

C6594588

MODEL 700TM M24

Model SWS TM

Action _____

Barrel Length _____

Capacity _____

Order No. 5716

*Includes 1 in chamber.

Remington




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

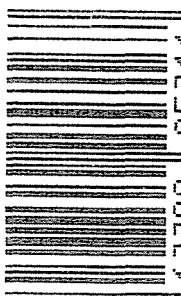
MODEL 700™ M24

SERIAL NO. C6594588

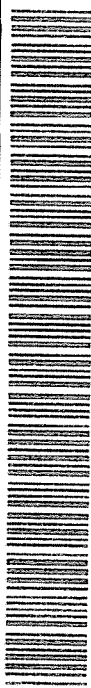
ORDER NO. 5716

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

LPC



0 47700 25716 2



5716 C6594588

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6594588

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 16	91	RW
600	Proof	1 16	91	RW
607	Check Headspace	1 16	91	RW
610	Dis-assemble Gun	1 16	91	RW
612	Magnaflux Barrel Action	1 18	91	KR
	Magnaflux Bolt	1 18	91	KR
615	Rollmark Caliber	1 1	91	LS
617	Drill and Tap Sight Holes	1 24	91	FB
618	Polish Barrel	1 24	91	WB
620	Apply Coatings (Barrel Action)		8-15-91	TH
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		2/19/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/19/91	RW
	C) Inspect Ejector Hole for Chamfer		2/19/91	RW
	D) Oil Firing Pin Ass'y		2/19/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		3/2/91	JK

op. #	OP. NAME	READINGS			DATE	INIT
625 cont.	F) Safety On Force	4	4	4	3/4/91	JH
	G) Safety Off Force	3	3	3	3/4/91	JH
	H) Trigger Pull Test & Retainability				3/2/91	JH
	I) Firing Pin Indent	.0215	.022	.022	3/4/91	JH
	J) Assemble Stock				3/5/91	RW
	K) Assemble Swivel Studs				3-8-91	D/H
	L) Attach Front and Rear Sight Assemblies				3/5/91	RW
	M) Iron Sight Alignment				3/5/91	RW
	N) Detach Front & Rear Sights & place in numbered container				3/5/91	RW
	O) Attach Scope to Rifle				3/5/91	RW
	P) Detach & Attach Scope 20 Times				3/5/91	RW
640	Gallery Target & Test				3/5/91	RW
	A) Time					12
	B) Malfunctions					12
	C) Pierced Primers					12
	D) Optical Clarity of Scope					12
645	Inspect for Live Ammo				3/5/91	12
655	Final Inspection					
	A) Headspace				3-8-91	D/H
	B) Trigger Pull	2.33	2.38	2.49	3/8/91	JH
	C) Function				3-8-91	D/H
660	Pack				3-11-91	N

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6594588

DATE 3-2-91

TESTER JEP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.23	2.41	2.33	MIN. SETTING,
PULL #2	2.26	2.17	2.46	2.38	NO AVG. OF 5
PULL #3	2.28	2.23	2.29	2.49	READINGS ACCEP-
PULL #4	2.34	2.19	2.31	2.58	TABLE LESS THAN 2#
PULL #5	2.19	2.19	2.34	2.56	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.37	3.17		
PULL #2	3.29	3.32		
PULL #3	3.23	3.28		
PULL #4	3.29	3.14		
PULL #5	3.26	3.23		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.46	4.44		4.46
PULL #2	4.32	4.45		4.32
PULL #3	4.40	4.48		4.31
PULL #4	4.23	4.30		4.32
PULL #5	4.41	4.53		4.31
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594588
6 Mar 1991

CENTROIDAL DISTANCES

0 TO	1	.0212603
1 TO	2	.205361
1 TO	3	.387156
1 TO	4	.0288617
1 TO	5	.290462

³
45 <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0876
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0176
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0893505
THE AMR FOR THIS RIFLE IS: .9956

6 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C653945B8

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 2.489

VS= 2.101

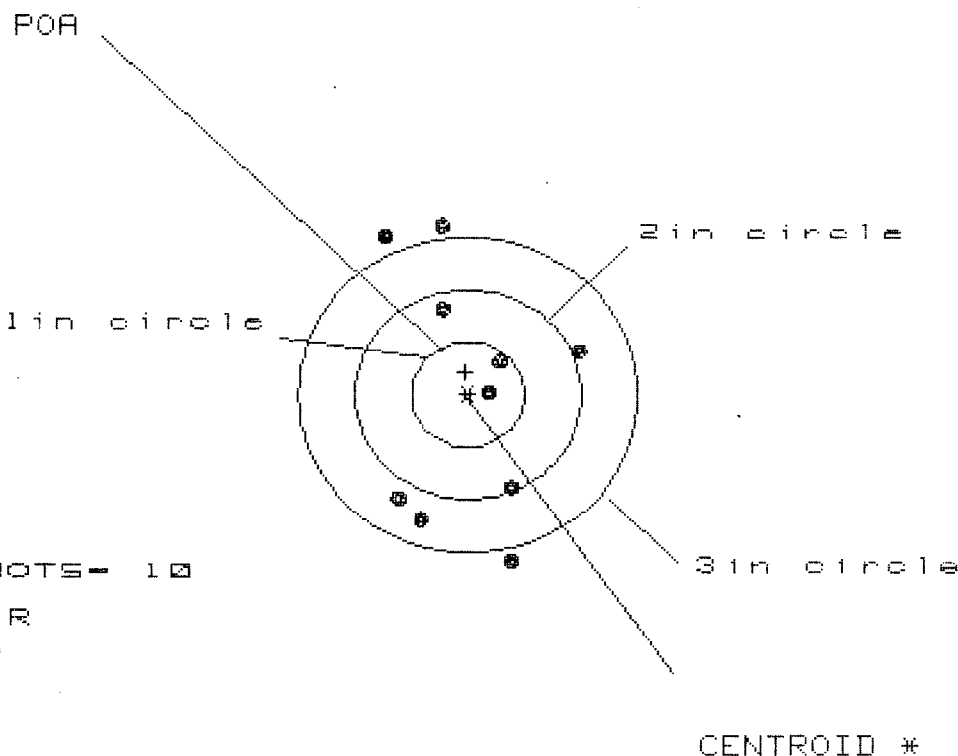
GS= 2.732

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.010	.846	.872
MINIMUM X	:	-1.479	-.699	-.673
MAXIMUM Y	:	1.057	.953	.622
MINIMUM Y	:	-1.044	-1.148	-1.029
CENTROID X	:	-.016	.148	.122
CENTROID Y	:	-.014	.090	-.029
POA TO CENTROID in.	:	.021	.173	.125
MIN RADIUS	:	.304	.322	.384
MEAN RADIUS	:	.850	.735	.704
MAX RADIUS	:	1.751	1.149	1.029
HORIZONTAL SPREAD	:	2.489	1.545	1.545
VERTICAL SPREAD	:	2.101	2.101	1.651
EXTREME SPREAD	:	2.732	2.118	1.706
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	9		

6 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8594588

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 2

2in = 4

3in = 7

HS= 1.704

VS= 3.249

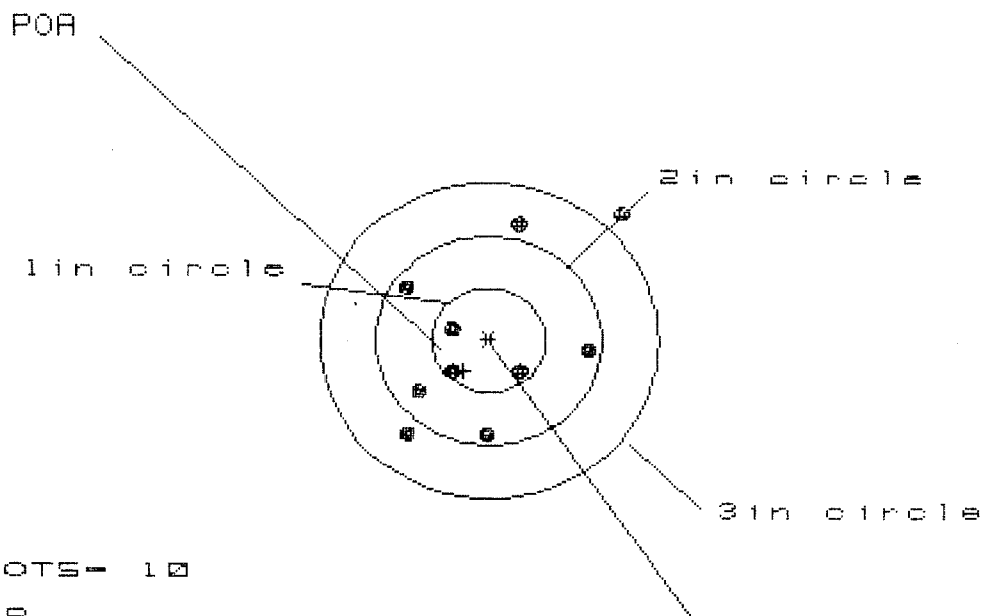
GS= 3.312

PATTERN #	2	2	2
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.007	.979	.888
MINIMUM X	-.697	-.725	-.774
MAXIMUM Y	1.647	1.683	1.191
MINIMUM Y	-1.602	-1.419	-1.208
CENTROID X	.021	.049	.140
CENTROID Y	-.216	-.399	-.610
POA TO CENTROID in.	.217	.402	.625
MIN RADIUS	.169	.229	.395
MEAN RADIUS	1.085	1.017	.908
MAX RADIUS	1.666	1.833	1.238
HORIZONTAL SPREAD	1.704	1.704	1.662
VERTICAL SPREAD	3.249	3.102	2.399
EXTREME SPREAD	3.312	3.287	2.466
NUMBER IN ONE INCH CIRCLE	= 2		
NUMBER IN TWO INCH CIRCLE	= 4		
NUMBER IN THREE INCH CIRCLE	= 7		

6 Mar 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 1.984

VS= 2.082

GS= 2.876

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.221	.994	.915
MINIMUM X	:	-.763	-.627	-.659
MAXIMUM Y	:	1.222	1.201	1.111
MINIMUM Y	:	-.860	-.724	-.814
CENTROID X	:	.225	.089	.168
CENTROID Y	:	.289	.153	.243
POA TO CENTROID in.	:	.366	.177	.296
MIN RADIUS	:	.292	.205	.259
MEAN RADIUS	:	.842	.698	.678
MAX RADIUS	:	1.728	1.275	1.164
HORIZONTAL SPREAD	:	1.984	1.621	1.574
VERTICAL SPREAD	:	2.082	1.925	1.925
EXTREME SPREAD	:	2.876	2.195	1.949
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

6 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594588

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 2.787

VS= 1.704

GS= 2.827

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.410	1.464	1.311
MINIMUM X	:	-1.377	-1.220	-.570
MAXIMUM Y	:	1.017	.941	.905
MINIMUM Y	:	-.687	-.682	-.718
CENTROID X	:	-.044	-.201	-.048
CENTROID Y	:	-.021	.055	.091
POA TO CENTROID in.	:	.049	.208	.103
MIN RADIUS	:	.283	.198	.331
MEAN RADIUS	:	.880	.774	.728
MAX RADIUS	:	1.568	1.464	1.311
HORIZONTAL SPREAD	:	2.787	2.684	1.881
VERTICAL SPREAD	:	1.704	1.623	1.623
EXTREME SPREAD	:	2.827	2.701	1.987
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

6 Mar 1991

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CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 0

2in = 3

3in = 6

HS= 2.487

VS= 3.131

GS= 3.299

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.999	1.099	1.143
MINIMUM X	:	-1.488	-1.388	-1.344
MAXIMUM Y	:	1.393	1.221	.982
MINIMUM Y	:	-1.738	-1.910	-1.224
CENTROID X	:	.252	.152	.108
CENTROID Y	:	-.126	.046	.285
POA TO CENTROID in.	:	.282	.159	.305
MIN RADIUS	:	.777	.621	.558
MEAN RADIUS	:	1.321	1.250	1.136
MAX RADIUS	:	1.790	1.942	1.430
HORIZONTAL SPREAD	:	2.487	2.487	2.487
VERTICAL SPREAD	:	3.131	3.131	2.206
EXTREME SPREAD	:	3.299	3.189	2.769
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		6	