

C6349117

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Steward®
A R M S

Remington[®] **DUPONT**
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.

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

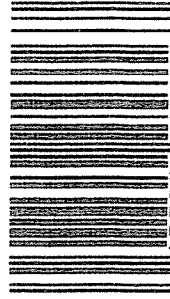
SERIAL NO.
C6349117

ORDER NO.
5716



5716 C6349117

UPC



0 47700 125716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349117

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 31	90	RW
600	Proof	2 31	90	RW
607	Check Headspace	2 31	90	RW
610	Dis-assemble Gun	2 31	90	RW
612	Magnaflux Barrel Action	4-2-90		KCR
	Magnaflux Bolt	4-2-90		KCR
615	Rollmark Caliber	4-2-90		SL
617	Drill and Tap Sight Holes		4/4/90	FB
618	Polish Barrel RB		4/5/90	WB
620	Apply Coatings (Barrel Action)		4-9-90	JA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		4/8/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/8/90	RW
	C) Inspect Ejector Hole for Chamfer		4/8/90	RW
	D) Oil Firing Pin Ass'y		4/8/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4/26/90	SL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			4/27/90	JU
	G) Safety Off Force	4	4	4			4/27/90	JU
	H) Trigger Pull Test & Retainability						4/26/90	JU
	I) Firing Pin Indent	.0215	.022	.0215			4/27/90	JU
	J) Assemble Stock						4/30/90	RW
	K) Assemble Swivel Studs						5/8/90	WB
	L) Attach Front and Rear Sight Assemblies						4/30/90	RW
	M) Iron Sight Alignment						4/30/90	RW
	N) Detach Front & Rear Sights & place in numbered container						4/30/90	RW
	O) Attach Scope to Rifle						4/30/90	WB
	P) Detach & Attach Scope 20 Times						4/30/90	WB
640	Gallery Target & Test						4-30-90	DH
	A) Time						4-30-90	AC
	B) Malfunctions						4-30-90	AC
	C) Pierced Primers						4-30-90	AC
	D) Optical Clarity of Scope						4-30-90	AC
645	Inspect for Live Ammo						4-30-90	AC
655	Final Inspection						5/8/90	WB
	A) Headspace						5/8/90	WB
	B) Trigger Pull	2.17	2.18	2.14	2.19	2.21	5/8/90	WB
	C) Function						5/8/90	WB
660	Pack						6-9-90	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. 06349117

DATE 4/26/90

TESTER JRI

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.55	2.45	2.30	2.17	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.40	2.53	2.32	2.18	
PULL #3	2.41	2.28	2.40	2.14	
PULL #4	2.32	2.33	2.33	2.19	
PULL #5	2.42	2.32	2.45	2.21	
TOTAL	12.10	11.91	11.80		
AVG.	2.42	2.382	2.36		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.50	3.49		
PULL #2	3.51	3.43		
PULL #3	3.44	3.27		
PULL #4	3.44	3.41		
PULL #5	3.50	3.39		
TOTAL	17.39	16.99		
AVG.	3.478	3.398		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.29	4.25		4.44
PULL #2	4.16	4.20		4.39
PULL #3	4.21	4.25		4.20
PULL #4	4.15	4.31		4.45
PULL #5	4.17	4.33		4.32
TOTAL	20.98	21.34		21.80
AVG.	4.196	4.268		4.36

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06349117
1 May 1990

CENTROIDAL DISTANCES

0 TO	1	.352755
1 TO	2	.284016
1 TO	3	.358041
1 TO	4	.438737
1 TO	5	.280492

$\frac{0}{4}$ <----POH

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .163
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0262
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .165092
THE AMR FOR THIS RIFLE IS: .8642

1 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8345117

CENTERFIRE PATTERNS

1

FOR

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 8

3 in = 10

HS = 1.509

VS = 1.855

GS = 2.096

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.797	.859	.794
MINIMUM X	-.712	-.650	-.715
MAXIMUM Y	.911	.955	.861
MINIMUM Y	-.944	-.843	-.937
CENTROID X	.340	.278	.343
CENTROID Y	-.094	-.195	-.101
FOR TO CENTROID in.	.352	.339	.357
MIN RADIUS	.497	.576	.495
MEAN RADIUS	.835	.805	.783
MAX RADIUS	1.067	1.026	.987
HORIZONTAL SPREAD	1.509	1.509	1.509
VERTICAL SPREAD	1.855	1.798	1.798
EXTREME SPREAD	2.096	1.923	1.809
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

1 May 1999

FILE:/PATTERNING/CENTERFIRE_PATT/CS349117

CENTERFIRE PATTERNS

2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 6

3 in = 10

HS= 2.351

VS= 1.498

GS= 2.461

CENTROID *

PATTERN #

2

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.101	.962	.799
MINIMUM X	:	-1.250	-1.300	-.959
MAXIMUM Y	:	.523	.571	.584
MINIMUM Y	:	-.975	-.927	-.914
CENTROID X	:	.111	.249	.412
CENTROID Y	:	.074	.026	.013
POA TO CENTROID in.	:	.133	.251	.412
MIN RADIUS	:	.382	.242	.084
MEAN RADIUS	:	.832	.745	.625
MAX RADIUS	:	1.323	1.304	1.123
HORIZONTAL SPREAD	:	2.351	2.262	1.758
VERTICAL SPREAD	:	1.498	1.498	1.498
EXTREME SPREAD	:	2.461	2.288	1.939
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

1 May 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08349117

CENTERFIRE PATTERNS

3

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 1.694

VS= 2.182

GS= 2.358

CENTROID *

PATTERN #

:

3

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

.961

.832

.802

MINIMUM X

:

-.733

-.812

-.702

MAXIMUM Y

:

1.032

.905

.813

MINIMUM Y

:

-1.150

-.895

-.987

CENTROID X

:

.007

.006

-.024

CENTROID Y

:

.032

.159

.251

POA TO CENTROID in.

:

.032

.181

.252

MIN RADIUS

:

.430

.389

.524

MEAN RADIUS

:

.876

.805

.765

MAX RADIUS

:

1.353

1.159

1.169

HORIZONTAL SPREAD

:

1.694

1.694

1.504

VERTICAL SPREAD

:

2.182

1.800

1.800

EXTREME SPREAD

:

2.358

2.145

1.985

NUMBER IN ONE INCH CIRCLE

:

=

2

NUMBER IN TWO INCH CIRCLE

:

=

5

NUMBER IN THREE INCH CIRCLE

:

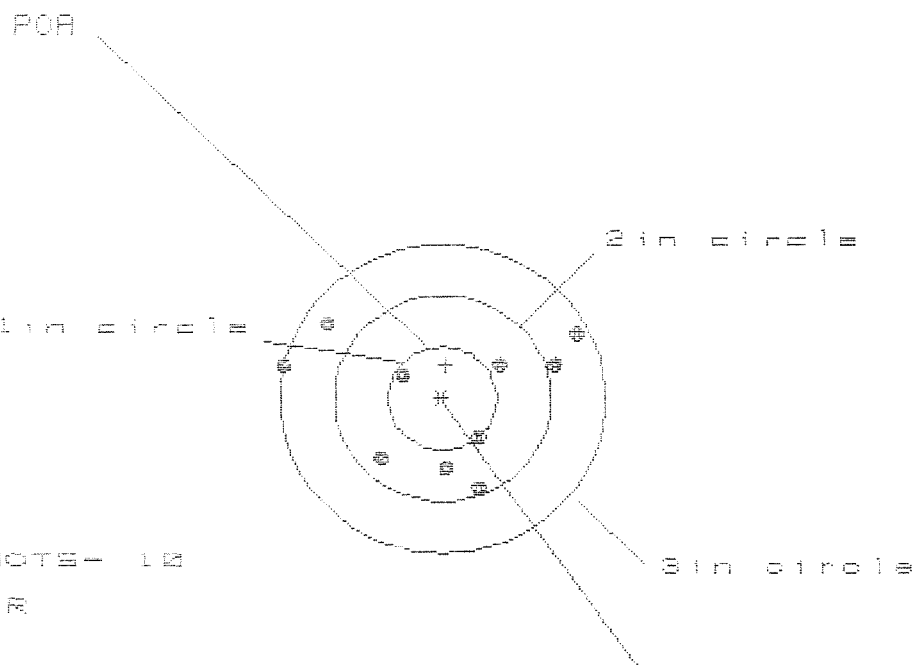
=

10

1 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06349117

CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

1st = 2.748

2nd = 1.677

3rd = 2.754

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.253	1.088	.954
MINIMUM X	:	-1.487	-1.225	-1.089
MAXIMUM Y	:	.760	.798	.880
MINIMUM Y	:	-.917	-.879	-.797
CENTROID X	:	-.033	.132	-.004
CENTROID Y	:	-.325	-.363	-.445
POA TO CENTROID in.	:	.327	.387	.445
MIN RADIUS	:	.421	.336	.353
MEAN RADIUS	:	.923	.836	.768
MAX RADIUS	:	1.526	1.462	1.400
HORIZONTAL SPREAD	:	2.740	2.313	2.043
VERTICAL SPREAD	:	1.677	1.677	1.677
EXTREME SPREAD	:	2.754	2.318	2.172
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

1 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8349117

CENTERFIRE PATTERNS

5

POR

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 10

101 = 2.084

V8 = 2.138

G8 = 2.276

CENTROID #

PATTERN #

5

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.025	.906	.881
MINIMUM X	:	-1.069	-.957	-.982
MAXIMUM Y	:	1.189	1.124	.725
MINIMUM Y	:	-.949	-1.014	-.874
CENTROID X	:	.390	.509	.534
CENTROID Y	:	.182	.247	.107
POR TO CENTROID in.	:	.430	.566	.545
MIN RADIUS	:	.137	.121	.244
MEAN RADIUS	:	.855	.809	.762
MAX RADIUS	:	1.220	1.167	1.033
HORIZONTAL SPREAD	:	2.094	1.863	1.863
VERTICAL SPREAD	:	2.138	2.138	1.599
EXTREME SPREAD	:	2.276	2.276	1.885
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	