

C6636234

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington®



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

MODEL 700™ M24

SERIAL NO.
C6636234

20

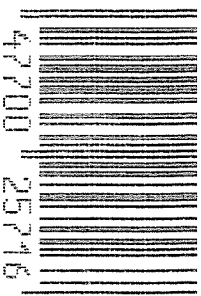
ORDER NO.
5716

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



5716 C6636234

UPC



0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636234

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 27	9 1	RW
600	Proof	6 27	9 1	RW
607	Check Headspace	6 27	9 1	RW
610	Dis-assemble Gun	6 27	9 1	RW
612	Magnaflux Barrel Action	JUL	2 1991	KR
	Magnaflux Bolt	JUL	2 1991	KR
615	Rollmark Caliber	JUL	2 1991	LS
617	Drill and Tap Sight Holes	JUL	2 1991	FB
618	Polish Barrel	JUL 1	7 1991	WB
620	Apply Coatings (Barrel Action)		7-22-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/23/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/23/91	RW
	C) Inspect Ejector Hole for Chamfer		7/23/91	RW
	D) Oil Firing Pin Ass'y		7/23/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		7-25-91	JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			7-26-91	DH
	G) Safety Off Force	3	3	3			7-26-91	DH
	H) Trigger Pull Test & Retainability						7-25-91	JM
	I) Firing Pin Indent	.020	.020	.020			7-26-91	DH
	J) Assemble Stock						8/1/91	RW
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies						8/1/91	RW
	M) Iron Sight Alignment						8/1/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/1/91	RW
	O) Attach Scope to Rifle						8/1/91	RW
	P) Detach & Attach Scope 20 Times						8/1/91	RW
640	Gallery Target & Test						8-1-91	AC
	A) Time						8-1-91	AC
	B) Malfunctions						8-1-91	AC
	C) Pierced Primers						8-1-91	AC
	D) Optical Clarity of Scope						8-1-91	AC
645	Inspect for Live Ammo						8-1-91	AC
655	Final Inspection							
	A) Headspace						8-5-91	A
	B) Trigger Pull	2.27	2.26	2.18	2.34	2.20	8-5-91	JM
	C) Function						8-5-91	A
660	Pack						7-17-91	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. C6636234

DATE 7-25-91

TESTER JH.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.44	2.40	2.27	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.36	2.45	2.43	2.26	
PULL #3	2.46	2.48	2.44	2.18	
PULL #4	2.38	2.35	2.50	2.34	
PULL #5	2.39	2.43	2.42	2.20	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.18	3.40		
PULL #2	3.51	3.41		
PULL #3	3.44	3.41		
PULL #4	3.47	3.46		
PULL #5	3.38	3.46		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.27	4.33		4.39
PULL #2	4.25	4.25		4.53
PULL #3	4.22	4.43		4.35
PULL #4	4.28	4.36		4.50
PULL #5	4.44	4.49		4.41
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636234
1 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.401103
1 TO	2	.560679
1 TO	3	.279517
1 TO	4	.376942
1 TO	5	.9108

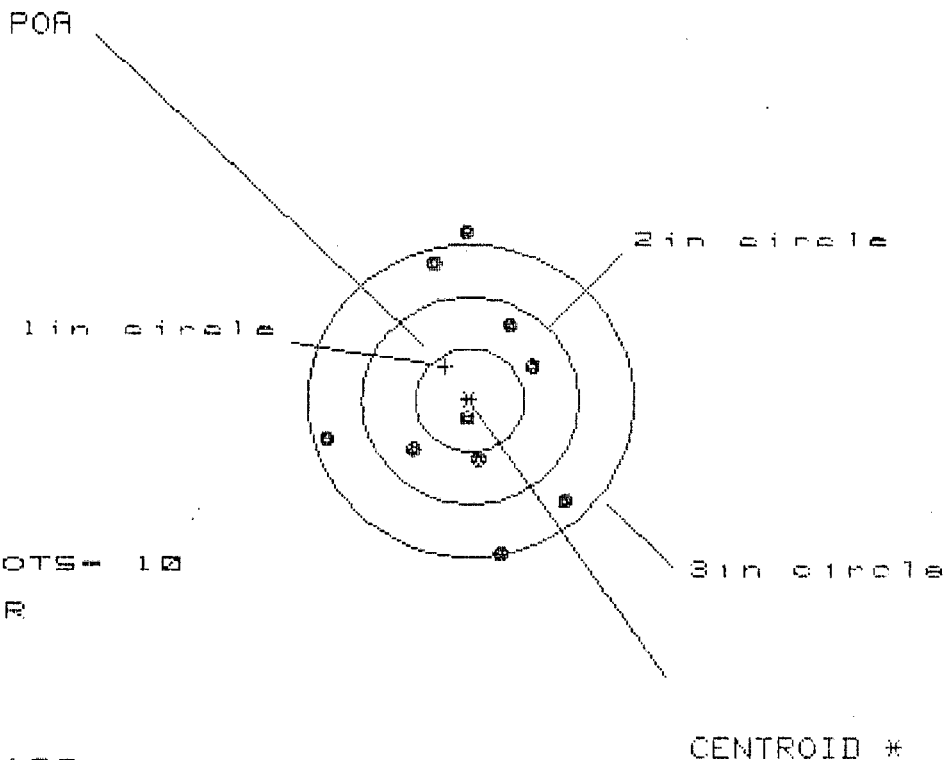
$\frac{5}{4} \frac{3}{1}$ <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0158
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0448
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0475045
THE AMR FOR THIS RIFLE IS: .9488

1 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6696234

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 2.186

VS= 3.021

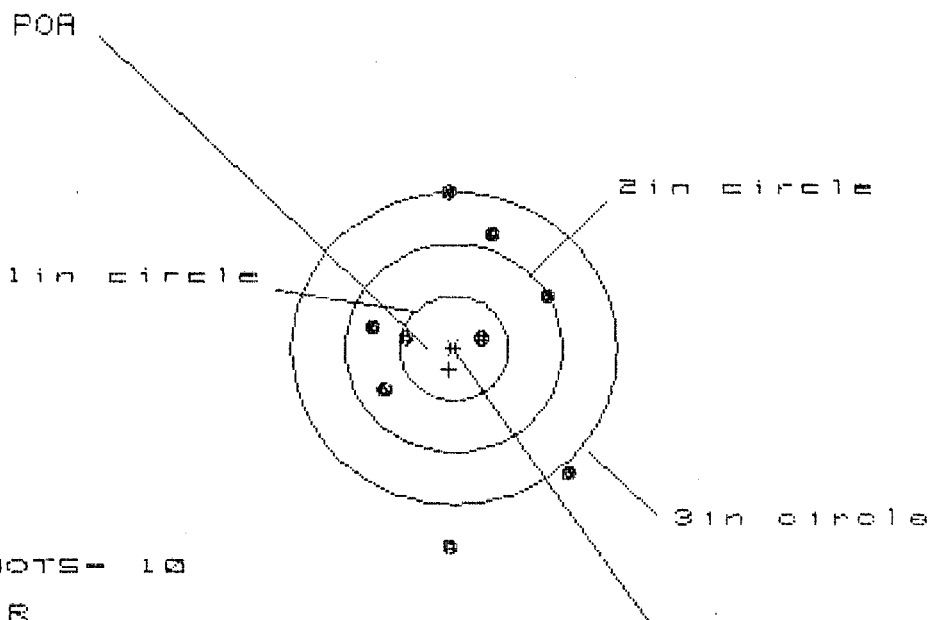
GS= 3.035

PATTERN #	:	45	90	135
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.907	.909	.948
MINIMUM X	:	-1.279	-1.277	-1.238
MAXIMUM Y	:	1.584	1.523	1.365
MINIMUM Y	:	-1.437	-1.260	-.904
CENTROID X	:	.228	.226	.187
CENTROID Y	:	-.330	-.506	-.348
POA TO CENTROID in.	:	.401	.554	.395
MIN RADIUS	:	.208	.076	.179
MEAN RADIUS	:	1.002	.904	.868
MAX RADIUS	:	1.585	1.555	1.393
HORIZONTAL SPREAD	:	2.186	2.186	2.186
VERTICAL SPREAD	:	3.021	2.783	2.269
EXTREME SPREAD	:	3.035	2.852	2.578
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	9		

1 Aug 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 8

HS = 1.818

VS = 3.344

GS = 3.344

CENTROID #

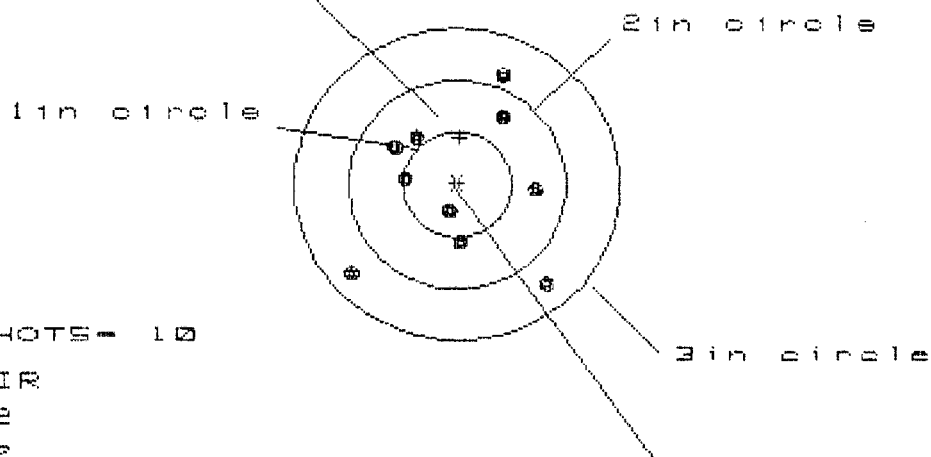
PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.839	1.833	1.000
MINIMUM X	:	-.779	-.785	-.656
MAXIMUM Y	:	1.452	1.242	1.069
MINIMUM Y	:	-1.892	-1.384	-.830
CENTROID X	:	.048	.054	-.075
CENTROID Y	:	.201	.411	.584
POA TO CENTROID in.	:	.206	.414	.589
MIN RADIUS	:	.240	.247	.385
MEAN RADIUS	:	.974	.847	.722
MAX RADIUS	:	1.892	1.727	1.069
HORIZONTAL SPREAD	:	1.818	1.818	1.656
VERTICAL SPREAD	:	3.344	2.626	1.899
EXTREME SPREAD	:	3.344	2.861	1.986
NUMBER IN ONE INCH CIRCLE =	:	3		
NUMBER IN TWO INCH CIRCLE =	:	6		
NUMBER IN THREE INCH CIRCLE =	:	8		

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CENTERFIRE PATTERNS # 3

POA



OF SHOTS - 10

IN CIR

1in = 2

2in = 7

3in = 10

LS= 1.752

VS= 2.016

GS= 2.327

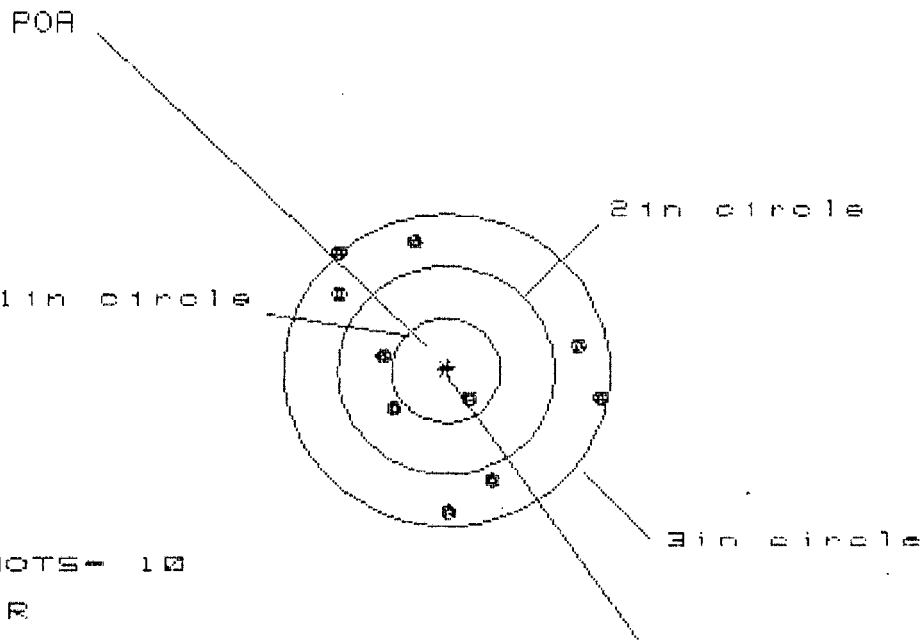
CENTROID *

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.811	.850	.743
MINIMUM X	:	-.941	-.850	-.625
MAXIMUM Y	:	1.031	.922	.801
MINIMUM Y	:	-.985	-.964	-.818
CENTROID X	:	-.023	-.114	-.007
CENTROID Y	:	-.453	-.344	-.223
POA TO CENTROID in.	:	.454	.362	.223
MIN RADIUS	:	.215	.311	.441
MEAN RADIUS	:	.781	.711	.645
MAX RADIUS	:	1.276	1.286	.898
HORIZONTAL SPREAD	:	1.752	1.700	1.368
VERTICAL SPREAD	:	2.016	1.886	1.619
EXTREME SPREAD	:	2.327	2.327	1.665
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 10

HS= 2.338

VS= 2.594

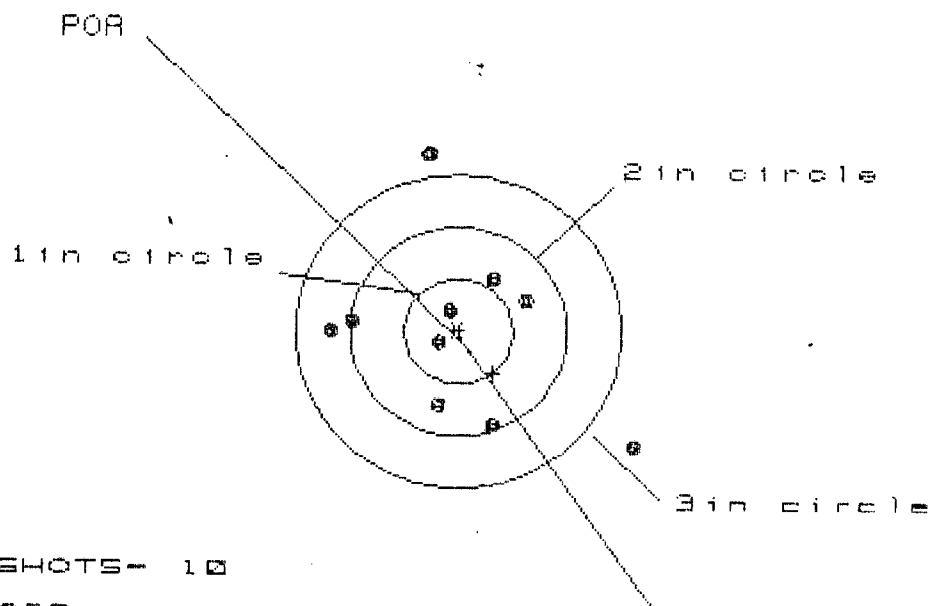
GS= 2.728

PATTERN #	1	4	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.393	1.288	1.305
MINIMUM X	-.945	-1.045	-.894
MAXIMUM Y	1.229	1.353	1.331
MINIMUM Y	-1.365	-1.241	-1.263
CENTROID X	-.014	.091	-.070
CENTROID Y	-.041	-.165	-.143
POA TO CENTROID in.	.043	.188	.160
MIN RADIUS	.352	.192	.311
MEAN RADIUS	1.068	1.007	.955
MAX RADIUS	1.460	1.406	1.350
HORIZONTAL SPREAD	2.338	2.333	2.189
VERTICAL SPREAD	2.594	2.594	2.594
EXTREME SPREAD	2.728	2.610	2.610
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	10		

1 Aug 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 2.834

VS= 2.733

GS= 3.365

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.653	.756	.740
MINIMUM X	:	-1.181	-.997	-1.013
MAXIMUM Y	:	1.668	1.550	.600
MINIMUM Y	:	-1.065	-.974	-.780
CENTROID X	:	-.318	-.502	-.486
CENTROID Y	:	.399	.517	.323
POR TO CENTROID in.	:	.510	.720	.584
MIN RADIUS	:	.188	.166	.062
MEAN RADIUS	:	.919	.795	.677
MAX RADIUS	:	1.966	1.555	1.014
HORIZONTAL SPREAD	:	2.834	1.753	1.753
VERTICAL SPREAD	:	2.733	2.524	1.380
EXTREME SPREAD	:	3.365	2.606	1.784
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			8	