

C6522202

MODEL 700™ M24

Model **SAS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6522202

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		8/1/90	KS
600	Proof		8/1/90	KS
607	Check Headspace		8/1/90	KS
610	Dis-assemble Gun		8/1/90	KS
612	Magnaflux Barrel Action		8/6/90	KR
	Magnaflux Bolt		8/6/90	KR
615	Rollmark Caliber		8/6/90	LS
617	Drill and Tap Sight Holes		8/10/90	FB
618	Polish Barrel RB		8/14/90	WB
620	Apply Coatings (Barrel Action)		8-22-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake		9/6/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			9/6/90	WLB
	G) Safety Off Force	2 1/4	2 1/4	2 1/4			9/6/90	WLB
	H) Trigger Pull Test & Retainability						9/6/90	WLB
	I) Firing Pin Indent	.024	.024	.024			9/6/90	WLB
	J) Assemble Stock						9/6/90	KS
	K) Assemble Swivel Studs						9/9/90	928
	L) Attach Front and Rear Sight Assemblies						9/6/90	KS
	M) Iron Sight Alignment						9/6/90	KS
	N) Detach Front & Rear Sights & place in numbered container						9/6/90	KS
	O) Attach Scope to Rifle						9/6/90	KS
	P) Detach & Attach Scope 20 Times						9/6/90	KS
640	Gallery Target & Test						9/8/90	KS
	A) Time						9/8/90	KS
	B) Malfunctions						9/8/90	KS
	C) Pierced Primers						9/8/90	KS
	D) Optical Clarity of Scope						9/8/90	KS
645	Inspect for Live Ammo						9/8/90	KS
655	Final Inspection						9/9/90	928
	A) Headspace						9/9/90	928
	B) Trigger Pull	215	227	226	234	235	9/9/90	928
	C) Function						9/9/90	928
660	Pack						9-18-90	928

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6522702

DATE 2/6/20

TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.37	2.16	2.21	2.15	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.28	2.17	2.30	2.27	
PULL #3	2.29	2.14	2.20	2.26	
PULL #4	2.31	2.15	2.23	2.34	
PULL #5	2.34	2.17	2.19	2.35	
TOTAL	11.59	10.79	11.13		
AVG.	2.32	2.16	2.22		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.12	3.02		
PULL #2	3.11	3.04		
PULL #3	3.07	3.00		
PULL #4	3.04	3.00		
PULL #5	3.09	3.09		
TOTAL	15.43	15.15		
AVG.	3.08	3.03		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.16	4.11		4.20
PULL #2	4.09	4.13		4.04
PULL #3	4.06	4.01		4.00
PULL #4	4.02	4.03		4.06
PULL #5	4.07	4.00		4.00
TOTAL	20.40	20.38		20.30
AVG.	4.08	4.076		4.06

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06522202
8 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.154185
1 TO	2	.0925419
1 TO	3	.535728
1 TO	4	.242547
1 TO	5	.255486

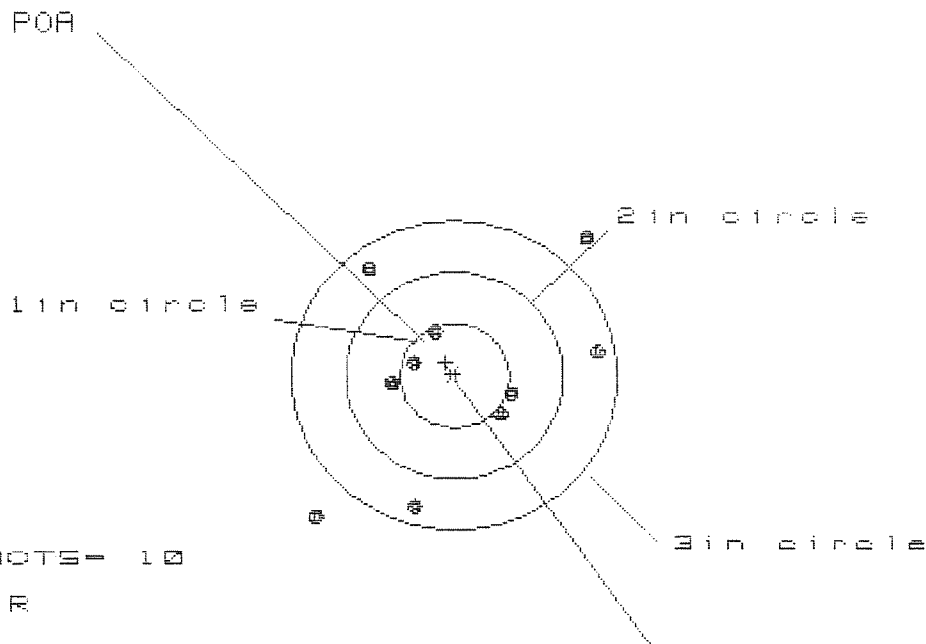
3 $\frac{1}{2}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0192
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0764
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0787756
THE AMR FOR THIS RIFLE IS: 1.114

8 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8522202

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS= 2.550

VS= 2.762

GS= 3.681

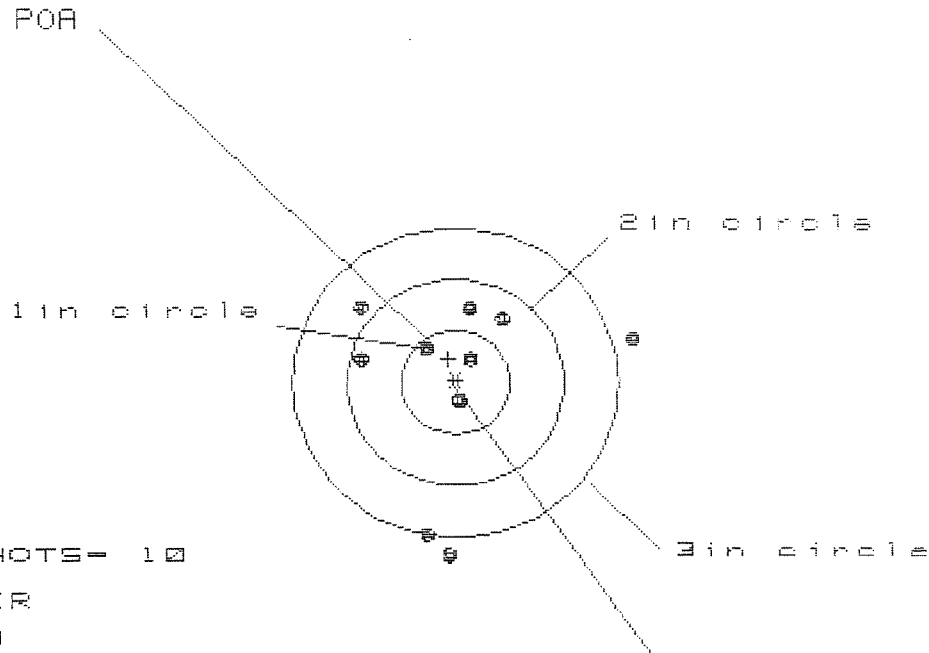
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.300	1.161	1.291
MINIMUM X	-1.250	-.941	-.811
MAXIMUM Y	1.377	1.223	.992
MINIMUM Y	-1.385	-1.371	-1.218
CENTROID X	.078	.217	.087
CENTROID Y	-.133	.021	-.132
POA TO CENTROID in.	.154	.218	.158
MIN RADIUS	.373	.408	.380
MEAN RADIUS	1.008	.915	.800
MAX RADIUS	1.866	1.608	1.322
HORIZONTAL SPREAD	2.550	2.102	2.102
VERTICAL SPREAD	2.762	2.594	2.210
EXTREME SPREAD	3.681	3.011	2.257
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 7

HS= 2.469

VS= 2.363

CS= 2.710

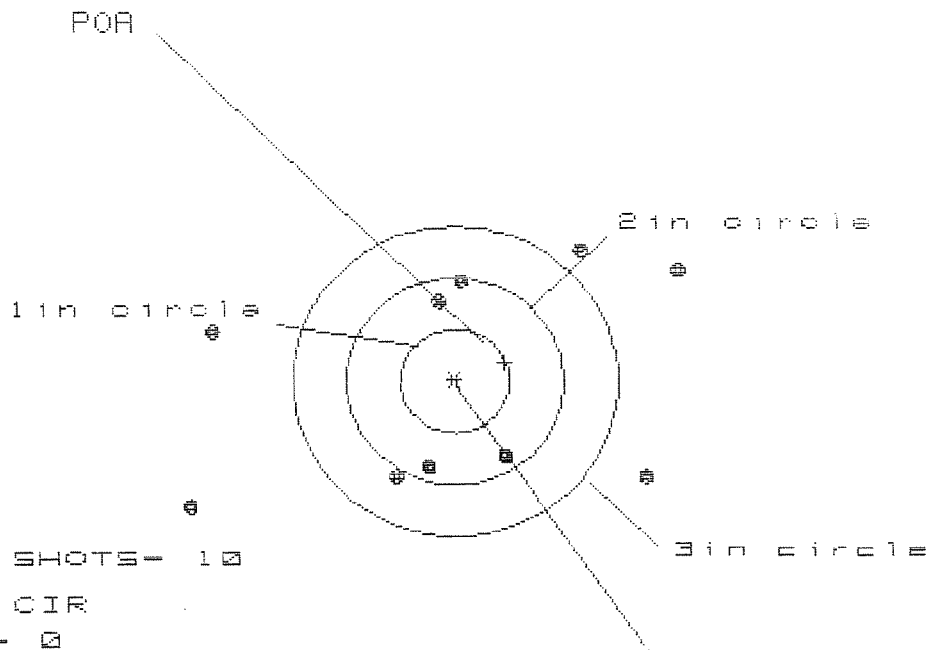
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.598	.594	.605
MINIMUM X	:	-.871	-.694	-.683
MAXIMUM Y	:	.731	.783	.586
MINIMUM Y	:	-1.632	-1.580	-1.631
CENTROID X	:	.068	-.109	-.120
CENTROID Y	:	-.225	-.277	-.080
POA TO CENTROID in.:	:	.235	.298	.144
MIN RADIUS	:	.204	.285	.189
MEAN RADIUS	:	.916	.844	.695
MAX RADIUS	:	1.664	1.583	1.634
HORIZONTAL SPREAD	:	2.469	1.288	1.288
VERTICAL SPREAD	:	2.363	2.363	2.217
EXTREME SPREAD	:	2.710	2.450	2.256
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in - 0

2 in - 3

3 in - 5

HS= 4.425

VS= 2.452

GS= 4.982

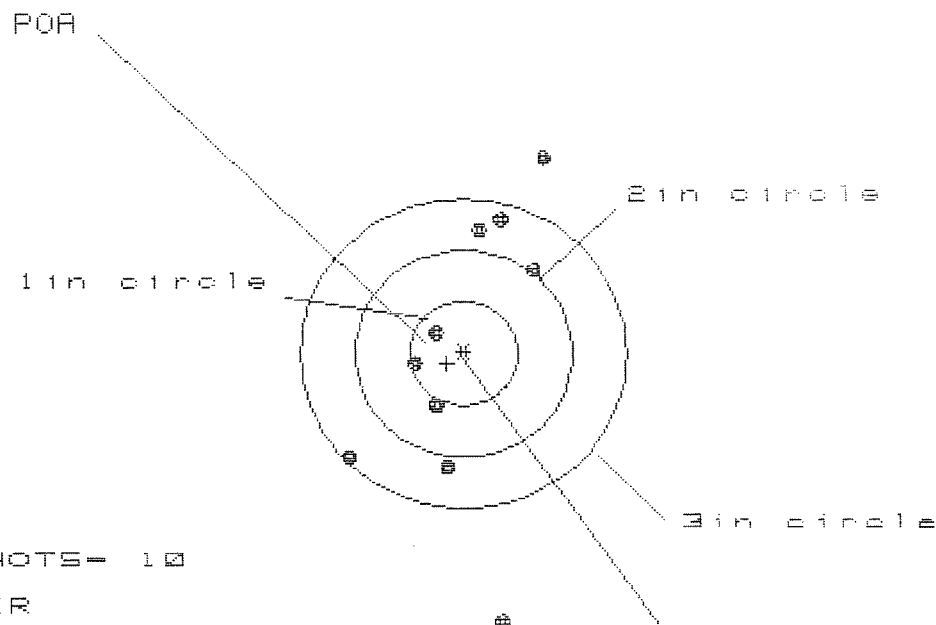
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.029	1.763	1.729
MINIMUM X	:	-2.396	-2.478	-2.258
MAXIMUM Y	:	1.236	1.101	1.218
MINIMUM Y	:	-1.216	-1.055	-.938
CENTROID X	:	-.456	-.190	-.410
CENTROID Y	:	-.176	-.041	-.158
POA TO CENTROID in.	:	.489	.194	.439
MIN RADIUS	:	.811	.764	.800
MEAN RADIUS	:	1.561	1.418	1.327
MAX RADIUS	:	2.687	2.508	2.313
HORIZONTAL SPREAD	:	4.425	4.241	3.987
VERTICAL SPREAD	:	2.452	2.156	2.156
EXTREME SPREAD	:	4.982	4.277	4.236
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		5	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS= 1.822

VS= 4.496

GS= 4.513

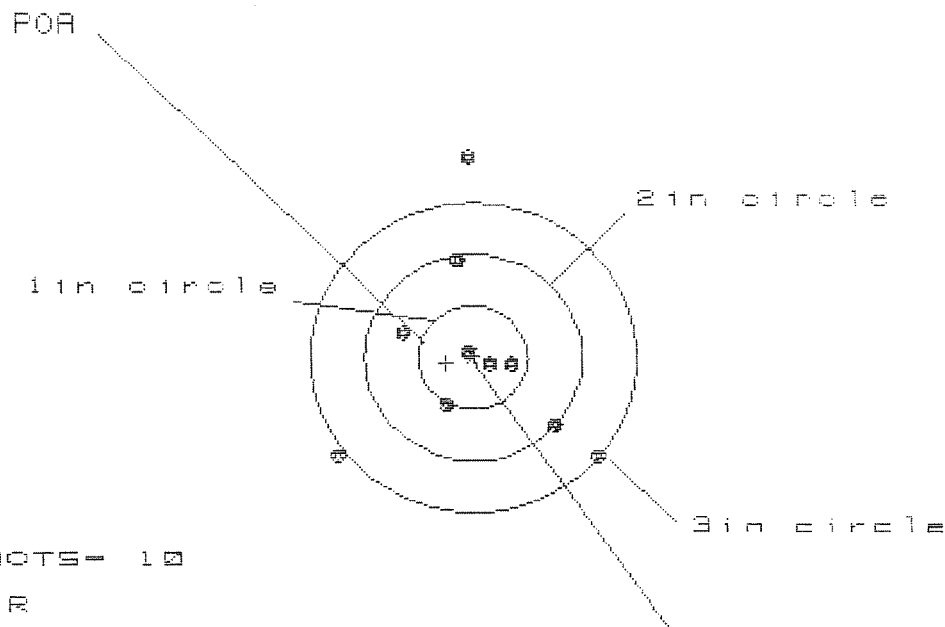
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.773	.815	.752
MINIMUM X	:	-1.049	-1.007	-.905
MAXIMUM Y	:	1.901	1.612	1.230
MINIMUM Y	:	-2.595	-1.356	-1.154
CENTROID X	:	.155	.113	.011
CENTROID Y	:	.097	.386	.184
POA TO CENTROID in.	:	.183	.402	.184
MIN RADIUS	:	.345	.277	.177
MEAN RADIUS	:	1.215	1.038	.904
MAX RADIUS	:	2.623	1.807	1.438
HORIZONTAL SPREAD	:	1.822	1.822	1.657
VERTICAL SPREAD	:	4.496	2.968	2.384
EXTREME SPREAD	:	4.513	3.452	2.753
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 7

HS= 2.427

VS= 2.895

GS= 3.157

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.175	1.165	1.087
MINIMUM X	-1.252	-1.262	-.792
MAXIMUM Y	1.988	1.186	1.092
MINIMUM Y	-.987	-.775	-.869
CENTROID X	.251	.261	.419
CENTROID Y	.055	-.157	-.063
POA TO CENTROID in.	.257	.304	.423
MIN RADIUS	.051	.191	.055
MEAN RADIUS	.868	.757	.635
MAX RADIUS	1.910	1.469	1.331
HORIZONTAL SPREAD	2.427	2.427	1.799
VERTICAL SPREAD	2.895	1.961	1.961
EXTREME SPREAD	3.157	2.427	2.344
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	7		

Remington [®]		DU PONT REG. U.S. PAT. & TM. OFF.	VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700 TM H24			SERIAL NO. C6522202
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		Q1	ORDER NO. 5716

