

C6611500

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington



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

MODEL 700TM M24

REG. U.S. PAT. & TM. OFF.

SERIAL NO.
C6611500

ORDER NO.
5716

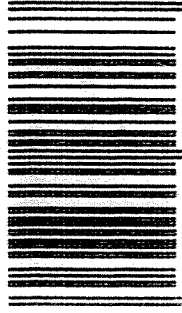
20

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



5716 C6611500

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6611500**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/12/91	K.S.
600	Proof		3/12/91	K.S.
607	Check Headspace		3/12/91	K.S.
610	Dis-assemble Gun		3/12/91	K.S.
612	Magnaflux Barrel Action		3/27/91	KR
	Magnaflux Bolt		11	KR
615	Rollmark Caliber		3/27/91	LS.
617	Drill and Tap Sight Holes		APR 3 1991	FB
618	Polish Barrel		APR 3 1991	WB
620	Apply Coatings (Barrel Action)		3-12-91	TA
	Apply Coating (Bolt)			TA
625	Final Assembly A) Clean inside of Bolt Assembly		4/26/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/26/91	KS
	C) Inspect Ejector Hole for Chamfer		4/26/91	KS
	D) Oil Firing Pin Ass'y		4/26/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		4/29/91	KS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			4/30/91	JM
	G) Safety Off Force	3	3	3			4/30/91	JM
	H) Trigger Pull Test & Retainability						4/29/91	JM
	I) Firing Pin Indent	.024	.024	.024			4/30/91	JM
	J) Assemble Stock						4/30/91	K.S
	K) Assemble Swivel Studs						5-11-91	D/H
	L) Attach Front and Rear Sight Assemblies						4/30/91	K.S
	M) Iron Sight Alignment						4/30/91	K.S
	N) Detach Front & Rear Sights & place in numbered container						4/30/91	K.S
	O) Attach Scope to Rifle						4/30/91	K.S
	P) Detach & Attach Scope 20 Times						4/30/91	K.S
640	Gallery Target & Test						4/30/91	KT
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	KT
645	Inspect for Live Ammo						4/30/91	KT
655	Final Inspection							
	A) Headspace						5-11-91	D/H
	B) Trigger Pull	2.30	2.24	2.24	2.13	2.17	5/10/91	JM
	C) Function						5-11-91	D/H
660	Pack						6-19-91	VF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6611500

DATE 4/29/91

TESTER 981

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.57	2.35	2.38	2.30	MINIMUM SETTING,
PULL #2	2.55	2.35	2.35	2.24	NO AVG. OF 5
PULL #3	2.37	2.33	2.33	2.24	READINGS ACCEPT-
PULL #4	2.24	2.34	2.37	2.13	ABLE LESS THAN 2#
PULL #5	2.35	2.25	2.37	2.17	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES			COMMENTS
PULL #1	3.54	3.36			
PULL #2	3.52	3.47			
PULL #3	3.43	3.18			
PULL #4	3.50	3.40			
PULL #5	3.51	3.51			
TOTAL					
AVG.					

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.53	4.31		4.37
PULL #2	4.38	4.45		4.46
PULL #3	4.41	4.48		4.43
PULL #4	4.49	4.50		4.49
PULL #5	4.33	4.27		4.42
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611500
30 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.416011
1 TO	2	.408718
1 TO	3	.498121
1 TO	4	.662583
1 TO	5	141.416

204 <----FOR
1

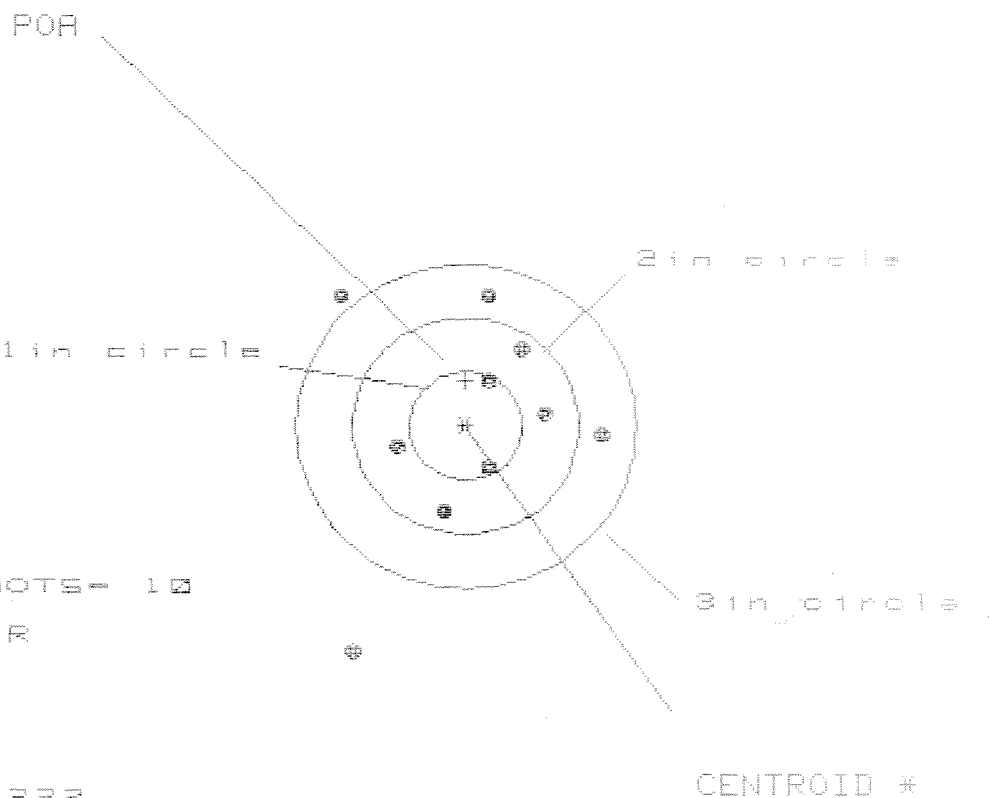
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS:
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS:
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE

THE AMR FOR THIS RIFLE IS: 1.02

30 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611500

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 6

3 in = 8

HS= 2.222

VS= 3.275

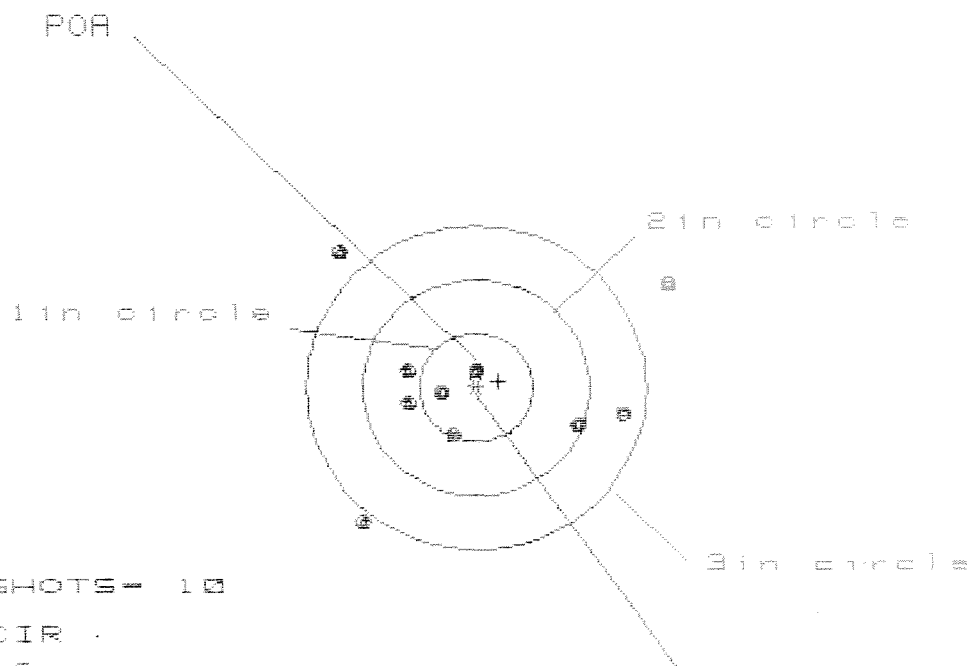
GS= 3.480

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.164	1.052	.906
MINIMUM X	:	-1.058	-1.170	-1.031
MAXIMUM Y	:	1.170	.936	1.053
MINIMUM Y	:	-2.105	-1.024	-1.000
CENTROID X	:	.003	.115	.261
CENTROID Y	:	-.416	-.182	.203
POA TO CENTROID in.	:	.416	.215	.401
MIN RADIUS	:	.391	.247	.221
MEAN RADIUS	:	1.009	.824	.773
MAX RADIUS	:	2.334	1.496	1.053
HORIZONTAL SPREAD	:	2.222	2.222	2.222
VERTICAL SPREAD	:	3.275	1.960	1.960
EXTREME SPREAD	:	3.480	2.554	1.960
NUMBER IN ONE INCH CIRCLE	=	1	1	1
NUMBER IN TWO INCH CIRCLE	=	6	6	6
NUMBER IN THREE INCH CIRCLE	=	8	8	8

30 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611500

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR .

1in = 2

2in = 6

3in = 7

HS= 2.876

VS= 2.502

GS= 3.435

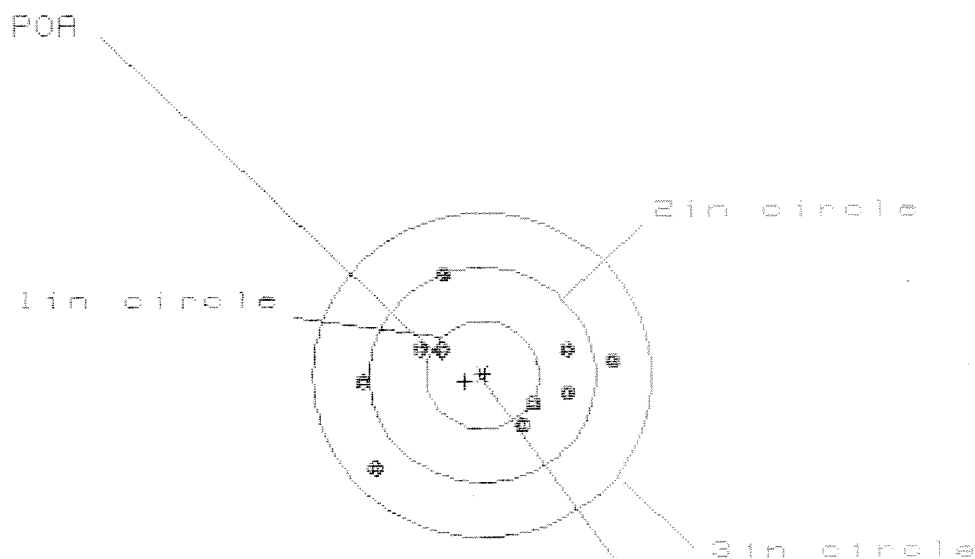
CENTROID #

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.719	1.495	1.375
MINIMUM X	-1.157	-.966	-.887
MAXIMUM Y	1.278	1.381	.473
MINIMUM Y	-1.224	-1.121	-.948
CENTROID X	-.196	-.387	-.266
CENTROID Y	-.059	-.162	-.335
POA TO CENTROID in.	.205	.420	.428
MIN RADIUS	.157	.148	.243
MEAN RADIUS	.986	.834	.746
MAX RADIUS	1.954	1.685	1.375
HORIZONTAL SPREAD	2.876	2.461	2.262
VERTICAL SPREAD	2.502	2.502	1.421
EXTREME SPREAD	3.435	2.902	2.459
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	7		

30 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611500

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 10

HS= 2.142

VS= 1.762

GS= 2.311

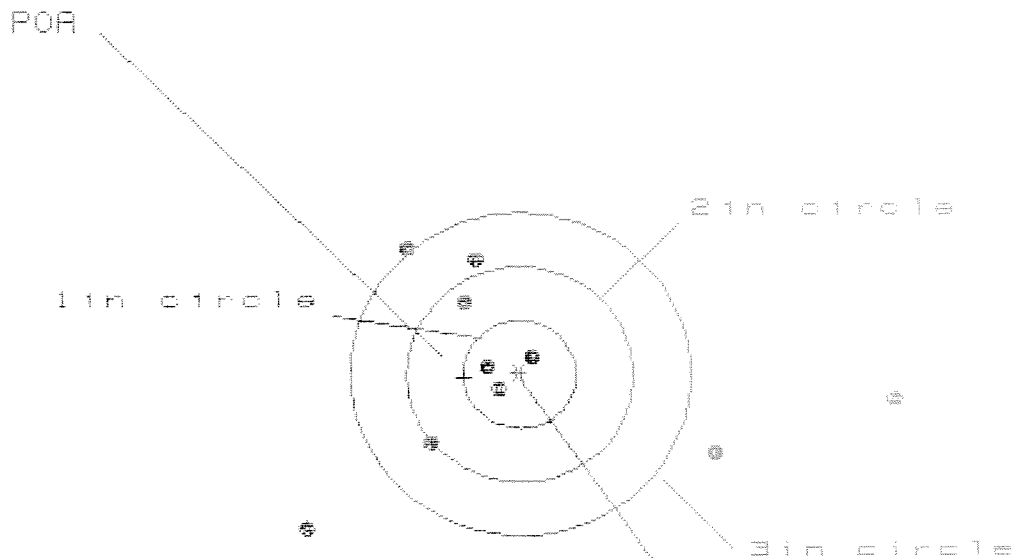
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.101	.992	.777
MINIMUM X	:	-1.041	-1.150	-1.026
MAXIMUM Y	:	.899	.804	.810
MINIMUM Y	:	-.863	-.566	-.560
CENTROID X	:	.153	.262	.138
CENTROID Y	:	.059	.154	.148
POA TO CENTROID in.	:	.164	.304	.203
MIN RADIUS	:	.478	.519	.420
MEAN RADIUS	:	.815	.750	.714
MAX RADIUS	:	1.306	1.155	1.031
HORIZONTAL SPREAD	:	2.142	2.142	1.803
VERTICAL SPREAD	:	1.762	1.370	1.370
EXTREME SPREAD	:	2.311	2.148	1.825
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

30 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611500

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 6

HS= 5.214

VS= 2.603

GS= 5.341

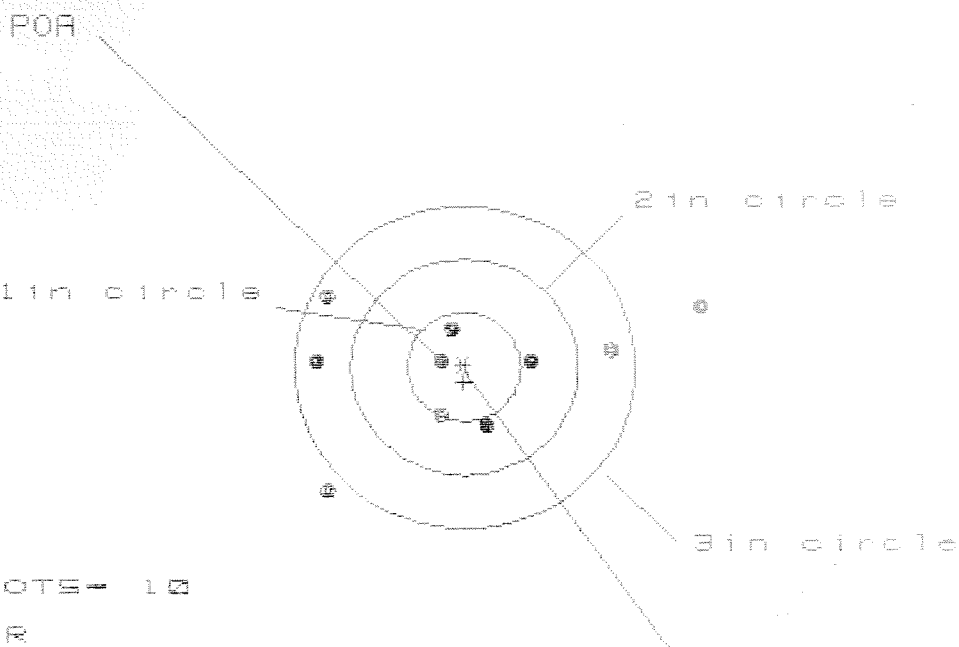
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	3.278	2.090	1.894
MINIMUM X	:	-1.936	-1.572	-1.807
MAXIMUM Y	:	1.170	1.140	.957
MINIMUM Y	:	-1.433	-1.463	-.931
CENTROID X	:	.493	.129	.325
CENTROID Y	:	.030	.060	.243
POA TO CENTROID in.	:	.494	.142	.406
MIN RADIUS	:	.151	.111	.183
MEAN RADIUS	:	1.279	.995	.836
MAX RADIUS	:	3.290	2.220	2.111
HORIZONTAL SPREAD	:	5.214	3.662	2.701
VERTICAL SPREAD	:	2.603	2.603	1.888
EXTREME SPREAD	:	5.341	3.731	3.295
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		6	

30 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611500

CENTERFIRE PATTERNS # 5



HS= 3.356
VS= 1.801
GS= 3.671

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.078	1.559	1.440
MINIMUM X	-1.278	-1.047	-1.166
MAXIMUM Y	.687	.752	.620
MINIMUM Y	-1.114	-1.049	-.845
CENTROID X	.010	-.221	-.102
CENTROID Y	.141	.076	.202
POA TO CENTROID in.	.141	.233	.231
MIN RADIUS	.221	.164	.092
MEAN RADIUS	1.009	.867	.776
MAX RADIUS	2.157	1.578	1.445
HORIZONTAL SPREAD	3.356	2.606	2.606
VERTICAL SPREAD	1.801	1.801	1.265
EXTREME SPREAD	3.671	2.823	2.627
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		8	