

C6611653

MODEL 700™ M24

Model **SAS**™

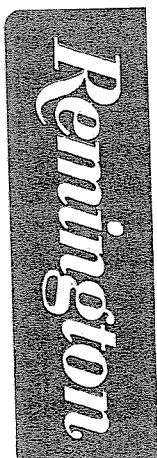
Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.






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

MODEL 700™ H24

SERIAL NO.
C6611653

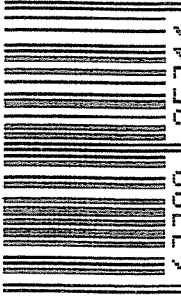
ORDER NO.
5716

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



5716 C6611653

UPC



0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611653

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	2 1 91		RW
600	Proof	2 1 91		RW
607	Check Headspace	2 1 91		RW
610	Dis-assemble Gun	2 1 91		RW
612	Magnaflux Barrel Action	2 1 91		Kcd
	Magnaflux Bolt	2 1 91		Kcd
615	Rollmark Caliber	2 1 1		GS
617	Drill and Tap Sight Holes	2 1 3 91		LB
618	Polish Barrel RBB	2 1 3 91		WB
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		3/25/91	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		3/25/91	WB
	C) Inspect Ejector Hole for Chamfer		3/25/91	WB
	D) Oil Firing Pin Ass'y		3/25/91	WB
	E) Adjust Trigger Pull to Min Setting and Stake		4/5/91	GM

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			4/5/91	RL
	G) Safety Off Force	3	3	3			4/5/91	RL
	H) Trigger Pull Test & Retainability						4/5/91	RL
	I) Firing Pin Indent	.023	.023	.022			4/5/91	RL
	J) Assemble Stock						4/12/91	RW
	K) Assemble Swivel Studs						4-17-91	L
	L) Attach Front and Rear Sight Assemblies						4/12/91	RW
	M) Iron Sight Alignment						4/12/91	RW
	N) Detach Front & Rear Sights & place in numbered container						4/12/91	RW
	O) Attach Scope to Rifle						4/12/91	RW
	P) Detach & Attach Scope 20 Times						4/12/91	RW
640	Gallery Target & Test						4-12-91	RF
	A) Time						"	RF
	B) Malfunctions						"	RF
	C) Pierced Primers						"	RF
	D) Optical Clarity of Scope						"	RF
645	Inspect for Live Ammo						4-12-91	RF
655	Final Inspection							
	A) Headspace						4-17-91	L
	B) Trigger Pull	2.28	2.27	2.33	2.33	2.33	4/16/91	RL
	C) Function						4-17-91	L
660	Pack						6-19-91	RF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C4611653

DATE 4/5/91

TESTER JLP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.39	2.51	2.39	2.28	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.27	2.32	2.14	2.27	
PULL #3	2.32	2.30	2.15	2.33	
PULL #4	2.39	2.36	2.16	2.33	
PULL #5	2.43	2.40	2.25	2.33	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.47	3.37		
PULL #2	3.45	3.33		
PULL #3	3.43	3.36		
PULL #4	3.43	3.38		
PULL #5	3.43	3.43		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.32	4.40		4.43
PULL #2	4.42	4.36		4.39
PULL #3	4.45	4.31		4.31
PULL #4	4.35	4.38		4.36
PULL #5	4.42	4.32		4.40
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611653
12 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.0414005
1 TO	2	.322386
1 TO	3	.106607
1 TO	4	.213843
1 TO	5	.109567

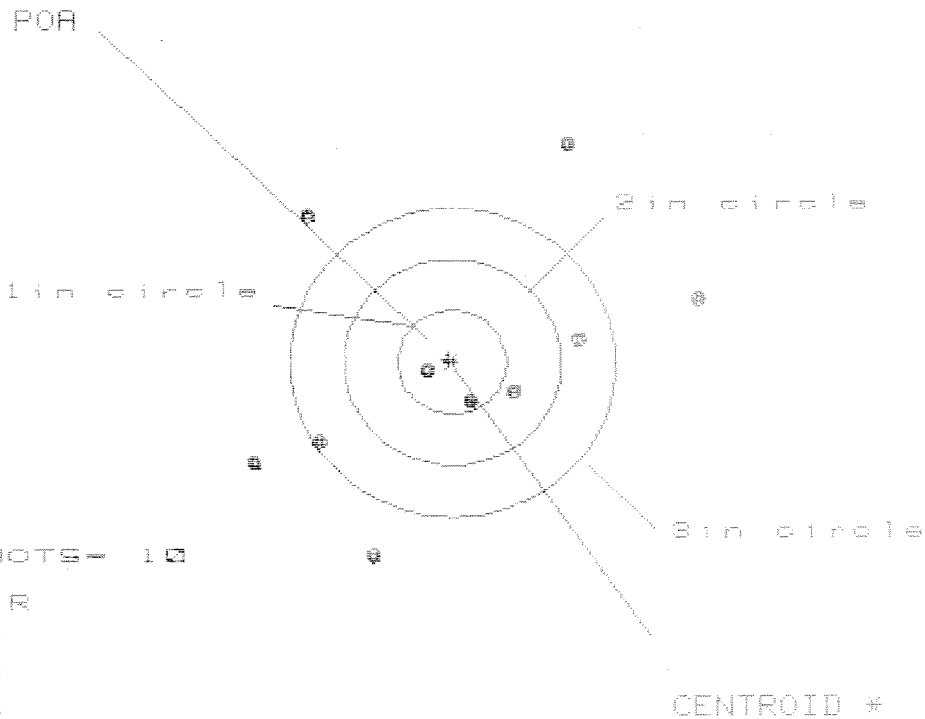
29 <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.089
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0186
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0909228
THE AMP FOR THIS RIFLE IS: 1.002

12 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611653

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 3

3in = 5

HS= 4.084

VS= 4.040

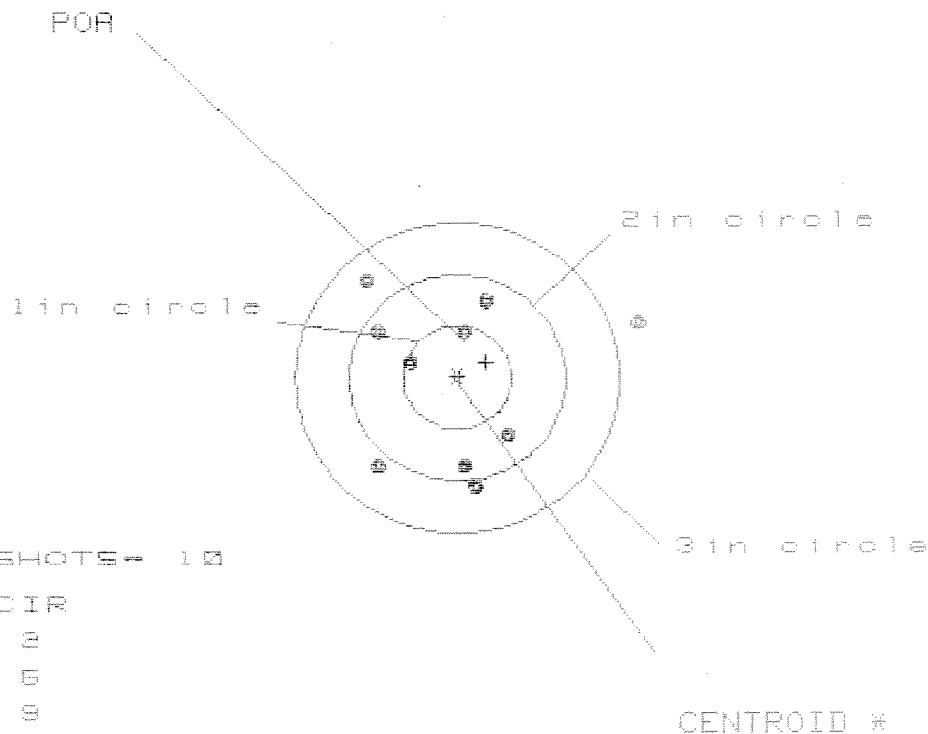
GS= 4.443

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.282	2.406	1.584
MINIMUM X	:	-1.802	-1.678	-1.377
MAXIMUM Y	:	2.134	1.693	1.806
MINIMUM Y	:	-1.906	-1.669	-1.556
CENTROID X	:	.033	-.090	-.391
CENTROID Y	:	-.025	-.262	-.375
POA TO CENTROID in.	:	.042	.277	.542
MIN RADIUS	:	.227	.157	.332
MEAN RADIUS	:	1.488	1.350	1.218
MAX RADIUS	:	2.406	2.570	2.028
HORIZONTAL SPREAD	:	4.084	4.084	2.961
VERTICAL SPREAD	:	4.040	3.362	3.362
EXTREME SPREAD	:	4.443	4.416	3.417
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		5	

12 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C08B11653

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HE= 2.583

VS= 2.017

QS= 2.807

CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.712	.673	.588
MINIMUM X	:	-.870	-.680	-.608
MAXIMUM Y	:	.978	1.041	.948
MINIMUM Y	:	-1.039	-.976	-.846
CENTROID X	:	-.265	-.456	-.371
CENTROID Y	:	-.148	-.211	-.341
POR TO CENTROID in.	:	.304	.502	.504
MIN RADIUS	:	.469	.315	.461
MEAN RADIUS	:	.947	.831	.776
MAX RADIUS	:	1.804	1.243	1.020
HORIZONTAL SPREAD	:	2.583	1.353	1.196
VERTICAL SPREAD	:	2.017	2.017	1.794
EXTREME SPREAD	:	2.807	2.270	1.900
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

12 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06811653

CENTERFIRE PATTERNS

3

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 7

HS= 3.399

VS= 1.938

GS= 3.485

CENTROID #

PATTERN #

3

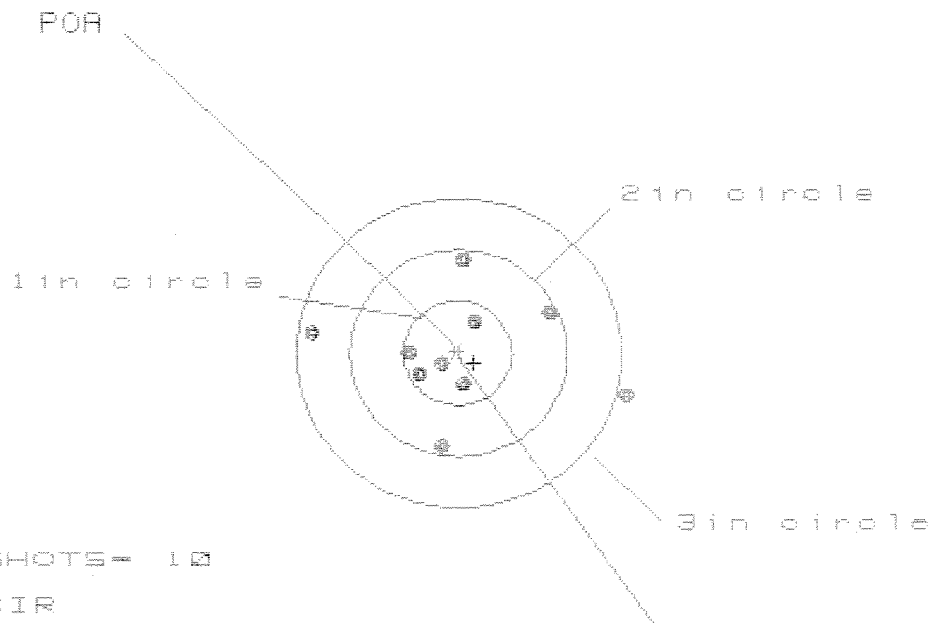
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.912	1.851	1.123
MINIMUM X	:	-1.487	-1.274	-1.043
MAXIMUM Y	:	1.147	.869	.845
MINIMUM Y	:	-.791	-.663	-.687
CENTROID X	:	-.053	-.266	-.497
CENTROID Y	:	-.088	-.216	-.192
POA TO CENTROID in.	:	.103	.342	.533
MIN RADIUS	:	.277	.067	.139
MEAN RADIUS	:	1.058	.863	.718
MAX RADIUS	:	2.230	1.861	1.177
HORIZONTAL SPREAD	:	3.399	3.125	2.166
VERTICAL SPREAD	:	1.938	1.532	1.532
EXTREME SPREAD	:	3.485	3.216	2.217
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

12 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C0611653

CENTERFIRE PATTERNS

4



OF SHOTS= 10

IN CIR

1in = 5

2in = 8

3in = 9

HS= 2.841

VS= 1.759

GS= 2.891

CENTROID #

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.519	.990	.846
MINIMUM X	-1.322	-1.153	-.463
MAXIMUM Y	.887	.847	.864
MINIMUM Y	-.872	-.912	-.895
CENTROID X	-.144	-.313	-.169
CENTROID Y	.095	.135	.118
POA TO CENTROID in.	.173	.341	.206
MIN RADIUS	.193	.117	.182
MEAN RADIUS	.728	.611	.545
MAX RADIUS	1.562	1.161	.914
HORIZONTAL SPREAD	2.841	2.143	1.309
VERTICAL SPREAD	1.759	1.759	1.759
EXTREME SPREAD	2.891	2.152	1.769
NUMBER IN ONE INCH CIRCLE =		5	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		9	

12 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C68611653

CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 4

2in = 7

3in = 8

HS= 2.993

VS= 1.538

GS= 3.107

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.759	.965	.835
MINIMUM X	:	-1.234	-1.039	-.996
MAXIMUM Y	:	.776	.691	.690
MINIMUM Y	:	-.762	-.517	-.518
CENTROID X	:	-.016	-.211	-.081
CENTROID Y	:	.073	.158	.159
POA TO CENTROID in.	:	.075	.264	.179
MIN RADIUS	:	.107	.258	.210
MEAN RADIUS	:	.790	.653	.596
MAX RADIUS	:	1.917	1.086	1.009
HORIZONTAL SPREAD	:	2.993	2.004	1.831
VERTICAL SPREAD	:	1.538	1.208	1.208
EXTREME SPREAD	:	3.107	2.062	1.948
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER

R 94-18384

INITIAL FDC CUSTOMER ORDER NO. DAAA09-92-C-0834

W/10X SCOPE, M-24 SNIPER, W/DEPLOYMENT KIT

ATTN: FRED MARTIN

SCOPE 90-0119

DATE RECEIVED 06/11/94

DATE OPENED 06/11/94

DATE CODE

SERIAL NUMBER

C6611653

NEW SERIAL NUMBER

MODEL AND GRADE

700 7.62

NATO

ACCESSORIES

SLING STRAP

HARD CASE

SCOPE MNTS

SCOPE BASE

FROM:

SHIP TO:

COMMANDER (W52H094138H226)
DEFENSE DIST DEPOT ANNISTON
ATTN DDAA-UR BLDG 112
ANNISTON

AL 36201-5025

COMMANDER (W52H094138H226)
DEFENSE DIST DEPOT ANNISTON
ATTN DDAA-UR BLDG 112
ANNISTON

AL
36201-5025

CUST NO: 098397 C.A.D.

ACCOUNT NUMBER

ACCOUNT NUMBER N/C

WRITE

☐

PROM. DATE

ESTIMATED

VIA

FRT

GUN CONDITION

☐ NEW

☐ LIGHTLY WORN

☐ WORN

☐ VERY WORN

☐ UNREPAIRABLE

☐ MARRED

REPAIR CHARGE

EXCISE

TAX

INSURANCE

UPS

PARCEL POST

TOTAL

CUSTOMER CONCERN	AMMO	FUNCTION	FINISH	ACCURACY	FIT	INSPECT
CYCLE	A1	B1				
TRIGGER GROUP		B2			E1	F1
BOLT ASSY.		B3			E2	F2
BARREL ASSY.		B4		D1	E3	F3
REC. ASSY.		B5		D2	E4	F4
WOOD			C1	D3	E5	F5
METAL			C2			

MAIN FAULT

PARTS

COMMENTS

Trigger Assy \$173.31
CIT 50.00
\$223.31

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

GALLERY TESTER

DATE

DATE

DATE

DATE

DATE

OFFICE COPY

RD6925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400033860

SWS TRIGGER PULL TEST

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

SERIAL NO. C6611653

DATE 2-20-96

TESTER GA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.80	2.83	2.32	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.84	2.78	2.55	
PULL #3	2.88	2.80	2.59	
PULL #4	2.74	2.90	2.70	
PULL #5	2.89	2.92	2.82	
TOTAL	1415	1423	1298	
AVG.	2.83	2.84	2.59	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.19	3.21		
PULL #2	3.12	3.00		
PULL #3	3.29	3.05		
PULL #4	3.15	3.22		
PULL #5	3.09	3.03		
TOTAL	1584	1551		
AVG.	3.16	3.10		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.23	4.30		4.23
PULL #2	4.28	4.21		4.22
PULL #3	4.27	4.19		4.01
PULL #4	4.48	4.16		4.28
PULL #5	4.46	4.16		4.27
TOTAL	2172	2102		2101
AVG.	4.34	4.20		4.20

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6611653

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock			
600	Proof			
607.	Check Headspace			
610	Dis-assemble Gun			
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	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			

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6 1/4	6 1/2	6 1/2			2/23/96	W3
	G) Safety Off Force	3 1/4	3 1/2	3 1/2			2/23/96	W3
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent							
	J) Assemble Stock							
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies							
	M) Iron Sight Alignment							
	N) Detach Front & Rear Sights & place in numbered container							
	O) Attach Scope to Rifle							
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test						2/23/96	RC
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection							
	A) Headspace						2/24/96	RW
	B) Trigger Pull	2.44	2.40	2.40	2.33	2.37	2/23/96	W3
	C) Function						2/24/96	RW
660	Pack							