

C6636140

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

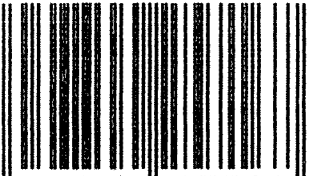
Order No. **5716**

*Includes 1 in chamber.



Remington [®]		 REG. U.S. PAT. & TM. OFF.	VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700TM H24		SERIAL NO. C6636140	ORDER NO. 5716
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		20	
 5716 C6636140			

UPC



0 47700 25716 7

M-24

Stock
Repaired

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636140

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		5/3/91	KS
600	Proof		5/3/91	KS
607	Check Headspace		5/3/91	KS
610	Dis-assemble Gun		5/3/91	KS
612	Magnaflux Barrel Action	5 6 9 1		KCD
	Magnaflux Bolt	5 6 9 1		KCD
615	Rollmark Caliber	5 6 9 1		KCD
617	Drill and Tap Sight Holes	5 15 9 1		LSB
618	Polish Barrel	5 15 9 1		LSB
620	Apply Coatings (Barrel Action)		5-29-91	LS
	Apply Coating (Bolt)			LS
625	Final Assembly A) Clean inside of Bolt Assembly		4/4/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/4/91	KS
	C) Inspect Ejector Hole for Chamfer		4/4/91	KS
	D) Oil Firing Pin Ass'y		4/4/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		6-5-91	91

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			6/5/91	JH
	G) Safety Off Force	3	3	3			6/5/91	JH
	H) Trigger Pull Test & Retainability						6-5-91	JH
	I) Firing Pin Indent	.021	.021	.021			6-5-91	JH
	J) Assemble Stock						6/5/91	KS
	K) Assemble Swivel Studs						6-8-91	DH
	L) Attach Front and Rear Sight Assemblies						6/5/91	KS
	M) Iron Sight Alignment						6/5/91	KS
	N) Detach Front & Rear Sights & place in numbered container						6/5/91	KS
	O) Attach Scope to Rifle						6/5/91	KS
	P) Detach & Attach Scope 20 Times						6/5/91	KS
640	Gallery Target & Test						6-6-91	DH
	A) Time						6-6-91	DH
	B) Malfunctions						6-6-91	DH
	C) Pierced Primers						6-6-91	DH
	D) Optical Clarity of Scope						6-6-91	DH
645	Inspect for Live Ammo						6-6-91	DH
655	Final Inspection						6-8-91	DH
	A) Headspace						6-8-91	JH
	B) Trigger Pull	2.38	2.42	2.44	2.50	2.65	6-8-91	JH
	C) Function						6-8-91	DH
660	Pack						6-20-91	N

SWS TRIGGER PULL TEST

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

SERIAL NO. C-663640

DATE 6-5-91

TESTER JCL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.45	2.35	2.43	2.38	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.36	2.34	2.38	2.42	
PULL #3	2.34	2.34	2.36	2.44	
PULL #4	2.35	2.34	2.39	2.50	
PULL #5	2.33	2.37	2.36	2.55	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.50	3.47		
PULL #2	3.59	3.52		
PULL #3	3.52	3.64		
PULL #4	3.52	3.55		
PULL #5	3.55	3.56		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.41	4.57		4.39
PULL #2	4.13	4.39		4.21
PULL #3	4.40	4.36		4.43
PULL #4	4.39	4.41		4.19
PULL #5	4.36	4.49		4.13
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636140
6 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.320807
1 TO	2	.537753
1 TO	3	.525681
1 TO	4	.403517
1 TO	5	.173159

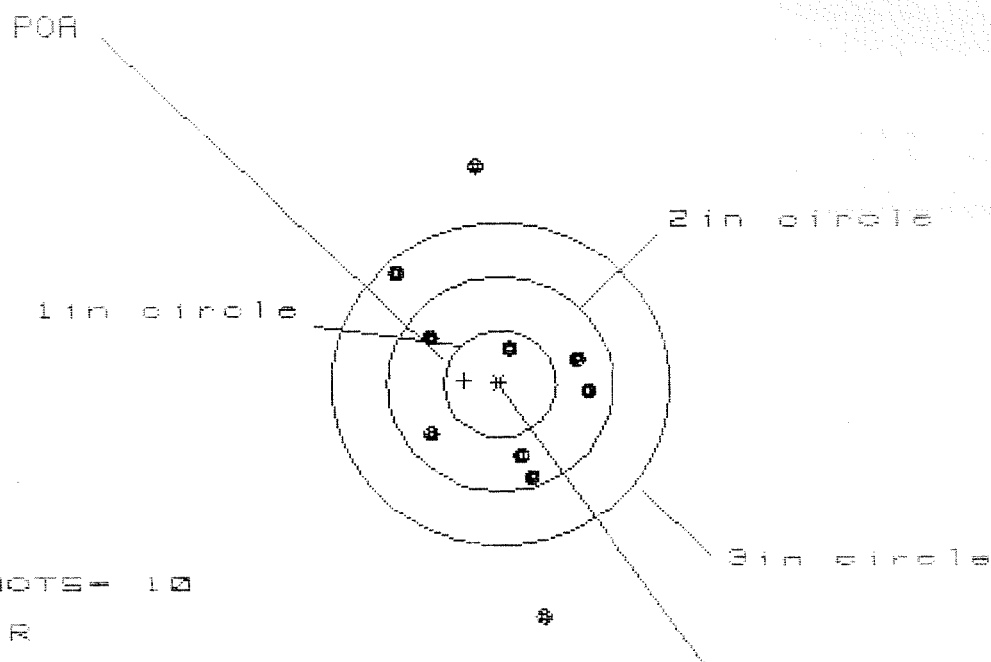
361 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0032
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.016
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0163169
THE AMR FOR THIS RIFLE IS: .9006

6 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08635140

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 8

HS= 1.686

VS= 4.109

GS= 4.161

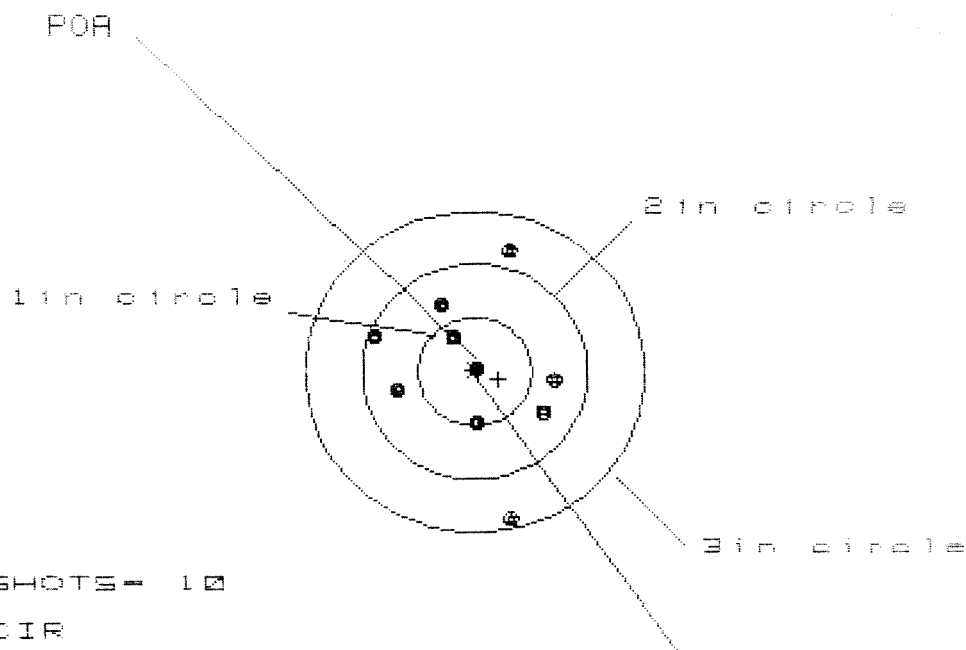
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.742	.788	.763
MINIMUM X	-.944	-.898	-.923
MAXIMUM Y	1.986	1.750	1.061
MINIMUM Y	-2.123	-1.088	-.869
CENTROID X	.319	.273	.298
CENTROID Y	-.034	.202	-.017
POA TO CENTROID in.	.321	.340	.298
MIN RADIUS	.372	.162	.358
MEAN RADIUS	1.054	.920	.798
MAX RADIUS	2.163	1.761	1.406
HORIZONTAL SPREAD	1.686	1.686	1.686
VERTICAL SPREAD	4.109	2.838	1.930
EXTREME SPREAD	4.161	2.890	2.298
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

HS = 1.689

VS = 2.475

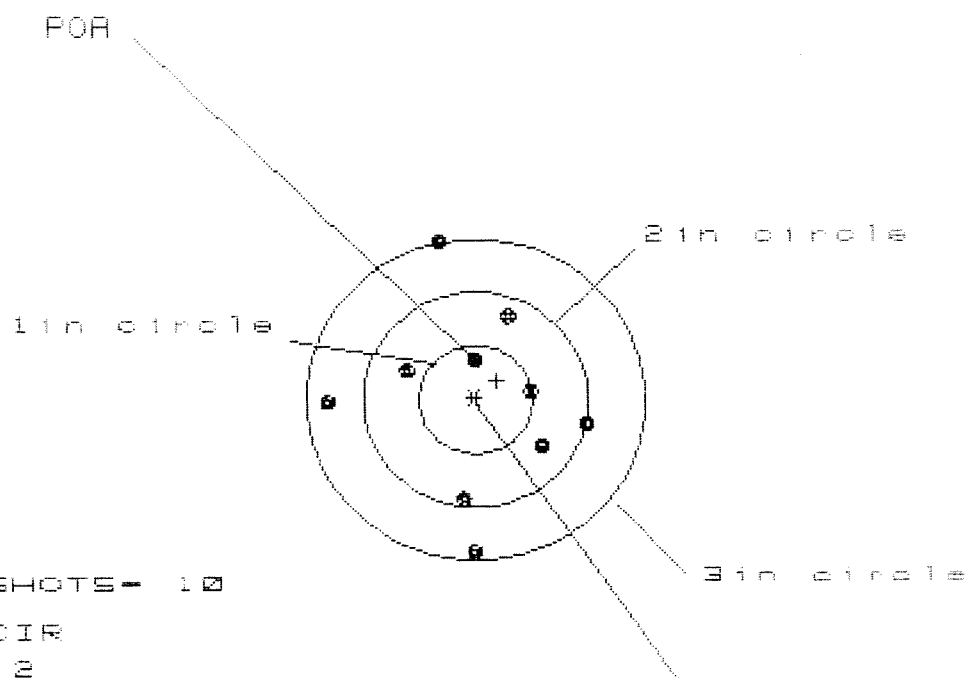
GS = 2.475

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.754	.792	.841
MINIMUM X	:	-.935	-.897	-.848
MAXIMUM Y	:	1.084	.930	.561
MINIMUM Y	:	-1.391	-.610	-.494
CENTROID X	:	-.208	-.246	-.295
CENTROID Y	:	.073	.227	.111
POA TO CENTROID in.	:	.221	.335	.315
MIN RADIUS	:	.059	.100	.076
MEAN RADIUS	:	.730	.640	.584
MAX RADIUS	:	1.430	1.010	.906
HORIZONTAL SPREAD	:	1.689	1.689	1.689
VERTICAL SPREAD	:	2.475	1.540	1.055
EXTREME SPREAD	:	2.475	1.745	1.745
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 2.292

VS= 2.962

GS= 2.977

CENTROID #

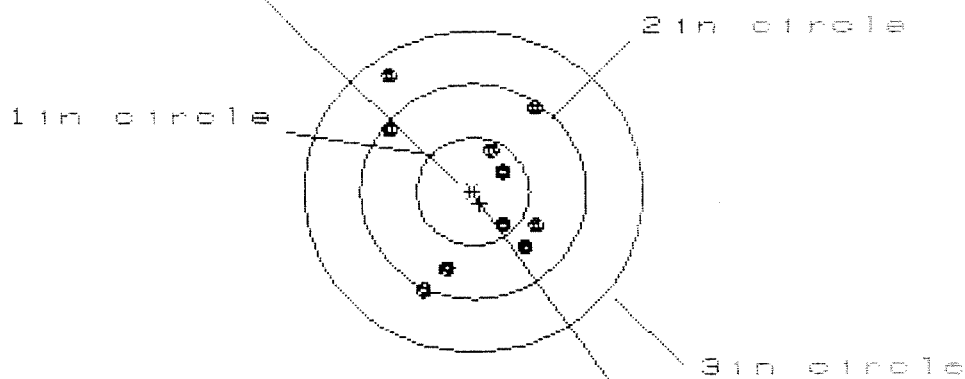
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.018	.984	.979
MINIMUM X	:	-1.274	-1.308	-1.313
MAXIMUM Y	:	1.522	.931	.772
MINIMUM Y	:	-1.440	-1.270	-.908
CENTROID X	:	-.186	-.152	-.147
CENTROID Y	:	-.180	-.349	-.190
POR TO CENTROID in.	:	.258	.380	.240
MIN RADIUS	:	.398	.481	.413
MEAN RADIUS	:	.930	.861	.785
MAX RADIUS	:	1.553	1.316	1.313
HORIZONTAL SPREAD	:	2.292	2.292	2.292
VERTICAL SPREAD	:	2.962	2.201	1.680
EXTREME SPREAD	:	2.977	2.299	2.299
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			9	

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CENTERFIRE PATTERNS # 4

POA



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.233

VS= 1.991

GS= 2.017

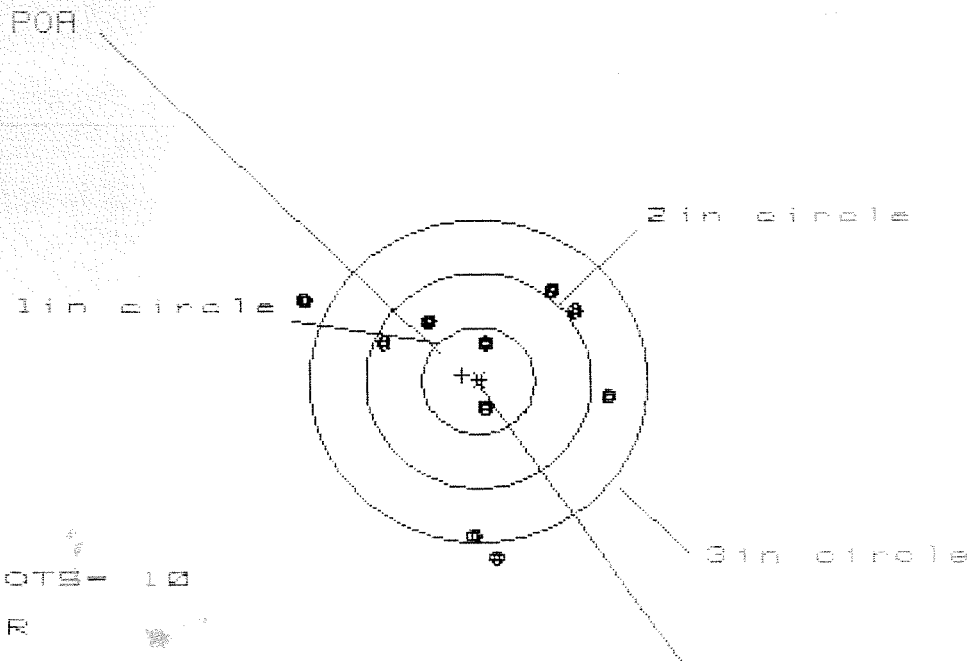
CENTROID #

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.524	.438	.371
MINIMUM X	:	-.769	-.795	-.862
MAXIMUM Y	:	1.052	.938	.835
MINIMUM Y	:	-.939	-.822	-.713
CENTROID X	:	-.056	.030	.097
CENTROID Y	:	.115	-.002	.101
POA TO CENTROID in.	:	.128	.030	.140
MIN RADIUS	:	.309	.274	.212
MEAN RADIUS	:	.742	.652	.597
MAX RADIUS	:	1.303	1.032	1.022
HORIZONTAL SPREAD	:	1.293	1.233	1.233
VERTICAL SPREAD	:	1.991	1.760	1.548
EXTREME SPREAD	:	2.017	2.007	1.709
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	8		
NUMBER IN THREE INCH CIRCLE	=	10		

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 2.736

VS= 2.476

GS= 2.984

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.188	1.016	1.018
MINIMUM X	:	-1.548	-1.033	-1.031
MAXIMUM Y	:	.828	.914	.719
MINIMUM Y	:	-1.648	-1.562	-1.583
CENTROID X	:	.147	.319	.317
CENTROID Y	:	-.054	-.140	.055
FOR TO CENTROID in.	:	.156	.348	.321
MIN RADIUS	:	.271	.201	.274
MEAN RADIUS	:	1.047	.968	.859
MAX RADIUS	:	1.732	1.562	1.605
HORIZONTAL SPREAD	:	2.736	2.049	2.049
VERTICAL SPREAD	:	2.476	2.476	2.302
EXTREME SPREAD	:	2.984	2.522	2.426
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	