

C66611571

MODEL 700<sup>TM</sup> M24

Model SAS <sup>TM</sup>

Action \_\_\_\_\_

Barrel Length \_\_\_\_\_

Capacity \_\_\_\_\_

Order No. 5716

\*Includes 1 in chamber.



|                                                                                      |  |                                         |                                                                                           |
|--------------------------------------------------------------------------------------|--|-----------------------------------------|-------------------------------------------------------------------------------------------|
| <b>Remington</b> ®                                                                   |  | <b>DU PONT</b><br>REG U.S. PAT & TM OFF | VERY IMPORTANT:<br>Instruction Book<br>enclosed to assure<br>safe use of this<br>firearm. |
| <b>MODEL 700™ H24</b>                                                                |  | <b>SERIAL NO.</b><br>C6611571           | <b>ORDER NO.</b><br><b>5716</b>                                                           |
| MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee. |  | 46                                      |                                                                                           |



5716 C6611571

UPC



0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611571

| OP. #        | OP. NAME                                                       | READINGS         | DATE    | INIT |
|--------------|----------------------------------------------------------------|------------------|---------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   | QUALITY<br>AUDIT | 2/1/91  | KJ   |
| 600          | Proof                                                          |                  | 2/1/91  | KJ   |
| 607          | Check Headspace                                                |                  | 2/1/91  | KJ   |
| 610          | Dis-assemble Gun                                               |                  | 2/1/91  | KJ   |
| 612          | Magnaflux Barrel<br>Action                                     | 2 11 91          |         | KJ   |
|              | Magnaflux Bolt                                                 | 2 11 91          |         | KJ   |
| 615          | Rollmark Caliber                                               | 2 11 91          |         | GB   |
| 617          | Drill and Tap Sight Holes                                      | 2 13 91          |         | KJ   |
| 618          | Polish Barrel RBB                                              | 2 13 91          |         | WB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |                  | 2/2/91  | KJ   |
|              | Apply Coating (Bolt)                                           |                  |         | KJ   |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |                  | 3/20/91 | KJ   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |                  | 3/20/91 | KJ   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |                  | 3/20/91 | KJ   |
|              | D) Oil Firing Pin Ass'y                                        |                  | 3/20/91 | KJ   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |                  | 3/25/91 | WB   |

| op. #        | OP. NAME                                                    | READINGS |       |       |      |      | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|-------|-------|------|------|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 4 3/4    | 4 3/4 | 4 3/4 |      |      | 3/25/91 | W.B. |
|              | G) Safety Off Force                                         | 2 1/4    | 2 1/4 | 2 1/4 |      |      | 3/25/91 | W.B. |
|              | H) Trigger Pull Test & Retainability                        |          |       |       |      |      | 3/25/91 | W.B. |
|              | I) Firing Pin Indent                                        | .0215    | .0205 | .021  |      |      | 3/25/91 | W.B. |
|              | J) Assemble Stock                                           |          |       |       |      |      | 9/25/91 | K.S. |
|              | K) Assemble Swivel Studs                                    |          |       |       |      |      | 4-22-91 | E    |
|              | L) Attach Front and Rear Sight Assemblies                   |          |       |       |      |      | 9/25/91 | K.S. |
|              | M) Iron Sight Alignment                                     |          |       |       |      |      | 9/25/91 | K.S. |
|              | N) Detach Front & Rear Sights & place in numbered container |          |       |       |      |      | 9/25/91 | K.S. |
|              | O) Attach Scope to Rifle                                    |          |       |       |      |      | 9/25/91 | K.S. |
|              | P) Detach & Attach Scope 20 Times                           |          |       |       |      |      | 9/25/91 | K.S. |
| 640          | Gallery Target & Test                                       |          |       |       |      |      | 4/4/91  | K.S. |
|              | A) Time                                                     |          |       |       |      |      | "       | E    |
|              | B) Malfunctions                                             |          |       |       |      |      | "       | E    |
|              | C) Pierced Primers                                          |          |       |       |      |      | "       | E    |
|              | D) Optical Clarity of Scope                                 |          |       |       |      |      | "       | E    |
| 645          | Inspect for Live Ammo                                       |          |       |       |      |      | 4/4/91  | E    |
| 655          | Final Inspection                                            |          |       |       |      |      | 4-22-91 | K    |
|              | A) Headspace                                                |          |       |       |      |      |         |      |
|              | B) Trigger Pull                                             | 2.45     | 2.50  | 2.37  | 2.56 | 2.44 | 4/5/91  | JH   |
|              | C) Function                                                 |          |       |       |      |      | 2-22-91 | E    |
| 660          | Pack                                                        |          |       |       |      |      | 6-17-91 | NF   |

## SWS. TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS2.50# + .50#  
3.00# + .75#  
4.00# + 1.00#SERIAL NO. C6611527DATE 3/25/91TESTER WB

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |                  | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------------------|------------------------------------------------------------------------|
| PULL #1 | 2.50             | 2.48                     | 2.59                           | 2.45             | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.48             | 2.42                     | 2.58                           | 2.50             |                                                                        |
| PULL #3 | 2.57             | 2.50                     | 2.59                           | 2.37             |                                                                        |
| PULL #4 | 2.37             | 2.48                     | 2.57                           | 2.56             |                                                                        |
| PULL #5 | 2.65             | 2.52                     | 2.48                           | 2.44             |                                                                        |
| TOTAL   | 12.57            | 12.41                    | 12.81                          | <del>12.56</del> |                                                                        |
| AVG.    | 2.51             | 2.48                     | 2.56                           |                  |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.72             | 3.25                     |  |          |
| PULL #2 | 3.27             | 3.23                     |  |          |
| PULL #3 | 3.28             | 3.11                     |  |          |
| PULL #4 | 3.17             | 3.29                     |  |          |
| PULL #5 | 3.32             | 3.29                     |  |          |
| TOTAL   | 16.16            | 16.17                    |  |          |
| AVG.    | 3.23             | 3.23                     |  |          |

|         | 4.00#<br>INITIAL | 4.00# AFTER<br>20 CYCLES | MAX SETTING<br>GREATER THAN 4# | RESET TO 4# FOR<br>TARGET & ACCURACY |
|---------|------------------|--------------------------|--------------------------------|--------------------------------------|
| PULL #1 | 4.13             | 4.73                     |                                | 4.33                                 |
| PULL #2 | 4.06             | 3.95                     |                                | 4.34                                 |
| PULL #3 | 4.12             | 4.09                     |                                | 4.09                                 |
| PULL #4 | 4.01             | 4.14                     |                                | 4.28                                 |
| PULL #5 | 4.16             | 4.00                     |                                | 4.37                                 |
| TOTAL   | 20.48            | 20.31                    |                                | 21.41                                |
| AVG.    | 4.09             | 4.06                     |                                | 4.28                                 |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6611571  
5 Apr 1991

CENTROIDAL DISTANCES

|      |   |          |
|------|---|----------|
| 0 TO | 1 | .276154  |
| 1 TO | 2 | .0610737 |
| 1 TO | 3 | .300193  |
| 1 TO | 4 | .175026  |
| 1 TO | 5 | .154029  |

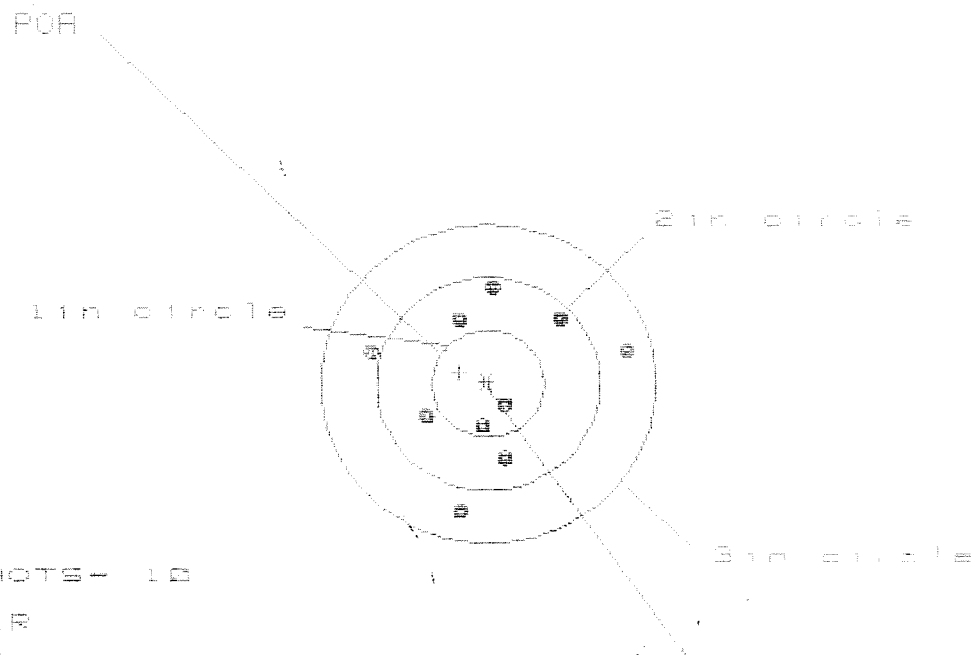
POA <-----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2028  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1036  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .22773  
THE AMR FOR THIS RIFLE IS: .7744

4 Apr 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C861197

# CENTERFIRE PATTERNS # 1



# OF SHOTS- 10

# IN CIR

1in = 2

2in = 7

3in = 10

HS= 2.321

VS= 2.166

GS= 2.321

CENTROID #

| PATTERN #                     | 1      | 2      | 3     |
|-------------------------------|--------|--------|-------|
| SHOTS (BEST OF)               | 10     | 9      | 8     |
| MAXIMUM X                     | 1.267  | .821   | .810  |
| MINIMUM X                     | -1.054 | -.913  | -.925 |
| MAXIMUM Y                     | .944   | .975   | .827  |
| MINIMUM Y                     | -1.216 | -1.185 | -.811 |
| CENTROID X                    | .255   | .114   | .126  |
| CENTROID Y                    | -.106  | -.137  | .011  |
| POA TO CENTROID in.           | .276   | .178   | .126  |
| MIN RADIUS                    | .215   | .369   | .369  |
| MEAN RADIUS                   | .813   | .750   | .701  |
| MAX RADIUS                    | 1.297  | 1.188  | .941  |
| HORIZONTAL SPREAD             | 2.321  | 1.734  | 1.734 |
| VERTICAL SPREAD               | 2.166  | 2.160  | 1.638 |
| EXTREME SPREAD                | 2.321  | 2.182  | 1.759 |
| NUMBER IN ONE INCH CIRCLE =   |        | 2      |       |
| NUMBER IN TWO INCH CIRCLE =   |        | 7      |       |
| NUMBER IN THREE INCH CIRCLE = |        | 10     |       |

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# CENTERFIRE PATTERNS

# 2

POA

1in circle

2in circle

3in circle

CENTROID \*

# OF SHOTS- 10

# IN CIR

1in = 2

2in = 0

3in = 0

HS= 2.500

VS= 1.836

GS= 2.606

| PATTERN #                   | : | 2      |       |       |
|-----------------------------|---|--------|-------|-------|
| SHOTS (BEST OF)             | : | 10     | 9     | 8     |
| MAXIMUM X                   | : | .843   | .649  | .618  |
| MINIMUM X                   | : | -1.750 | -.920 | -.951 |
| MAXIMUM Y                   | : | 1.155  | 1.171 | .653  |
| MINIMUM Y                   | : | -.601  | -.665 | -.519 |
| CENTROID X                  | : | .302   | .496  | .527  |
| CENTROID Y                  | : | -.067  | -.083 | -.229 |
| POA TO CENTROID in.         | : | .309   | .503  | .575  |
| MIN RADIUS                  | : | .432   | .239  | .213  |
| MEAN RADIUS                 | : | .863   | .716  | .645  |
| MAX RADIUS                  | : | 1.756  | 1.197 | .957  |
| HORIZONTAL SPREAD           | : | 2.593  | 1.589 | 1.569 |
| VERTICAL SPREAD             | : | 1.836  | 1.836 | 1.172 |
| EXTREME SPREAD              | : | 2.606  | 1.966 | 1.569 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2     |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 6     |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 9     |       |

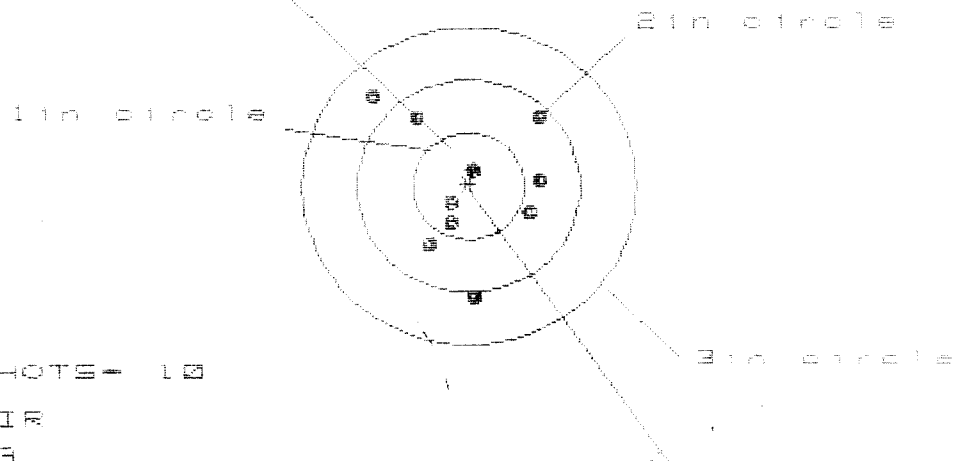
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FILE:/PATTERNING/CENTERFIRE\_PATT/06611571

# CENTERFIRE PATTERNS

# 3

POB



# OF SHOTS= 10

# IN CIR

1in = 3

2in = 9

3in = 10

HS= 1.500

VS= 1.811

GS= 2.016

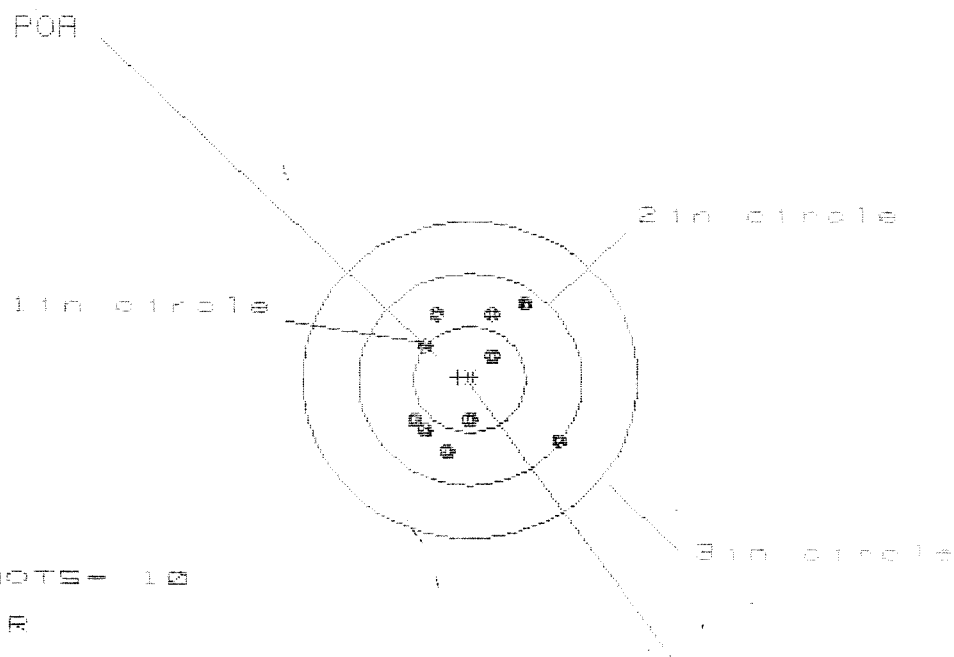
CENTROID #

| PATTERN #                   | : | 3     |       |       |
|-----------------------------|---|-------|-------|-------|
| SHOTS (BEST OF)             | : | 10    | 9     | 8     |
| MAXIMUM X                   | : | .659  | .565  | .558  |
| MINIMUM X                   | : | -.849 | -.513 | -.520 |
| MAXIMUM Y                   | : | .812  | .784  | .671  |
| MINIMUM Y                   | : | -.999 | -.909 | -.580 |
| CENTROID X                  | : | -.041 | .053  | .060  |
| CENTROID Y                  | : | -.156 | -.246 | -.133 |
| POB TO CENTROID in.         | : | .162  | .252  | .146  |
| MIN RADIUS                  | : | .123  | .211  | .144  |
| MEAN RADIUS                 | : | .662  | .599  | .560  |
| MAX RADIUS                  | : | 1.175 | .966  | .871  |
| HORIZONTAL SPREAD           | : | 1.500 | 1.078 | 1.078 |
| VERTICAL SPREAD             | : | 1.811 | 1.693 | 1.251 |
| EXTREME SPREAD              | : | 2.016 | 1.803 | 1.631 |
| NUMBER IN ONE INCH CIRCLE   | = |       | 3     |       |
| NUMBER IN TWO INCH CIRCLE   | = |       | 9     |       |
| NUMBER IN THREE INCH CIRCLE | = |       | 10    |       |

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# CENTERFIRE PATTERNS # 4



# OF SHOTS- 10

# IN CIR

1in = 2

2in = 8

3in = 10

HS= 1.300

VS= 1.349

GS= 1.672

|                             |   |       |       |       |
|-----------------------------|---|-------|-------|-------|
| PATTERN #                   | : | 4     |       |       |
| SHOTS (BEST OF)             | : | 10    | 9     | 8     |
| MAXIMUM X                   | : | .797  | .558  | .386  |
| MINIMUM X                   | : | -.503 | -.414 | -.345 |
| MAXIMUM Y                   | : | .685  | .615  | .663  |
| MINIMUM Y                   | : | -.664 | -.734 | -.657 |
| CENTROID X                  | : | .102  | .013  | -.056 |
| CENTROID Y                  | : | -.021 | .049  | -.028 |
| POA TO CENTROID in.         | : | .104  | .051  | .063  |
| MIN RADIUS                  | : | .317  | .351  | .399  |
| MEAN RADIUS                 | : | .641  | .591  | .554  |
| MAX RADIUS                  | : | 1.015 | .830  | .742  |
| HORIZONTAL SPREAD           | : | 1.300 | .972  | .731  |
| VERTICAL SPREAD             | : | 1.349 | 1.349 | 1.320 |
| EXTREME SPREAD              | : | 1.672 | 1.494 | 1.362 |
| NUMBER IN ONE INCH CIRCLE   | = |       | 2     |       |
| NUMBER IN TWO INCH CIRCLE   | = |       | 9     |       |
| NUMBER IN THREE INCH CIRCLE | = |       | 10    |       |

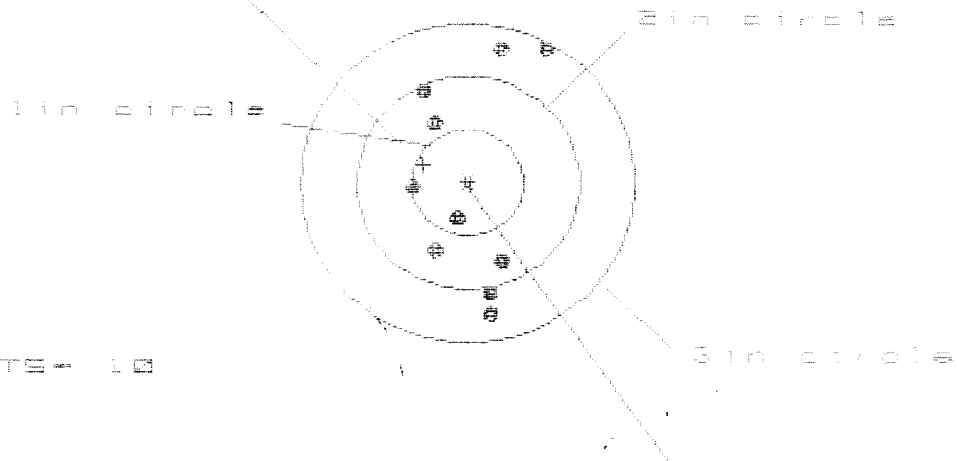
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FILE:/PATTERNING/CENTERFIRE\_PATT/08611571

# CENTERFIRE PATTERNS

# 5

FOR



# OF SHOTS - 10

# IN CIR

1 in = 1

2 in = 5

3 in = 10

HE = 1.245

VS = 2.540

GS = 2.540

CENTROID \*

| PATTERN #                     | 5      | 9      | 8     |
|-------------------------------|--------|--------|-------|
| SHOTS (BEST OF)               | 10     | 9      | 8     |
| MAXIMUM X                     | .741   | .345   | .368  |
| MINIMUM X                     | -.504  | -.422  | -.379 |
| MAXIMUM Y                     | 1.299  | 1.437  | 1.210 |
| MINIMUM Y                     | -1.241 | -1.103 | -.923 |
| CENTROID X                    | .396   | .314   | .271  |
| CENTROID Y                    | -.168  | -.306  | -.486 |
| FOR TO CENTROID in.           | .431   | .439   | .556  |
| MIN RADIUS                    | .338   | .180   | .018  |
| MEAN RADIUS                   | .893   | .790   | .651  |
| MAX RADIUS                    | 1.444  | 1.477  | 1.235 |
| HORIZONTAL SPREAD             | 1.245  | .767   | .767  |
| VERTICAL SPREAD               | 2.540  | 2.540  | 2.133 |
| EXTREME SPREAD                | 2.549  | 2.342  | 2.197 |
| NUMBER IN ONE INCH CIRCLE =   | 1      |        |       |
| NUMBER IN TWO INCH CIRCLE =   | 5      |        |       |
| NUMBER IN THREE INCH CIRCLE = | 10     |        |       |