

C6611533

MODEL 700TM M24

Model **SAS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

 		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700™ M24		SERIAL NO. C6611533
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		ORDER NO. 5716



5716 C6611533

UPC



0 47700 25716 7

Light trigger pull
and
creep adjusted
T. Pull + as
got most as
creep out

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6611533

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		2/1/91	KA
600	Proof		2/1/91	KA
607	Check Headspace		2/1/91	KA
610	Dis-assemble Gun		2/1/91	KA
612	Magnaflux Barrel Action	2 11	91	Kcd
	Magnaflux Bolt	2 11	91	Kcd
615	Rollmark Caliber	2 11	91	GS
617	Drill and Tap Sight Holes	2 13	91	LB
618	Polish Barrel RBB	2 13	91	WB
620	Apply Coatings (Barrel Action)		3-12-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		3/20/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		3/20/91	KS
	C) Inspect Ejector Hole for Chamfer		3/20/91	KS
	D) Oil Firing Pin Ass'y		3/20/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		4-2-91	D/H

op. #	BARBER - M24 0078371 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4½	5			4-29-91	DH
	G) Safety Off Force	2	2½	2½			4-2-91	DH
	H) Trigger Pull Test & Retainability						4-2-91	D/H
	I) Firing Pin Indent	.020	.020	.020			4-2-91	DH
	J) Assemble Stock						4/8/91	KS
	K) Assemble Swivel Studs						5-9-91	K
	L) Attach Front and Rear Sight Assemblies						4/8/91	KS
	M) Iron Sight Alignment						4/8/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/8/91	KS
	O) Attach Scope to Rifle						4/8/91	KS
	P) Detach & Attach Scope 20 Times						4/8/91	KS
640	Gallery Target & Test						4-9-91	AC
	A) Time						4-9-91	AC
	B) Malfunctions						4-9-91	AC
	C) Pierced Primers						4-9-91	AC
	D) Optical Clarity of Scope						4-9-91	AC
645	Inspect for Live Ammo						4-9-91	AC
655	Final Inspection							
	A) Headspace						5-9-91	K
	B) Trigger Pull	2.55	2.53	2.50	2.49	2.50	4/16/91	JK
	C) Function						5-9-91	K
660	Pack						6-17-91	N

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C66-1533

DATE 4-2-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.50	2.61	2.49	2.55	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.42	2.51	2.45	2.53	
PULL #3	2.43	2.47	2.54	2.50	
PULL #4	2.45	2.50	2.40	2.48	
PULL #5	2.63	2.49	2.43	2.50	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.12	3.08		
PULL #2	3.11	3.00		
PULL #3	3.03	3.13		
PULL #4	3.00	3.09		
PULL #5	3.12	3.00		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.15	4.14		4.27
PULL #2	4.16	4.09		4.43
PULL #3	4.18	4.24		4.40
PULL #4	4.11	4.13		4.32
PULL #5	3.96	4.04		4.28
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06611533
9 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.320938
1 TO	2	.821458
1 TO	3	.820532
1 TO	4	.655446
1 TO	5	.518139

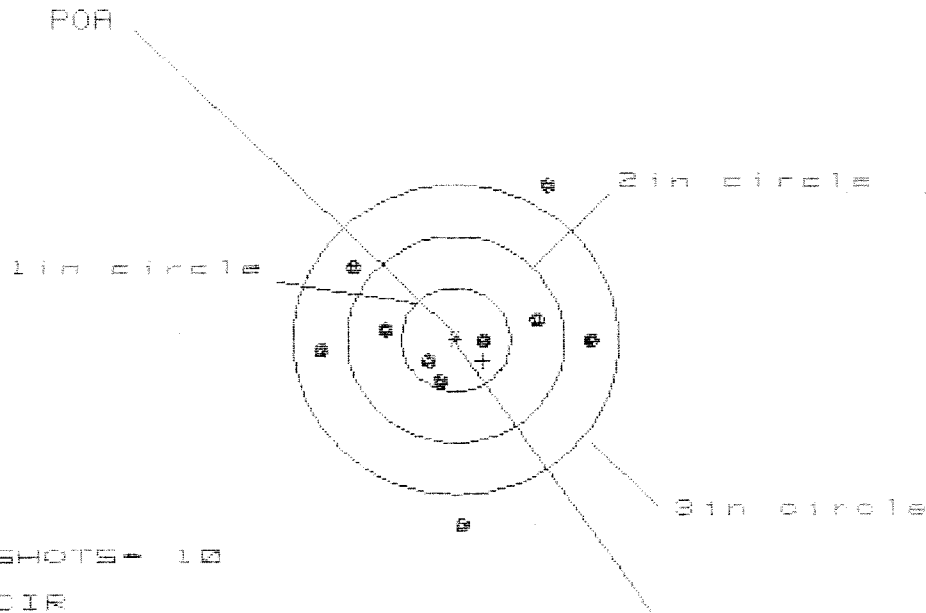
1+4 <----POA
2

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1966
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1178
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .229191
THE AMR FOR THIS RIFLE IS: 1.017

9 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611533

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 5

3 in = 8

H0 = 2.528

V0 = 3.206

Q0 = 3.308

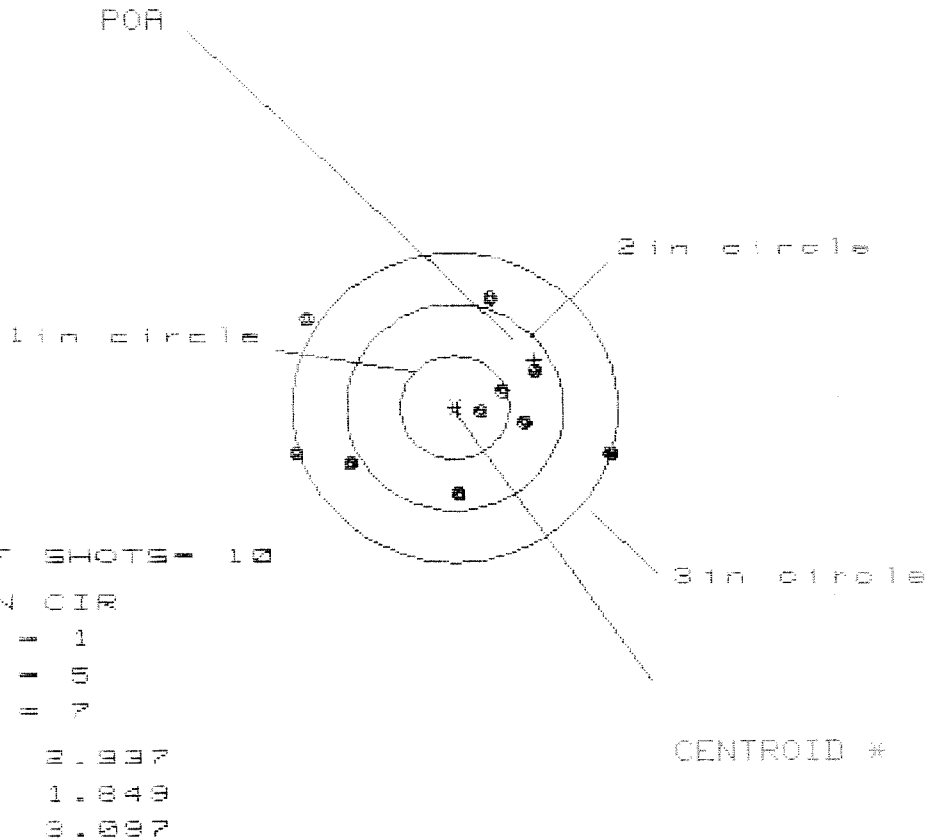
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.260	1.268	1.379
MINIMUM X	-1.278	-1.270	-1.159
MAXIMUM Y	1.454	1.259	.639
MINIMUM Y	-1.752	-.638	-.481
CENTROID X	-.251	-.259	-.370
CENTROID Y	.200	.395	.238
POA TO CENTROID in.	.321	.472	.440
MIN RADIUS	.214	.263	.255
MEAN RADIUS	.950	.876	.751
MAX RADIUS	1.754	1.543	1.379
HORIZONTAL SPREAD	2.538	2.538	2.538
VERTICAL SPREAD	3.206	1.897	1.120
EXTREME SPREAD	3.308	2.641	2.540
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 2

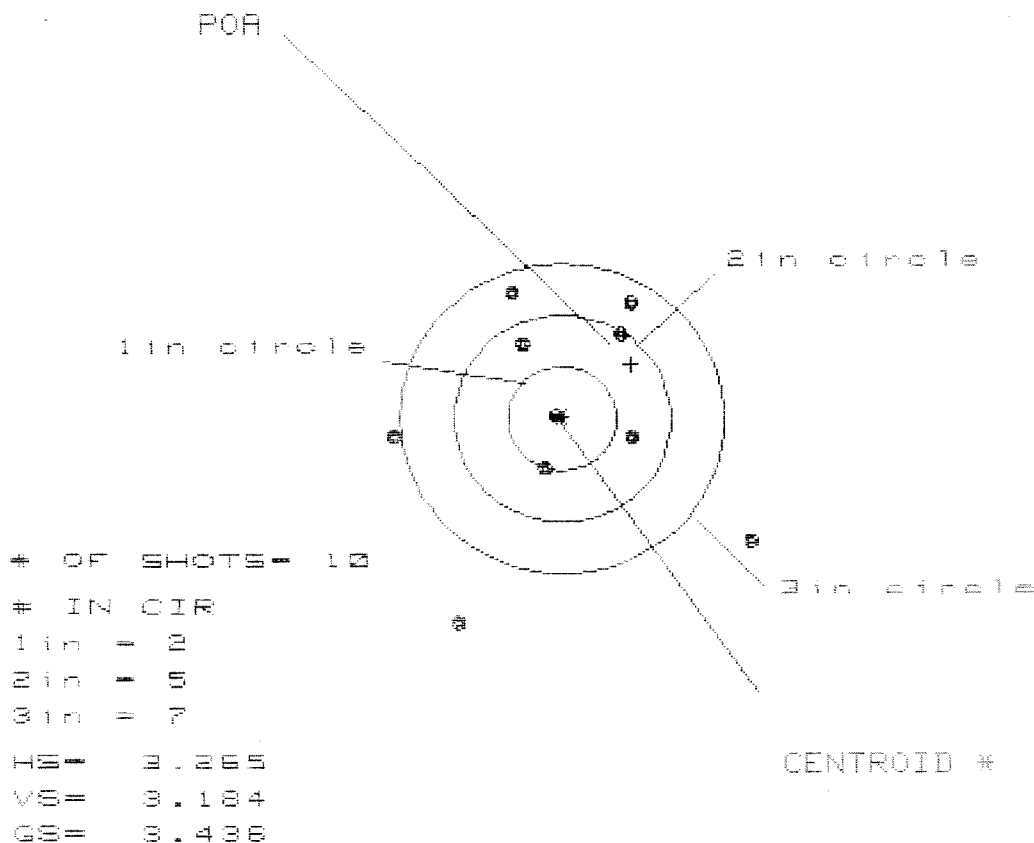


PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.454	1.382	1.098
MINIMUM X	-1.483	-1.635	-1.341
MAXIMUM Y	1.024	1.115	1.070
MINIMUM Y	-.825	-.734	-.779
CENTROID X	-.736	-.584	-.380
CENTROID Y	-.463	-.554	-.509
POA TO CENTROID in.	.869	.805	.635
MIN RADIUS	.214	.121	.154
MEAN RADIUS	.984	.871	.717
MAX RADIUS	1.595	1.674	1.415
HORIZONTAL SPREAD	2.937	2.937	2.439
VERTICAL SPREAD	1.849	1.849	1.849
EXTREME SPREAD	3.097	2.937	2.439
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

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CENTERFIRE PATTERNS # 3



PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.742	1.637	.713
MINIMUM X	-1.523	-1.628	-1.423
MAXIMUM Y	1.214	.995	.823
MINIMUM Y	-1.970	-1.369	-.829
CENTROID X	-.639	-.534	-.738
CENTROID Y	-.523	-.304	-.132
POA TO CENTROID in.	.825	.614	.750
MIN RADIUS	.895	.268	.957
MEAN RADIUS	1.131	.996	.835
MAX RADIUS	2.185	2.134	1.524
HORIZONTAL SPREAD	3.265	3.265	2.137
VERTICAL SPREAD	3.184	2.364	1.652
EXTREME SPREAD	3.436	3.413	2.475
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

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CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 7

HS= 3.548

VS= 2.906

GS= 3.548

CENTROID #

PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	1.839
MINIMUM X	-1.789
MAXIMUM Y	1.708
MINIMUM Y	-1.198
CENTROID X	.376
CENTROID Y	.009
POA TO CENTROID in.	.376
MIN RADIUS	.349
MEAN RADIUS	1.099
MAX RADIUS	1.922
HORIZONTAL SPREAD	3.548
VERTICAL SPREAD	2.906
EXTREME SPREAD	3.548
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	7

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FILE:/PATTERNING/CENTERFIRE_PATT/06611533

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

HS = 2.102

VS = 2.093

GS = 2.361

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.136
MINIMUM X	-.966
MAXIMUM Y	1.036
MINIMUM Y	-1.057
CENTROID X	.267
CENTROID Y	.188
POA TO CENTROID in.	.326
MIN RADIUS	.445
MEAN RADIUS	.921
MAX RADIUS	1.187
HORIZONTAL SPREAD	2.102
VERTICAL SPREAD	2.093
EXTREME SPREAD	2.361
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	10