

C6611690

MODEL 700™ M24

Model SAS™

Action \_\_\_\_\_

Barrel Length \_\_\_\_\_

Capacity \_\_\_\_\_

Order No. 5716

\*Includes 1 in chamber.



**Remington®**

**MODEL 700™ H24**

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.

**DUPONT**  
REG. U.S. PAT. & T.M. OFF.

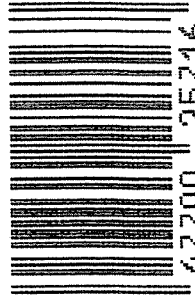
|                               |                          |
|-------------------------------|--------------------------|
| <b>SERIAL NO.</b><br>C6611690 | <b>ORDER NO.</b><br>5716 |
|-------------------------------|--------------------------|

46



5716 C6611690

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611690

| OP. #     | OP. NAME                                                 | READINGS | DATE    | INIT |
|-----------|----------------------------------------------------------|----------|---------|------|
| 575 & 580 | Assemble Action and Stock                                | 3 28 91  |         | RW   |
| 600       | Proof                                                    | 3 28 91  |         | RW   |
| 607       | Check Headspace                                          | 3 28 91  |         | RW   |
| 610       | Dis-assemble Gun                                         | 3 28 91  |         | RW   |
| 612       | Magnaflux Barrel Action                                  | APR      | 2 1991  | KR   |
|           | Magnaflux Bolt                                           | APR      | 2 1991  | U    |
| 615       | Rollmark Caliber                                         | APR      | 2 1991  | LS   |
| 617       | Drill and Tap Sight Holes                                | APR      | 5 1991  | LB   |
| 618       | Polish Barrel                                            | APR      | 5 1991  | WB   |
| 620       | Apply Coatings (Barrel Action)                           |          |         | JA   |
|           | Apply Coating (Bolt)                                     |          |         |      |
| 625       | Final Assembly                                           |          |         |      |
|           | A) Clean inside of Bolt Assembly                         |          | 4/10/91 | RW   |
|           | B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head |          | 4/10/91 | RW   |
|           | C) Inspect Ejector Hole for Chamfer                      |          | 4/10/91 | RW   |
|           | D) Oil Firing Pin Ass'y                                  |          | 4/10/91 | RW   |
|           | E) Adjust Trigger Pull to Min Setting and Stake          |          | 4/18/91 | JA   |

| op. #        | OP. NAME                                                    | READINGS |       |       |      |      | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|-------|-------|------|------|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 6        | 6     | 6     |      |      | 4/18/91 | RL   |
|              | G) Safety Off Force                                         | 4        | 4     | 4     |      |      | 4/18/91 | RL   |
|              | H) Trigger Pull Test & Retainability                        |          |       |       |      |      | 4/18/91 | RL   |
|              | I) Firing Pin Indent                                        | .0225    | .0225 | .0225 |      |      | 4/18/91 | RL   |
|              | J) Assemble Stock                                           |          |       |       |      |      | 4/19/91 | RL   |
|              | K) Assemble Swivel Studs                                    |          |       |       |      |      | 4-23-91 | D/H  |
|              | L) Attach Front and Rear Sight Assemblies                   |          |       |       |      |      | 4/19/91 | RL   |
|              | M) Iron Sight Alignment                                     |          |       |       |      |      | 4/19/91 | RL   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |       |       |      |      | 4/19/91 | RL   |
|              | O) Attach Scope to Rifle                                    |          |       |       |      |      | 4/19/91 | RL   |
|              | P) Detach & Attach Scope 20 Times                           |          |       |       |      |      | 4/19/91 | RL   |
| 640          | Gallery Target & Test                                       |          |       |       |      |      | 4-19-91 | RF   |
|              | A) Time                                                     |          |       |       |      |      | "       | RF   |
|              | B) Malfunctions                                             |          |       |       |      |      | "       | RF   |
|              | C) Pierced Primers                                          |          |       |       |      |      | "       | RF   |
|              | D) Optical Clarity of Scope                                 |          |       |       |      |      | "       | RF   |
| 645          | Inspect for Live Ammo                                       |          |       |       |      |      | 4-19-91 | RF   |
| 655          | Final Inspection                                            |          |       |       |      |      |         |      |
|              | A) Headspace                                                |          |       |       |      |      | 4-23-91 | D/H  |
|              | B) Trigger Pull                                             | 2.32     | 2.31  | 2.33  | 2.23 | 2.33 | 4/22/91 | RL   |
|              | C) Function                                                 |          |       |       |      |      | 4-23-91 | D/H  |
| 660          | Pack                                                        |          |       |       |      |      | 6-17-91 | RF   |

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6611690

DATE 4/18/91

TESTER JU

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.19             | 2.38                     | 2.43                           | 2.32 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.43             | 2.31                     | 2.38                           | 2.31 |                                                                        |
| PULL #3 | 2.43             | 2.41                     | 2.40                           | 2.33 |                                                                        |
| PULL #4 | 2.42             | 2.39                     | 2.38                           | 2.23 |                                                                        |
| PULL #5 | 2.32             | 2.41                     | 2.40                           | 2.33 |                                                                        |
| TOTAL   |                  |                          |                                |      |                                                                        |
| AVG.    |                  |                          |                                |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.42             | 3.40                     |  |          |
| PULL #2 | 3.39             | 3.21                     |  |          |
| PULL #3 | 3.38             | 3.40                     |  |          |
| PULL #4 | 3.36             | 3.39                     |  |          |
| PULL #5 | 3.34             | 3.45                     |  |          |
| 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 | 4.37             | 4.39                     |                                | 4.43                                 |
| PULL #2 | 4.38             | 4.41                     |                                | 4.50                                 |
| PULL #3 | 4.39             | 4.45                     |                                | 4.52                                 |
| PULL #4 | 4.44             | 4.45                     |                                | 4.53                                 |
| PULL #5 | 4.31             | 4.46                     |                                | 4.51                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6611690  
19 Apr 1991

CENTROIDAL DISTANCES

|      |   |          |
|------|---|----------|
| 0 TO | 1 | .0980867 |
| 1 TO | 2 | .0997246 |
| 1 TO | 3 | .252622  |
| 1 TO | 4 | .281775  |
| 1 TO | 5 | .195451  |

90 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0426  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0766  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0876486  
THE AMR FOR THIS RIFLE IS: .9444

19 Apr 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C8611690

## CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

# OF SHOTS= 10

# IN CIR

1in = 2

2in = 5

3in = 7

CENTROID \*

HS= 1.276

VS= 3.163

GS= 3.214

| PATTERN #                     | 1      | 2      | 3      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | .585   | .571   | .483   |
| MINIMUM X                     | -.691  | -.705  | -.367  |
| MAXIMUM Y                     | 1.685  | 1.172  | 1.010  |
| MINIMUM Y                     | -1.478 | -1.291 | -1.386 |
| CENTROID X                    | .039   | .053   | .141   |
| CENTROID Y                    | -.090  | -.277  | -.115  |
| POA TO CENTROID in.           | .098   | .282   | .182   |
| MIN RADIUS                    | .194   | .072   | .150   |
| MEAN RADIUS                   | .991   | .905   | .824   |
| MAX RADIUS                    | 1.689  | 1.471  | 1.467  |
| HORIZONTAL SPREAD             | 1.276  | 1.276  | .850   |
| VERTICAL SPREAD               | 3.163  | 2.463  | 2.396  |
| EXTREME SPREAD                | 3.214  | 2.635  | 2.420  |
| NUMBER IN ONE INCH CIRCLE =   | 2      |        |        |
| NUMBER IN TWO INCH CIRCLE =   |        | 5      |        |
| NUMBER IN THREE INCH CIRCLE = |        | 7      |        |

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## CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

# OF SHOTS = 10

# IN CIR

1in = 1

2in = 5

3in = 10

HS = 2.5550

VS = 2.024

GS = 2.574

CENTROID #

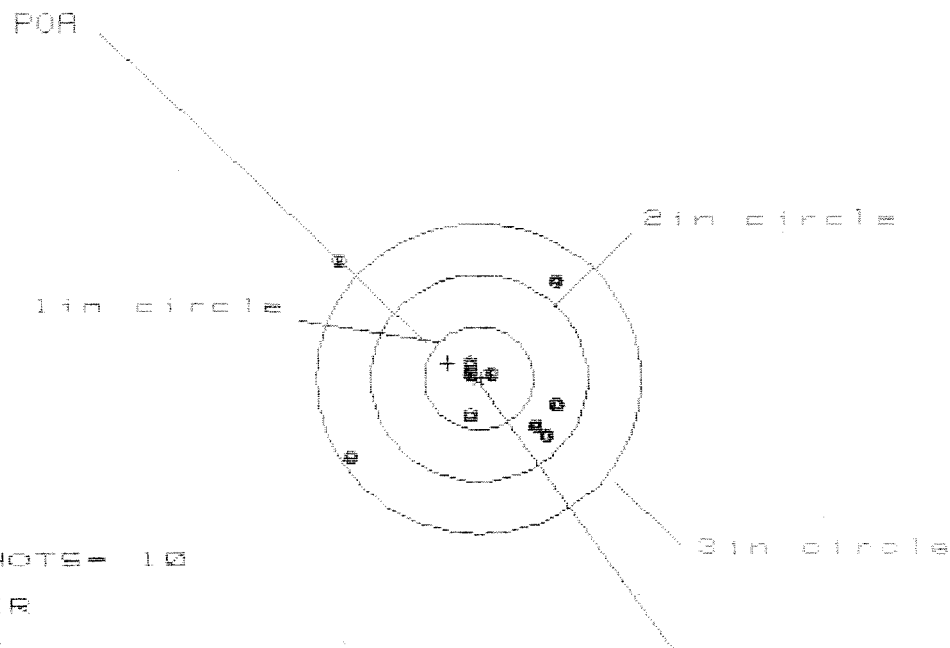
| PATTERN #                   | : | 2      |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.153  | .997   | .920   |
| MINIMUM X                   | : | -1.406 | -1.052 | -1.129 |
| MAXIMUM Y                   | : | 1.247  | 1.264  | 1.004  |
| MINIMUM Y                   | : | -.777  | -.760  | -.602  |
| CENTROID X                  | : | .132   | .288   | .365   |
| CENTROID Y                  | : | -.126  | -.143  | -.301  |
| POA TO CENTROID in.         | : | .182   | .322   | .473   |
| MIN RADIUS                  | : | .479   | .362   | .189   |
| MEAN RADIUS                 | : | .993   | .922   | .822   |
| MAX RADIUS                  | : | 1.415  | 1.407  | 1.187  |
| HORIZONTAL SPREAD           | : | 2.559  | 2.049  | 2.049  |
| VERTICAL SPREAD             | : | 2.024  | 2.024  | 1.606  |
| EXTREME SPREAD              | : | 2.574  | 2.209  | 2.209  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 1      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 5      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 10     |        |



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## CENTERFIRE PATTERNS # 3



# OF SHOTS= 10

# IN CIR

1in = 4

2in = 7

3in = 9

HS= 1.996

VS= 1.856

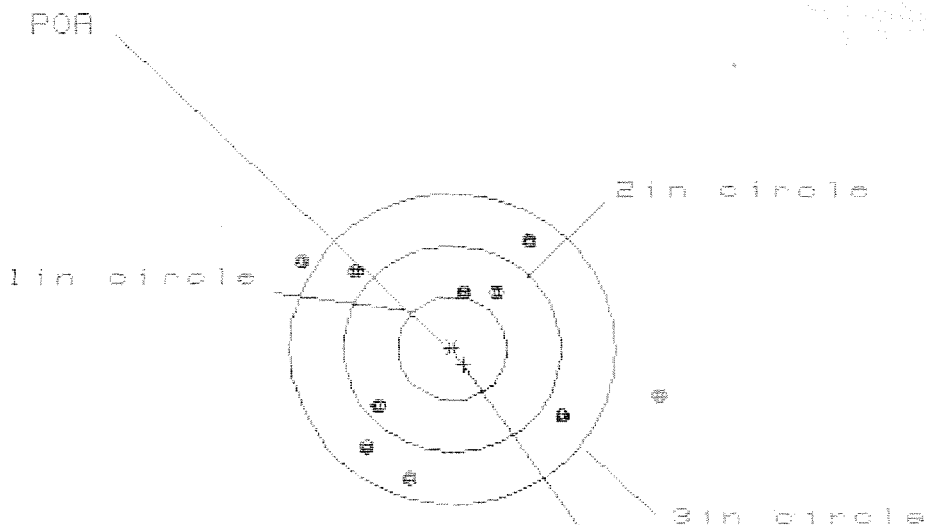
GS= 2.585

| PATTERN #                     | : | 3      |        |       |
|-------------------------------|---|--------|--------|-------|
| SHOTS (BEST OF)               | : | 10     | 9      | 8     |
| MAXIMUM X                     | : | .714   | .572   | .401  |
| MINIMUM X                     | : | -1.282 | -1.370 | -.399 |
| MAXIMUM Y                     | : | 1.126  | 1.078  | 1.002 |
| MINIMUM Y                     | : | -.730  | -.605  | -.551 |
| CENTROID X                    | : | .286   | .428   | .599  |
| CENTROID Y                    | : | -.143  | -.268  | -.192 |
| POA TO CENTROID in.           | : | .319   | .505   | .629  |
| MIN RADIUS                    | : | .042   | .197   | .255  |
| MEAN RADIUS                   | : | .736   | .623   | .521  |
| MAX RADIUS                    | : | 1.706  | 1.498  | 1.077 |
| HORIZONTAL SPREAD             | : | 1.996  | 1.942  | .800  |
| VERTICAL SPREAD               | : | 1.856  | 1.683  | 1.553 |
| EXTREME SPREAD                | : | 2.585  | 2.565  | 1.554 |
| NUMBER IN ONE INCH CIRCLE =   |   |        | 4      |       |
| NUMBER IN TWO INCH CIRCLE =   |   |        | 7      |       |
| NUMBER IN THREE INCH CIRCLE = |   |        | 9      |       |

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## CENTERFIRE PATTERNS # 4



# OF SHOTS- 10

# IN CIR

1in = 0

2in = 3

3in = 8

HS= 2.261

VS= 2.314

GS= 3.521

CENTROID #

| PATTERN #                     | 1      | 2      | 3      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.887  | 1.198  | 1.052  |
| MINIMUM X                     | -1.374 | -1.164 | -0.806 |
| MAXIMUM Y                     | 1.093  | 1.043  | 1.146  |
| MINIMUM Y                     | -1.221 | -1.271 | -1.168 |
| CENTROID X                    | -0.107 | -0.317 | -0.171 |
| CENTROID Y                    | 0.151  | 0.201  | 0.098  |
| POR TO CENTROID in.           | 0.185  | 0.375  | 0.197  |
| MIN RADIUS                    | 0.567  | 0.608  | 0.636  |
| MEAN RADIUS                   | 1.191  | 1.093  | 1.044  |
| MAX RADIUS                    | 1.941  | 1.428  | 1.365  |
| HORIZONTAL SPREAD             | 3.261  | 2.362  | 1.858  |
| VERTICAL SPREAD               | 2.314  | 2.314  | 2.314  |
| EXTREME SPREAD                | 3.521  | 2.801  | 2.570  |
| NUMBER IN ONE INCH CIRCLE =   | 0      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 3      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 8      |        |        |

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## CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

# OF SHOTS= 10

# IN CIR

1in = 1

2in = 8

3in = 10

HS= 2.107

VS= 1.552

GS= 2.392

CENTROID \*

| PATTERN #                   | 5      |
|-----------------------------|--------|
| SHOTS (BEST OF)             | 10     |
| MAXIMUM X                   | 1.099  |
| MINIMUM X                   | -1.008 |
| MAXIMUM Y                   | .815   |
| MINIMUM Y                   | -.737  |
| CENTROID X                  | -.137  |
| CENTROID Y                  | -.175  |
| POA TO CENTROID in.         | .222   |
| MIN RADIUS                  | .386   |
| MEAN RADIUS                 | .811   |
| MAX RADIUS                  | 1.221  |
| HORIZONTAL SPREAD           | 2.107  |
| VERTICAL SPREAD             | 1.552  |
| EXTREME SPREAD              | 2.392  |
| NUMBER IN ONE INCH CIRCLE   | 1      |
| NUMBER IN TWO INCH CIRCLE   | 8      |
| NUMBER IN THREE INCH CIRCLE | 10     |