

C6648937

MODEL 706™ M24

Model **SAS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

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




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

MODEL 700TM M24

SERIAL NO.
C6648937

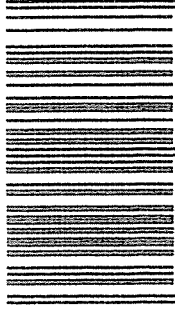
ORDER NO.
5716

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



5716 C6648937

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6648937

X

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 2 5 1		RW
600	Proof	7 2 5 1		RW
607	Check Headspace	7 2 9 1		RW
610	Dis-assemble Gun	7 2 0 1		RW
612	Magnaflux Barrel Action		JUL 22 1991	JS
	Magnaflux Bolt		JUL 22 1991	JS
615	Rollmark Caliber		JUL 22 1991	JS
617	Drill and Tap Sight Holes		JUL 22 1991	FB
618	Polish Barrel		7/22/91	WB
620	Apply Coatings (Barrel Action)		7-22-91	JS
	Apply Coating (Bolt)		7-22-91	JS
625	Final Assembly			
	A) Clean inside of Bolt Assembly		8/9/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/9/91	RW
	C) Inspect Ejector Hole for Chamfer		8/9/91	RW
	D) Oil Firing Pin Ass'y		8/9/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8-10-91	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	8	8	8			8-12-91	DH
	G) Safety Off Force	3 1/2	3	3			8-12-91	DH
	H) Trigger Pull Test & Retainability						8-10-91	JL
	I) Firing Pin Indent	.020	.020	.020			8-12-91	DH
	J) Assemble Stock						8/12/91	RW
	K) Assemble Swivel Studs						8-13-91	DH
	L) Attach Front and Rear Sight Assemblies						8/12/91	RW
	M) Iron Sight Alignment						8/12/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/13/91	RW
	O) Attach Scope to Rifle						8/12/91	RW
	P) Detach & Attach Scope 20 Times						8/12/91	RW
640	Gallery Target & Test						8-12-91	RF
	A) Time						"	RF
	B) Malfunctions						"	RF
	C) Pierced Primers						"	RF
	D) Optical Clarity of Scope						"	RF
645	Inspect for Live Ammo						8-12-91	RF
655	Final Inspection						8-13-91	DH
	A) Headspace							
	B) Trigger Pull	2.27	2.36	2.27	2.33	2.29	8-13-91	JL
	C) Function						8-13-91	DH
660	Pack						9-12-91	RF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C6648937

DATE 8-10-91

TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.33	2.45	2.49	2.27	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.43	2.44	2.52	2.36	
PULL #3	2.36	2.52	2.50	2.27	
PULL #4	2.36	2.49	2.44	2.33	
PULL #5	2.44	2.52	2.49	2.29	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.59	3.56		
PULL #2	3.60	3.54		
PULL #3	3.39	3.54		
PULL #4	3.43	3.64		
PULL #5	3.50	3.58		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.53	4.17		4.25
PULL #2	4.35	4.19		4.23
PULL #3	4.20	4.37		4.28
PULL #4	4.23	4.18		4.28
PULL #5	4.20	4.25		4.39
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6648937
12 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.319714
1 TO	2	.401808
1 TO	3	.171283
1 TO	4	.525935
1 TO	5	.374214

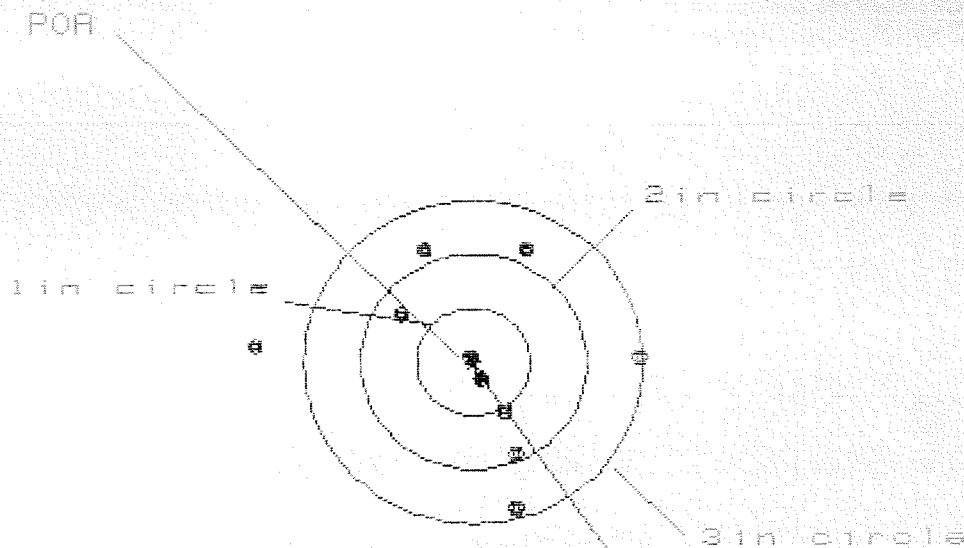
POI (---POI

POI COORDINATE FOR THIS RIFLE IS: .028
POI COORDINATE FOR THIS RIFLE IS: .0254
POI RADIUS FOR THIS RIFLE IS: .0378042
POI RADIUS IS: .887

12 AUG 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6648937

CENTERFIRE PATTERNS # 5



* OF SHOTS - 10

IN CIR

1in = 3

2in = 5

3in = 8

ME = 2.475

VS = 2.461

CS = 2.477

CENTROID *

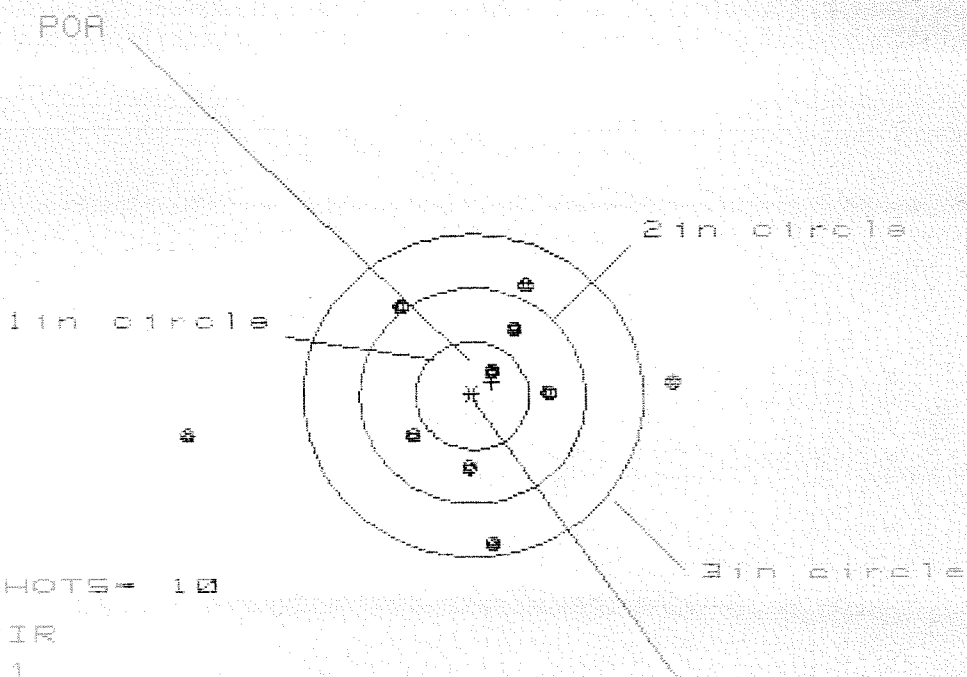
PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.496	1.276	.414
MINIMUM X	:	-1.979	-.844	-.684
MAXIMUM Y	:	1.077	1.095	1.103
MINIMUM Y	:	-1.384	-1.366	-1.358
CENTROID X	:	-.066	.154	-.006
CENTROID Y	:	.155	.137	.129
POR TO CENTROID in.	:	.169	.206	.129
MIN RADIUS	:	.068	.203	.132
MEAN RADIUS	:	.973	.862	.780
MAX RADIUS	:	1.985	1.379	1.401
HORIZONTAL SPREAD	:	3.475	2.120	1.098
VERTICAL SPREAD	:	2.461	2.461	2.461
EXTREME SPREAD	:	3.477	2.603	2.603
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS

4



OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 8

HS= 4.251

VS= 2.417

GS= 4.291

CENTROID *

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.732	1.450	.575
MINIMUM X	-2.530	-.864	-.682
MAXIMUM Y	1.010	.965	.971
MINIMUM Y	-1.407	-1.452	-1.446
CENTROID X	-.168	.114	-.068
CENTROID Y	-.133	-.088	-.094
POA TO CENTROID in.	.214	.143	.116
MIN RADIUS	.326	.222	.240
MEAN RADIUS	1.089	.882	.807
MAX RADIUS	2.562	1.456	1.448
HORIZONTAL SPREAD	4.261	2.314	1.257
VERTICAL SPREAD	2.417	2.417	2.417
EXTREME SPREAD	4.291	2.430	2.430
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

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FILE:/PATTERNING/CENTERFIRE_PATT/C664B937

CENTERFIRE PATTERNS

3

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 10

HS= 1.260

VS= 2.086

GS= 2.095

CENTROID *

PATTERN #

3

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.590

.621

.691

MINIMUM X

-.670

-.639

-.561

MAXIMUM Y

1.146

1.079

.365

MINIMUM Y

-.940

-.812

-.678

CENTROID X

.151

.120

.042

CENTROID Y

.022

-.106

-.240

POA TO CENTROID in.

.153

.160

.244

MIN RADIUS

.179

.123

.171

MEAN RADIUS

.674

.597

.506

MAX RADIUS

1.180

1.245

.897

HORIZONTAL SPREAD

1.260

1.260

1.252

VERTICAL SPREAD

2.086

1.891

1.043

EXTREME SPREAD

2.095

1.894

1.455

NUMBER IN ONE INCH CIRCLE =

4

NUMBER IN TWO INCH CIRCLE =

7

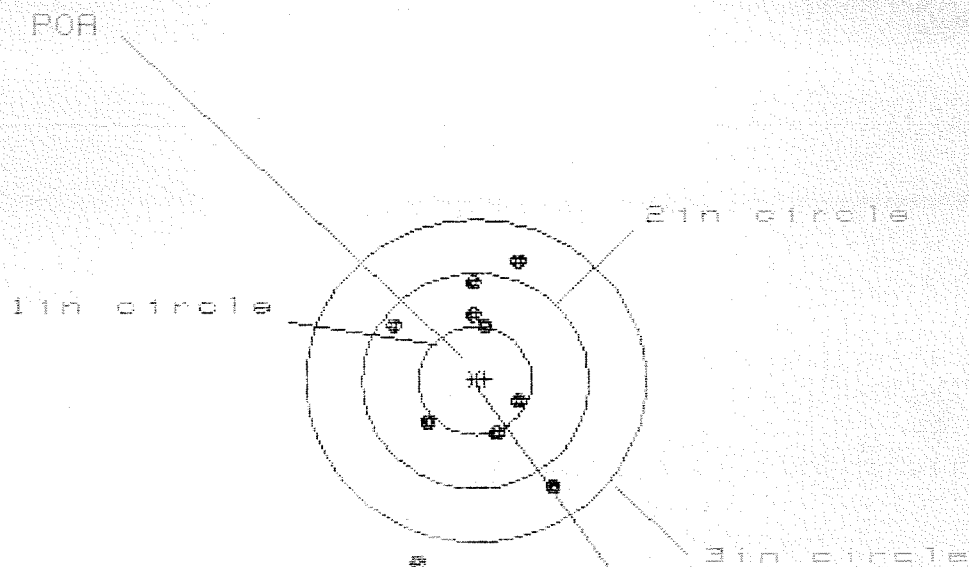
NUMBER IN THREE INCH CIRCLE =

10

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 9

HS= 1.426

VS= 2.747

GS= 2.894

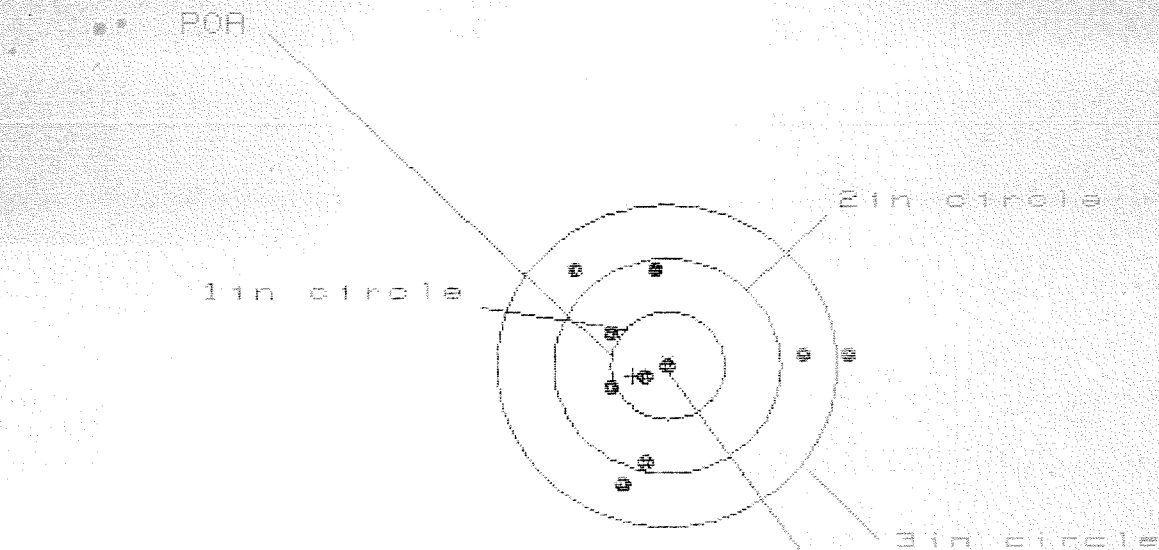
CENTROID #

PATTERN #	:	2
SHOTS (BEST OF)	:	10 9 8
MAXIMUM X	:	.681 .623 .412
MINIMUM X	:	-.745 -.883 -.725
MAXIMUM Y	:	1.091 .907 .766
MINIMUM Y	:	-1.656 -1.131 -.845
CENTROID X	:	-.081 -.023 -.101
CENTROID Y	:	-.016 .168 .309
POA TO CENTROID in.	:	.082 .170 .325
MIN RADIUS	:	.425 .369 .249
MEAN RADIUS	:	.863 .737 .636
MAX RADIUS	:	1.736 1.291 .875
HORIZONTAL SPREAD	:	1.426 1.426 1.137
VERTICAL SPREAD	:	2.747 2.938 1.611
EXTREME SPREAD	:	2.894 2.058 1.704
NUMBER IN ONE INCH CIRCLE	=	1
NUMBER IN TWO INCH CIRCLE	=	7
NUMBER IN THREE INCH CIRCLE	=	9

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FILE:/PATTERNING/CENTERFIRE_PATT/C6648937

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 2.340

VS= 1.999

GS= 2.458

CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.563	1.337	1.307
MINIMUM X	:	-1.777	-1.603	-1.633
MAXIMUM Y	:	.880	.894	.756
MINIMUM Y	:	-1.119	-1.105	-1.001
CENTROID X	:	.304	.130	.160
CENTROID Y	:	.099	.085	.223
POR TO CENTROID in.	:	.319	.155	.274
MIN RADIUS	:	.058	.117	.192
MEAN RADIUS	:	.836	.715	.675
MAX RADIUS	:	1.568	1.347	1.307
HORIZONTAL SPREAD	:	2.340	1.940	1.940
VERTICAL SPREAD	:	1.999	1.999	1.757
EXTREME SPREAD	:	2.458	2.074	2.074
NUMBER IN ONE INCH CIRCLE	=	2	2	2
NUMBER IN TWO INCH CIRCLE	=	6	6	6
NUMBER IN THREE INCH CIRCLE	=	9	9	9