

C6611652

MODEL 700TM M24

Model **SAS**TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington[®] **DUPONT**
REG. U.S. PAT. & TM. OFF.

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

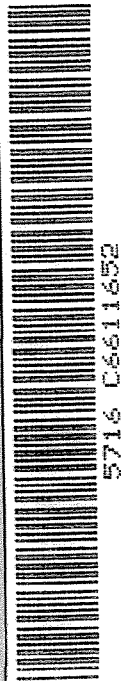
MODEL 700TM M24

SERIAL NO.
C6611652

ORDER NO.
5716

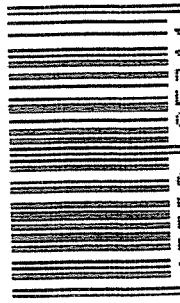
46

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



5716 C6611652

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611652

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/18/91	KL
600	Proof		3/18/91	KL
607	Check Headspace		3/18/91	KL
610	Dis-assemble Gun		3/18/91	KL
612	Magnaflux Barrel Action		3/28/91	KR
	Magnaflux Bolt		"	"
615	Rollmark Caliber		"	GL
617	Drill and Tap Sight Holes		APR 3 1991	KL
618	Polish Barrel		APR 3 1991	KL
620	Apply Coatings (Barrel Action)		4/19/91	KL
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/29/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/29/91	KL
	C) Inspect Ejector Hole for Chamfer		4/29/91	KL
	D) Oil Firing Pin Ass'y		4/29/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		5/6/91	KL

op. #	BARBER M24 0033796	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5/6/91	KL
	G) Safety Off Force	4	4	4			5/6/91	KL
	H) Trigger Pull Test & Retainability						5/6/91	KL
	I) Firing Pin Indent	1.023	1.023	1.023			5/6/91	KL
	J) Assemble Stock						5/6/91	KS
	K) Assemble Swivel Studs						5-9-91	AC
	L) Attach Front and Rear Sight Assemblies						5/6/91	KS
	M) Iron Sight Alignment						5/6/91	KS
	N) Detach Front & Rear Sights & place in numbered container						5/6/91	KS
	O) Attach Scope to Rifle						5/6/91	KS
	P) Detach & Attach Scope 20 Times						5/6/91	KS
640	Gallery Target & Test						5/6/91	KT
	A) Time						5/6/91	KT
	B) Malfunctions						5/6/91	KT
	C) Pierced Primers						5/6/91	KT
	D) Optical Clarity of Scope						5/6/91	KT
645	Inspect for Live Ammo						5/6/91	KT
655	Final Inspection						5-9-91	AC
	A) Headspace						5/6/91	KL
	B) Trigger Pull	2.37	2.32	2.32	2.39	2.39	5/6/91	KL
	C) Function						5-9-91	AC
660	Pack						6-18-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6611652

DATE 5/6/91

TESTER [Signature] (H)

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.28	2.42	2.50	2.39	MIN. SETTING,
PULL #2	2.43	2.47	2.48	2.37	NO AVG. OF 5
PULL #3	2.40	2.51	2.39	2.32	READINGS (ACCEPT-
PULL #4	2.44	2.44	2.46	2.39	ABLE LESS THAN 2#
PULL #5	2.42	2.47	2.48	2.39	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES			COMMENTS
PULL #1	3.56	3.53			
PULL #2	3.56	3.54			
PULL #3	3.19	3.29			
PULL #4	3.27	3.32			
PULL #5	3.46	3.46			
TOTAL					
AVG.					

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.16	4.22		4.29
PULL #2	4.35	4.30		4.21
PULL #3	4.21	4.24		4.30
PULL #4	4.26	4.17		4.39
PULL #5	4.31	4.27		4.29
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06611652
8 May 1991

CENTROIDAL DISTANCES

0 TO	1	.193132
1 TO	2	.266085
1 TO	3	.0578014
1 TO	4	.178025
1 TO	5	.289928

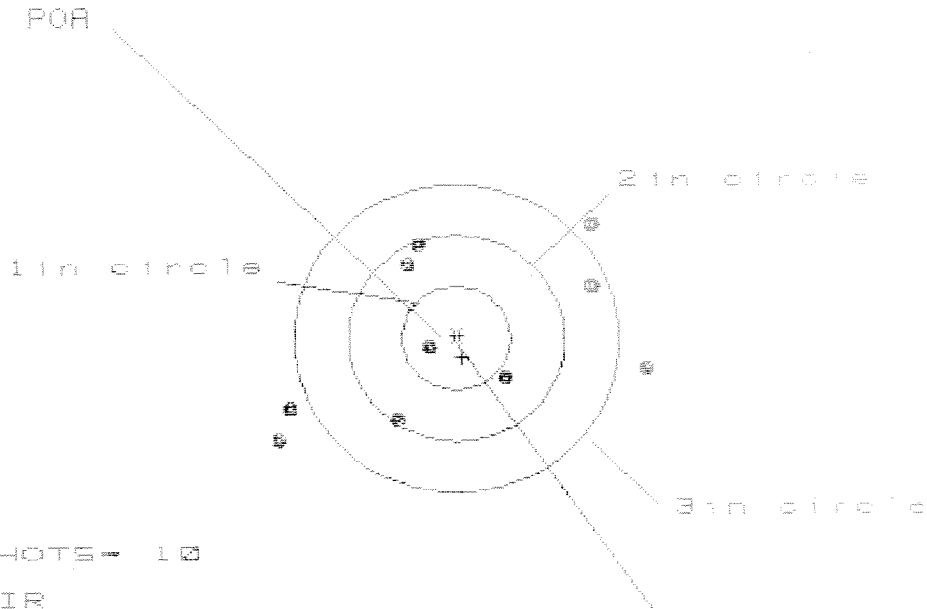
45
0 <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .007
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1972
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .197324
THE AMR FOR THIS RIFLE IS: .9786

8 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611552

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 6

HS = 3.402

VS = 2.100

GS = 3.606

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.730	1.544	1.266
MINIMUM X	-1.672	-1.697	-1.504
MAXIMUM Y	1.096	.984	.934
MINIMUM Y	-1.004	-.940	-.990
CENTROID X	-.052	.134	-.059
CENTROID Y	.186	.298	.348
POA TO CENTROID in.	.193	.326	.353
MIN RADIUS	.271	.487	.364
MEAN RADIUS	1.201	1.119	1.036
MAX RADIUS	1.950	1.866	1.717
HORIZONTAL SPREAD	3.402	3.241	2.770
VERTICAL SPREAD	2.100	1.924	1.924
EXTREME SPREAD	3.606	3.283	3.283
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	6		

8 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C0611652

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 7

HS = 2.560

VS = 2.624

GS = 3.509

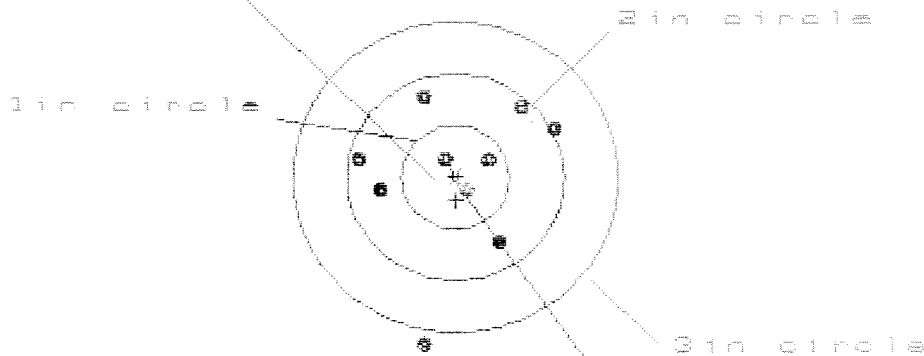
PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.971	.818	.691
MINIMUM X	-1.589	-1.742	-1.027
MAXIMUM Y	1.388	.682	.620
MINIMUM Y	-1.236	-1.081	-1.143
CENTROID X	-.028	.125	.342
CENTROID Y	-.079	-.234	-.172
POA TO CENTROID in.	.084	.265	.383
MIN RADIUS	.232	.279	.275
MEAN RADIUS	.988	.866	.700
MAX RADIUS	1.953	1.810	1.284
HORIZONTAL SPREAD	2.560	2.560	1.628
VERTICAL SPREAD	2.624	1.763	1.763
EXTREME SPREAD	3.509	2.659	2.236
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		7	

8 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8B11652

CENTERFIRE PATTERNS # 3

POA



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 8

3 in = 9

HS = 1.832

VS = 2.436

GS = 2.509

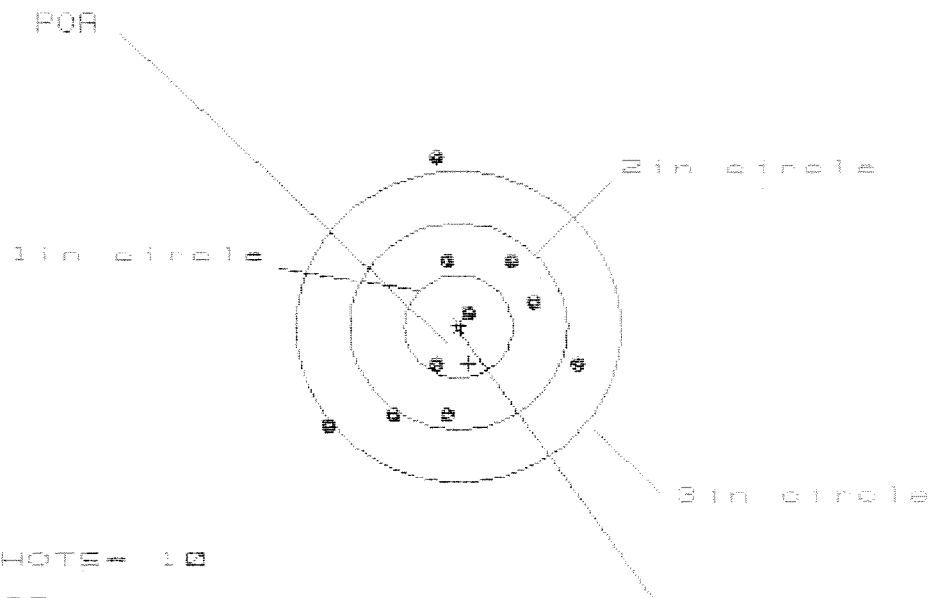
CENTROID *

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	.913
MINIMUM X	-.919
MAXIMUM Y	.767
MINIMUM Y	-1.669
CENTROID X	-.006
CENTROID Y	.221
POA TO CENTROID in.	.221
MIN RADIUS	.154
MEAN RADIUS	.751
MAX RADIUS	1.687
HORIZONTAL SPREAD	1.832
VERTICAL SPREAD	2.436
EXTREME SPREAD	2.509
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	8
NUMBER IN THREE INCH CIRCLE =	9

8 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06611652

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 2

2in = 6

3in = 8

HS = 2.288

VS = 2.592

GS = 2.788

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.094	1.075	.923
MINIMUM X	:	-1.195	-1.214	-.760
MAXIMUM Y	:	1.634	.838	.741
MINIMUM Y	:	-.958	-.776	-.753
CENTROID X	:	-.094	-.075	.077
CENTROID Y	:	.359	.177	.274
POA TO CENTROID in.	:	.371	.192	.285
MIN RADIUS	:	.111	.278	.210
MEAN RADIUS	:	.895	.809	.718
MAX RADIUS	:	1.643	1.441	1.070
HORIZONTAL SPREAD	:	2.289	2.289	1.683
VERTICAL SPREAD	:	2.592	1.614	1.494
EXTREME SPREAD	:	2.788	2.376	1.845
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

6 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611652

CENTERFIRE PATTERNS # 5

POR

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 3.348

VS= 3.305

GS= 4.550

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	2.126
MINIMUM X	-1.222
MAXIMUM Y	1.561
MINIMUM Y	-1.744
CENTROID X	.215
CENTROID Y	.299
POA TO CENTROID in.	.368
MIN RADIUS	.167
MEAN RADIUS	1.058
MAX RADIUS	2.638
HORIZONTAL SPREAD	3.348
VERTICAL SPREAD	3.305
EXTREME SPREAD	4.550
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	8

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611652
6 May 1991

CENTROIDAL DISTANCES

0 TO	1	.113358
1 TO	2	.0693542
1 TO	3	.224644
1 TO	4	.156464
1 TO	5	.393146

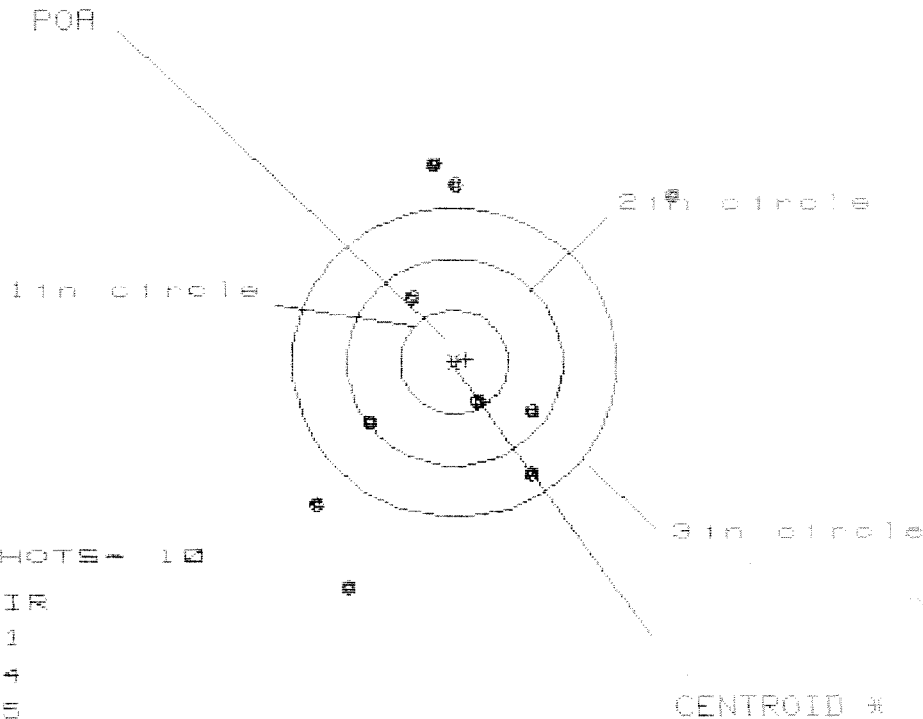
<----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0622
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .083
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .10372
THE AMR FOR THIS RIFLE IS: 1.213

8 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C881/652

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 1

2in = 4

3in = 5

HS = 3.378

VS = 4.093

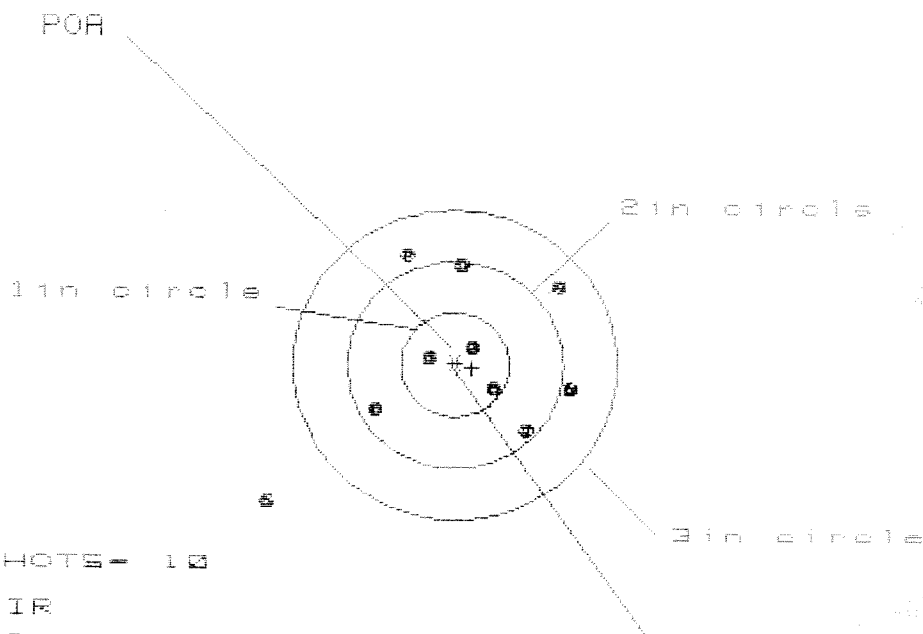
GS = 4.849

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.051	.945	.855
MINIMUM X	-1.327	-1.099	-1.189
MAXIMUM Y	1.936	2.120	1.873
MINIMUM Y	-2.157	-1.973	-1.415
CENTROID X	-.111	-.339	-.249
CENTROID Y	-.023	-.207	.040
POA TO CENTROID in.	.114	.397	.252
MIN RADIUS	.410	.475	.543
MEAN RADIUS	1.491	1.342	1.246
MAX RADIUS	2.634	2.120	1.875
HORIZONTAL SPREAD	3.378	2.044	2.044
VERTICAL SPREAD	4.093	4.093	3.288
EXTREME SPREAD	4.849	4.157	3.469
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =			5

6 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611/652

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 3

2in = 6

3in = 9

HS = 2.704

VS = 2.364

GS = 3.382

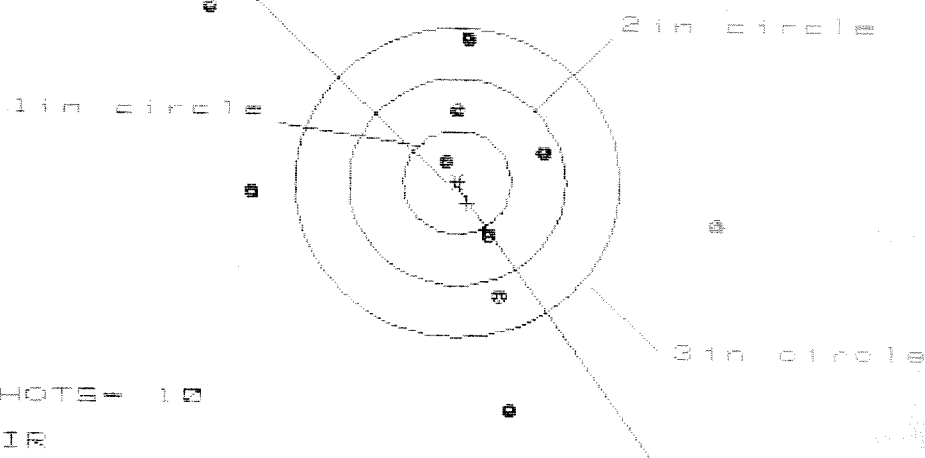
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.011	.823	.920
MINIMUM X	:	-1.693	-.923	-.826
MAXIMUM Y	:	1.022	.873	.948
MINIMUM Y	:	-1.342	-.807	-.733
CENTROID X	:	-.158	.030	-.067
CENTROID Y	:	.028	.177	.103
POA TO CENTROID in.	:	.160	.100	.122
MIN RADIUS	:	.175	.068	.059
MEAN RADIUS	:	.918	.753	.710
MAX RADIUS	:	2.161	1.094	1.087
HORIZONTAL SPREAD	:	2.704	1.746	1.746
VERTICAL SPREAD	:	2.364	1.680	1.680
EXTREME SPREAD	:	3.382	2.074	2.000
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			9	

6 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611152

CENTERFIRE PATTERNS # 3

POA



OF SHOTS = 10

IN CIR

1in = 1

2in = 4

3in = 6

HS = 4.591

VS = 3.876

GS = 5.135

CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.357	2.098	.781
MINIMUM X	:	-2.334	-2.177	-1.915
MAXIMUM Y	:	1.683	1.633	1.605
MINIMUM Y	:	-2.193	-2.006	-2.034
CENTROID X	:	-.094	.165	-.097
CENTROID Y	:	.201	.014	.042
POA TO CENTROID in.	:	.222	.166	.106
MIN RADIUS	:	.180	.291	.333
MEAN RADIUS	:	1.436	1.261	1.150
MAX RADIUS	:	2.877	2.178	2.091
HORIZONTAL SPREAD	:	4.691	4.275	2.696
VERTICAL SPREAD	:	3.876	3.639	3.639
EXTREME SPREAD	:	5.135	4.284	3.661
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	

6 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C861162

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 7

ME = 3.024

VS = 3.596

GS = 3.705

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.064	1.147	.913
MINIMUM X	-1.960	-1.877	-1.337
MAXIMUM Y	1.591	1.368	1.359
MINIMUM Y	-2.086	-1.178	-1.187
CENTROID X	.005	-.078	.156
CENTROID Y	-.128	.094	.103
POA TO CENTROID in.	.129	.123	.187
MIN RADIUS	.189	.423	.386
MEAN RADIUS	1.180	1.091	.949
MAX RADIUS	2.143	1.878	1.389
HORIZONTAL SPREAD	3.024	3.024	2.250
VERTICAL SPREAD	3.596	2.546	2.546
EXTREME SPREAD	3.705	3.028	2.554
NUMBER IN ONE INCH CIRCLE	= 1		
NUMBER IN TWO INCH CIRCLE	= 4		
NUMBER IN THREE INCH CIRCLE	= 7		

6 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C881162

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 2.607

VS= 2.497

GS= 3.049

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.072	1.155	.973
MINIMUM X	-1.535	-1.452	-1.214
MAXIMUM Y	1.693	.934	.916
MINIMUM Y	-.804	-.616	-.633
CENTROID X	.047	-.036	.146
CENTROID Y	.337	.149	.166
POA TO CENTROID in.	.340	.153	.221
MIN RADIUS	.101	.285	.297
MEAN RADIUS	1.038	.945	.852
MAX RADIUS	1.848	1.459	1.335
HORIZONTAL SPREAD	2.607	2.607	2.187
VERTICAL SPREAD	2.497	1.558	1.550
EXTREME SPREAD	3.049	2.649	2.351
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		