

C6636270

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

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

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

MODEL 700™ M24

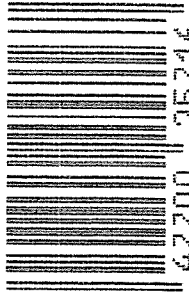
SERIAL NO.
C6636270

ORDER NO.
5716

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



UPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6636270

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/24/91	KE
600	Proof		6/24/91	KE
607	Check Headspace		6/24/91	KE
610	Dis-assemble Gun		6/24/91	KE
612	Magnaflux Barrel Action	JUL	1 1991	KR
	Magnaflux Bolt	JUL	1 1991	KR
615	Rollmark Caliber	JUL	1 1991	SS
617	Drill and Tap Sight Holes	JUL	1 1991	KB
618	Polish Barrel	JUL	2 1991	WB
620	Apply Coatings (Barrel Action)		7-23-91	DA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/23/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/23/91	KS
	C) Inspect Ejector Hole for Chamfer		7/23/91	KS
	D) Oil Firing Pin Ass'y		7/23/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		7/24/91	JP

op. #	BARBER - M24 0032445 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			7-24-91	SL
	G) Safety Off Force	4	4	4			7-24-91	SL
	H) Trigger Pull Test & Retainability						7-24-91	SL
	I) Firing Pin Indent	.0225	.0225	.0225			7-24-91	SL
	J) Assemble Stock						7/29/91	KS
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies						7/29/91	KS
	M) Iron Sight Alignment						7/29/91	KS
	N) Detach Front & Rear Sights & place in numbered container						7/29/91	KS
	O) Attach Scope to Rifle						7/29/91	KS
	P) Detach & Attach Scope 20 Times						7/29/91	KS
640	Gallery Target & Test						7-30-91	DH
	A) Time						7-30-91	DH
	B) Malfunctions						7-30-91	DH
	C) Pierced Primers						7-30-91	DH
	D) Optical Clarity of Scope						7-30-91	DH
645	Inspect for Live Ammo						7-30-91	DH
655	Final Inspection						8-5-91	A
	A) Headspace							
	B) Trigger Pull	2.40	2.41	2.42	2.43	2.37	8-5-91	SL
	C) Function						8-5-91	A
660	Pack						7/7/91	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6636270DATE 7-24-91TESTER JLP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.52	2.25	2.20	2.40	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.39	2.20	2.28	2.41	
PULL #3	2.38	2.18	2.32	2.42	
PULL #4	2.33	2.26	2.28	2.43	
PULL #5	2.31	2.22	2.25	2.37	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.54		
PULL #2	3.58	3.49		
PULL #3	3.60	3.34		
PULL #4	3.55	3.20		
PULL #5	3.20	3.60		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.48	4.50		4.43
PULL #2	4.52	4.19		4.42
PULL #3	4.33	4.19		4.47
PULL #4	4.55	4.34		4.36
PULL #5	4.57	4.38		4.23
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
 FOR RIFLE # C6636270
 31 JUL 1991

CENTROIDAL DISTANCES

0	TO	1	.108908
1	TO	2	.186968
1	TO	3	.138698
1	TO	4	.129252
1	TO	5	.477671

B $\frac{1}{2}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0092
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0259
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0273912
 THE AMP FOR THIS RIFLE IS: .9976

11 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06696270

CENTERFIRE PATTERNS # 1

FOR

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 2

2in = 8

3in = 8

HS = 2.7300

VS = 1.445

GS = 2.848

CENTROID *

PATTERN #

1

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.883

.566

.486

MINIMUM X

-.847

-.637

-.631

MAXIMUM Y

.653

.626

.695

MINIMUM Y

-.792

-.819

-.750

CENTROID X

.106

-.104

-.024

CENTROID Y

.025

.052

-.017

FOR TO CENTROID in.

.109

.116

.029

MIN RADIUS

.232

.160

.219

MEAN RADIUS

.756

.609

.579

MAX RADIUS

1.898

.842

.798

HORIZONTAL SPREAD

2.730

1.203

1.117

VERTICAL SPREAD

1.445

1.445

1.445

EXTREME SPREAD

2.848

1.677

1.465

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

8

NUMBER IN THREE INCH CIRCLE =

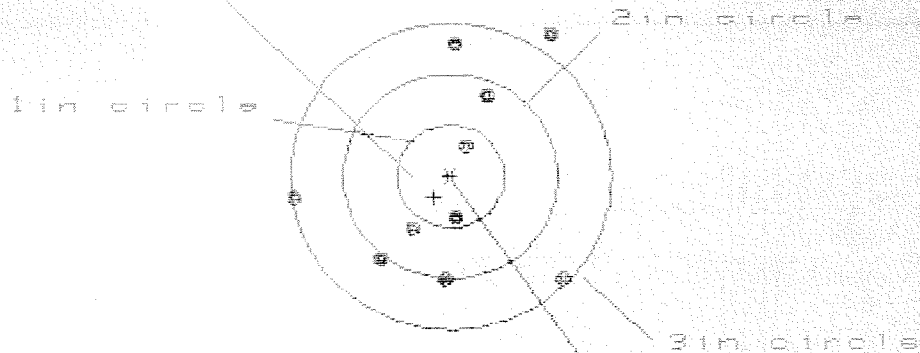
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31 JUL 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636270

CENTERFIRE PATTERNS # 2

POA



OF SHOTS- 10

IN CIR

1 in - 2

2 in - 4

3 in - 9

HS- 2.521

VS= 2.418

GS= 2.848

CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.055	1.159	.634
MINIMUM X	-1.466	-1.362	-1.218
MAXIMUM Y	1.387	1.499	1.389
MINIMUM Y	-1.031	-0.877	-0.973
CENTROID X	.160	.056	-.088
CENTROID Y	.204	.050	.160
POA TO CENTROID in.	.259	.075	.182
MIN RADIUS	.377	.273	.444
MEAN RADIUS	1.034	.935	.883
MAX RADIUS	1.669	1.504	1.415
HORIZONTAL SPREAD	2.521	2.521	1.852
VERTICAL SPREAD	2.418	2.376	2.362
EXTREME SPREAD	2.848	2.669	2.364
NUMBER IN ONE INCH CIRCLE	= 2		
NUMBER IN TWO INCH CIRCLE	= 4		
NUMBER IN THREE INCH CIRCLE	= 9		

31 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636270

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 1

2in = 3

3in = 7

HS= 2.605

VS= 3.089

GS= 3.235

CENTROID +

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.372
MINIMUM X	-1.233
MAXIMUM Y	1.386
MINIMUM Y	-1.703
CENTROID X	-0.008
CENTROID Y	.104
POA TO CENTROID in.	.104
MIN RADIUS	.358
MEAN RADIUS	1.228
MAX RADIUS	1.817
HORIZONTAL SPREAD	2.605
VERTICAL SPREAD	3.089
EXTREME SPREAD	3.235
NUMBER IN ONE INCH CIRCLE	1
NUMBER IN TWO INCH CIRCLE	3
NUMBER IN THREE INCH CIRCLE	7

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FILE:/PATTERNING/CENTERFIRE_PATT/C6636270

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 0

2in = 4

3in = 10

CENTROID X

HS= 2.198

VS= 2.374

GS= 2.749

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.130

1.061

.751

MINIMUM X

-1.068

-1.137

-1.005

MAXIMUM Y

1.017

.866

.942

MINIMUM Y

-1.257

-1.371

-1.296

CENTROID X

.047

.116

-.016

CENTROID Y

-.090

.061

-.014

POA TO CENTROID in.

.101

.132

.022

MIN RADIUS

.611

.611

.616

MEAN RADIUS

1.030

.956

.928

MAX RADIUS

1.495

1.420

1.317

HORIZONTAL SPREAD

2.198

2.198

1.756

VERTICAL SPREAD

2.374

2.237

2.237

EXTREME SPREAD

2.749

2.439

2.359

NUMBER IN ONE INCH CIRCLE =

0

NUMBER IN TWO INCH CIRCLE =

4

NUMBER IN THREE INCH CIRCLE =

10

31 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636270

CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in - 1

2in - 4

3in - 10

HS= 2.299

VS= 2.128

GS= 2.622

CENTROID +

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.045
MINIMUM X	-1.254
MAXIMUM Y	.972
MINIMUM Y	-1.156
CENTROID X	-.351
CENTROID Y	-.114
POA TO CENTROID in.	.369
MIN RADIUS	.067
MEAN RADIUS	.940
MAX RADIUS	1.447
HORIZONTAL SPREAD	2.299
VERTICAL SPREAD	2.128
EXTREME SPREAD	2.622
NUMBER IN ONE INCH CIRCLE	1
NUMBER IN TWO INCH CIRCLE	4
NUMBER IN THREE INCH CIRCLE	10