

C6649262

MODEL 700™ M24

Model **SAS**™

Action

Barrel Length

Capacity

Order No. **5715**

\*Includes 1 in chamber.

*Remington*

Still  
mand.

**Remington**  
REG. U.S. PAT. & TM. OFF.

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

**MODEL 700<sup>TM</sup> H24**

**SERIAL NO.**  
 C6649262

**ORDER NO.**  
**5716**

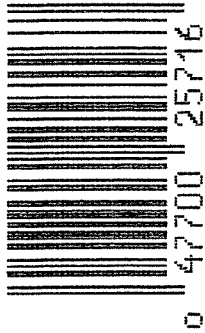
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada. Marque Deposee.

**20**



5716 C6649262

LPC



0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649262

| OP. #        | OP. NAME                                                       | READINGS | DATE    | INIT |
|--------------|----------------------------------------------------------------|----------|---------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   | 6 25     | 9 1     | RW   |
| 600          | Proof                                                          | 6 25     | 9 1     | RW   |
| 607          | Check Headspace                                                | 6 25     | 9 1     | RW   |
| 610          | Dis-assemble Gun                                               | 6 25     | 9 1     | RW   |
| 612          | Magnaflux Barrel<br>Action                                     | JUL      | 1 1991  | KR   |
|              | Magnaflux Bolt                                                 | JUL      | 1 1991  | KR   |
| 615          | Rollmark Caliber                                               | JUL      | 1 1991  | LS   |
| 617          | Drill and Tap Sight Holes                                      | JUL      | 1 1991  | FB   |
| 618          | Polish Barrel                                                  | JUL      | 2 1991  | WB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 8-27-91 | AA   |
|              | Apply Coating (Bolt)                                           |          |         | AB   |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 8/28/91 | RW   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 8/28/91 | RW   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 8/28/91 | RW   |
|              | D) Oil Firing Pin Ass'y                                        |          | 8/28/91 | RW   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 9.3.91  | JL   |

| op.          | NAME                                                        | READINGS |       |       |     |     | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|-------|-------|-----|-----|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 6        | 6     | 6     |     |     | 9/3/91  | SL   |
|              | G) Safety Off Force                                         | 4        | 4     | 4     |     |     | 9/3/91  | SL   |
|              | H) Trigger Pull Test & Retainability                        |          |       |       |     |     | 9/3/91  | SL   |
|              | I) Firing Pin Indent                                        | 10215    | 10215 | 10215 |     |     | 9/3/91  | SL   |
|              | J) Assemble Stock                                           |          |       |       |     |     | 9/3/91  | RW   |
|              | K) Assemble Swivel Studs                                    |          |       |       |     |     | 9-9-91  | K    |
|              | L) Attach Front and Rear Sight Assemblies                   |          |       |       |     |     | 9/3/91  | RW   |
|              | M) Iron Sight Alignment                                     |          |       |       |     |     | 9/3/91  | RW   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |       |       |     |     | 9/3/91  | RW   |
|              | O) Attach Scope to Rifle                                    |          |       |       |     |     | 9/3/91  | RW   |
|              | P) Detach & Attach Scope 20 Times                           |          |       |       |     |     | 9/3/91  | RW   |
| 640          | Gallery Target & Test                                       |          |       |       |     |     | 9-3-91  | AF   |
|              | A) Time                                                     |          |       |       |     |     | "       | AF   |
|              | B) Malfunctions                                             |          |       |       |     |     | "       | AF   |
|              | C) Pierced Primers                                          |          |       |       |     |     | "       | AF   |
|              | D) Optical Clarity of Scope                                 |          |       |       |     |     | "       | AF   |
| 645          | Inspect for Live Ammo                                       |          |       |       |     |     | 9-3-91  | AF   |
| 655          | Final Inspection                                            |          |       |       |     |     |         |      |
|              | A) Headspace                                                |          |       |       |     |     | 9-9-91  | K    |
|              | B) Trigger Pull                                             | 227      | 233   | 229   | 238 | 261 | 9-6-91  | SL   |
|              | C) Function                                                 |          |       |       |     |     | 9-9-91  | AC   |
| 660          | Pack                                                        |          |       |       |     |     | 9-17-91 | DH   |

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS  
2.50# + .50#  
3.00# + .75#  
4.00# + 1.00#

SERIAL NO. 6649262DATE 9-3-91TESTER JH

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.45             | 2.24                     | 2.30                           | 2.27 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.37             | 2.25                     | 2.35                           | 2.33 |                                                                        |
| PULL #3 | 2.34             | 2.22                     | 2.25                           | 2.29 |                                                                        |
| PULL #4 | 2.29             | 2.30                     | 2.20                           | 2.38 |                                                                        |
| PULL #5 | 2.32             | 2.19                     | 2.20                           | 2.61 |                                                                        |
| TOTAL   |                  |                          |                                |      |                                                                        |
| AVG.    |                  |                          |                                |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.59             | 3.65                     |  |          |
| PULL #2 | 3.62             | 3.54                     |  |          |
| PULL #3 | 3.53             | 3.54                     |  |          |
| PULL #4 | 3.62             | 3.52                     |  |          |
| PULL #5 | 3.65             | 3.52                     |  |          |
| 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 | 4.30             | 4.35                     |                                | 4.40                                 |
| PULL #2 | 4.38             | 4.32                     |                                | 4.46                                 |
| PULL #3 | 4.44             | 4.39                     |                                | 4.34                                 |
| PULL #4 | 4.42             | 4.38                     |                                | 4.38                                 |
| PULL #5 | 4.20             | 4.35                     |                                | 4.26                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6649262  
4 Sep 1991

CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| 0 TO | 1 | .579677 |
| 1 TO | 2 | .383275 |
| 1 TO | 3 | .189932 |
| 1 TO | 4 | .326974 |
| 1 TO | 5 | .552241 |

41<sup>th</sup> <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .284  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1682  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .330072  
THE AMR FOR THIS RIFLE IS: 1.022

3 Sep 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C8649262

## CENTERFIRE PATTERNS

# 1

POR

1in circle

2in circle

3in circle

# OF SHOTS - 10

# IN CIR

1in = 0

2in = 3

3in = 5

HS = 3.403

VS = 4.394

GS = 4.403

CENTROID \*

PATTERN #

SHOTS (BEST OF)

MAXIMUM X

MINIMUM X

MAXIMUM Y

MINIMUM Y

CENTROID X

CENTROID Y

POR TO CENTROID in.

MIN RADIUS

MEAN RADIUS

MAX RADIUS

HORIZONTAL SPREAD

VERTICAL SPREAD

EXTREME SPREAD

NUMBER IN ONE INCH CIRCLE =

NUMBER IN TWO INCH CIRCLE =

NUMBER IN THREE INCH CIRCLE =

10

9

8

1.878

1.699

1.661

-1.605

-.916

-.954

2.325

2.514

1.499

-2.069

-1.880

-1.566

.548

.727

.765

.189

-.000

-.314

.580

.727

.827

.635

.754

.587

1.525

1.403

1.218

2.340

2.533

2.237

3.403

2.615

2.615

4.394

4.394

3.065

4.403

4.403

3.829

0

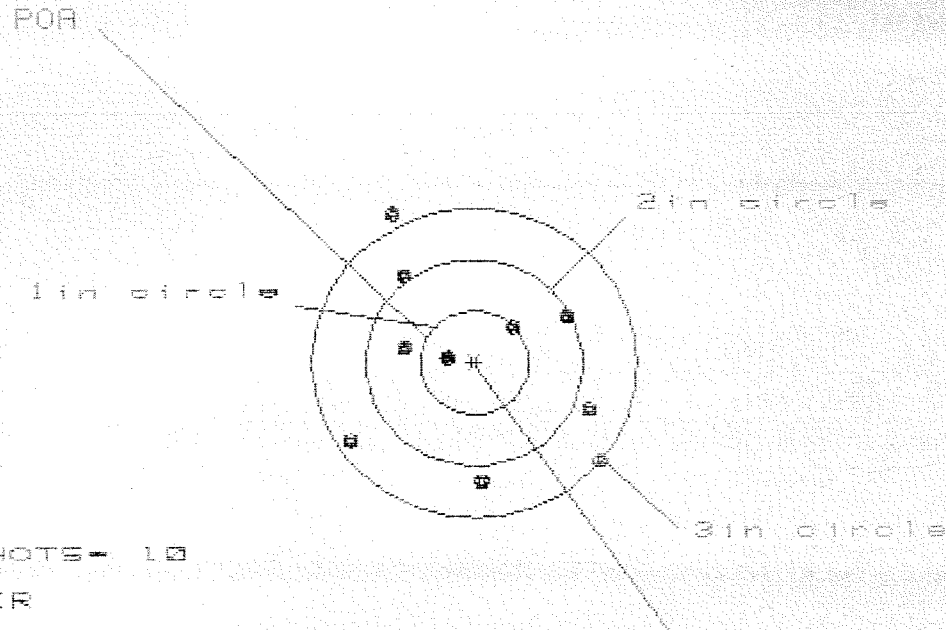
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3-Sep-1991

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## CENTERFIRE PATTERNS # 2



# OF SHOTS- 10

# IN CIR

1in = 2

2in = 4

3in = 8

HS= 2.221

VS= 2.631

GS= 3.018

CENTROID \*

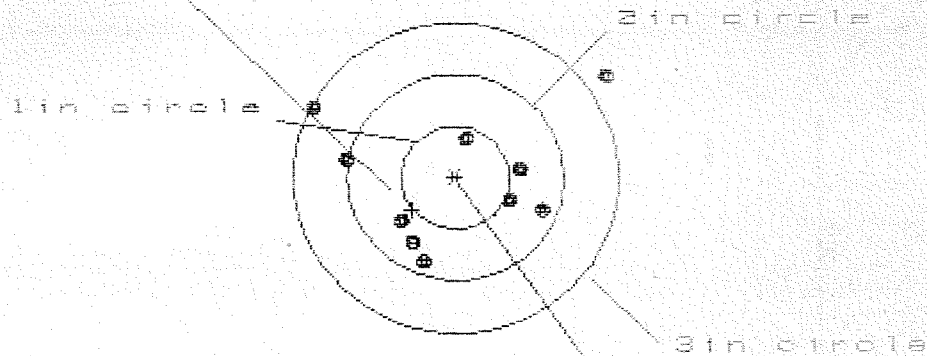
| PATTERN #                     | 2      | 9      | 8      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.104  | 1.020  | 1.099  |
| MINIMUM X                     | -1.117 | -1.201 | -1.073 |
| MAXIMUM Y                     | 1.464  | .968   | .874   |
| MINIMUM Y                     | -1.167 | -1.004 | -1.098 |
| CENTROID X                    | .246   | .330   | .202   |
| CENTROID Y                    | -.047  | -.210  | -.116  |
| POA TO CENTROID in.           | .251   | .391   | .233   |
| MIN RADIUS                    | .279   | .416   | .258   |
| MEAN RADIUS                   | 1.011  | .949   | .880   |
| MAX RADIUS                    | 1.645  | 1.319  | 1.250  |
| HORIZONTAL SPREAD             | 2.221  | 2.221  | 2.162  |
| VERTICAL SPREAD               | 2.631  | 1.972  | 1.972  |
| EXTREME SPREAD                | 3.018  | 2.473  | 2.293  |
| NUMBER IN ONE INCH CIRCLE =   | 2      | 2      | 2      |
| NUMBER IN TWO INCH CIRCLE =   | 4      | 4      | 4      |
| NUMBER IN THREE INCH CIRCLE = | 9      | 9      | 9      |

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## CENTERFIRE PATTERNS # 3

POA



# OF SHOTS- 10

# IN CIR

1in = 1

2in = 8

3in = 9

HS= 2.670

VS= 1.784

GS= 2.682

CENTROID \*

PATTERN #

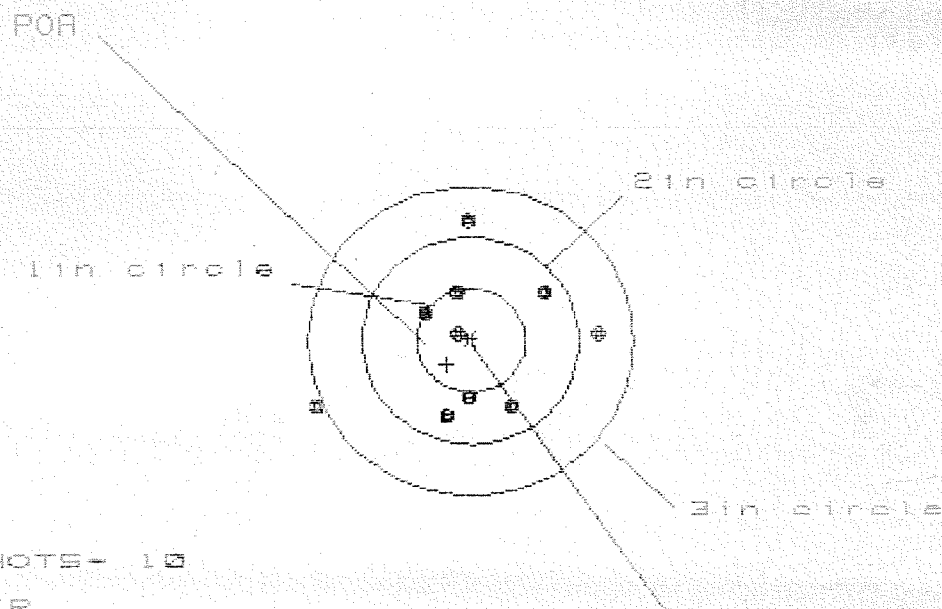
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| SHOTS (BEST OF)             | 10     | 9      | 8     |
|-----------------------------|--------|--------|-------|
| MAXIMUM X                   | 1.384  | .952   | .811  |
| MINIMUM X                   | -1.285 | -1.132 | -.942 |
| MAXIMUM Y                   | .948   | .799   | .598  |
| MINIMUM Y                   | -.836  | -.730  | -.631 |
| CENTROID X                  | .405   | .251   | .392  |
| CENTROID Y                  | .314   | .208   | .109  |
| POA TO CENTROID in.         | .512   | .326   | .407  |
| MIN RADIUS                  | .401   | .446   | .502  |
| MEAN RADIUS                 | .882   | .780   | .683  |
| MAX RADIUS                  | 1.678  | 1.385  | 1.036 |
| HORIZONTAL SPREAD           | 2.670  | 2.084  | 1.753 |
| VERTICAL SPREAD             | 1.784  | 1.529  | 1.229 |
| EXTREME SPREAD              | 2.682  | 2.300  | 1.824 |
| NUMBER IN ONE INCH CIRCLE   | = 1    |        |       |
| NUMBER IN TWO INCH CIRCLE   | = 8    |        |       |
| NUMBER IN THREE INCH CIRCLE | = 9    |        |       |

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## CENTERFIRE PATTERNS # 4



# OF SHOTS- 10

# IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 2.588

VS= 1.937

GS= 2.689

| PATTERN #                   | 10     | 9     | 8     |
|-----------------------------|--------|-------|-------|
| SHOTS (BEST OF)             | 10     | 9     | 8     |
| MAXIMUM X                   | 1.214  | 1.061 | .685  |
| MINIMUM X                   | -1.374 | -.584 | -.451 |
| MAXIMUM Y                   | 1.210  | 1.138 | 1.141 |
| MINIMUM Y                   | -.727  | -.799 | -.796 |
| CENTROID X                  | .224   | .377  | .244  |
| CENTROID Y                  | .233   | .305  | .302  |
| POA TO CENTROID in.         | .323   | .484  | .389  |
| MIN RADIUS                  | .158   | .288  | .156  |
| MEAN RADIUS                 | .791   | .721  | .647  |
| MAX RADIUS                  | 1.516  | 1.146 | 1.141 |
| HORIZONTAL SPREAD           | 2.588  | 1.645 | 1.136 |
| VERTICAL SPREAD             | 1.937  | 1.937 | 1.937 |
| EXTREME SPREAD              | 2.689  | 1.952 | 1.952 |
| NUMBER IN ONE INCH CIRCLE   | = 3    |       |       |
| NUMBER IN TWO INCH CIRCLE   | = 7    |       |       |
| NUMBER IN THREE INCH CIRCLE | = 9    |       |       |

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## CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

# OF SHOTS- 10

# IN CIR

1in = 1

2in = 7

3in = 9

HS= 2.091

VS= 2.354

GS= 2.511

CENTROID \*

| PATTERN #                   | 10     | 9     | 8     |
|-----------------------------|--------|-------|-------|
| SHOTS (BEST OF)             | 10     | 9     | 8     |
| MAXIMUM X                   | 1.097  | 1.176 | 1.226 |
| MINIMUM X                   | -.994  | -.872 | -.822 |
| MAXIMUM Y                   | 1.324  | .759  | .648  |
| MINIMUM Y                   | -1.038 | -.883 | -.731 |
| CENTROID X                  | -.003  | -.125 | -.175 |
| CENTROID Y                  | .152   | .004  | .115  |
| POA TO CENTROID in.         | .152   | .125  | .209  |
| MIN RADIUS                  | .386   | .288  | .171  |
| MEAN RADIUS                 | .901   | .777  | .740  |
| MAX RADIUS                  | 1.719  | 1.180 | 1.226 |
| HORIZONTAL SPREAD           | 2.091  | 2.048 | 2.048 |
| VERTICAL SPREAD             | 2.354  | 1.642 | 1.379 |
| EXTREME SPREAD              | 2.511  | 2.052 | 2.052 |
| NUMBER IN ONE INCH CIRCLE   | = 1    |       |       |
| NUMBER IN TWO INCH CIRCLE   | = 7    |       |       |
| NUMBER IN THREE INCH CIRCLE | = 9    |       |       |