

C6611650

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington



MODEL 700™ H24

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

20

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

SERIAL NO.	C6611650
ORDER NO.	5716



5716 C6611650

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611650

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	1/15/91	KS
600	Proof		1/15/91	KS
607	Check Headspace		1/15/91	KS
610	Dis-assemble Gun		1/15/91	KS
612	Magnaflux Barrel Action	1 18	91	KR
	Magnaflux Bolt	1 18	91	KR
615	Rollmark Caliber	1 18	91	LG
617	Drill and Tap Sight Holes	1 24	91	FB
618	Polish Barrel	1 24	91	WB
620	Apply Coatings (Barrel Action)		2-15-91	TA
	Apply Coating (Bolt)			
625	Final Assembly		3/8/91	KL
	A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		3/8/91	KL
	C) Inspect Ejector Hole for Chamfer		3/8/91	KL
	D) Oil Firing Pin Ass'y		3/8/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		4/1/91	JL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			4/1/91	JJ
	G) Safety Off Force	3	3	3			4/1/91	JJ
	H) Trigger Pull Test & Retainability						4/1/91	JJ
	I) Firing Pin Indent	.020	.021	.021			4/1/91	JJ
	J) Assemble Stock						4/2/91	K.S.
	K) Assemble Swivel Studs						4-8-91	D/H
	L) Attach Front and Rear Sight Assemblies						4/2/91	K.S.
	M) Iron Sight Alignment						4/2/91	K.S.
	N) Detach Front & Rear Sights & place in numbered container						4/2/91	K.S.
	O) Attach Scope to Rifle						4/2/91	K.S.
	P) Detach & Attach Scope 20 Times						4/2/91	K.S.
640	Gallery Target & Test						4-3-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						4-3-91	AF
655	Final Inspection							
	A) Headspace						4-8-91	D/H
	B) Trigger Pull	2.42	2.47	2.42	2.46	2.45	4/5/91	JJ
	C) Function						4-8-91	D/H
660	Pack							

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6611650

DATE 4/1/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.34	2.12	2.40	2.42	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.27	2.51	2.38	2.47	
PULL #3	2.20	2.39	2.44	2.42	
PULL #4	2.33	2.43	2.35	2.46	
PULL #5	2.24	2.50	2.48	2.45	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.41	3.23		
PULL #2	3.39	3.26		
PULL #3	3.38	3.10		
PULL #4	3.22	3.26		
PULL #5	3.30	3.34		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.49	4.30		4.44
PULL #2	4.18	4.18		4.23
PULL #3	4.58	4.20		4.56
PULL #4	4.50	4.44		4.49
PULL #5	4.34	4.33		4.47
TOTAL				
AVG.				

MOD. _____ GA. CAL. _____ GUN # 1650

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st		
NF	4/3	Safe Binders	KS
	2nd	FILED STOCK	KS. 4/4/91
	3rd		
	4th		
		FUNCTION	

RD 6654

Rev 1

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

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611650
4 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.0478539
1 TO	2	.10017
1 TO	3	.174003
1 TO	4	.0463897
1 TO	5	.116499

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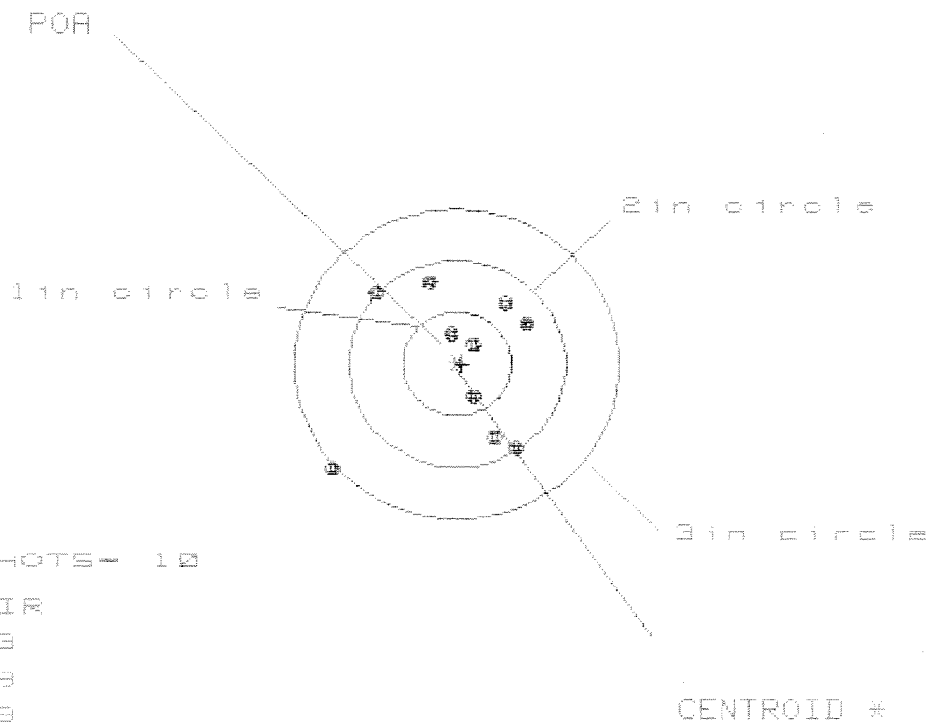
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.009
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0092
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0128701
THE AVERAGE FOR THIS RIFLE IS: .001

4 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611650

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1in = 3

2in = 9

3in = 9

HS= 1.807

VS= 1.815

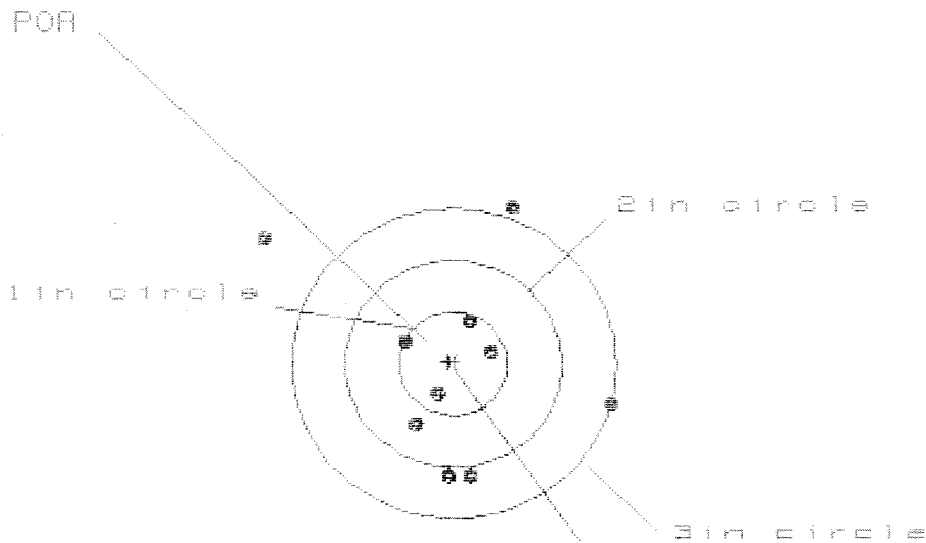
GS= 2.304

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.614	.481	.376
MINIMUM X	:	-1.193	-.839	-.506
MAXIMUM Y	:	.797	.684	.750
MINIMUM Y	:	-1.018	-.885	-.819
CENTROID X	:	-.047	.086	.191
CENTROID Y	:	.009	.122	.056
POA TO CENTROID in.	:	.040	.149	.198
MIN RADIUS	:	.178	.051	.174
MEAN RADIUS	:	.744	.614	.576
MAX RADIUS	:	1.569	.994	.905
HORIZONTAL SPREAD	:	1.807	1.320	.883
VERTICAL SPREAD	:	1.815	1.569	1.569
EXTREME SPREAD	:	2.304	1.894	1.769
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			9	
NUMBER IN THREE INCH CIRCLE =			9	

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 4

2in = 5

3in = 8

HS= 2.164

VS= 2.624

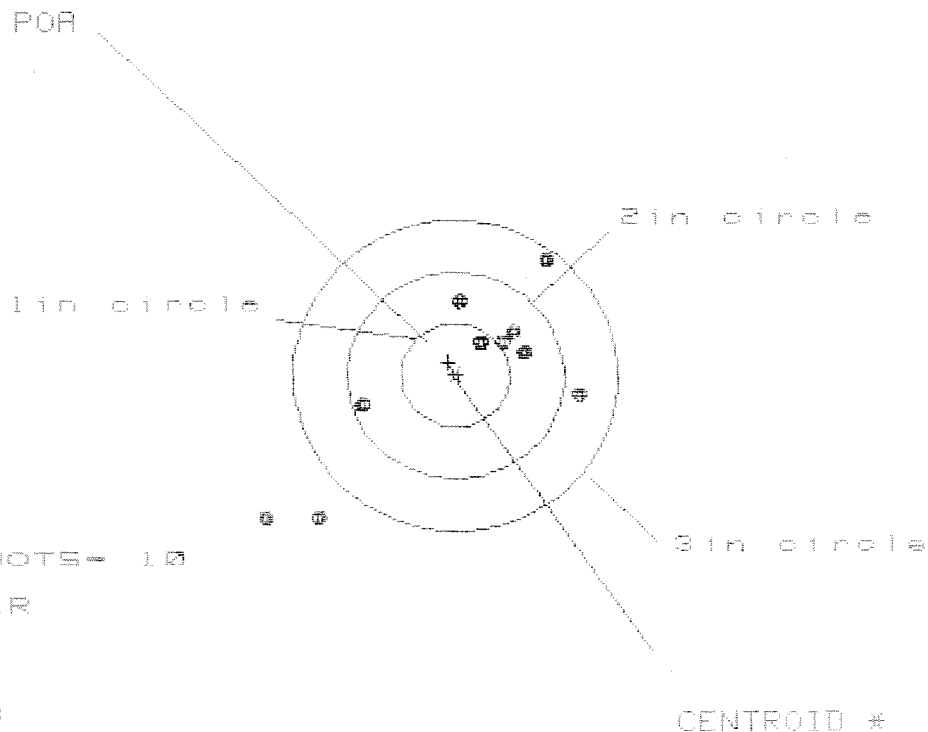
GS= 3.537

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.415	1.221	1.266
MINIMUM X	:	-1.749	-.611	-.567
MAXIMUM Y	:	1.509	1.642	.712
MINIMUM Y	:	-1.115	-.982	-.777
CENTROID X	:	.050	.244	.200
CENTROID Y	:	-.016	-.149	-.354
POR TO CENTROID in.	:	.052	.206	.406
MIN RADIUS	:	.319	.285	.352
MEAN RADIUS	:	.965	.830	.711
MAX RADIUS	:	2.117	1.600	1.266
HORIZONTAL SPREAD	:	3.164	1.832	1.832
VERTICAL SPREAD	:	2.624	2.624	1.489
EXTREME SPREAD	:	3.537	2.681	1.937
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS= 2.845

VS= 2.469

GS= 3.518

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.096	.901	.722
MINIMUM X	-1.749	-1.433	-1.198
MAXIMUM Y	1.091	.944	.753
MINIMUM Y	-1.378	-1.525	-1.573
CENTROID X	.064	.259	.438
CENTROID Y	-.125	.022	.213
POA TO CENTROID in.	.141	.260	.487
MIN RADIUS	.401	.192	.092
MEAN RADIUS	1.040	.803	.536
MAX RADIUS	2.198	2.093	1.321
HORIZONTAL SPREAD	2.845	2.334	1.912
VERTICAL SPREAD	2.469	2.469	1.326
EXTREME SPREAD	3.518	3.203	2.093
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		8	

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CENTERFIRE PATTERNS

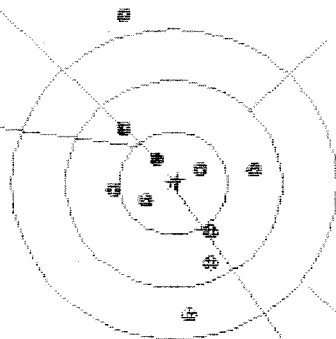
4

POA

1in circle

2in circle

3in circle



OF SHOTS= 10

IN CIR

1in = 3

2in = 8

3in = 9

HS= 1.273

VS= 2.957

GS= 3.022

CENTROID #

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.763	.710	.723
MINIMUM X	-.510	-.563	-.550
MAXIMUM Y	1.686	.684	.549
MINIMUM Y	-1.271	-1.084	-.753
CENTROID X	-.041	.012	-.001
CENTROID Y	-.037	-.224	-.089
POA TO CENTROID in.	.055	.224	.089
MIN RADIUS	.253	.266	.263
MEAN RADIUS	.721	.608	.526
MAX RADIUS	1.750	1.089	.813
HORIZONTAL SPREAD	1.273	1.273	1.273
VERTICAL SPREAD	2.957	1.768	1.302
EXTREME SPREAD	3.022	1.882	1.548
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 1.361

VS= 2.448

GS= 2.818

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.858	.736	.820
MINIMUM X	:	-1.103	-.987	-.903
MAXIMUM Y	:	1.222	1.104	.936
MINIMUM Y	:	-1.226	-1.344	-.880
CENTROID X	:	-.071	.051	-.033
CENTROID Y	:	.123	.241	.403
POA TO CENTROID in.	:	.142	.246	.410
MIN RADIUS	:	.358	.315	.146
MEAN RADIUS	:	.935	.861	.759
MAX RADIUS	:	1.528	1.503	1.060
HORIZONTAL SPREAD	:	1.961	1.723	1.723
VERTICAL SPREAD	:	2.448	2.448	1.816
EXTREME SPREAD	:	2.818	2.726	1.912
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	