

C6611690

MODEL 700™ M24

Model SAS™

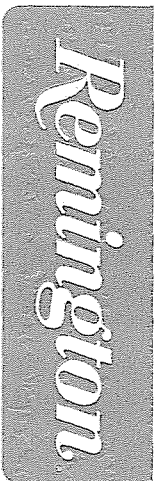
Action _____

Barrel Length _____

Capacity _____

Order No. 5715

*Includes 1 in chamber.



Remington®



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

MODEL 700™ M24

SERIAL NO.
C6611690

ORDER NO.
5716

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

46



5716 C6611690

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611690

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 28	91	RW
600	Proof	3 28	91	RW
607	Check Headspace	3 28	91	RW
610	Dis-assemble Gun	3 28	91	RW
612	Magnaflux Barrel Action		APR 2 1991	KR
	Magnaflux Bolt		APR 2 1991	W
615	Rollmark Caliber		APR 2 1991	LS
617	Drill and Tap Sight Holes		APR 5 1991	LB
618	Polish Barrel		APR 5 1991	WB
620	Apply Coatings (Barrel Action)		4-9-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/10/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/10/91	RW
	C) Inspect Ejector Hole for Chamfer		4/10/91	RW
	D) Oil Firing Pin Ass'y		4/10/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4/18/91	JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			4/18/91	RL
	G) Safety Off Force	4	4	4			4/18/91	RL
	H) Trigger Pull Test & Retainability						4/18/91	RL
	I) Firing Pin Indent	.0225	.0225	.0225			4/18/91	RL
	J) Assemble Stock						4/19/91	RW
	K) Assemble Swivel Studs						4-23-91	D/H
	L) Attach Front and Rear Sight Assemblies						4/19/91	RW
	M) Iron Sight Alignment						4/19/91	RW
	N) Detach Front & Rear Sights & place in numbered container						4/19/91	RW
	O) Attach Scope to Rifle						4/19/91	RW
	P) Detach & Attach Scope 20 Times						4/19/91	RW
640	Gallery Target & Test						4-19-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						4-19-91	NF
655	Final Inspection							
	A) Headspace						4-23-91	D/H
	B) Trigger Pull	2.32	2.31	2.33	2.23	2.33	4/22/91	RL
	C) Function						4-23-91	D/H
660	Pack						6-17-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6611690

DATE 4/18/91

TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.19	2.38	2.43	2.32	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.43	2.31	2.38	2.31	
PULL #3	2.43	2.41	2.40	2.33	
PULL #4	2.42	2.39	2.38	2.23	
PULL #5	2.32	2.41	2.40	2.33	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.42	3.40		
PULL #2	3.39	3.21		
PULL #3	3.38	3.40		
PULL #4	3.36	3.39		
PULL #5	3.34	3.45		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.37	4.39		4.43
PULL #2	4.38	4.41		4.50
PULL #3	4.39	4.45		4.52
PULL #4	4.44	4.45		4.53
PULL #5	4.31	4.46		4.51
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611690
19 Apr 1991

CENTROIDAL DISTANCES

0 TO 1	.0980867
1 TO 2	.0997246
1 TO 3	.252622
1 TO 4	.281775
1 TO 5	.195451

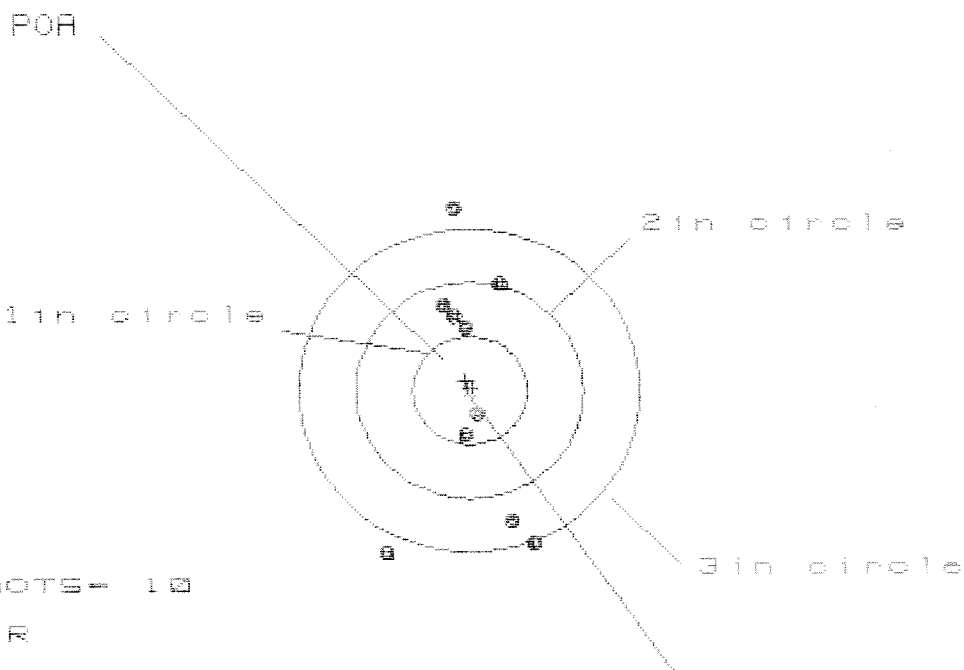
50 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0426
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0766
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0876488
THE AMR FOR THIS RIFLE IS: .9444

19 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611690

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 7

HS= 1.276

VS= 3.163

GS= 3.214

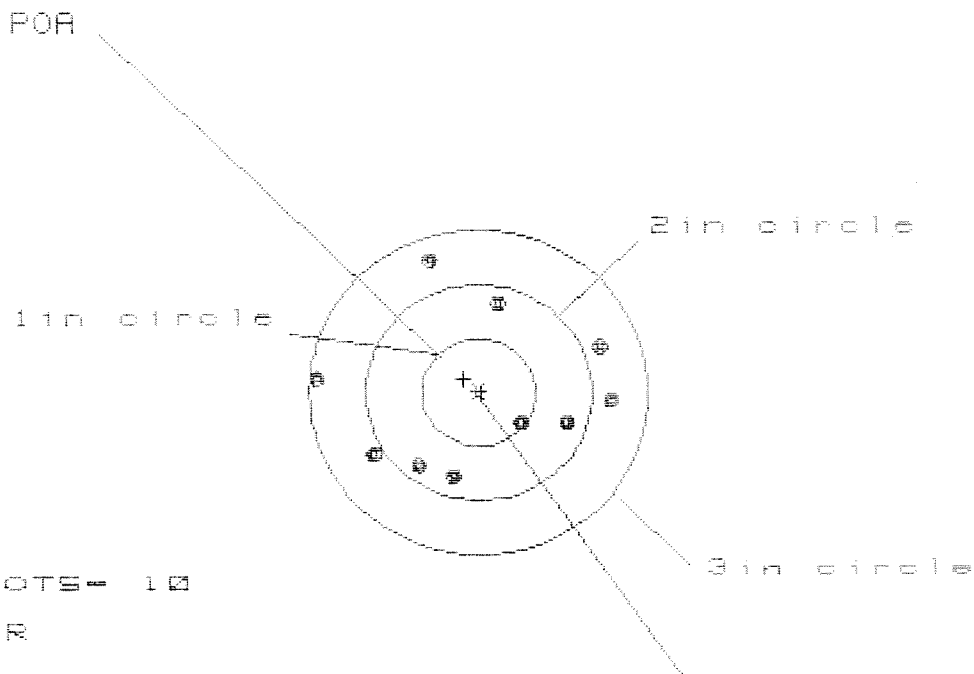
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.585	.571	.483
MINIMUM X	:	-.691	-.785	-.367
MAXIMUM Y	:	1.685	1.172	1.010
MINIMUM Y	:	-1.478	-1.291	-1.386
CENTROID X	:	.039	.053	.141
CENTROID Y	:	-.090	-.277	-.115
POA TO CENTROID in.	:	.098	.282	.182
MIN RADIUS	:	.194	.072	.150
MEAN RADIUS	:	.991	.905	.824
MAX RADIUS	:	1.689	1.471	1.467
HORIZONTAL SPREAD	:	1.276	1.276	.850
VERTICAL SPREAD	:	3.163	2.463	2.396
EXTREME SPREAD	:	3.214	2.635	2.420
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			7	

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 10

HS = 2.559

VS = 2.024

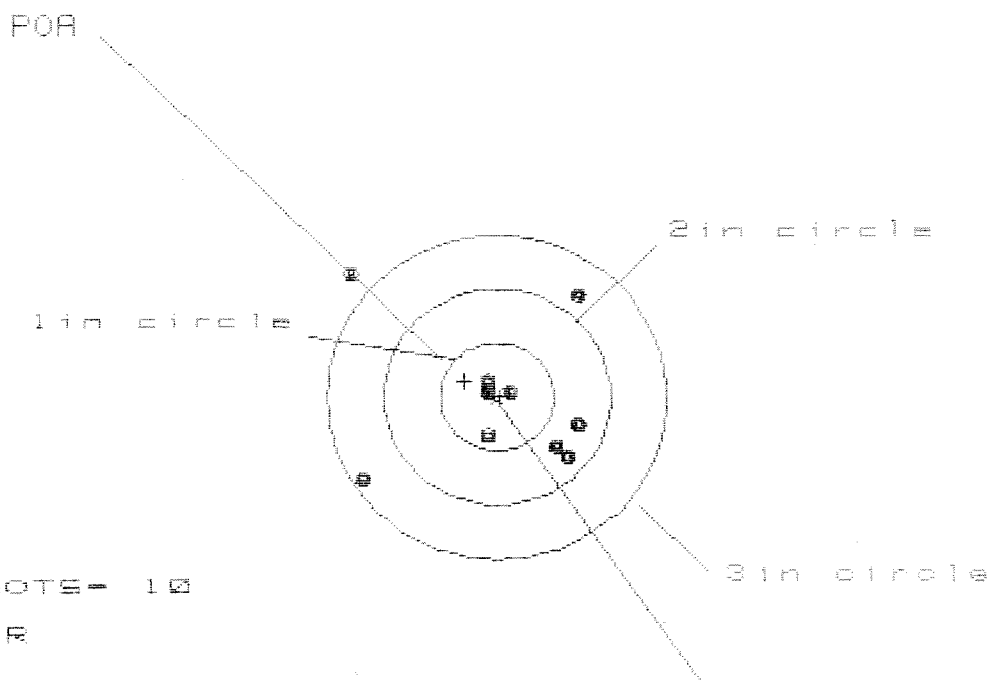
GS = 2.574

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.153	.997	.920
MINIMUM X	:	-1.406	-1.052	-1.129
MAXIMUM Y	:	1.247	1.264	1.004
MINIMUM Y	:	-.777	-.760	-.602
CENTROID X	:	.132	.288	.365
CENTROID Y	:	-.126	-.143	-.301
POA TO CENTROID in.	:	.182	.322	.473
MIN RADIUS	:	.479	.362	.189
MEAN RADIUS	:	.993	.922	.822
MAX RADIUS	:	1.415	1.407	1.187
HORIZONTAL SPREAD	:	2.559	2.049	2.049
VERTICAL SPREAD	:	2.024	2.024	1.606
EXTREME SPREAD	:	2.574	2.209	2.209
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 4

2in = 7

3in = 9

HS = 1.996

VS = 1.856

GS = 2.585

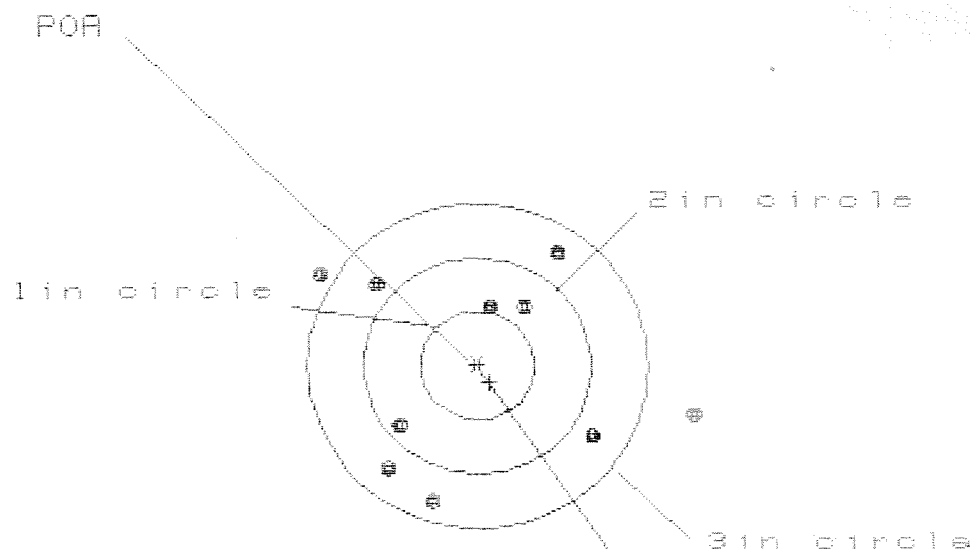
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.714	.572	.401
MINIMUM X	:	-1.282	-1.370	-.399
MAXIMUM Y	:	1.126	1.078	1.002
MINIMUM Y	:	-.730	-.605	-.551
CENTROID X	:	.286	.428	.599
CENTROID Y	:	-.143	-.268	-.192
POR TO CENTROID in.	:	.319	.505	.629
MIN RADIUS	:	.042	.197	.255
MEAN RADIUS	:	.736	.623	.521
MAX RADIUS	:	1.706	1.498	1.077
HORIZONTAL SPREAD	:	1.996	1.942	.800
VERTICAL SPREAD	:	1.856	1.683	1.553
EXTREME SPREAD	:	2.585	2.565	1.554
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 0

2in = 3

3in = 8

HS= 2.261

VS= 2.314

GS= 3.521

CENTROID *

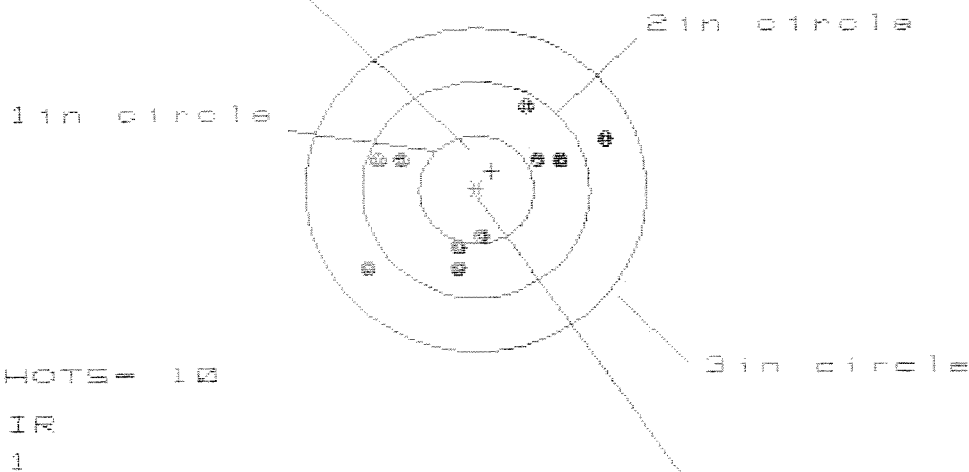
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.887	1.198	1.052
MINIMUM X	:	-1.374	-1.164	-.806
MAXIMUM Y	:	1.093	1.043	1.146
MINIMUM Y	:	-1.221	-1.271	-1.168
CENTROID X	:	-.107	-.317	-.171
CENTROID Y	:	.151	.201	.098
POA TO CENTROID in.	:	.185	.375	.197
MIN RADIUS	:	.567	.608	.636
MEAN RADIUS	:	1.191	1.093	1.044
MAX RADIUS	:	1.941	1.428	1.365
HORIZONTAL SPREAD	:	3.261	2.362	1.858
VERTICAL SPREAD	:	2.314	2.314	2.314
EXTREME SPREAD	:	3.521	2.801	2.570
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5

POA



OF SHOTS= 10

IN CIR

1in = 1

2in = 8

3in = 10

HS= 2.107

VS= 1.552

GS= 2.392

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.099	.987	.772
MINIMUM X	:	-1.008	-1.017	-.894
MAXIMUM Y	:	.815	.738	.784
MINIMUM Y	:	-.737	-.814	-.768
CENTROID X	:	-.137	-.025	-.148
CENTROID Y	:	-.175	-.098	-.144
POA TO CENTROID in.	:	.222	.101	.207
MIN RADIUS	:	.386	.479	.417
MEAN RADIUS	:	.811	.762	.715
MAX RADIUS	:	1.221	1.053	.923
HORIZONTAL SPREAD	:	2.107	2.004	1.666
VERTICAL SPREAD	:	1.552	1.552	1.552
EXTREME SPREAD	:	2.392	2.012	1.677
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	