

C6349105

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.

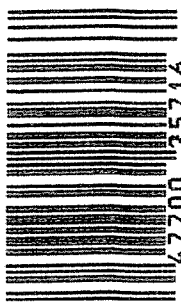
REG. U.S. PAT. & TM. OFF.

MODEL 700TM M24

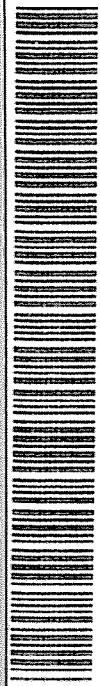
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada. Marque Deposee.

SERIAL NO. C6349105	01
ORDER NO. 5716	

UPC



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5716 C6349105

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349105

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	5 9	90	RW
600	Proof	5 9	90	RW
607	Check Headspace	5 9	90	RW
610	Dis-assemble Gun	5 9	90	RW
612	Magnaflux Barrel Action	5-15-90		KER
	Magnaflux Bolt	5-15-90		KER
615	Rollmark Caliber	5-15-90		BS
617	Drill and Tap Sight Holes		5/17/90	K-B
618	Polish Barrel RB		5/17/90	WB
620	Apply Coatings (Barrel Action)		5-25-90	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/25/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/25/90	RW
	C) Inspect Ejector Hole for Chamfer		5/25/90	RW
	D) Oil Firing Pin Ass'y		5/25/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/29/90	RW

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/4	4 1/4	4			5/30/90	WB
	G) Safety Off Force	2	2	2			5/30/90	WB
	H) Trigger Pull Test & Retainability						5/29/90	gll
	I) Firing Pin Indent	.024	.024	.024			5/30/90	WB
	J) Assemble Stock						5/30/90	RW
	K) Assemble Swivel Studs						6-6-90	JD
	L) Attach Front and Rear Sight Assemblies						5/30/90	RW
	M) Iron Sight Alignment						5/30/90	RW
	N) Detach Front & Rear Sights & place in numbered container						5/30/90	RW
	O) Attach Scope to Rifle						5/30/90	WB
	P) Detach & Attach Scope 20 Times						5/30/90	WB
640	Gallery Target & Test						6-1-90	A
	A) Time						11	A
	B) Malfunctions						11	A
	C) Pierced Primers						11	A
	D) Optical Clarity of Scope						11	A
645	Inspect for Live Ammo						6-1-90	A
655	Final Inspection							
	A) Headspace						6-8-90	JD
	B) Trigger Pull	255	263	242	271	263	6-6-90	JD
	C) Function						6-6-90	JD
660	Pack						6-19-90	D/H

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6349105

DATE 5/29/90

TESTER 94

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.34	2.34	2.35	2.55	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.23	2.30	2.29	2.63	
PULL #3	2.36	2.30	2.33	2.42	
PULL #4	2.36	2.35	2.32	2.71	
PULL #5	2.34	2.30	2.43	2.63	
TOTAL	11.63	11.59	11.72		
AVG.	2.326	2.318	2.344		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.45	3.41		
PULL #2	3.43	3.45		
PULL #3	3.44	3.38		
PULL #4	3.43	3.41		
PULL #5	3.45	3.39		
TOTAL	17.20	16.99		
AVG.	3.44	3.398		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.30	4.28		4.37
PULL #2	4.31	4.29		4.28
PULL #3	4.27	4.31		4.24
PULL #4	4.28	4.25		4.29
PULL #5	4.29	4.29		4.30
TOTAL	21.45	21.42		21.48
AVG.	4.29	4.284		4.296

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349105
1 Jun 1990

CENTROIDAL DISTANCES

0 TO	1	.220708
1 TO	2	.123822
1 TO	3	.443803
1 TO	4	.302106
1 TO	5	.42184

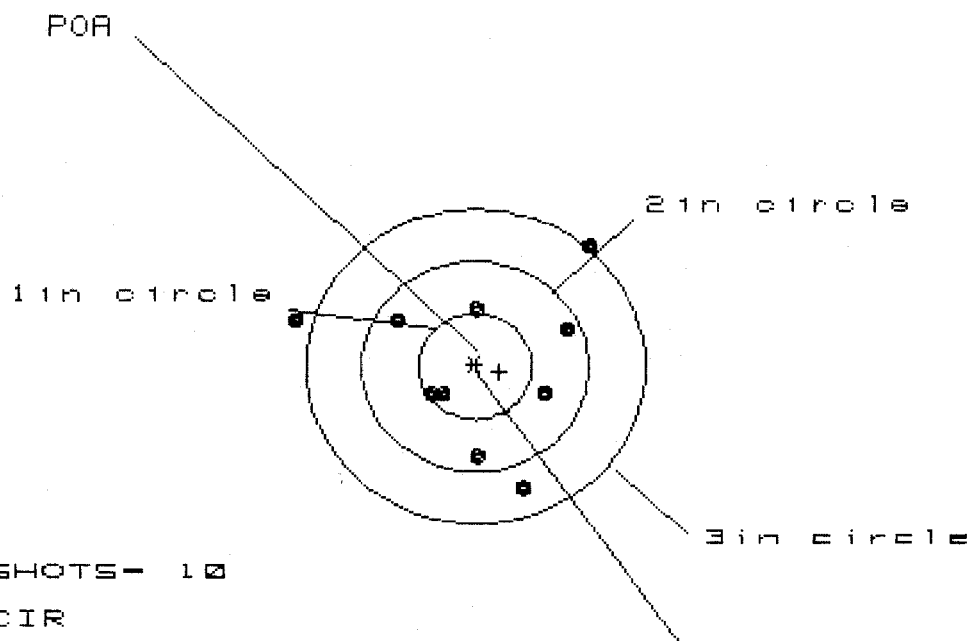
$\frac{1}{5}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0688
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .088
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .111702
THE AMR FOR THIS RIFLE IS: .9734

1 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6349105

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in - 2

2 in - 7

3 in - 8

HS= 2.583

VS= 2.291

GS= 2.676

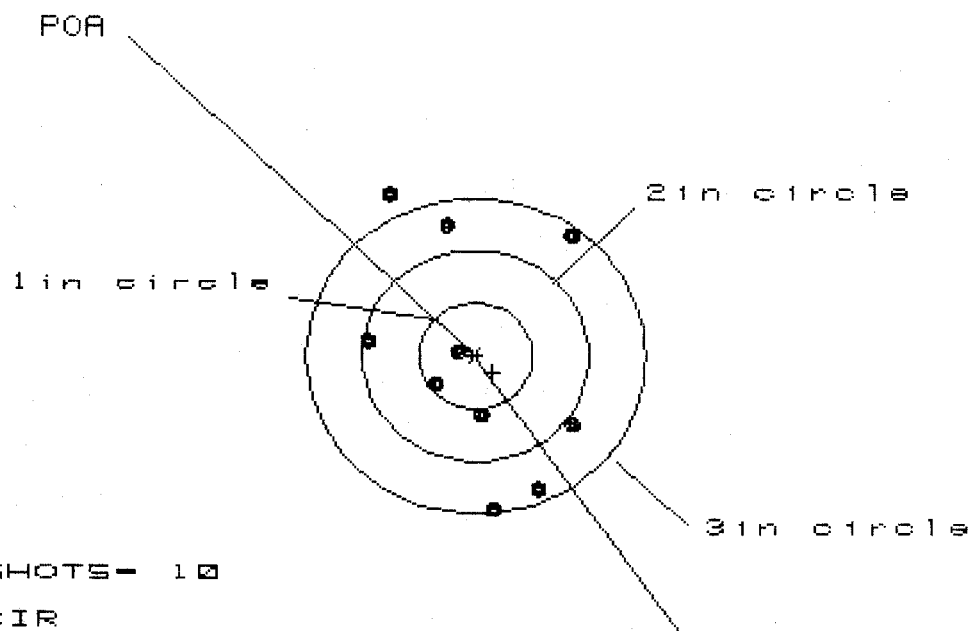
CENTROID *

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.015	.841	.726
MINIMUM X	:	-1.568	-.906	-.801
MAXIMUM Y	:	1.118	1.165	.696
MINIMUM Y	:	-1.173	-1.126	-.980
CENTROID X	:	-.214	-.040	-.145
CENTROID Y	:	.054	.007	-.139
POA TO CENTROID in.	:	.221	.040	.201
MIN RADIUS	:	.339	.469	.335
MEAN RADIUS	:	.901	.820	.717
MAX RADIUS	:	1.623	1.437	1.043
HORIZONTAL SPREAD	:	2.583	1.747	1.527
VERTICAL SPREAD	:	2.291	2.291	1.676
EXTREME SPREAD	:	2.676	2.366	2.010
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	8		

1 Jun 1998

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 4

3 in = 9

HS = 1.854

VS = 2.998

GS = 3.140

CENTROID *

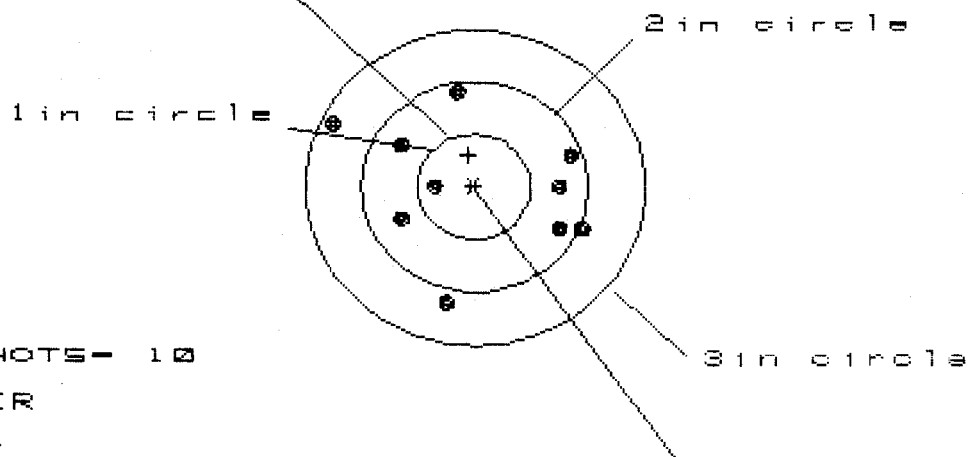
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.883	.900	.812
MINIMUM X	:	-.981	-1.064	-1.052
MAXIMUM Y	:	1.583	1.446	1.291
MINIMUM Y	:	-1.415	-1.239	-1.261
CENTROID X	:	-.150	-.067	-.079
CENTROID Y	:	.160	-.016	.139
POA TO CENTROID in.	:	.219	.069	.160
MIN RADIUS	:	.140	.310	.214
MEAN RADIUS	:	1.048	.954	.922
MAX RADIUS	:	1.750	1.522	1.400
HORIZONTAL SPREAD	:	1.864	1.864	1.864
VERTICAL SPREAD	:	2.998	2.685	2.552
EXTREME SPREAD	:	3.140	2.721	2.675
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3

POA



OF SHOTS- 10

IN CIR

1 in - 1

2 in - 7

3 in = 10

HS- 2.176

VS= 1.966

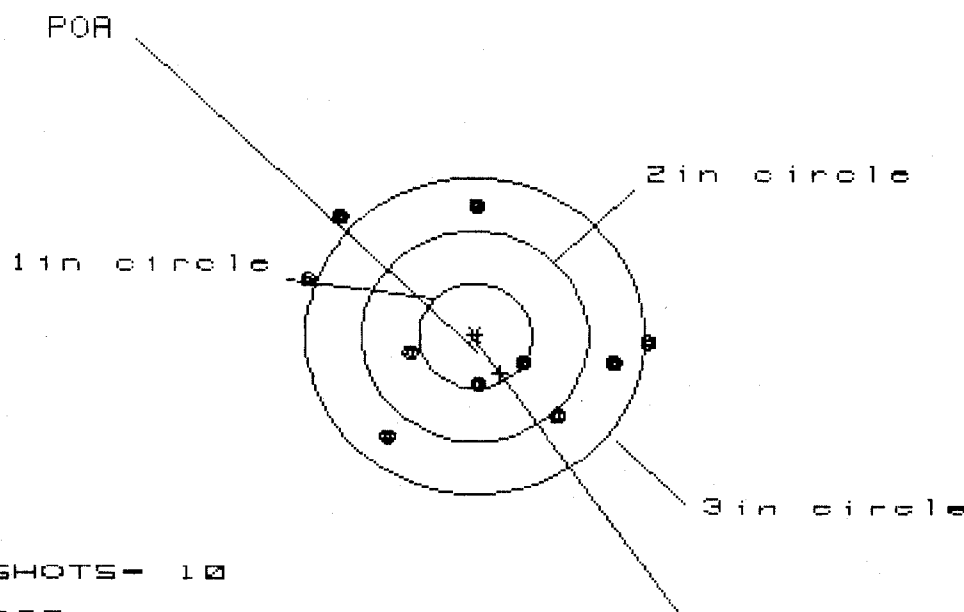
GS= 2.434

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.952	.816	.765
MINIMUM X	:	-1.224	-.794	-.845
MAXIMUM Y	:	.872	.943	.815
MINIMUM Y	:	-1.094	-1.023	-.503
CENTROID X	:	.051	.187	.238
CENTROID Y	:	-.302	-.373	-.245
POA TO CENTROID in.	:	.306	.418	.342
MIN RADIUS	:	.349	.487	.522
MEAN RADIUS	:	.872	.808	.761
MAX RADIUS	:	1.383	1.100	.916
HORIZONTAL SPREAD	:	2.176	1.610	1.610
VERTICAL SPREAD	:	1.966	1.966	1.318
EXTREME SPREAD	:	2.434	1.969	1.813
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 7

HS= 3.005

VS= 2.174

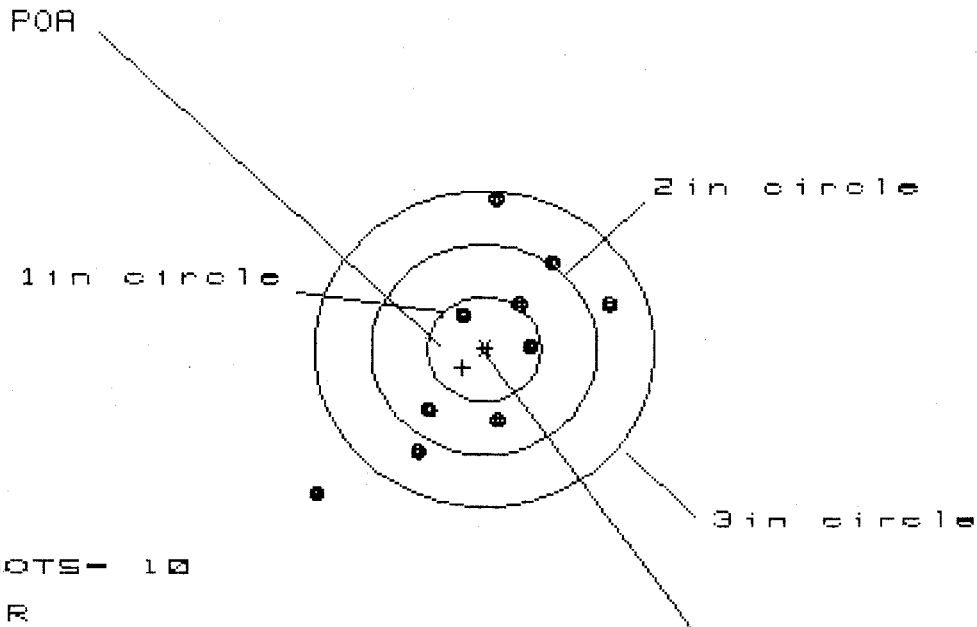
GS= 3.054

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.565	1.440	1.268
MINIMUM X	:	-1.440	-1.565	-1.385
MAXIMUM Y	:	1.215	1.338	1.352
MINIMUM Y	:	-.959	-.836	-.822
CENTROID X	:	-.222	-.097	-.277
CENTROID Y	:	.356	.233	.219
POA TO CENTROID in.	:	.419	.252	.353
MIN RADIUS	:	.410	.315	.278
MEAN RADIUS	:	1.095	1.005	.945
MAX RADIUS	:	1.579	1.697	1.539
HORIZONTAL SPREAD	:	3.005	3.005	2.653
VERTICAL SPREAD	:	2.174	2.174	2.174
EXTREME SPREAD	:	3.054	3.054	2.771
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			3	
NUMBER IN THREE INCH CIRCLE =			7	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 2.548

VS= 2.745

GS= 3.140

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.100	.939	.928
MINIMUM X	:	-1.448	-.733	-.744
MAXIMUM Y	:	1.421	1.274	.855
MINIMUM Y	:	-1.324	-1.111	-.952
CENTROID X	:	.191	.352	.363
CENTROID Y	:	.172	.319	.160
POA TO CENTROID in.	:	.257	.475	.397
MIN RADIUS	:	.409	.253	.246
MEAN RADIUS	:	.951	.798	.742
MAX RADIUS	:	1.962	1.331	1.208
HORIZONTAL SPREAD	:	2.548	1.672	1.672
VERTICAL SPREAD	:	2.745	2.385	1.807
EXTREME SPREAD	:	3.140	2.472	2.183
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	