

C6611499

MODEL 700™ M24

Model **SAS**™

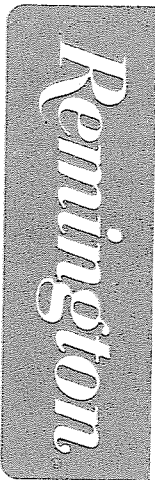
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Remington		 REG. U.S. PAT. & TM. OFF.	VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700™ M24		SERIAL NO. C6611499	ORDER NO. 5716
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.			
 5716 C6611499			

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611499

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/13/91	K.S.
600	Proof		3/13/91	K.S.
607	Check Headspace		3/13/91	K.S.
610	Dis-assemble Gun		3/13/91	K.S.
612	Magnaflux Barrel Action		3/28/91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	LS
617	Drill and Tap Sight Holes		APR 3 1991	LS
618	Polish Barrel		APR 3 1991	LS
620	Apply Coatings (Barrel Action)		5/1/91	LS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/1/91	LS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/1/91	LS
	C) Inspect Ejector Hole for Chamfer		5/1/91	LS
	D) Oil Firing Pin Ass'y		5/1/91	LS
	E) Adjust Trigger Pull to Min Setting and Stake		5-16-91	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5-16-91	JK
	G) Safety Off Force	4	4	4			5-16-91	JK
	H) Trigger Pull Test & Retainability						5-16-91	JK
	I) Firing Pin Indent	.0215	.0215	.0215			5-16-91	JK
	J) Assemble Stock						5/14/91	KS
	K) Assemble Swivel Studs						5-20-91	A
	L) Attach Front and Rear Sight Assemblies						5/14/91	KS
	M) Iron Sight Alignment						5/14/91	KS
	N) Detach Front & Rear Sights & place in numbered container						5/14/91	KS
	O) Attach Scope to Rifle						5/14/91	KS
	P) Detach & Attach Scope 20 Times						5/14/91	KS
640	Gallery Target & Test						5-17-91	AF
	A) Time							AF
	B) Malfunctions							AF
	C) Pierced Primers							AF
	D) Optical Clarity of Scope							AF
645	Inspect for Live Ammo						5-17-91	AF
655	Final Inspection							
	A) Headspace						5-20-91	A
	B) Trigger Pull	2.50	2.52	2.42	2.51	2.51	5/20/91	JK
	C) Function						5-20-91	A
660	Pack						6-17-91	AF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6611499

DATE 5-16-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.59	2.49	2.48	2.50	MIN. SETTING,
PULL #2	2.39	2.43	2.35	2.52	NO AVG. OF 5
PULL #3	2.50	2.25	2.39	2.42	READINGS ACCEPT-
PULL #4	2.44	2.48	2.40	2.51	ABLE LESS THAN 2#
PULL #5	2.46	2.44	2.45	2.51	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.44	3.36		
PULL #2	3.48	3.40		
PULL #3	3.51	3.49		
PULL #4	3.50	3.41		
PULL #5	3.48	3.42		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.30		4.33
PULL #2	4.35	4.38		4.34
PULL #3	4.26	4.26		4.43
PULL #4	4.34	4.32		4.39
PULL #5	4.21	4.35		4.39
TOTAL				
AVG.				

BBL GROVES WIDE
MAY BE TOSSED OUT
at INSP. Ya get what
we have to work with

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611499
17 May 1991

CENTROIDAL DISTANCES

0 TO	1	.292318
1 TO	2	.779776
1 TO	3	.783516
1 TO	4	.471653
1 TO	5	.652854

43
IT 2 C --POR
5

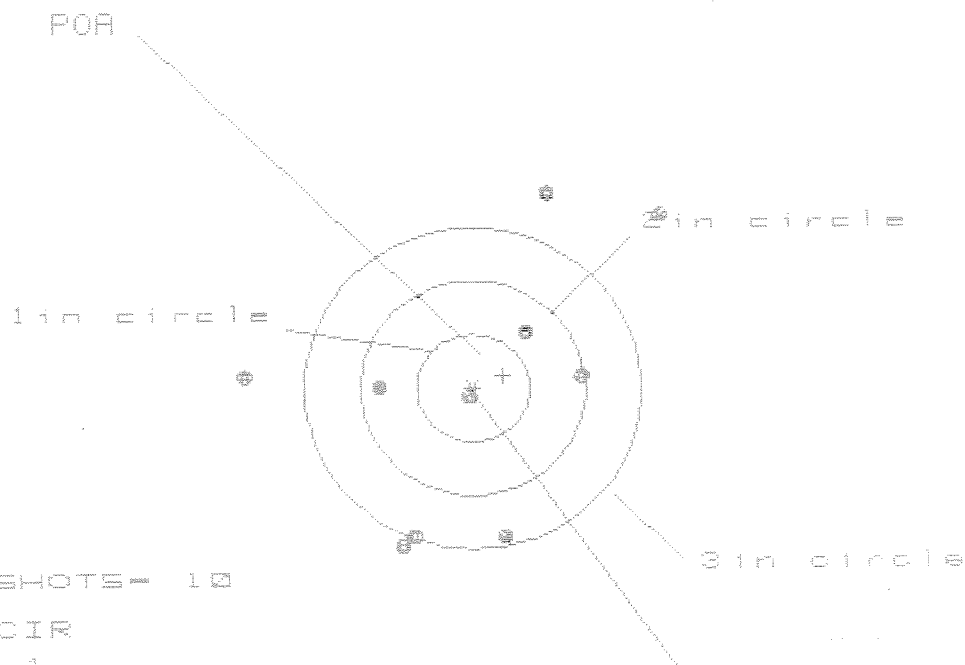
THE AVERAGE X-COORDINATE IS 100.0000
THE AVERAGE Y-COORDINATE IS 100.0000
THE RESULTING AVERAGE IS 100.0000

APP FOR THIS RIFLE IS 100.0000

17 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611499

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 6

HS= 3.691

VS= 3.285

GS= 3.983

CENTROID *

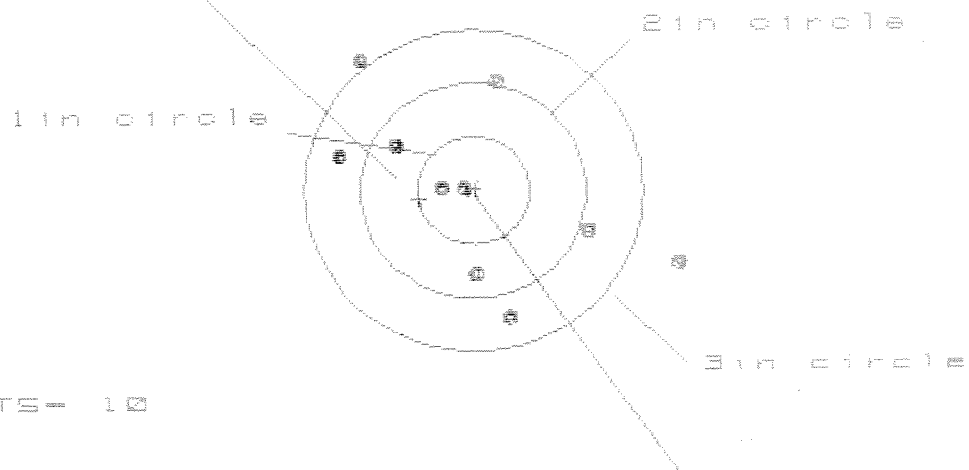
PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.684	1.185	.957
MINIMUM X	:	-2.007	-1.820	-.859
MAXIMUM Y	:	1.868	1.990	2.032
MINIMUM Y	:	-1.477	-1.295	-1.253
CENTROID X	:	-.167	-.454	-.226
CENTROID Y	:	-.119	-.101	-.151
FOR TO CENTROID in.	:	.241	.545	.611
MIN RADIUS	:	.093	.187	.211
MEAN RADIUS	:	1.347	1.325	1.311
MAX RADIUS	:	2.351	2.198	2.121
HORIZONTAL SPREAD	:	3.691	3.003	2.916
VERTICAL SPREAD	:	3.285	3.287	3.218
EXTREME SPREAD	:	3.983	3.518	3.418
NUMBER IN ONE INCH CIRCLE	=	1	3	6
NUMBER IN TWO INCH CIRCLE	=			
NUMBER IN THREE INCH CIRCLE	=			

17 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CGB11493

CENTERFIRE PATTERNS # 2

POA



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 3.071

VS= 2.406

GS= 3.467

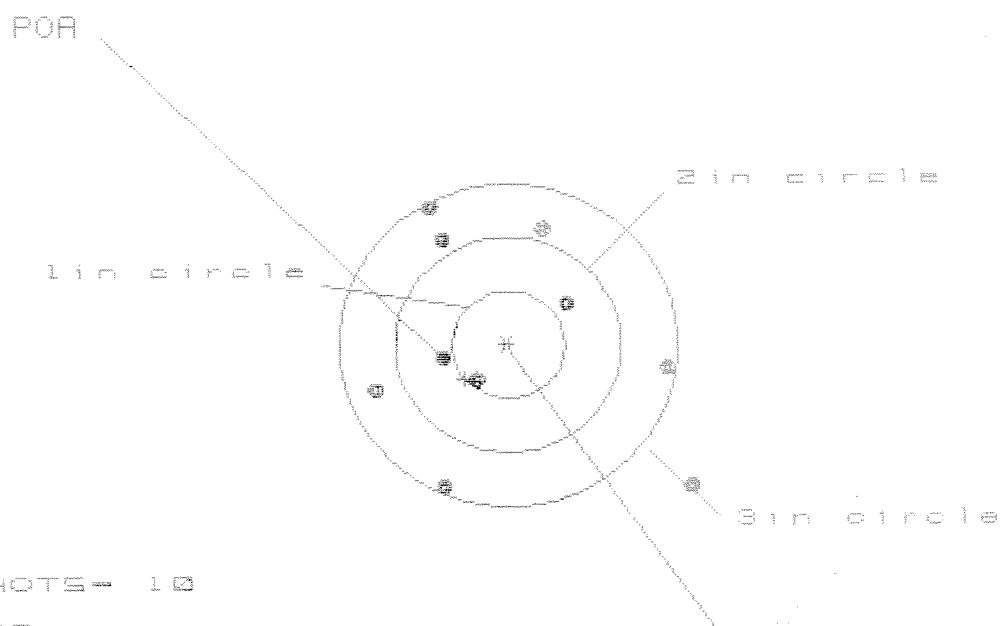
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.856	1.215	1.112
MINIMUM X	:	-1.215	-1.009	-1.112
MAXIMUM Y	:	1.202	1.122	1.039
MINIMUM Y	:	-1.204	-1.284	-1.143
CENTROID X	:	.488	.282	.385
CENTROID Y	:	.076	.156	.016
POA TO CENTROID in.	:	.494	.323	.385
MIN RADIUS	:	.145	.077	.120
MEAN RADIUS	:	1.017	.863	.865
MAX RADIUS	:	1.990	1.392	1.204
HORIZONTAL SPREAD	:	3.071	2.224	2.224
VERTICAL SPREAD	:	2.406	2.406	2.183
EXTREME SPREAD	:	3.467	2.737	2.329
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

17 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06511499

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 9

HS= 2.836

VS= 2.612

GS= 3.468

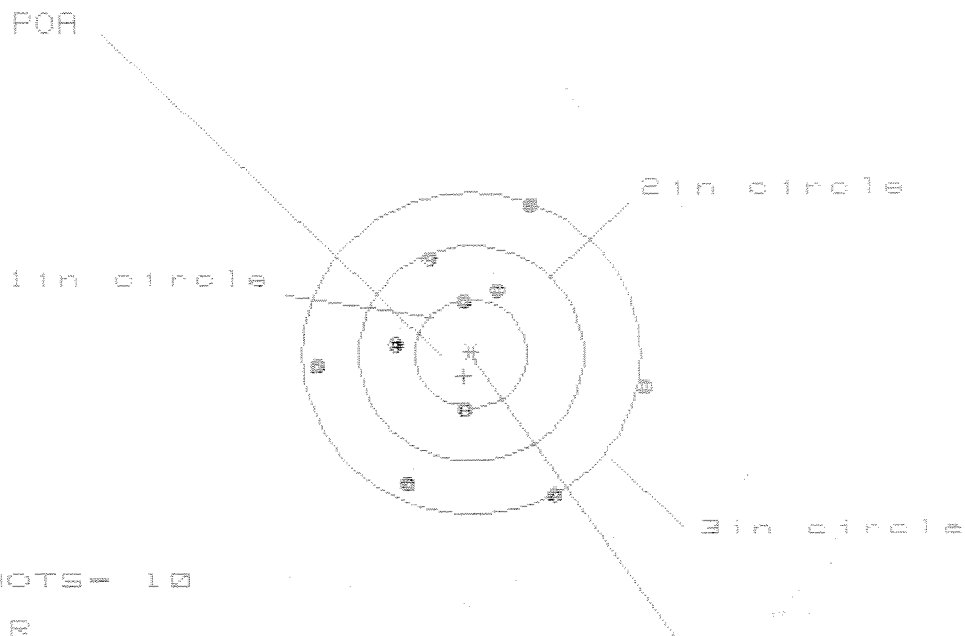
CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.623	1.643	.904
MINIMUM X	-1.213	-1.033	-.827
MAXIMUM Y	1.262	1.112	1.069
MINIMUM Y	-1.350	-1.483	-1.526
CENTROID X	.386	.206	.000
CENTROID Y	.314	.464	.507
POA TO CENTROID in.	.497	.507	.507
MIN RADIUS	.363	.422	.307
MEAN RADIUS	1.156	1.018	.914
MAX RADIUS	2.111	1.680	1.542
HORIZONTAL SPREAD	2.836	2.676	1.731
VERTICAL SPREAD	2.612	2.595	2.595
EXTREME SPREAD	3.468	2.687	2.596
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	9		

(7 May 1991)

FILE:/PATTERNING/CENTERFIRE_PATT/08611499

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.835

VS= 2.723

GS= 2.855

CENTROID *

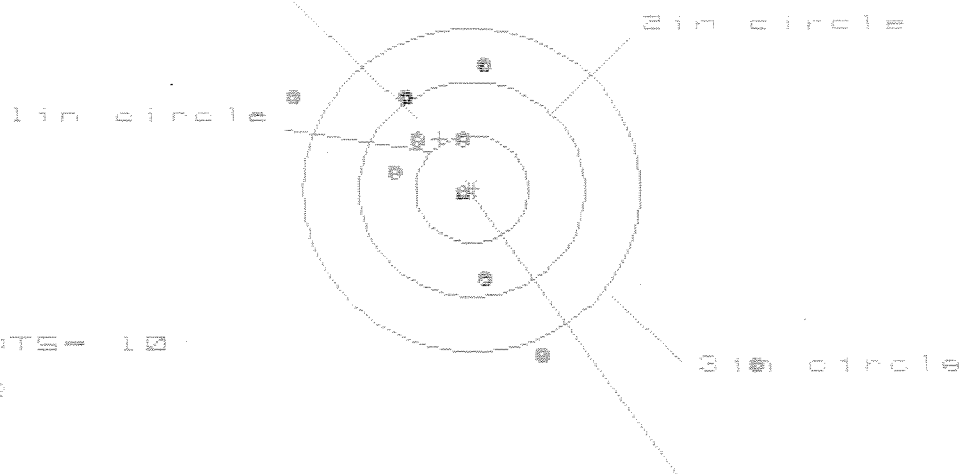
PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.488	1.544	.951
MINIMUM X	:	-1.347	-1.291	-1.098
MAXIMUM Y	:	1.432	1.036	1.022
MINIMUM Y	:	-1.291	-1.131	-1.145
CENTROID X	:	.069	.013	-.180
CENTROID Y	:	.212	.052	.066
POA TO CENTROID in.	:	.223	.054	.192
MIN RADIUS	:	.458	.317	.398
MEAN RADIUS	:	1.039	.983	.893
MAX RADIUS	:	1.520	1.548	1.488
HORIZONTAL SPREAD	:	2.835	2.835	2.849
VERTICAL SPREAD	:	2.723	2.167	2.167
EXTREME SPREAD	:	2.855	2.837	2.484
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	8		

17 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8B11489

CENTERFIRE PATTERNS # 5

POA



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 7

HS= 4.096

VS= 2.776

GS= 4.778

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.555	.881	.724
MINIMUM X	:	-1.541	-1.257	-1.572
MAXIMUM Y	:	1.144	.963	1.044
MINIMUM Y	:	-1.632	-1.677	-1.596
CENTROID X	:	.286	.002	.159
CENTROID Y	:	-.466	-.285	-.366
POA TO CENTROID in.	:	.547	.285	.389
MIN RADIUS	:	.140	.205	.161
MEAN RADIUS	:	1.145	.850	.792
MAX RADIUS	:	3.032	1.894	1.753
HORIZONTAL SPREAD	:	4.096	2.138	1.296
VERTICAL SPREAD	:	2.776	2.640	2.640
EXTREME SPREAD	:	4.778	3.156	2.676
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	