

06225079

MODEL 700™ M24

Model **SAS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Smead



Remington®



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

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

MODEL 700™ H24

SERIAL NO.

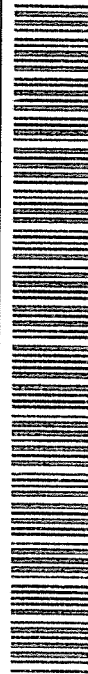
C6225079

ORDER NO.

5716

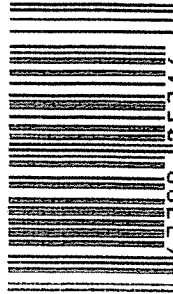
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



5716 C6225079

UPC



0 47700 25716

7

Score 0432

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225079

OP.#	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and stock	8	9/88	FB
600	Proof	9	7/88	RW
607	Check Headspace	9	7/88	RW
610	Dis-assemble gun	9	7/88	RW
612	Magnaflux Barrel Action		9-14-88	Pfe.
	Magnaflux Bolt		9-14-88	Pfe.
615	Rollmark Caliber		10/22	G.S.
617	Drill & Tap Sight Holes		10/23	G.S.
618	Polish Barrel		10/24	WST
620	Apply Coatings (Barrel Action)		10-31-88	TJA
	Apply Coatings (Bolt)		10-31-88	TJA
625	Final Assembly A) Clean inside of Bolt Assembly		1/11/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/11/89	RW
	C) Inspect Ejector Hole for Chamfer		1/11/89	RW

OVER

OP.#		READINGS	DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y		1/11/89	RW
	E) Adjust Trigger Pull to Min. Setting and Stake		10 Jan 89	JS
	F) Safety on Force	6 5 5	11 Jan 89	JS
	G) Safety off Force	4 4 4	11 Jan 89	JS
	H) Trigger Pull Test & Retainability		10 Jan 89	JS
	I) Firing Pin Indent	.021 .0215 .022	11 Jan 89	JS
	J) Assemble Stock		1/11/89	RW
	K) Assemble Swivel Studs		31 Jan 89	JS
	L) Attach Front & Rear Sight Assemblies		1/11/89	RW
	M) Iron Sight Alignment		1/11/89	RW
	N) Detach Front & Rear Sights & place in numbered container		1/11/89	RW
	O) Attach Scope to Rifle		16 Jan 89	JS
	P) Detach & Attach Scope 20 times		16 Jan 89	JS
640	Gallery Target & Test	75R 76L	1/24/89	AC
	A) Optical Clarity of Scope	OK	1/24/89	AC
645	Inspect for Live Ammo	NONE	1/24/89	AC
655	Final Inspection			
	A) Headspace		31 Jan 89	JS
	B) Trigger Pull		31 Jan 89	JS
	C) Function		31 Jan 89	JS
660	Pack		3/77	WB

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. 1225079

DATE 4-11-90

TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.44	2.41	2.54	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.49	2.44	2.53	
PULL #3	2.47	2.40	2.54	
PULL #4	2.44	2.42	2.49	
PULL #5	2.41	2.29	2.44	
TOTAL	12.25	11.96	12.54	
AVG.	2.45	2.392	2.508	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.40	3.37	
PULL #2	3.36	3.45	
PULL #3	3.35	3.39	
PULL #4	3.42	3.43	
PULL #5	3.42	3.44	
TOTAL	16.95	17.08	
AVG.	3.39	3.416	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.04	4.24		
PULL #2	4.26	4.31		
PULL #3	4.23	4.22		
PULL #4	4.33	4.31		
PULL #5	4.31	4.32		
TOTAL	21.17	21.40		
AVG.	4.234	4.28		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225079
26 Jan 1989

CENTROIDAL DISTANCES

0 TO	1	.891992
1 TO	2	1.3641
1 TO	3	1.18565
1 TO	4	1.22971
1 TO	5	.474423

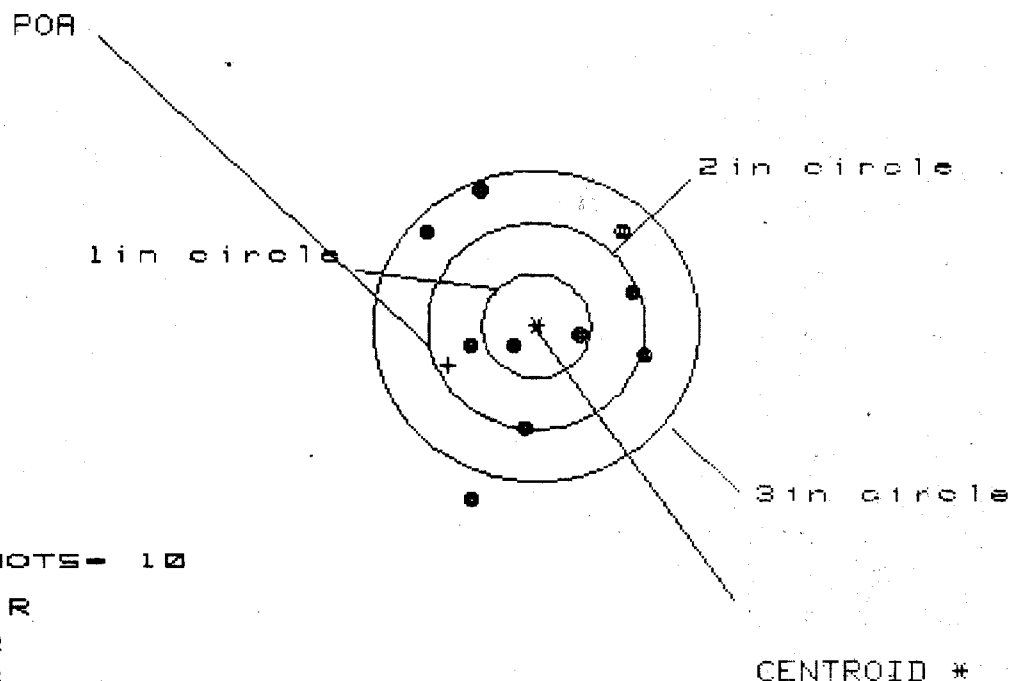
$\frac{5}{4} +$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.014
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .212
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .212462
THE AMR FOR THIS RIFLE IS: 1.022

25 Jan 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6225079

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS= 1.951

VS= 2.991

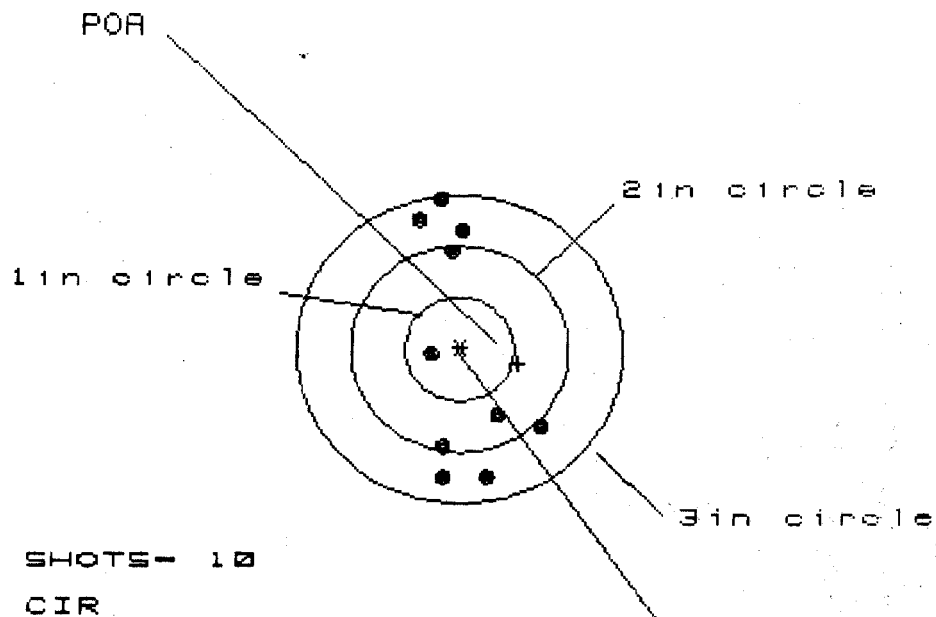
GS= 2.992

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.955	.890	.818
MINIMUM X	-.996	-1.061	-1.133
MAXIMUM Y	1.346	1.163	.910
MINIMUM Y	-1.645	-1.195	-1.050
CENTROID X	.807	.872	.944
CENTROID Y	.380	.563	.418
POA TO CENTROID in.	.892	1.038	1.032
MIN RADIUS	.307	.428	.277
MEAN RADIUS	1.003	.929	.848
MAX RADIUS	1.745	1.308	1.453
HORIZONTAL SPREAD	1.951	1.951	1.951
VERTICAL SPREAD	2.991	2.358	1.960
EXTREME SPREAD	2.992	2.388	2.303
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

25 Jan 1989

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 1

2in = 4

3in = 10

HS = 1.0000

VS = 2.704

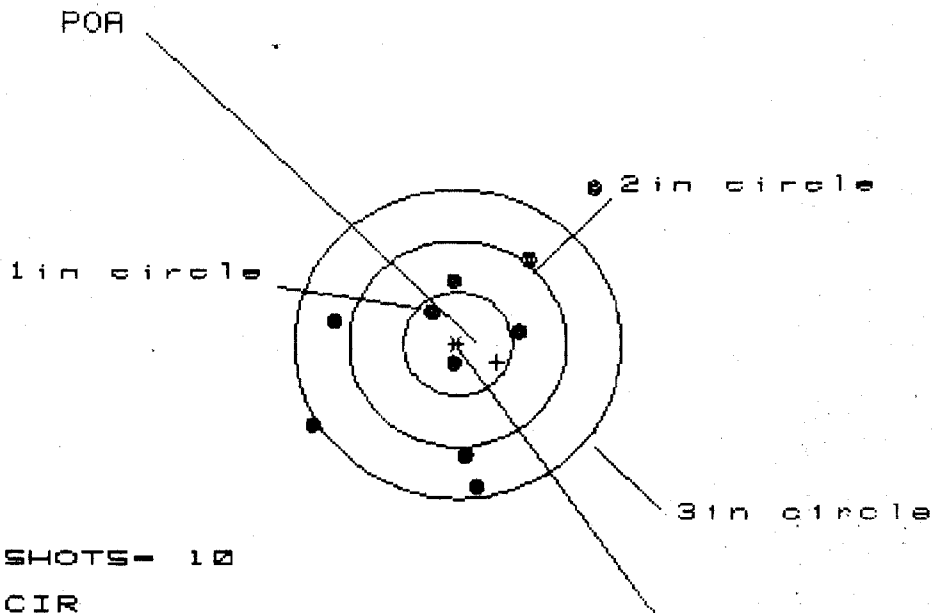
GS = 2.732

PATTERN #			
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.695	.675	.625
MINIMUM X	-.385	-.405	-.372
MAXIMUM Y	1.450	1.424	1.546
MINIMUM Y	-1.254	-1.092	-.914
CENTROID X	-.536	-.516	-.466
CENTROID Y	.141	-.021	-.199
POA TO CENTROID in.	.554	.517	.506
MIN RADIUS	.312	.332	.412
MEAN RADIUS	1.052	.979	.873
MAX RADIUS	1.461	1.480	1.546
HORIZONTAL SPREAD	1.080	1.080	.997
VERTICAL SPREAD	2.704	2.516	2.460
EXTREME SPREAD	2.732	2.585	2.467
NUMBER IN ONE INCH CIRCLE	=	1	
NUMBER IN TWO INCH CIRCLE	=	4	
NUMBER IN THREE INCH CIRCLE	=	10	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10
 # IN CIR
 1 in = 2
 2 in = 4
 3 in = 8
 HS= 2.631
 VS= 2.890
 GS= 3.537

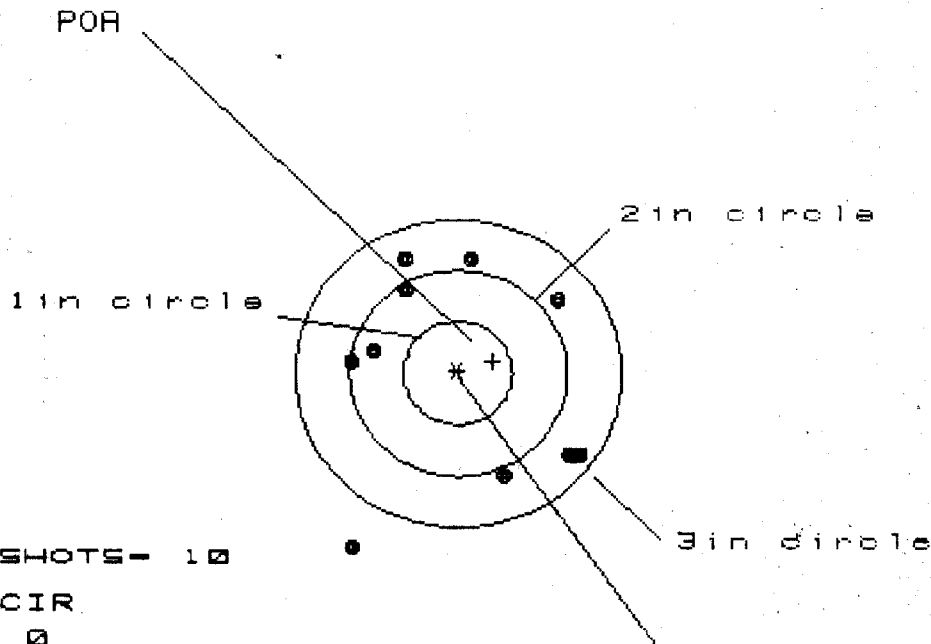
CENTROID #

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.294	.829	.680
MINIMUM X	:	-1.337	-1.193	-1.103
MAXIMUM Y	:	1.540	.968	.886
MINIMUM Y	:	-1.350	-1.179	-1.261
CENTROID X	:	-.362	-.506	-.357
CENTROID Y	:	.182	.011	.093
POA TO CENTROID in.	:	.406	.506	.369
MIN RADIUS	:	.207	.141	.118
MEAN RADIUS	:	.989	.876	.789
MAX RADIUS	:	2.012	1.360	1.270
HORIZONTAL SPREAD	:	2.631	2.022	1.783
VERTICAL SPREAD	:	2.890	2.147	2.147
EXTREME SPREAD	:	3.537	2.592	2.210
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			4	
NUMBER IN THREE INCH CIRCLE =			8	

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1in = 0

2in = 3

3in = 9

HE = 2.048

VS = 2.829

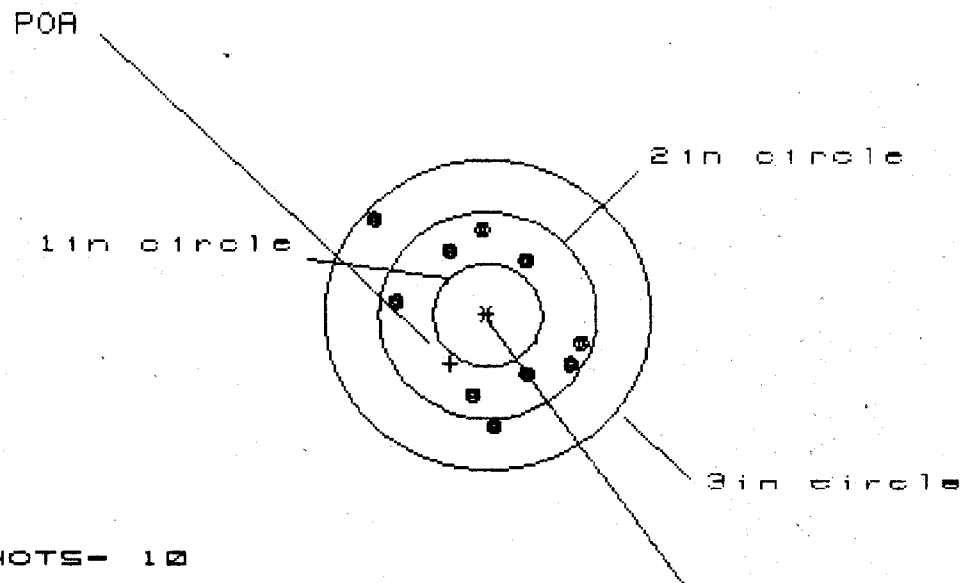
GS = 3.060

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.105	1.002	1.042
MINIMUM X	:	-.943	-1.046	-.921
MAXIMUM Y	:	1.153	.967	.847
MINIMUM Y	:	-1.676	-1.141	-1.261
CENTROID X	:	-.320	-.217	-.342
CENTROID Y	:	-.112	.074	.194
POA TO CENTROID in.	:	.340	.229	.393
MIN RADIUS	:	.793	.856	.703
MEAN RADIUS	:	1.182	1.077	1.000
MAX RADIUS	:	1.918	1.387	1.503
HORIZONTAL SPREAD	:	2.048	2.048	1.963
VERTICAL SPREAD	:	2.829	2.108	2.108
EXTREME SPREAD	:	3.060	2.476	2.427
NUMBER IN ONE INCH CIRCLE	=	0	3	9
NUMBER IN TWO INCH CIRCLE	=	3	9	9
NUMBER IN THREE INCH CIRCLE	=	9	9	9

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 0

2in = 8

3in = 10

HM = 1.948

VS = 2.042

GS = 2.309

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.907	.791	.781
MINIMUM X	:	-1.041	-.962	-.972
MAXIMUM Y	:	.947	.965	.841
MINIMUM Y	:	-1.095	-.990	-.761
CENTROID X	:	.341	.457	.467
CENTROID Y	:	.469	.364	.488
POA TO CENTROID in.	:	.580	.584	.675
MIN RADIUS	:	.609	.495	.536
MEAN RADIUS	:	.884	.807	.779
MAX RADIUS	:	1.407	.993	.976
HORIZONTAL SPREAD	:	1.948	1.753	1.753
VERTICAL SPREAD	:	2.042	1.955	1.602
EXTREME SPREAD	:	2.309	1.958	1.797
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	