

C6611420

MODEL 700™ M24

Model **SAS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington




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

MODEL 700™ H2A

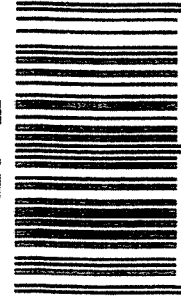
MADE IN ILION, N.Y. USA. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

SERIAL NO.
C6611420

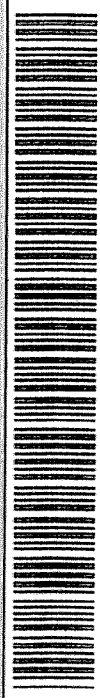
ORDER NO.
5716

20

UPC



0 47700 25716 7



5716 C6611420

MOD.		GA. CAL.	GUN #
# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st	<i>Safe file stock</i>	<i>RW</i>
	2nd	<i>File stock by Safety Arm. Bench Check OK</i>	<i>RW</i>
	3rd		
	4th		
		FUNCTION	RD 5654 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

CEM

GUN SERIAL #

C6611420

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 25 9		RW
600	Proof	1 25 9		RW
607	Check Headspace	1 25 91		RW
610	Dis-assemble Gun	1 25 91		RW
612	Magnaflux Barrel Action	1 25 91		KR
	Magnaflux Bolt	1 25 91		KR
615	Rollmark Caliber	1 25 91		LG
617	Drill and Tap Sight Holes	1 30 91		LB
618	Polish Barrel <i>RBB</i>	1 30 91		WB
620	Apply Coatings (Barrel Action)		2-10-91	TJ
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/11/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/11/91	RW
	C) Inspect Ejector Hole for Chamfer		2/11/91	RW
	D) Oil Firing Pin Ass'y		2/11/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2/15/91	RL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2			2/15/91	WB
	G) Safety Off Force	2	2	2			2/15/91	WB
	H) Trigger Pull Test & Retainability						2/15/91	WJ
	I) Firing Pin Indent	.020	.0205	.020			2/15/91	WB
	J) Assemble Stock						2/15/91	RW
	K) Assemble Swivel Studs						2-25-91	A
	L) Attach Front and Rear Sight Assemblies						2/15/91	RW
	M) Iron Sight Alignment						2/15/91	RW
	N) Detach Front & Rear Sights & place in numbered container						2/15/91	RW
	O) Attach Scope to Rifle						2/15/91	RW
	P) Detach & Attach Scope 20 Times						2/15/91	RW
640	Gallery Target & Test						2-15-91	A
	A) Time						"	A
	B) Malfunctions						"	A
	C) Pierced Primers						"	A
	D) Optical Clarity of Scope						"	A
645	Inspect for Live Ammo						2-15-91	A
655	Final Inspection							
	A) Headspace						2-25-91	A
	B) Trigger Pull	2.15	2.12	2.13	2.15	2.15	2/21/91	WJ
	C) Function						2-25-91	A
660	Pack						3/19/91	W

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C 6611420DATE 2/15/91TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.34	2.27	2.15	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.33	2.24	2.24	2.12	
PULL #3	2.26	2.26	2.35	2.13	
PULL #4	2.21	2.24	2.26	2.15	
PULL #5	2.26	2.27	2.35	2.15	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.23	3.20		
PULL #2	3.29	3.22		
PULL #3	3.23	3.20		
PULL #4	3.14	3.16		
PULL #5	3.20	3.22		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.20	4.37		4.29
PULL #2	4.50	4.42		4.27
PULL #3	4.51	4.39		4.19
PULL #4	4.37	4.29		4.27
PULL #5	4.55	4.19		4.21
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611420
15 Feb 1991

CENTROIDAL DISTANCES

0 TO 1	.243354
1 TO 2	.0601664
1 TO 3	.410943
1 TO 4	.309416
1 TO 5	.384796

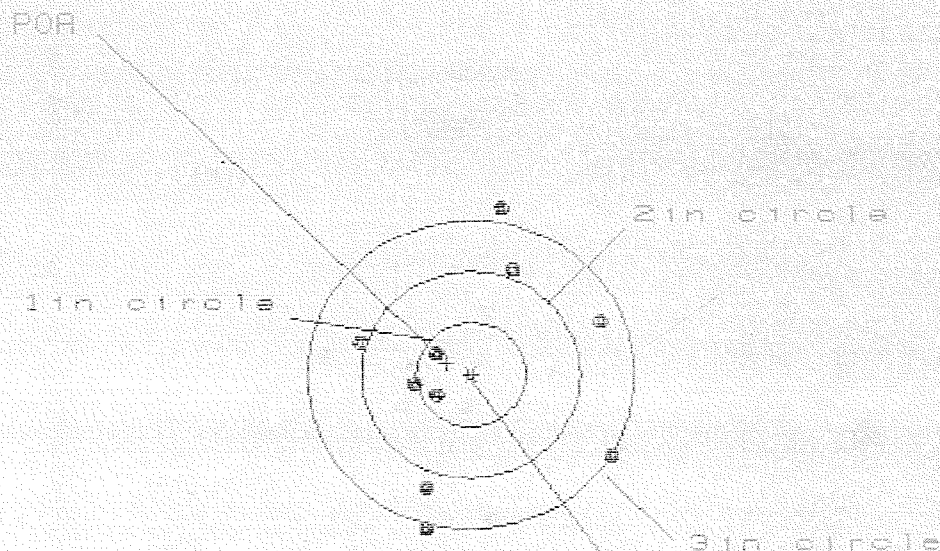
←---POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0042
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0576
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0577529
THE AMP FOR THIS RIFLE IS: .9238

15 Feb 1991

FILE: PATTERNING/CENTERFIRE_PATT/C6611420

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 3

3in = 8

HS= 2.267

VS= 3.002

GS= 3.154

CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.273	1.301	1.253
MINIMUM X	:	-.994	-.966	-1.014
MAXIMUM Y	:	1.626	1.157	.997
MINIMUM Y	:	-1.456	-1.275	-1.112
CENTROID X	:	.215	.187	.235
CENTROID Y	:	-.114	-.295	-.135
POR TO CENTROID in.	:	.244	.349	.271
MIN RADIUS	:	.396	.311	.411
MEAN RADIUS	:	1.061	.984	.936
MAX RADIUS	:	1.646	1.433	1.466
HORIZONTAL SPREAD	:	2.267	2.267	2.267
VERTICAL SPREAD	:	3.002	2.432	2.109
EXTREME SPREAD	:	3.154	2.548	2.536
NUMBER IN ONE INCH CIRCLE =	:	2	2	2
NUMBER IN TWO INCH CIRCLE =	:	3	3	3
NUMBER IN THREE INCH CIRCLE =	:	8	8	8

15 Feb 1991

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CENTERFIRE PATTERNS

2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in - 2

2 in - 7

3 in - 9

HS = 2.756

VS = 1.989

GS = 2.909

CENTROID *

PATTERN #

2

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.463

.965

.824

MINIMUM X

-1.293

-1.131

-.551

MAXIMUM Y

.955

.909

.968

MINIMUM Y

-1.034

-1.080

-1.021

CENTROID X

.157

-.005

.136

CENTROID Y

-.130

-.084

-.143

POA TO CENTROID in.

.204

.084

.197

MIN RADIUS

.080

.219

.105

MEAN RADIUS

.820

.730

.660

MAX RADIUS

1.520

1.225

1.063

HORIZONTAL SPREAD

2.756

2.096

1.375

VERTICAL SPREAD

1.989

1.989

1.989

EXTREME SPREAD

2.909

2.205

1.989

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

7

NUMBER IN THREE INCH CIRCLE =

9

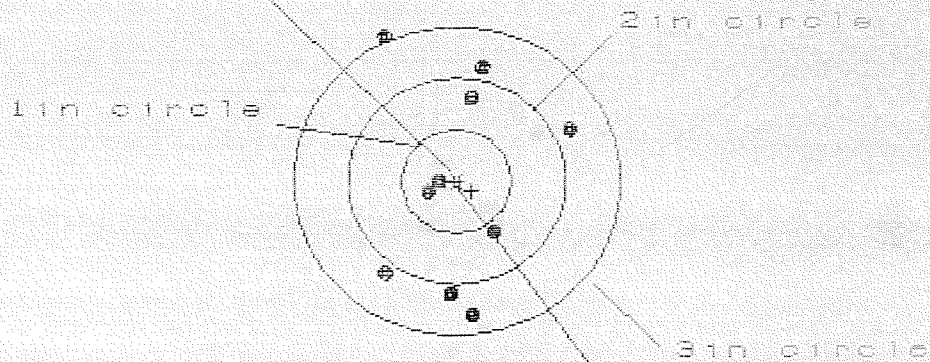
15 Feb 1991

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CENTERFIRE PATTERNS

3

POB



OF SHOTS - 10

IN CIR

1in = 2

2in = 4

3in = 9

HS = 1.729

VS = 2.648

GS = 2.753

CENTROID *

PATTERN #	:	3
SHOTS (BEST OF)	:	10
MAXIMUM X	:	1.836
MINIMUM X	:	-.693
MAXIMUM Y	:	1.374
MINIMUM Y	:	-1.274
CENTROID X	:	-.140
CENTROID Y	:	.093
POB TO CENTROID in.	:	.168
MIN RADIUS	:	.192
MEAN RADIUS	:	.915
MAX RADIUS	:	1.524
HORIZONTAL SPREAD	:	1.729
VERTICAL SPREAD	:	2.648
EXTREME SPREAD	:	2.753
NUMBER IN ONE INCH CIRCLE =	:	2
NUMBER IN TWO INCH CIRCLE =	:	4
NUMBER IN THREE INCH CIRCLE =	:	9

15 Feb 1981

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CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 2

2in = 8

3in = 10

HS= 1.608

VS= 2.308

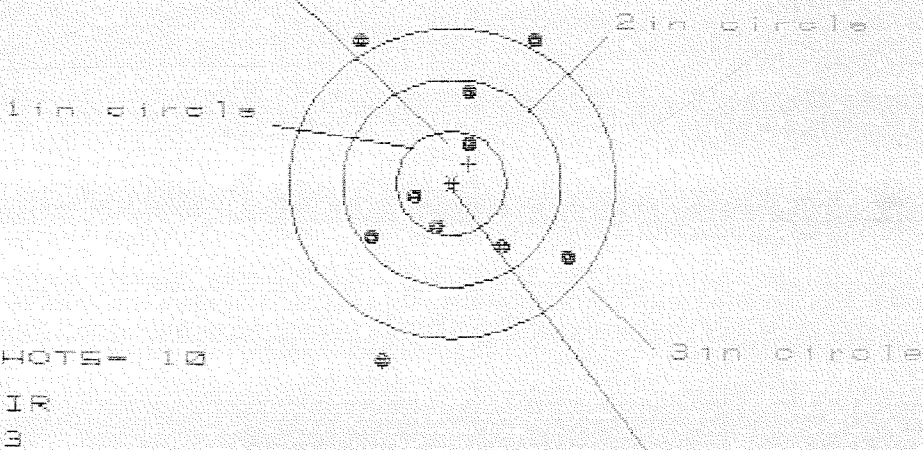
GS= 2.341

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.705	.773	.809
MINIMUM X	-.903	-.835	-.799
MAXIMUM Y	1.297	.870	.761
MINIMUM Y	-1.011	-.867	-.859
CENTROID X	-.048	-.116	-.152
CENTROID Y	.049	-.095	.014
POA TO CENTROID in.	.069	.150	.153
MIN RADIUS	.326	.251	.216
MEAN RADIUS	.797	.712	.672
MAX RADIUS	1.435	.915	.940
HORIZONTAL SPREAD	1.608	1.608	1.608
VERTICAL SPREAD	2.308	1.737	1.620
EXTREME SPREAD	2.341	1.778	1.751
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	

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CENTERFIRE PATTERNS # 5

POA



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 6

3 in = 7

HS = 1.841

VS = 3.170

GS = 3.465

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.014	.949	1.041
MINIMUM X	-.827	-.892	-.800
MAXIMUM Y	1.427	1.233	1.373
MINIMUM Y	-1.743	-.912	-.750
CENTROID X	-.163	-.097	-.109
CENTROID Y	-.186	.008	-.146
POA TO CENTROID in.	.247	.097	.239
MIN RADIUS	.389	.239	.379
MEAN RADIUS	1.026	.935	.849
MAX RADIUS	1.841	1.511	1.589
HORIZONTAL SPREAD	1.841	1.841	1.841
VERTICAL SPREAD	3.170	2.145	2.131
EXTREME SPREAD	3.465	2.816	2.816
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	7		