C6665902

5716

ORDER NO.

MODEL 700 TM M24

# Remington



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

MODEL 700 <sup>TM</sup> M24

SERIAL NO.

C6665902

ORDER NO.

5716

20

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

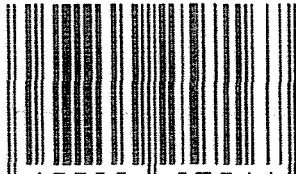


5716 C6665902

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 #

**C6665902**

| OP. #        | OP. NAME                                                       | READINGS                                                                                                  | DATE        | INIT |
|--------------|----------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------|-------------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   | <div style="border: 1px solid black; padding: 10px; text-align: center;"> <b>QUALITY<br/>AUDIT</b> </div> | 9/23/91     | KL   |
| 600          | Proof                                                          |                                                                                                           | 9/23/91     | KL   |
| 607          | Check Headspace                                                |                                                                                                           | 9/23/91     | KL   |
| 610          | Dis-assemble Gun                                               |                                                                                                           | 9/23/91     | KL   |
| 612          | Magnaflux Barrel<br>Action                                     |                                                                                                           | SEP 30 1991 | KR   |
|              | Magnaflux Bolt                                                 |                                                                                                           | SEP 30 1991 | KR   |
| 615          | Rollmark Caliber                                               |                                                                                                           | SEP 30 1991 | LS   |
| 617          | Drill and Tap Sight Holes                                      |                                                                                                           | SEP 30 1991 | LB   |
| 618          | Polish Barrel                                                  |                                                                                                           | OCT 2 1991  | WB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |                                                                                                           | 11/20/91    | JA   |
|              | Apply Coating (Bolt)                                           |                                                                                                           | 11/20/91    | JA   |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |                                                                                                           | 10/8/91     | KL   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |                                                                                                           | 10/8/91     | KL   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |                                                                                                           | 10/8/91     | KL   |
|              | D) Oil Firing Pin Ass'y                                        |                                                                                                           | 10/8/91     | KL   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |                                                                                                           | 10/9/91     | JA   |

| op. #        | OP. NAME                                                    | READINGS |       |       |     |     | DATE     | INIT |
|--------------|-------------------------------------------------------------|----------|-------|-------|-----|-----|----------|------|
| 625<br>cont. | F) Safety On Force                                          | 5        | 5     | 5     |     |     | 10/14/91 | SM   |
|              | G) Safety Off Force                                         | 4        | 4     | 4     |     |     | 10/14/91 | SM   |
|              | H) Trigger Pull Test & Retainability                        |          |       |       |     |     | 10/9/91  | SM   |
|              | I) Firing Pin Indent                                        | .0205    | .0205 | .0205 |     |     | 10/14/91 | SM   |
|              | J) Assemble Stock                                           |          |       |       |     |     | 10/14/91 | SM   |
|              | K) Assemble Swivel Studs                                    |          |       |       |     |     | 10-18-91 | SM   |
|              | L) Attach Front and Rear Sight Assemblies                   |          |       |       |     |     | 10/14/91 | SM   |
|              | M) Iron Sight Alignment                                     |          |       |       |     |     | 10/16/91 | SM   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |       |       |     |     | 10/16/91 | SM   |
|              | O) Attach Scope to Rifle                                    |          |       |       |     |     | 10/16/91 | SM   |
|              | P) Detach & Attach Scope 20 Times                           |          |       |       |     |     | 10/16/91 | SM   |
| 640          | Gallery Target & Test                                       |          |       |       |     |     | 10-17-91 | SM   |
|              | A) Time                                                     |          |       |       |     |     | "        | SM   |
|              | B) Malfunctions                                             |          |       |       |     |     | "        | SM   |
|              | C) Pierced Primers                                          |          |       |       |     |     | "        | SM   |
|              | D) Optical Clarity of Scope                                 |          |       |       |     |     | "        | SM   |
| 645          | Inspect for Live Ammo                                       |          |       |       |     |     | 10-17-91 | SM   |
| 655          | Final Inspection                                            |          |       |       |     |     |          |      |
|              | A) Headspace                                                |          |       |       |     |     | 10-18-91 | SM   |
|              | B) Trigger Pull                                             | 250      | 277   | 278   | 278 | 271 | 10-18-91 | SM   |
|              | C) Function                                                 |          |       |       |     |     | 10-18-91 | SM   |
| 660          | Pack                                                        |          |       |       |     |     | 12-14-91 | SM   |

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS  
2.50# ± .50#  
3.00# ± .75#  
4.00# ± 1.00#

SERIAL NO. C-6665902  
DATE 10-9-91  
TESTER JH

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |     | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|-----|------------------------------------------------------------------------|
| PULL #1 | 2.65             | 2.60                     | 2.55                           | 250 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.61             | 2.64                     | 2.61                           | 277 |                                                                        |
| PULL #3 | 2.60             | 2.63                     | 2.65                           | 278 |                                                                        |
| PULL #4 | 2.68             | 2.64                     | 2.60                           | 278 |                                                                        |
| PULL #5 | 2.65             | 2.65                     | 2.44                           | 271 |                                                                        |
| TOTAL   |                  |                          |                                |     |                                                                        |
| AVG.    |                  |                          |                                |     |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.50             | 3.40                     |  |          |
| PULL #2 | 3.46             | 3.42                     |  |          |
| PULL #3 | 3.43             | 3.43                     |  |          |
| PULL #4 | 3.43             | 3.44                     |  |          |
| PULL #5 | 3.43             | 3.28                     |  |          |
| 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             | 4.36                     |                                | 4.34                                 |
| PULL #2 | 4.35             | 4.35                     |                                | 4.36                                 |
| PULL #3 | 4.35             | 4.34                     |                                | 4.22                                 |
| PULL #4 | 4.33             | 4.36                     |                                | 4.25                                 |
| PULL #5 | 4.33             | 4.38                     |                                | 4.40                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6665902  
18 Oct 1991

CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| 0 TO | 1 | .623238 |
| 1 TO | 2 | .23342  |
| 1 TO | 3 | .850021 |
| 1 TO | 4 | .943615 |
| 1 TO | 5 | .530506 |

100000

<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0618  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0978  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .11569

THE AMR FOR THIS RIFLE IS: 1.023

18 Oct 1991

FILE: \PATTERNING\CENTERFIRE\_PATT\06885902

# CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

# OF SHOTS- 10

# IN CIR

1in - 0

2in - 3

3in - 7

HS= 4.160

VS= 2.490

GS= 4.207

CENTROID \*

PATTERN #

|                             | 10     | 9      | 8      |
|-----------------------------|--------|--------|--------|
| SHOTS (BEST OF)             | 10     | 9      | 8      |
| MAXIMUM X                   | 1.498  | 1.203  | 1.007  |
| MINIMUM X                   | -2.662 | -1.563 | -1.624 |
| MAXIMUM Y                   | 1.286  | 1.329  | 1.184  |
| MINIMUM Y                   | -1.204 | -1.161 | -0.666 |
| CENTROID X                  | -0.295 | 0.000  | 0.196  |
| CENTROID Y                  | -0.549 | -0.592 | -0.447 |
| POA TO CENTROID IN.         | 0.620  | 0.592  | 0.488  |
| MIN RADIUS                  | 0.581  | 0.515  | 0.398  |
| MEAN RADIUS                 | 1.360  | 1.163  | 1.017  |
| MAX RADIUS                  | 2.689  | 1.949  | 1.680  |
| HORIZONTAL SPREAD           | 4.160  | 2.766  | 2.631  |
| VERTICAL SPREAD             | 2.490  | 2.490  | 1.850  |
| EXTREME SPREAD              | 4.207  | 3.162  | 2.632  |
| NUMBER IN ONE INCH CIRCLE   | = 0    |        |        |
| NUMBER IN TWO INCH CIRCLE   | = 3    |        |        |
| NUMBER IN THREE INCH CIRCLE | = 7    |        |        |

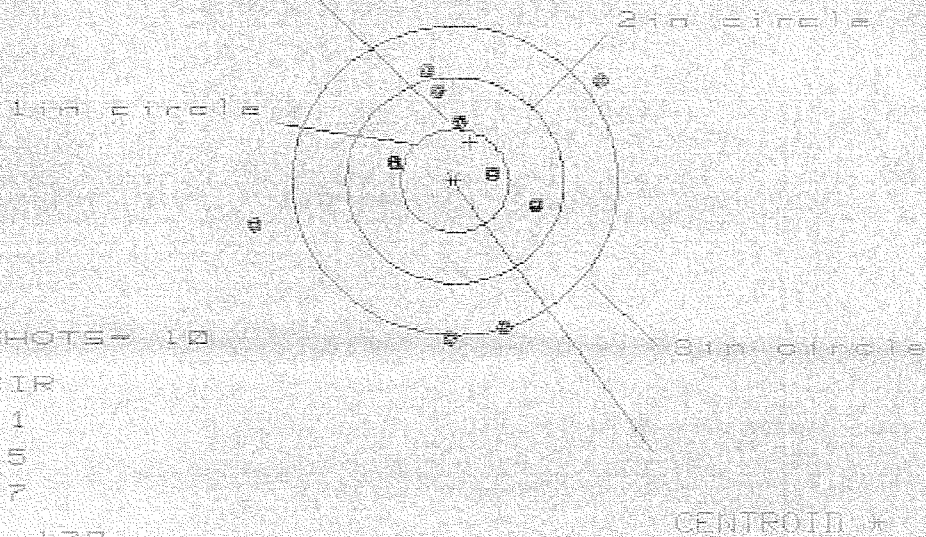


18 Oct 1991

FILE: PATTERNING/CENTERFIRE\_PATT/C6865502

# CENTERFIRE PATTERNS # 2

POA



# OF SHOTS= 10

# IN CIR

1in = 1

2in = 5

3in = 7

HS= 3.179

VS= 2.578

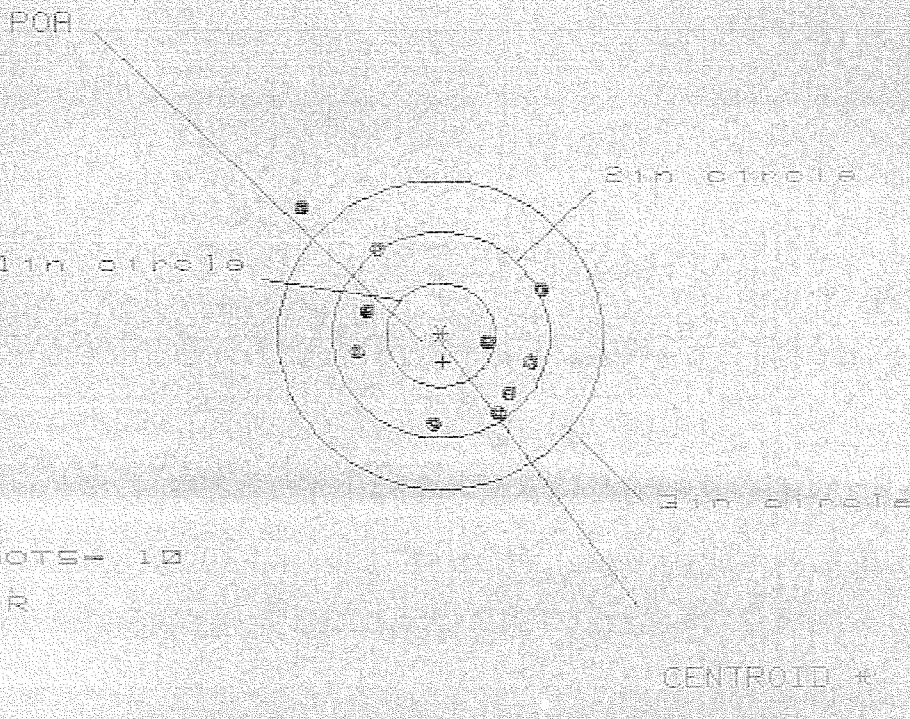
GS= 3.481

| PATTERN #                     | 1      | 2      | 3      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.304  | 1.096  | .692   |
| MINIMUM X                     | -1.875 | -.763  | -.626  |
| MAXIMUM Y                     | 1.030  | .979   | 1.093  |
| MINIMUM Y                     | -1.548 | -1.593 | -1.485 |
| CENTROID X                    | -.144  | .064   | -.073  |
| CENTROID Y                    | -.371  | -.320  | -.434  |
| POA TO CENTROID in.           | .398   | .327   | .440   |
| MIN RADIUS                    | .355   | .143   | .303   |
| MEAN RADIUS                   | 1.082  | .955   | .913   |
| MAX RADIUS                    | 1.930  | 1.619  | 1.490  |
| HORIZONTAL SPREAD             | 3.179  | 1.859  | 1.318  |
| VERTICAL SPREAD               | 2.578  | 2.578  | 2.578  |
| EXTREME SPREAD                | 3.481  | 2.851  | 2.585  |
| NUMBER IN ONE INCH CIRCLE =   |        | 1      |        |
| NUMBER IN TWO INCH CIRCLE =   |        | 5      |        |
| NUMBER IN THREE INCH CIRCLE = |        | 7      |        |

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FILE:/PATTERNING/CENTERFIRE\_PATT/06663982

# CENTERFIRE PATTERNS # 3



# OF SHOTS= 10

# IN CIR

1 in = 1

2 in = 7

3 in = 9

HS= 2.186

VS= 2.080

GS= 2.659

## PATTERN #

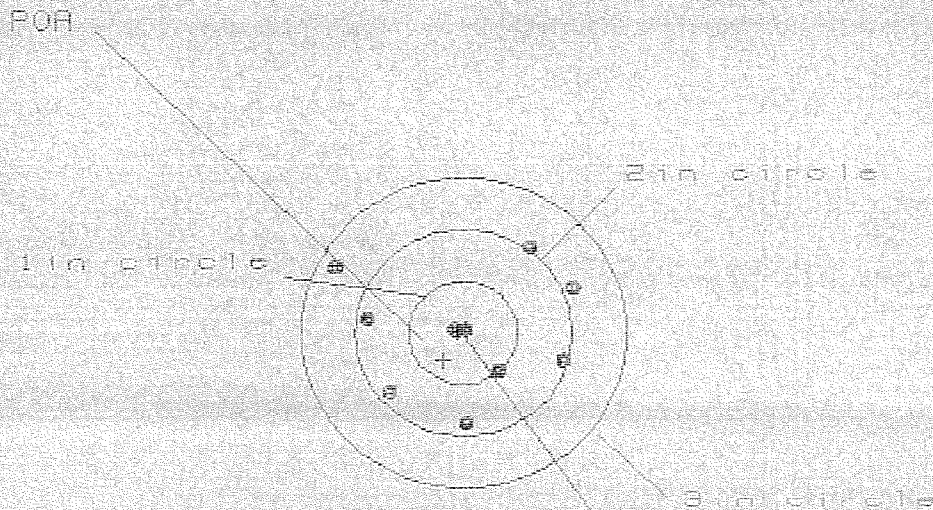
| SHOTS (BEST OF)               | 10     | 9     | 8     |
|-------------------------------|--------|-------|-------|
| MAXIMUM X                     | .953   | .816  | .772  |
| MINIMUM X                     | -1.233 | -.982 | -.800 |
| MAXIMUM Y                     | 1.230  | .986  | 1.052 |
| MINIMUM Y                     | -.850  | -.713 | -.647 |
| CENTROID X                    | -.025  | .112  | .010  |
| CENTROID Y                    | .257   | .120  | .054  |
| POA TO CENTROID in.           | .258   | .165  | .055  |
| MIN RADIUS                    | .438   | .306  | .423  |
| MEAN RADIUS                   | .928   | .798  | .777  |
| MAX RADIUS                    | 1.742  | 1.218 | 1.218 |
| HORIZONTAL SPREAD             | 2.186  | 1.718 | 1.572 |
| VERTICAL SPREAD               | 2.080  | 1.699 | 1.699 |
| EXTREME SPREAD                | 2.659  | 1.957 | 1.957 |
| NUMBER IN ONE INCH CIRCLE =   |        | 1     |       |
| NUMBER IN TWO INCH CIRCLE =   |        | 7     |       |
| NUMBER IN THREE INCH CIRCLE = |        | 9     |       |



18 Oct 1991

FILE: \PATTERNING\CENTERFIRE\_PATT\06685902

# CENTERFIRE PATTERNS # 4



\* OF SHOTS- 10

# IN CIR

1 in = 3

2 in = 8

3 in = 10

HS= 2.157

VS= 1.650

GS= 2.251

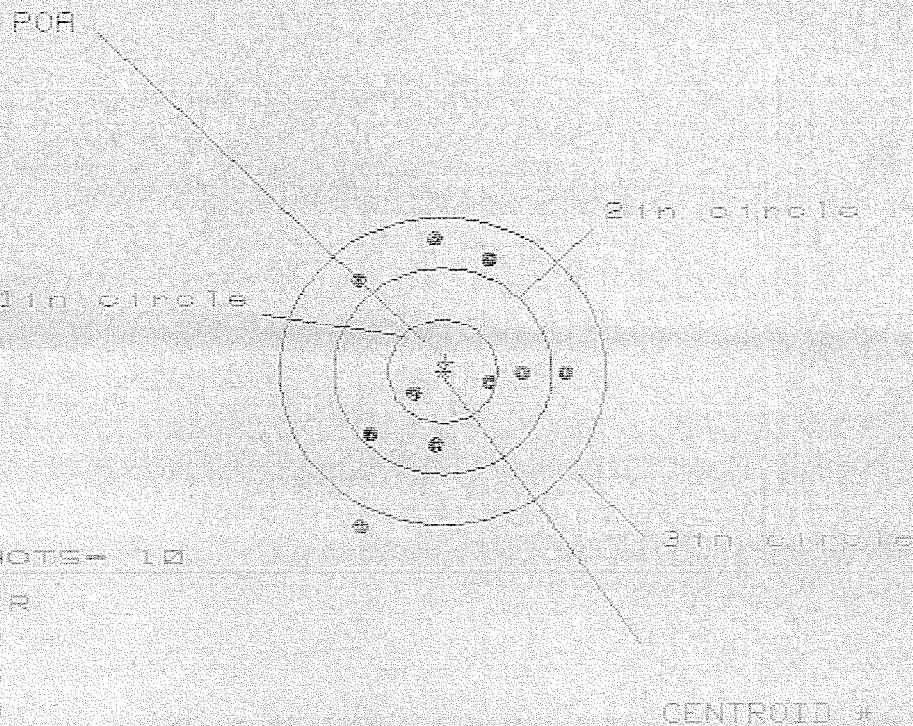
CENTROID \*

| PATTERN #                   | 1      | 4      | 8     |
|-----------------------------|--------|--------|-------|
| SHOTS (BEST OF)             | 10     | 9      | 8     |
| MAXIMUM X                   | 1.019  | .893   | .886  |
| MINIMUM X                   | -1.138 | -1.030 | -.918 |
| MAXIMUM Y                   | .792   | .863   | .921  |
| MINIMUM Y                   | -.858  | -.787  | -.730 |
| CENTROID X                  | .184   | .318   | .198  |
| CENTROID Y                  | .264   | .193   | .136  |
| P0A TO CENTROID in.         | .322   | .365   | .240  |
| MIN RADIUS                  | .056   | .160   | .180  |
| MEAN RADIUS                 | .769   | .710   | .665  |
| MAX RADIUS                  | 1.307  | 1.057  | 1.074 |
| HORIZONTAL SPREAD           | 2.157  | 1.923  | 1.804 |
| VERTICAL SPREAD             | 1.650  | 1.650  | 1.650 |
| EXTREME SPREAD              | 2.251  | 1.993  | 1.800 |
| NUMBER IN ONE INCH CIRCLE   | =      | 3      |       |
| NUMBER IN TWO INCH CIRCLE   | =      | 8      |       |
| NUMBER IN THREE INCH CIRCLE | =      | 10     |       |

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FILE: PATTERNING/CENTERFIRE\_PATT/C6665902

# CENTERFIRE PATTERNS # 5



# OF SHOTS= 10

# IN CIR

1in = 2

2in = 5

3in = 9

HS= 1.945

VS= 2.857

GS= 2.946

| PATTERN #           | 1      | 2     | 3     |
|---------------------|--------|-------|-------|
| SHOTS (BEST OF)     | 10     | 9     | 8     |
| MAXIMUM X           | 1.138  | 1.049 | 1.028 |
| MINIMUM X           | -.807  | -.896 | -.917 |
| MAXIMUM Y           | 1.316  | 1.145 | 1.089 |
| MINIMUM Y           | -1.541 | -.927 | -.784 |
| CENTROID X          | -.029  | .060  | .081  |
| CENTROID Y          | -.090  | .081  | -.062 |
| POA TO CENTROID in. | .095   | .101  | .102  |
| MIN RADIUS          | .288   | .459  | .360  |
| MEAN RADIUS         | .975   | .893  | .830  |
| MAX RADIUS          | 1.736  | 1.157 | 1.261 |
| HORIZONTAL SPREAD   | 1.945  | 1.945 | 1.945 |
| VERTICAL SPREAD     | 2.857  | 2.072 | 1.873 |



|                 |               |       |       |       |
|-----------------|---------------|-------|-------|-------|
| EXTREME         | SPREAD :      | 2.946 | 2.149 | 2.149 |
| NUMBER IN ONE   | INCH CIRCLE = | 2     |       |       |
| NUMBER IN TWO   | INCH CIRCLE = | 5     |       |       |
| NUMBER IN THREE | INCH CIRCLE = | 9     |       |       |