

C6636210

MODEL 700™ M24

Model **SAS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington®  REG. U.S. PAT. & TM. OFF.

MODEL 700™ M24

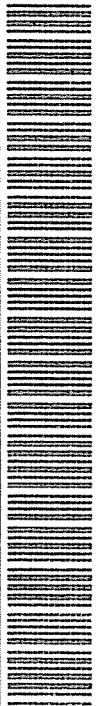
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

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

SERIAL NO.
C6636210

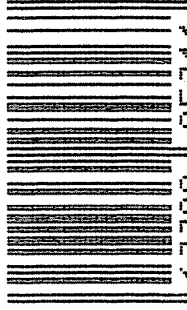
ORDER NO.
5716

20



5716 C6636210

UPC



0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636210

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/27/91	KL
600	Proof		6/27/91	KL
607	Check Headspace		6/27/91	KL
610	Dis-assemble Gun		6/27/91	KL
612	Magnaflux Barrel Action		JUL 2 1991	KR
	Magnaflux Bolt		JUL 2 1991	KR
615	Rollmark Caliber		JUL 22 1991	KR
617	Drill and Tap Sight Holes		JUL 2 1991	FB
618	Polish Barrel		JUL 7 1991	WB
620	Apply Coatings (Barrel Action)		8-6-91	KL
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/19/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/19/91	KL
	C) Inspect Ejector Hole for Chamfer		8/19/91	KL
	D) Oil Firing Pin Ass'y		8/19/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		8/20/91	KL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8/20/91	JK
	G) Safety Off Force	4	4	4			8/20/91	JK
	H) Trigger Pull Test & Retainability						8/20/91	JK
	I) Firing Pin Indent						8/20/91	JK
	J) Assemble Stock						8/22/91	JK
	K) Assemble Swivel Studs						8/20/91	JK
	L) Attach Front and Rear Sight Assemblies						8/20/91	JK
	M) Iron Sight Alignment						8/20/91	JK
	N) Detach Front & Rear Sights & place in numbered container						8/20/91	JK
	O) Attach Scope to Rifle						8/20/91	JK
	P) Detach & Attach Scope 20 Times						8/20/91	JK
640	Gallery Target & Test						8-21-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						8-21-91	NF
655	Final Inspection							
	A) Headspace						8/22/91	JK
	B) Trigger Pull	2.66	2.62	2.55	2.64	2.65	8/22/91	JK
	C) Function						8/22/91	JK
660	Pack						9-19-91	NF

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636210
23 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.0594643
1 TO	2	.203593
1 TO	3	.210297
1 TO	4	.157153
1 TO	5	.136125

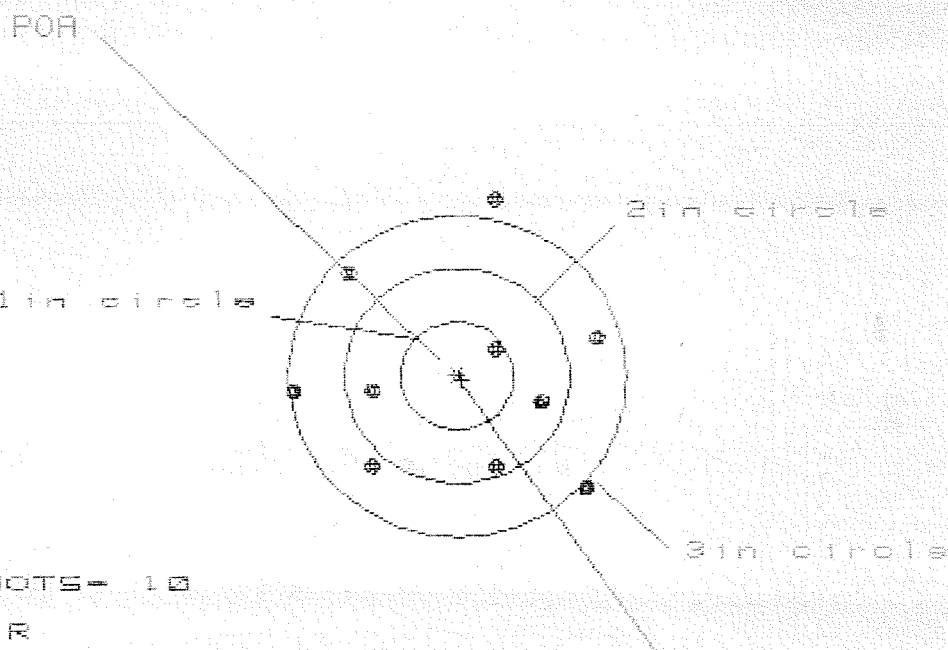
83 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0498
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0418
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0650175
THE AMR FOR THIS RIFLE IS: .9814

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08636210

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS= 2.700

VS= 2.647

GS= 2.847

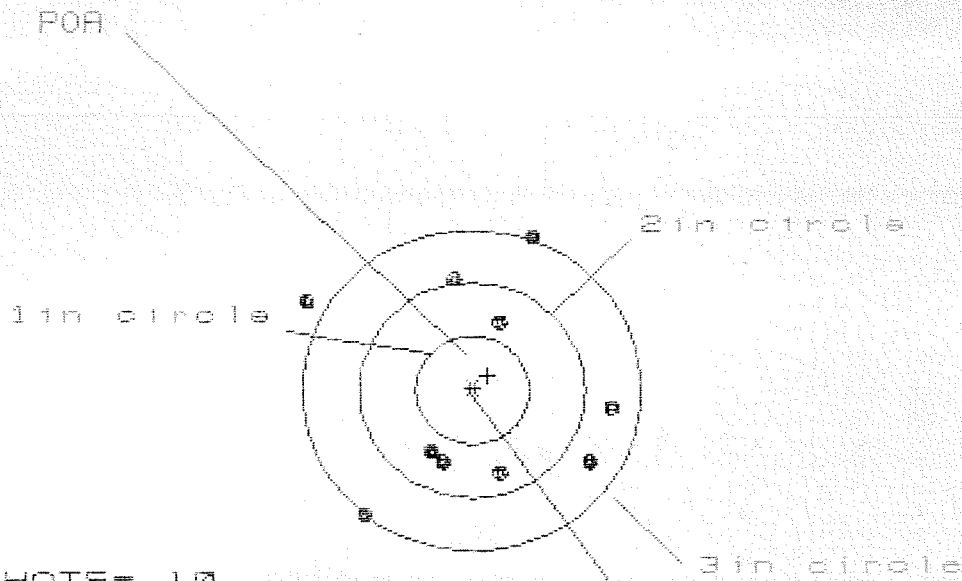
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.230	1.263	1.405
MINIMUM X	:	-1.470	-1.437	-1.295
MAXIMUM Y	:	1.627	1.120	1.015
MINIMUM Y	:	-1.020	-.839	-.802
CENTROID X	:	-.040	-.073	-.215
CENTROID Y	:	.044	-.137	-.032
POA TO CENTROID in.	:	.059	.155	.217
MIN RADIUS	:	.413	.565	.599
MEAN RADIUS	:	1.129	1.059	1.010
MAX RADIUS	:	1.653	1.455	1.474
HORIZONTAL SPREAD	:	2.700	2.700	2.700
VERTICAL SPREAD	:	2.647	1.959	1.817
EXTREME SPREAD	:	2.847	2.847	2.750
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 0

2in = 4

3in = 7

HS= 2.661

VS= 2.670

GS= 3.078

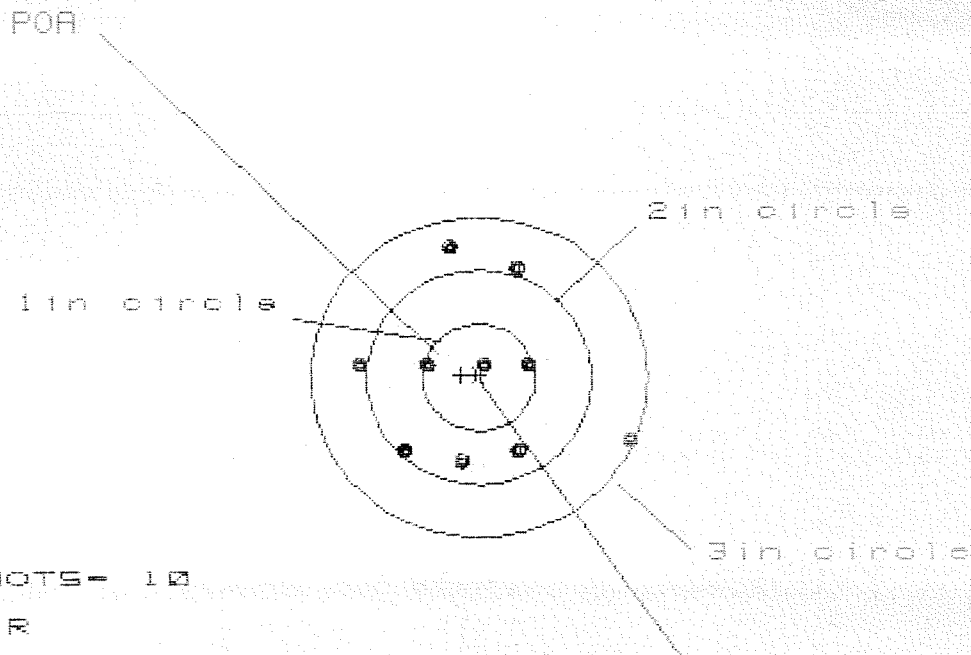
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.204	1.042	1.088
MINIMUM X	-1.457	-1.161	-1.115
MAXIMUM Y	1.474	1.563	1.315
MINIMUM Y	-1.196	-1.107	-0.911
CENTROID X	-0.137	.025	-0.021
CENTROID Y	-0.135	-0.224	-0.420
POA TO CENTROID in.	.192	.226	.420
MIN RADIUS	.627	.650	.475
MEAN RADIUS	1.120	1.040	.933
MAX RADIUS	1.664	1.606	1.440
HORIZONTAL SPREAD	2.661	2.203	2.203
VERTICAL SPREAD	2.670	2.670	2.226
EXTREME SPREAD	3.078	3.076	2.447
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		7	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 10

HS= 2.347

VS= 2.013

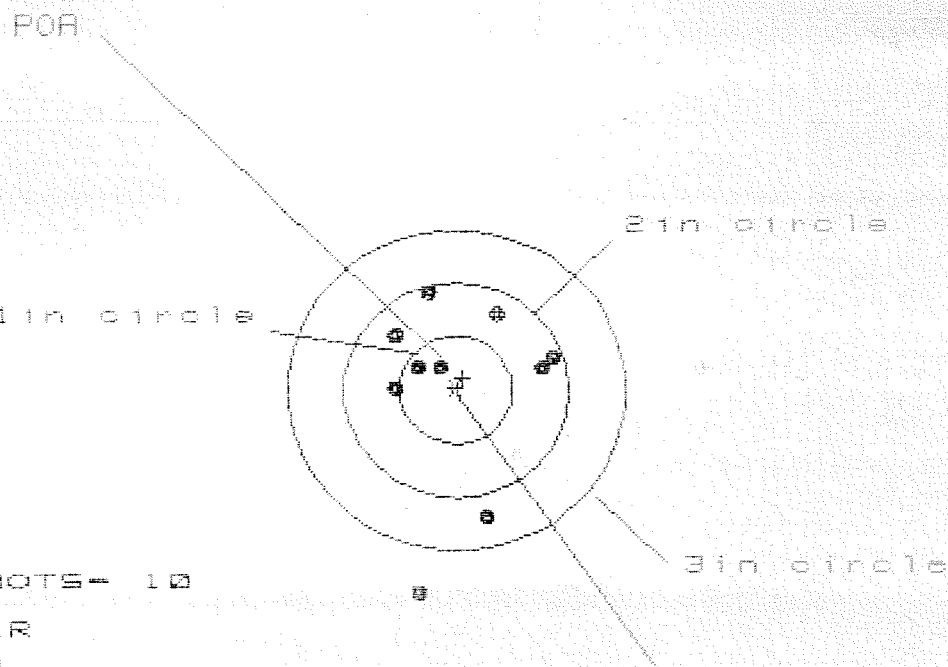
GS= 2.454

PATTERN #	3	3	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.328	.622	.607
MINIMUM X	-1.027	-.880	-.895
MAXIMUM Y	1.258	1.189	1.090
MINIMUM Y	-.763	-.824	-.676
CENTROID X	.160	.013	.028
CENTROID Y	-.021	.040	-.108
POA TO CENTROID in.	.161	.043	.112
MIN RADIUS	.147	.237	.299
MEAN RADIUS	.844	.774	.712
MAX RADIUS	1.431	1.195	1.198
HORIZONTAL SPREAD	2.347	1.502	1.502
VERTICAL SPREAD	2.013	2.013	1.766
EXTREME SPREAD	2.454	2.046	2.018
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 8

3in = 9

HS= 1.431

VS= 2.889

GS= 2.895

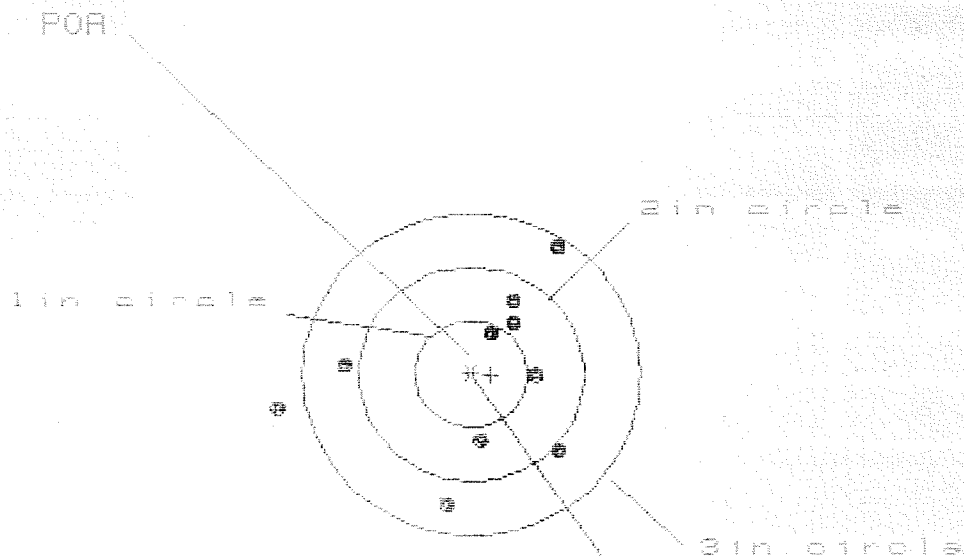
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.876	.834	.860
MINIMUM X	:	-.555	-.597	-.571
MAXIMUM Y	:	.952	.737	.567
MINIMUM Y	:	-1.937	-1.357	-.398
CENTROID X	:	-.059	-.017	-.043
CENTROID Y	:	-.112	.103	.273
POA TO CENTROID in.	:	.127	.105	.276
MIN RADIUS	:	.255	.193	.245
MEAN RADIUS	:	.855	.683	.576
MAX RADIUS	:	1.974	1.373	.861
HORIZONTAL SPREAD	:	1.431	1.431	1.431
VERTICAL SPREAD	:	2.889	2.094	.965
EXTREME SPREAD	:	2.895	2.142	1.474
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 2.538

VS= 2.377

GS= 2.946

CENTROID #

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.769	.572	.634
MINIMUM X	-1.769	-1.313	-1.241
MAXIMUM Y	1.155	1.118	.827
MINIMUM Y	-1.222	-1.259	-1.128
CENTROID X	-.173	.024	-.048
CENTROID Y	.015	.052	-.087
POR TO CENTROID in.	.173	.058	.099
MIN RADIUS	.409	.313	.427
MEAN RADIUS	.959	.816	.778
MAX RADIUS	1.802	1.323	1.261
HORIZONTAL SPREAD	2.538	1.885	1.875
VERTICAL SPREAD	2.377	2.377	1.947
EXTREME SPREAD	2.946	2.570	2.038
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 0-6636210

DATE 8/20/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.36	2.36	2.20	2.66	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.35	2.25	2.38	2.62	
PULL #3	2.35	2.39	2.36	2.55	
PULL #4	2.34	2.35	2.38	2.64	
PULL #5	2.34	2.34	2.25	2.65	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.42	3.31		
PULL #2	3.42	3.36		
PULL #3	3.43	3.37		
PULL #4	3.43	3.37		
PULL #5	3.44	3.37		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.61	4.57		4.55
PULL #2	4.49	4.50		4.54
PULL #3	4.42	4.59		4.51
PULL #4	4.46	4.50		4.52
PULL #5	4.53	4.49		4.55
TOTAL				
AVG.				