

C6648993

MODEL 700TM M24

Model **SAS**TM

Action

Barrel Length

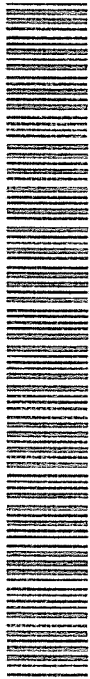
Capacity

Order No. **5715**

* Includes 1 in chamber.

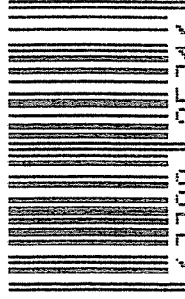
Remington

Remington® 		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700 TH H24		SERIAL NO. C6648993
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.		ORDER NO. 5716



5716 C6648993

UPC



0 47700 25716 7

INTERCHANGEABILITY

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6648993

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	6/27/91	KA
600	Proof		6/27/91	KA
607	Check Headspace		6/27/91	KA
610	Dis-assemble Gun		6/27/91	KA
612	Magnaflux Barrel Action		JUL 18 1991	GS
	Magnaflux Bolt		JUL 18 1991	GS
615	Rollmark Caliber		JUL 18 1991	GS
617	Drill and Tap Sight Holes		JUL 18 1991	LB
618	Polish Barrel		JUL 20 1991	WB
620	Apply Coatings (Barrel Action)		7-01/91	KA
	Apply Coating (Bolt)		7-01/91	KA
625	Final Assembly			
	A) Clean inside of Bolt Assembly		8/22/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/22/91	KA
	C) Inspect Ejector Hole for Chamfer		8/22/91	KA
	D) Oil Firing Pin Ass'y		8/22/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		8/23/91	KA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/2	5 1/2	5			8-23-91	DH
	G) Safety Off Force	2 1/2	2 1/2	2 3/4			8-23-91	DH
	H) Trigger Pull Test & Retainability						8/23/91	JU
	I) Firing Pin Indent	.021	.022	.020			8-23-91	DH
	J) Assemble Stock						8/28/91	KV
	K) Assemble Swivel Studs						8-31-91	DH
	L) Attach Front and Rear Sight Assemblies						8/28/91	KV
	M) Iron Sight Alignment						8/28/91	KV
	N) Detach Front & Rear Sights & place in numbered container						8/28/91	KV
	O) Attach Scope to Rifle						8/28/91	KV
	P) Detach & Attach Scope 20 Times						8/28/91	KV
640	Gallery Target & Test						8-29-91	AC
	A) Time						8-29-91	AC
	B) Malfunctions						8-29-91	AC
	C) Pierced Primers						8-29-91	AC
	D) Optical Clarity of Scope						8-29-91	AC
645	Inspect for Live Ammo						8-29-91	AC
655	Final Inspection						8-31-91	DH
	A) Headspace						8-31-91	DH
	B) Trigger Pull	2.44	2.25	2.31	2.29	2.46	8-29-91	DH
	C) Function						8-31-91	DH
660	Pack						9-17-91	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. 0-6648993

DATE 8/23/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.48	2.36	2.20	2.44	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.26	2.42	2.22	2.25	
PULL #3	2.23	2.45	2.30	2.31	
PULL #4	2.36	2.29	2.28	2.29	
PULL #5	2.32	2.23	2.20	2.46	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.31	3.40		
PULL #2	3.25	3.29		
PULL #3	3.25	3.42		
PULL #4	3.31	3.20		
PULL #5	3.38	3.20		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.24	4.46		4.41
PULL #2	4.24	4.44		4.43
PULL #3	4.59	4.41		4.46
PULL #4	4.61	4.44		4.47
PULL #5	4.60	4.42		4.49
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06648993
29 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.231138
1 TO	2	.360606
1 TO	3	.0784347
1 TO	4	.331747
1 TO	5	.47102

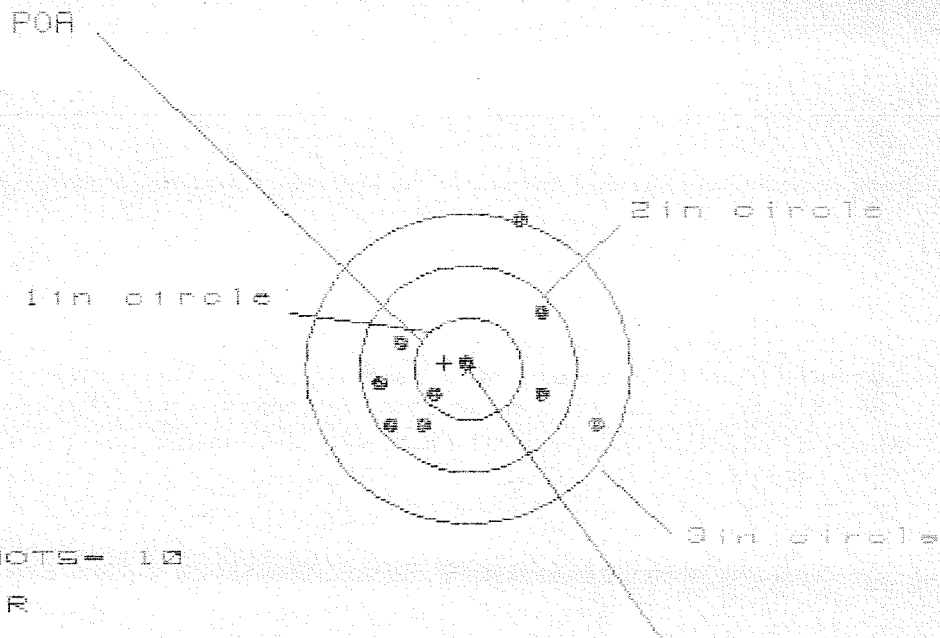
5 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0126
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1222
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .122848
THE AMR FOR THIS RIFLE IS: .8574

29 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6648993

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 2

2in = 8

3in = 9

HS= 2.018

VS= 2.021

GS= 2.346

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.198	1.254	.865
MINIMUM X	:	-.820	-.764	-.607
MAXIMUM Y	:	1.430	.691	.643
MINIMUM Y	:	-.591	-.432	-.480
CENTROID X	:	.224	.168	.011
CENTROID Y	:	-.057	-.216	-.168
POR TO CENTROID in.	:	.231	.274	.168
MIN RADIUS	:	.075	.237	.195
MEAN RADIUS	:	.893	.710	.600
MAX RADIUS	:	1.515	1.312	1.071
HORIZONTAL SPREAD	:	2.018	2.018	1.472
VERTICAL SPREAD	:	2.021	1.123	1.123
EXTREME SPREAD	:	2.346	2.056	1.777
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

29 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8846393

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 9

HS = 2.247

VS = 2.271

GS = 2.599

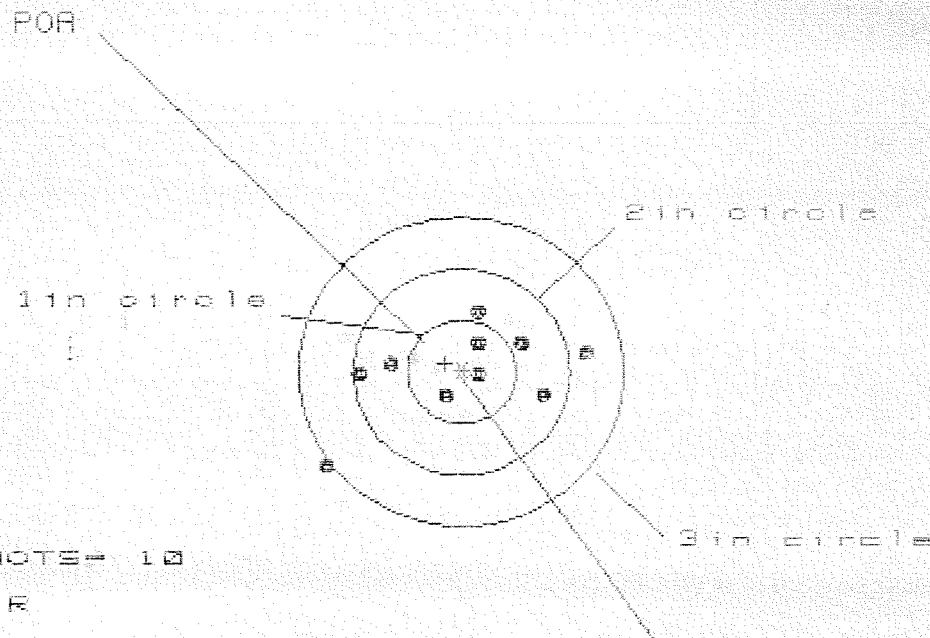
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	6
MAXIMUM X	1.208	1.092	.647
MINIMUM X	-1.039	-.981	-.844
MAXIMUM Y	1.098	.968	.936
MINIMUM Y	-1.173	-.655	-.687
CENTROID X	-.135	-.019	-.156
CENTROID Y	-.023	.107	.139
POA TO CENTROID in.	.137	.109	.209
MIN RADIUS	.265	.159	.193
MEAN RADIUS	.788	.692	.631
MAX RADIUS	1.567	1.123	.967
HORIZONTAL SPREAD	2.247	2.073	1.491
VERTICAL SPREAD	2.271	1.623	1.623
EXTREME SPREAD	2.599	2.116	1.639
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

29 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08648993

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 3

2in = 8

3in = 9

HS = 2.389

VS = 1.507

CS = 2.625

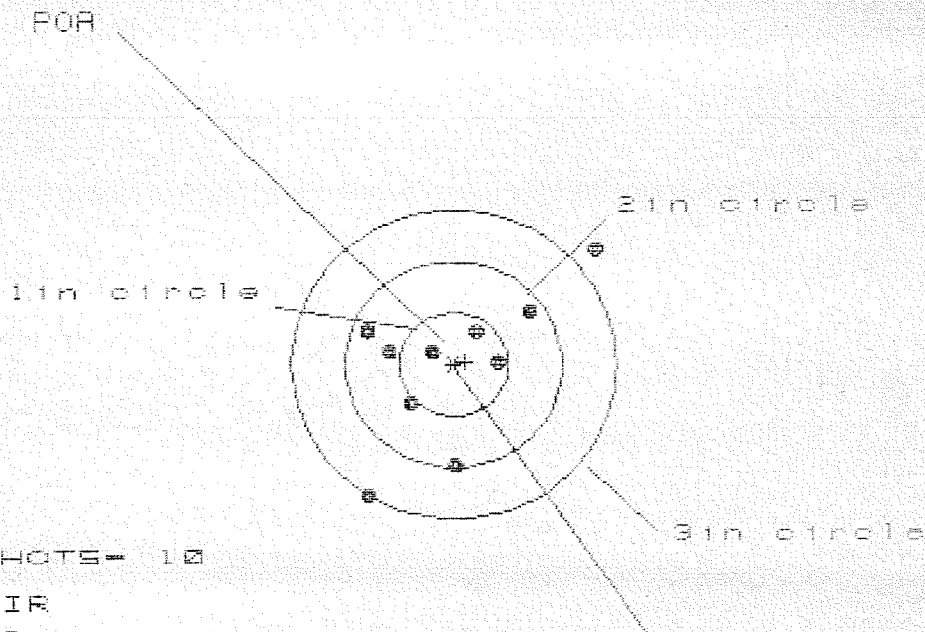
CENTROID *

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.173	1.038	.733
MINIMUM X	-1.216	-1.095	-.966
MAXIMUM Y	.607	.507	.517
MINIMUM Y	-.900	-.296	-.286
CENTROID X	.150	.285	.156
CENTROID Y	-.003	.017	.007
POA TO CENTROID in.	.171	.286	.156
MIN RADIUS	.188	.141	.198
MEAN RADIUS	.701	.584	.534
MAX RADIUS	1.513	1.100	.978
HORIZONTAL SPREAD	2.389	2.133	1.699
VERTICAL SPREAD	1.507	.803	.803
EXTREME SPREAD	2.625	2.148	1.703
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	9		

29 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8646993

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 8

3 in = 8

HS= 2.113

VS= 2.452

GS= 3.237

CENTROID #

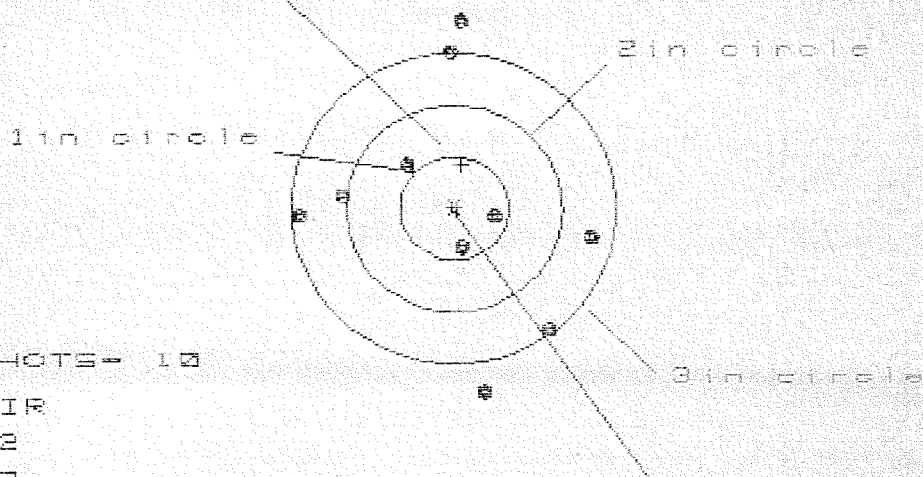
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.314	.889	.908
MINIMUM X	:	-.799	-.653	-.727
MAXIMUM Y	:	1.151	.673	.526
MINIMUM Y	:	-1.301	-1.173	-.969
CENTROID X	:	-.106	-.252	-.171
CENTROID Y	:	-.023	-.151	-.004
POA TO CENTROID in.	:	.109	.294	.171
MIN RADIUS	:	.216	.281	.160
MEAN RADIUS	:	.821	.713	.609
MAX RADIUS	:	1.747	1.342	.973
HORIZONTAL SPREAD	:	2.113	1.542	1.535
VERTICAL SPREAD	:	2.452	1.846	1.495
EXTREME SPREAD	:	3.237	2.405	1.639
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		8	

29 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8646993

CENTERFIRE PATTERNS # 5

POA



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 3

3 in = 5

HS= 2.711

VS= 3.616

GS= 3.624

CENTROID *

PATTERN # : 5

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.246	1.277	1.286
MINIMUM X	:	-1.465	-1.434	-1.425
MAXIMUM Y	:	1.814	1.613	1.496
MINIMUM Y	:	-1.802	-1.327	-1.125
CENTROID X	:	-.070	-.101	-.110
CENTROID Y	:	-.425	-.224	-.426
POA TO CENTROID in.	:	.430	.246	.440
MIN RADIUS	:	.382	.421	.404
MEAN RADIUS	:	1.174	1.102	1.013
MAX RADIUS	:	1.825	1.627	1.487
HORIZONTAL SPREAD	:	2.711	2.711	2.711
VERTICAL SPREAD	:	3.616	2.940	2.611
EXTREME SPREAD	:	3.624	3.067	2.760
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6648993
14 Sep 1991

CENTROIDAL DISTANCES

0 TO 1	.035805
1 TO 2	.157429
1 TO 3	.158685
1 TO 4	.0575847
1 TO 5	.250863

-----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0424
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.025
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0492215

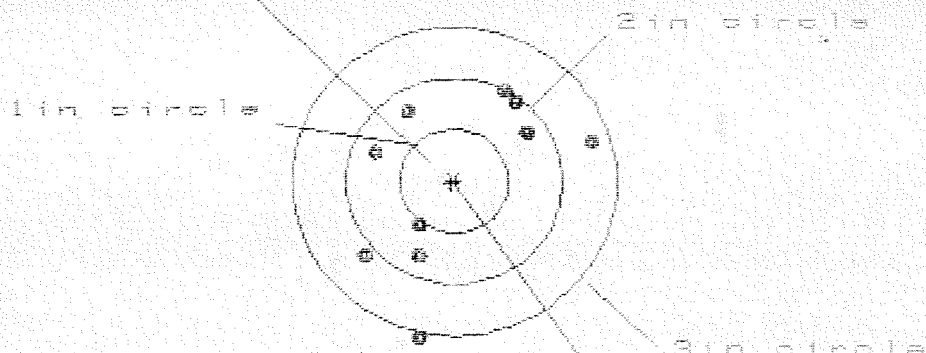
THE AMR FOR THIS RIFLE IS: 1.07

14 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C884B993.1

CENTERFIRE PATTERNS # 1

POA



OF SHOTS - 10

IN CIR

1in = 0

2in = 7

3in = 9

HS = 2.063

VS = 2.383

GS = 2.523

CENTROID *

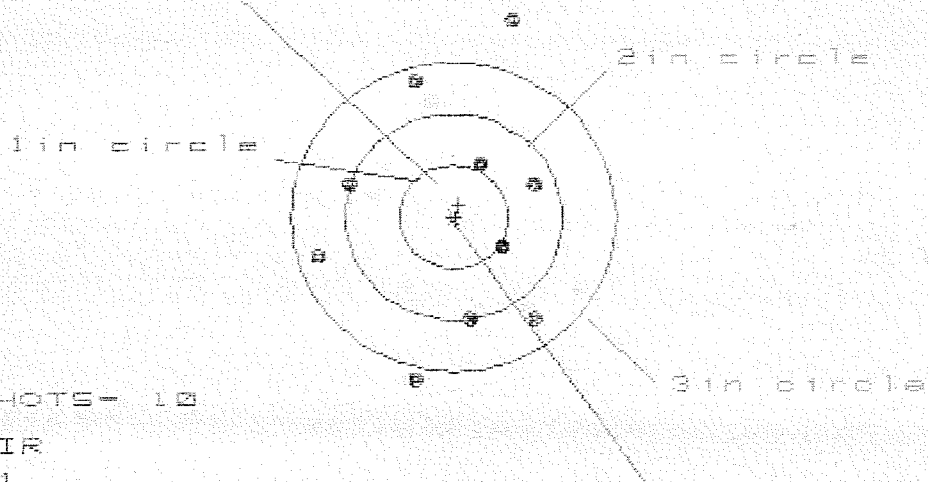
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.242	1.202	.826
MINIMUM X	-.821	-.861	-.711
MAXIMUM Y	.876	.709	.736
MINIMUM Y	-1.507	-.934	-.907
CENTROID X	.029	.069	-.081
CENTROID Y	.021	.188	.162
POA TO CENTROID in.	.036	.201	.181
MIN RADIUS	.534	.685	.616
MEAN RADIUS	.969	.888	.833
MAX RADIUS	1.551	1.271	1.153
HORIZONTAL SPREAD	2.063	2.063	1.537
VERTICAL SPREAD	2.383	1.643	1.643
EXTREME SPREAD	2.523	2.361	2.085
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

14 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8648983.1

CENTERFIRE PATTERNS # 2

POR



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS= 1.991

VS= 3.503

GS= 3.623

CENTROID

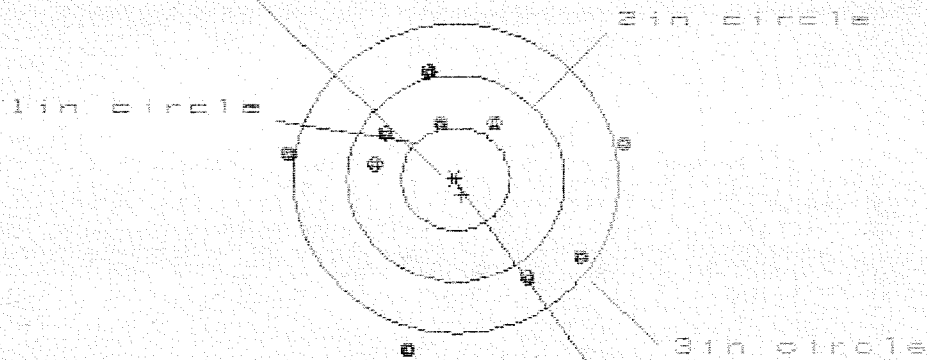
PATTERN #	2
SHOTS (BEST OF)	10
MAXIMUM X	.776
MINIMUM X	-1.215
MAXIMUM Y	1.877
MINIMUM Y	-1.626
CENTROID X	-.049
CENTROID Y	-.119
POR TO CENTROID in.	.126
MIN RADIUS	.499
MEAN RADIUS	1.134
MAX RADIUS	1.949
HORIZONTAL SPREAD	1.991
VERTICAL SPREAD	3.503
EXTREME SPREAD	3.623
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	8

14 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6640993.1

CENTERFIRE PATTERNS # 3

POA



OF SHOTS = 10

IN CIR

1in = 0

2in = 4

3in = 7

HS = 3.042

VS = 2.708

GS = 3.043

CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.514	1.469	1.329
MINIMUM X	:	-1.528	-1.573	-1.398
MAXIMUM Y	:	1.074	.893	.916
MINIMUM Y	:	-1.634	-1.183	-1.160
CENTROID X	:	-.056	-.011	-.194
CENTROID Y	:	.155	.336	.313
POA TO CENTROID in.	:	.165	.337	.368
MIN RADIUS	:	.523	.365	.354
MEAN RADIUS	:	1.121	1.019	.935
MAX RADIUS	:	1.684	1.576	1.597
HORIZONTAL SPREAD	:	3.042	3.042	2.710
VERTICAL SPREAD	:	2.708	2.076	2.076
EXTREME SPREAD	:	3.043	3.043	2.893
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

14 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B4B353.1

CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 1

2 in = 5

3 in = 7

HS = 3.044

VS = 3.567

GS = 3.579

CENTROID #

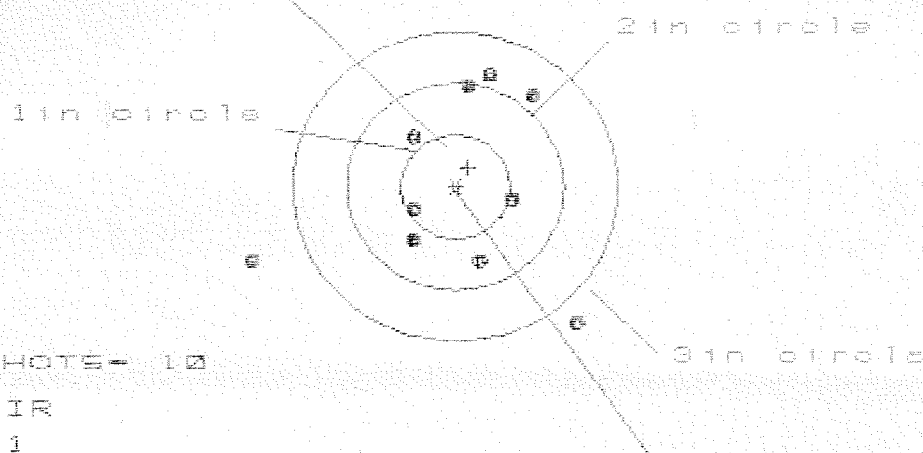
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.754	1.836	1.963
MINIMUM X	:	-1.290	-1.208	-1.141
MAXIMUM Y	:	1.773	1.163	.963
MINIMUM Y	:	-1.794	-1.597	-.984
CENTROID X	:	-.025	-.107	-.174
CENTROID Y	:	.001	-.196	.004
POA TO CENTROID in.	:	.025	.223	.174
MIN RADIUS	:	.255	.462	.301
MEAN RADIUS	:	1.144	1.036	.928
MAX RADIUS	:	1.923	1.976	1.976
HORIZONTAL SPREAD	:	3.044	3.044	3.044
VERTICAL SPREAD	:	3.567	2.760	1.867
EXTREME SPREAD	:	3.579	3.078	3.078
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

14 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6648353.1

CENTERFIRE PATTERNS # 5

POA



OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 8

HS= 3.011

VS= 2.369

GS= 3.075

CENTROID #

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.140	.932	.587
MINIMUM X	-1.871	-.608	-.492
MAXIMUM Y	1.073	.999	.828
MINIMUM Y	-1.296	-1.370	-.954
CENTROID X	-.117	.091	-.025
CENTROID Y	-.183	-.109	.062
POA TO CENTROID in.	.217	.142	.067
MIN RADIUS	.387	.378	.516
MEAN RADIUS	.984	.867	.748
MAX RADIUS	1.988	1.657	.958
HORIZONTAL SPREAD	3.011	1.540	1.079
VERTICAL SPREAD	2.369	2.369	1.782
EXTREME SPREAD	3.075	2.505	1.789
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	