

C6648945

MODEL 700™ M24

Model **SAS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

MOD. _____ GA. _____ GUN# 6648945
 CAL. _____ # 6648945

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st	Shaver cross ejector stick	RW
	2nd 9/12/91	Repaired it for DICK (my Pal)	<u>KS</u>
	3rd	100 Rd test OK	
	4th	9-13-91	AL
		FUNCTION	RD 6654 Rev 1

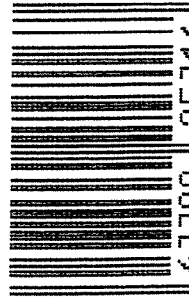
TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

Remington REG. U.S. PAT. & TM. OFF.		DU PONT VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.	
MODEL 700TM M24		SERIAL NO. C6648945	
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.		ORDER NO. 5716	



5716 C6648945

LIPC



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CONTRACT # DAAA21-87-C-0086

GFM

GUN SERIAL # C6648945

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 2	9 1	RW
600	Proof	7 2	9 1	RW
607	Check Headspace	7 2	9 1	RW
610	Dis-assemble Gun	7 2	9 1	RW
612	Magnaflux Barrel Action		JUL 22 1991	YS
	Magnaflux Bolt		JUL 22 1991	YS
615	Rollmark Caliber		JUL 22 1991	YS
617	Drill and Tap Sight Holes		JUL 22 1991	LB
618	Polish Barrel		8/22/91	WB
620	Apply Coatings (Barrel Action)		8-22-91	LB
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/28/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/28/91	RW
	C) Inspect Ejector Hole for Chamfer		8/28/91	RW
	D) Oil Firing Pin Ass'y		8/28/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/29/91	YS

op. #	BARBER M24 0033627	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7	7	7			8-29-91	DH
	G) Safety Off Force	2	2 3/4	2 3/4			8-29-91	DH
	H) Trigger Pull Test & Retainability						8/29/91	SH
	I) Firing Pin Indent	.021	.023	.022			8-29-91	DH
	J) Assemble Stock						8/31/91	RW
	K) Assemble Swivel Studs						9-13-91	AC
	L) Attach Front and Rear Sight Assemblies						8/31/91	RW
	M) Iron Sight Alignment						8/31/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/31/91	RW
	O) Attach Scope to Rifle						8/31/91	RW
	P) Detach & Attach Scope 20 Times						8/30/91	RW
640	Gallery Target & Test						9-3-91	DH
	A) Time						9-3-91	DH
	B) Malfunctions						9-3-91	DH
	C) Pierced Primers						9-3-91	DH
	D) Optical Clarity of Scope						9-3-91	DH
645	Inspect for Live Ammo						9-3-91	DH
655	Final Inspection							
	A) Headspace						9-13-91	AC
	B) Trigger Pull	2.42	2.54	2.47	2.45	2.46	9/13/91	SH
	C) Function						9-13-91	AC
660	Pack						9-19-91	AC

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6648945DATE 8/29/91TESTER JL.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.50	2.47	2.30	2.42	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.38	2.39	2.36	2.34	
PULL #3	2.42	2.35	2.33	2.47	
PULL #4	2.46	2.36	2.30	2.45	
PULL #5	2.43	2.33	2.31	2.46	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.56	3.59		
PULL #2	3.45	3.49		
PULL #3	3.42	3.36		
PULL #4	3.44	3.50		
PULL #5	3.47	3.49		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.25	4.37		4.22
PULL #2	4.34	4.24		4.20
PULL #3	4.39	4.22		4.23
PULL #4	4.27	4.18		4.19
PULL #5	4.27	4.21		4.22
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6648945
3 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.237622
1 TO	2	.270007
1 TO	3	.398769
1 TO	4	.210319
1 TO	5	.428348

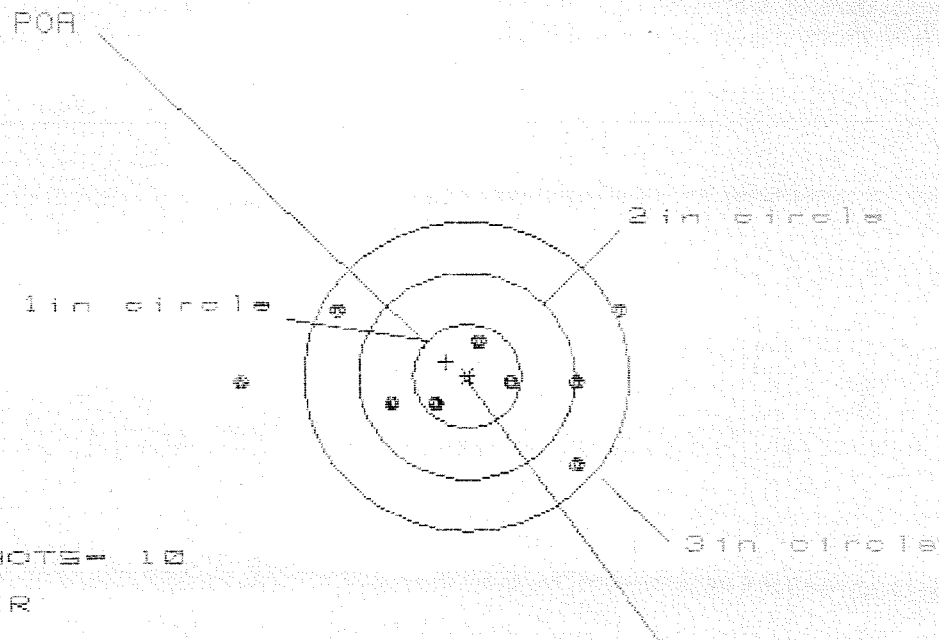
5
14
3 (----POI

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1424
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1614
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .215239
THE AMR FOR THIS RIFLE IS: 1.067

3 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C804B945

CENTERFIRE PATTERNS # 1



HS= 3.491

VS= 1.532

GS= 3.545

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.430	1.201	.962
MINIMUM X	-2.861	-1.440	-1.290
MAXIMUM Y	.655	.653	.728
MINIMUM Y	-.877	-.879	-.804
CENTROID X	.192	.421	.271
CENTROID Y	-.140	-.138	-.213
POA TO CENTROID in.	.238	.443	.345
MIN RADIUS	.353	.131	.207
MEAN RADIUS	.959	.787	.733
MAX RADIUS	2.861	1.581	1.481
HORIZONTAL SPREAD	3.491	2.641	2.252
VERTICAL SPREAD	1.532	1.532	1.532
EXTREME SPREAD	3.545	2.656	2.656
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

3 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06648945

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 1

2in = 4

3in = 8

HS= 3.129

VS= 1.756

GS= 3.135

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.464	1.279	1.282
MINIMUM X	-1.665	-1.356	-1.196
MAXIMUM Y	.989	.928	.827
MINIMUM Y	-.767	-.828	-.929
CENTROID X	-.058	.127	-.033
CENTROID Y	-.242	-.181	-.079
POA TO CENTROID in.	.249	.221	.086
MIN RADIUS	.174	.363	.253
MEAN RADIUS	1.134	1.041	.978
MAX RADIUS	1.754	1.589	1.515
HORIZONTAL SPREAD	3.129	2.635	2.478
VERTICAL SPREAD	1.756	1.756	1.756
EXTREME SPREAD	3.135	3.036	2.625
NUMBER IN ONE INCH CIRCLE	=	1	
NUMBER IN TWO INCH CIRCLE	=	4	
NUMBER IN THREE INCH CIRCLE	=	8	

3 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C864B945

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 2

2 in = 4

3 in = 9

HS = 1.990

VS = 2.413

GS = 2.780

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.083	1.160	1.065
MINIMUM X	:	-.897	-.820	-.915
MAXIMUM Y	:	.888	.718	.795
MINIMUM Y	:	-1.530	-.838	-.761
CENTROID X	:	.068	-.010	.085
CENTROID Y	:	-.519	-.349	-.426
POA TO CENTROID in.	:	.523	.349	.434
MIN RADIUS	:	.193	.064	.158
MEAN RADIUS	:	.906	.787	.774
MAX RADIUS	:	1.682	1.177	1.120
HORIZONTAL SPREAD	:	1.980	1.980	1.980
VERTICAL SPREAD	:	2.413	1.556	1.556
EXTREME SPREAD	:	2.780	2.116	2.116
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

3 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8648945

CENTERFIRE PATTERNS # 4

POB

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 0

2 in = 3

3 in = 5

HS = 2.664

VS = 3.489

GS = 3.520

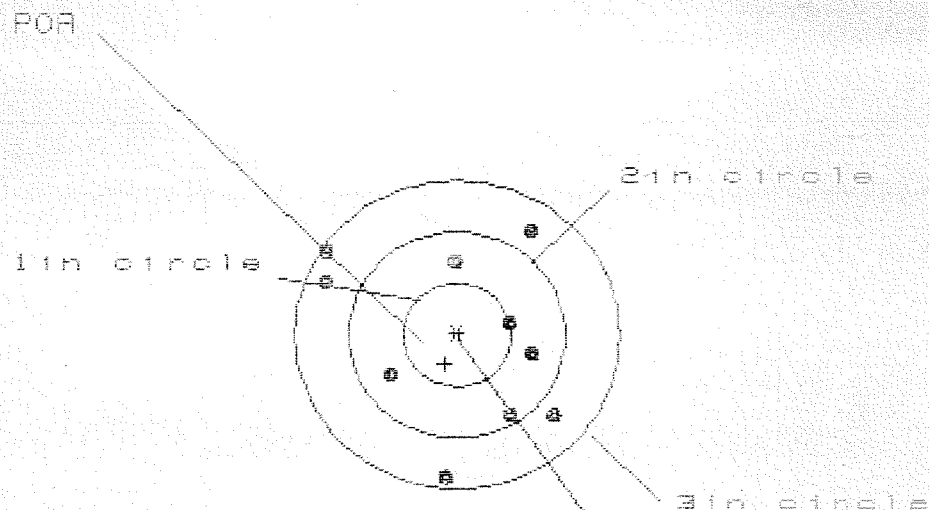
CENTROID *

PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	1.391
MINIMUM X	-1.273
MAXIMUM Y	1.608
MINIMUM Y	-1.881
CENTROID X	.397
CENTROID Y	-.187
POB TO CENTROID in.	.489
MIN RADIUS	.611
MEAN RADIUS	1.330
MAX RADIUS	2.031
HORIZONTAL SPREAD	2.664
VERTICAL SPREAD	3.489
EXTREME SPREAD	3.520
NUMBER IN ONE INCH CIRCLE =	0
NUMBER IN TWO INCH CIRCLE =	3
NUMBER IN THREE INCH CIRCLE =	5

3 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C654B945

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

HS= 2.113

VS= 2.367

GS= 2.644

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.920	.788	.759
MINIMUM X	-1.193	-1.325	-1.354
MAXIMUM Y	1.009	1.105	.947
MINIMUM Y	-1.358	-1.262	-.802
CENTROID X	.113	.245	.274
CENTROID Y	.281	.185	.343
POA TO CENTROID in.	.303	.307	.439
MIN RADIUS	.463	.394	.290
MEAN RADIUS	1.004	.928	.868
MAX RADIUS	1.466	1.474	1.439
HORIZONTAL SPREAD	2.113	2.113	2.113
VERTICAL SPREAD	2.367	2.367	1.749
EXTREME SPREAD	2.644	2.492	2.474
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		