

C6636045

MODEL 700™ M24

Model **SWS**™

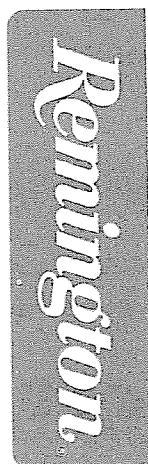
Action

Barrel Length

Capacity

Order No. **5716**

*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.
C6636045

ORDER NO.
5716

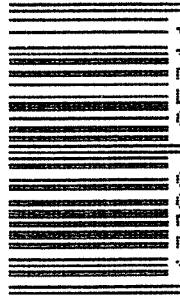
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

20



5716 C6636045

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6636045

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		5/1/91	KS
600	Proof		5/1/91	KS
607	Check Headspace		5/1/91	KS
610	Dis-assemble Gun		5/1/91	KS
612	Magnaflux Barrel Action	5 8 9 1		KCR
	Magnaflux Bolt	5 8 9 1		KCR
615	Rollmark Caliber	5 8 9 1		CS
617	Drill and Tap Sight Holes	5 15 9 1		FB
618	Polish Barrel	5 15 9 1		WB
620	Apply Coatings (Barrel Action)		5/31/91	DA
	Apply Coating (Bolt)		5/31/91	DA
625	Final Assembly A) Clean inside of Bolt Assembly		7/15/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/15/91	KL
	C) Inspect Ejector Hole for Chamfer		7/15/91	KL
	D) Oil Firing Pin Ass'y		7/15/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		7-17-91	KL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			7-17-91	SH
	G) Safety Off Force	3	3	3			7-17-91	SH
	H) Trigger Pull Test & Retainability						7-17-91	SH
	I) Firing Pin Indent	.0215	.0215	.0215			7-17-91	SH
	J) Assemble Stock						7/18/91	KS
	K) Assemble Swivel Studs						7-24-91	D/H
	L) Attach Front and Rear Sight Assemblies						7/18/91	KS
	M) Iron Sight Alignment						7/18/91	KS
	N) Detach Front & Rear Sights & place in numbered container						7/18/91	KS
	O) Attach Scope to Rifle						7/18/91	KS
	P) Detach & Attach Scope 20 Times						7/18/91	KS
640	Gallery Target & Test						7/23/91	KT
	A) Time						1	KT
	B) Malfunctions						1	KT
	C) Pierced Primers						1	KT
	D) Optical Clarity of Scope						1	KT
645	Inspect for Live Ammo						7/23/91	KT
655	Final Inspection							
	A) Headspace						7-24-91	D/H
	B) Trigger Pull	2.30	2.30	2.31	2.24	2.25	7-24-91	SH
	C) Function						7-24-91	D/H
660	Pack						9-18-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6636045

DATE 7-17-91

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.41	2.40	2.30	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.39	2.37	2.43	2.30	
PULL #3	2.36	2.34	2.36	2.31	
PULL #4	2.35	2.43	2.35	2.24	
PULL #5	2.35	2.35	2.43	2.25	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.48	3.50		
PULL #2	3.43	3.46		
PULL #3	3.45	3.54		
PULL #4	3.41	3.53		
PULL #5	3.48	3.55		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.35	4.33		4.29
PULL #2	4.35	4.36		4.38
PULL #3	4.32	4.35		4.33
PULL #4	4.32	4.31		4.35
PULL #5	4.38	4.38		4.29
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636045
29 Jul 1991

CENTROIDAL DISTANCES

0 TO	1	.243479
1 TO	2	.241207
1 TO	3	.162865
1 TO	4	.331127
1 TO	5	.128082

✱ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0942
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.087
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .128229
THE AMR FOR THIS RIFLE IS: .7028

23 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08636045

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

HS= 1.756

VS= 2.489

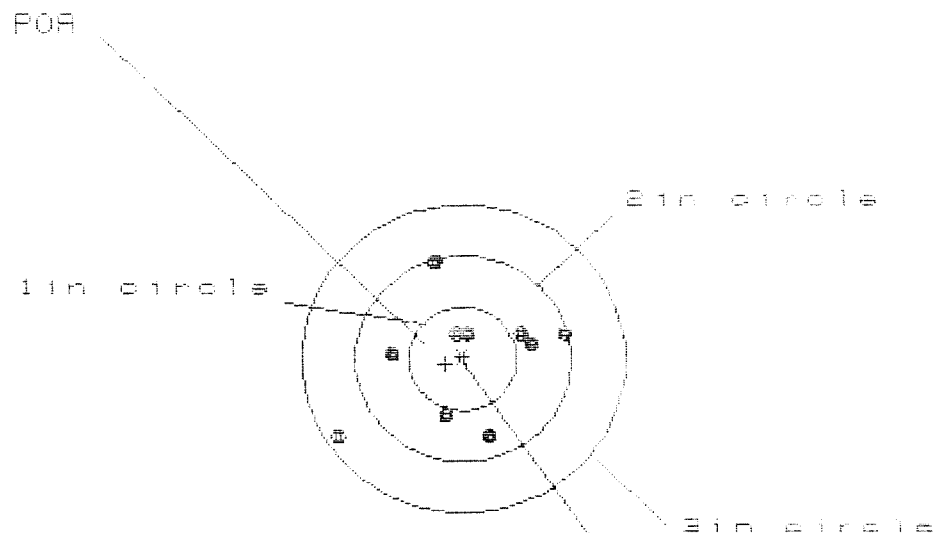
GS= 2.551

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.697	.674	.715
MINIMUM X	:	-1.059	-1.082	-1.041
MAXIMUM Y	:	1.131	.980	.838
MINIMUM Y	:	-1.358	-1.151	-1.028
CENTROID X	:	.151	.174	.133
CENTROID Y	:	-.191	-.040	-.163
POA TO CENTROID in.	:	.244	.179	.210
MIN RADIUS	:	.350	.443	.344
MEAN RADIUS	:	.955	.896	.871
MAX RADIUS	:	1.373	1.252	1.156
HORIZONTAL SPREAD	:	1.756	1.756	1.756
VERTICAL SPREAD	:	2.489	2.131	1.866
EXTREME SPREAD	:	2.551	2.169	1.991
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	10		

23 Jul 1981

FILE:/PATTERNING/CENTERFIRE_PATT/08636045

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 8

3 in = 10

HS = 2.107

VS = 1.712

GS = 2.297

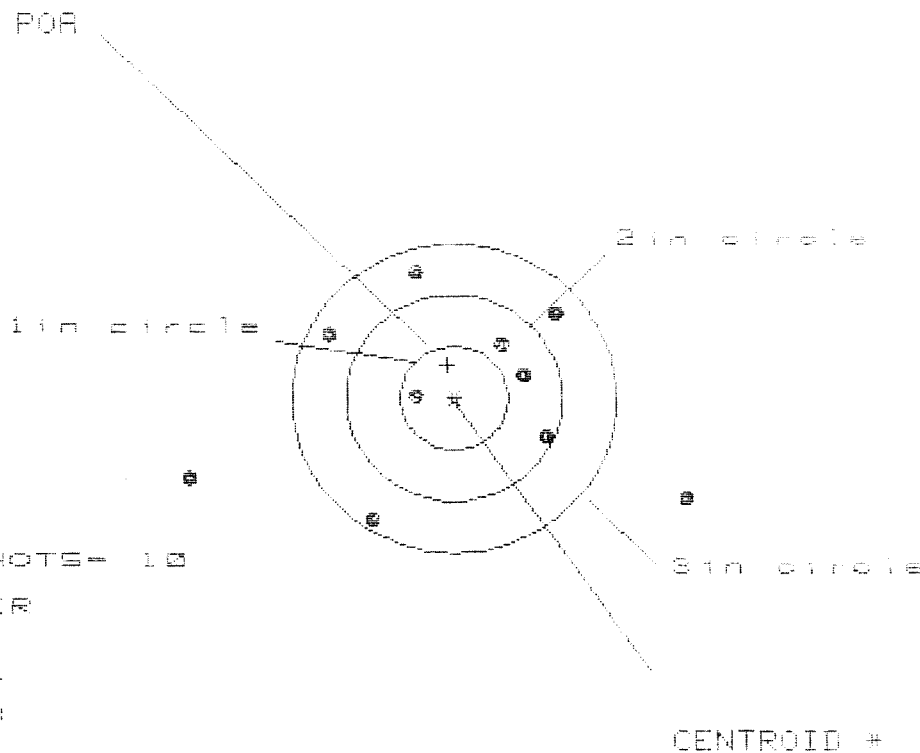
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.909	.776	.721
MINIMUM X	:	-1.198	-.840	-.895
MAXIMUM Y	:	.994	.915	.253
MINIMUM Y	:	-.718	-.797	-.683
CENTROID X	:	.161	.294	.349
CENTROID Y	:	.050	.129	.015
POA TO CENTROID in.	:	.169	.321	.349
MIN RADIUS	:	.208	.183	.305
MEAN RADIUS	:	.715	.619	.575
MAX RADIUS	:	1.393	1.015	.897
HORIZONTAL SPREAD	:	2.107	1.616	1.616
VERTICAL SPREAD	:	1.712	1.712	.936
EXTREME SPREAD	:	2.297	1.812	1.627
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

23 JUL 1981

FILE:/PATTERNING/CENTERFIRE_PATT/C8636045

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HBI = 4.607

VS = 2.382

GS = 4.611

CENTROID +

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	2.133
MINIMUM X	-2.474
MAXIMUM Y	1.210
MINIMUM Y	-1.172
CENTROID X	.057
CENTROID Y	-.324
POR TO CENTROID in.	.329
MIN RADIUS	.312
MEAN RADIUS	1.279
MAX RADIUS	2.607
HORIZONTAL SPREAD	4.607
VERTICAL SPREAD	2.382
EXTREME SPREAD	4.611
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	8

23 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636045

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 5

2in = 7

3in = 10

HS= 1.065

VS= 2.603

GS= 2.633

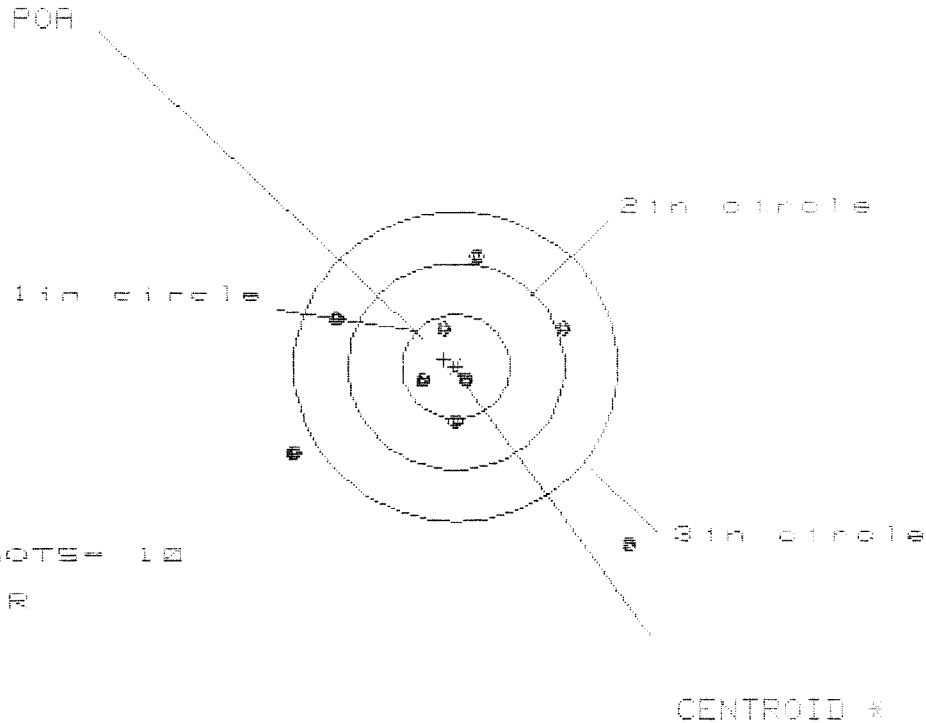
CENTROID #

PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	.547
MINIMUM X	-.518
MAXIMUM Y	1.400
MINIMUM Y	-1.203
CENTROID X	-.007
CENTROID Y	.100
POA TO CENTROID in.	.100
MIN RADIUS	.167
MEAN RADIUS	.725
MAX RADIUS	1.419
HORIZONTAL SPREAD	1.065
VERTICAL SPREAD	2.603
EXTREME SPREAD	2.633
NUMBER IN ONE INCH CIRCLE	5
NUMBER IN TWO INCH CIRCLE	7
NUMBER IN THREE INCH CIRCLE	10

23 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636045

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 3

2in = 4

3in = 8

HS= 3.140

VS= 2.846

QS= 3.476

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.628
MINIMUM X	-1.512
MAXIMUM Y	1.110
MINIMUM Y	-1.736
CENTROID X	.109
CENTROID Y	-.070
POA TO CENTROID in.	.129
MIN RADIUS	.152
MEAN RADIUS	.991
MAX RADIUS	2.380
HORIZONTAL SPREAD	3.140
VERTICAL SPREAD	2.846
EXTREME SPREAD	3.476
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	8