

C6225089

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Remington-Union



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

MODEL 700™ H24

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

01

SERIAL NO.
C6225089

ORDER NO.
5716

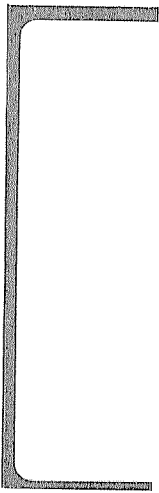


5716 C6225089

UPC



0 47700 25716 7



C 6225089

NEW BBL ACTION

SEE

C 6702827

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225089

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 12	89	RW
600	Proof	4 12	89	RW
607	Check Headspace	4 12	89	RW
610	Dis-assemble Gun	4 12	89	RW
612	Magnaflux Barrel Action		4/13/89	KCR
	Magnaflux Bolt		4/14/89	KCR
615	Rollmark Caliber		4/15/89	GS
617	Drill and Tap Sight Holes	4 14	89	LB
618	Polish Barrel RB	4 14	89	BT
620	Apply Coatings (Barrel Action)		4-19-89	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/4/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/4/89	RW
	C) Inspect Ejector Hole for Chamfer		5/4/89	RW
	D) Oil Firing Pin Ass'y		5/4/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/9/89	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5/9/89	JP
	G) Safety Off Force	3	3	3			5/9/89	JP
	H) Trigger Pull Test & Retainability						5/9/89	WB
	I) Firing Pin Indent	.021	.020	.020			5/9/89	JP
	J) Assemble Stock						5/10/89	RW
	K) Assemble Swivel Studs						15 May 89	JS
	L) Attach Front and Rear Sight Assemblies						5/10/89	RW
	M) Iron Sight Alignment						5/10/89	RW
	N) Detach Front & Rear Sights & place in numbered container						5/10/89	RW
	O) Attach Scope to Rifle						5/10/89	JP
	P) Detach & Attach Scope 20 Times						5/10/89	JP
640	Gallery Target & Test	55 R	97 L				5/10/89	JP
	A) Time						5/10/89	JP
	B) Malfunctions						5/10/89	JP
	C) Pierced Primers						5/10/89	JP
	D) Optical Clarity of Scope						5/10/89	JP
645	Inspect for Live Ammo						5/10/89	JP
655	Final Inspection							
	A) Headspace						15 May 89	JS
	B) Trigger Pull	2.76	2.61	2.65	2.58	2.61	15 May 89	JS
	C) Function						15 May 89	JS
660	Pack						21 June 89	JS

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 26225089

DATE 4-11-90

TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.35	2.42		2.55	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.44	2.43		2.37	
PULL #3	2.39	2.40		2.37	
PULL #4	2.42	2.38		2.32	
PULL #5	2.43	2.45		2.29	
TOTAL	12.03	12.08		11.90	
AVG.	2.406	2.416		2.38	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.49	3.50		
PULL #2	3.45	3.41		
PULL #3	3.48	3.47		
PULL #4	3.50	3.50		
PULL #5	3.46	3.49		
TOTAL	17.38	17.37		
AVG.	3.476	3.474		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.14	4.16		
PULL #2	4.26	4.18		
PULL #3	4.15	4.14		
PULL #4	4.13	4.21		
PULL #5	4.19	4.17		
TOTAL	20.87	20.86		
AVG.	4.174	4.172		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225089
15 May 1989

CENTROIDAL DISTANCES

0 TO	1	.280371
1 TO	2	.816854
1 TO	3	.615805
1 TO	4	.839738
1 TO	5	1.036

$\frac{5}{4} + 1$ <-----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.4318
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0286
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .432746
THE AMR FOR THIS RIFLE IS: .845

11 May 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06225089

CENTERFIRE PATTERNS # 1

FOR

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 8

3 in = 9

HS = 1.748

VS = 2.575

GS = 2.612

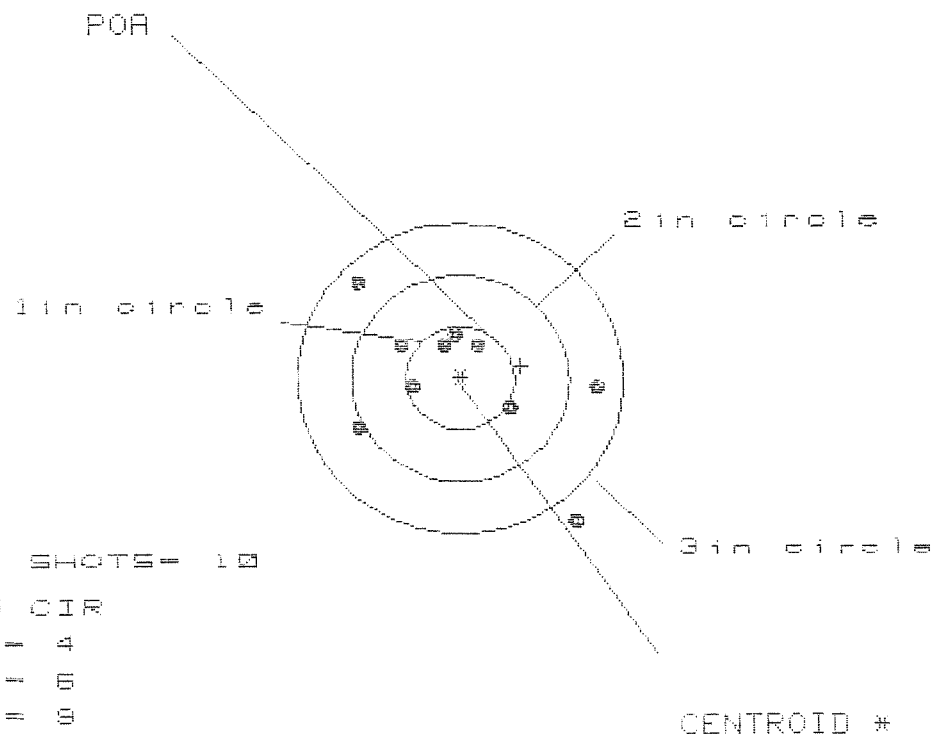
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.745	.634	.550
MINIMUM X	-1.003	-.807	-.891
MAXIMUM Y	1.347	1.211	.845
MINIMUM Y	-1.228	-.526	-.375
CENTROID X	.188	.299	.383
CENTROID Y	.208	.344	.193
FOR TO CENTROID in.	.280	.456	.429
MIN RADIUS	.149	.256	.148
MEAN RADIUS	.814	.722	.584
MAX RADIUS	1.585	1.386	.961
HORIZONTAL SPREAD	1.748	1.441	1.441
VERTICAL SPREAD	2.575	1.737	1.220
EXTREME SPREAD	2.612	2.174	1.617
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	9		

11 May 1989

FILE:/PATTERNING/CENTERFIRE_PATT/08225069

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 4

2 in = 6

3 in = 9

HS= 2.268

VS= 2.262

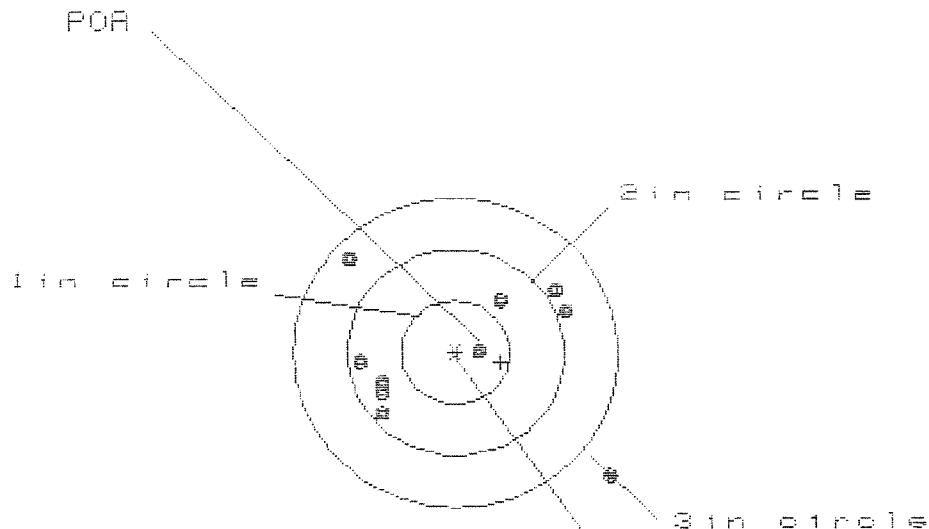
GS= 3.036

PATTERN #	:	2
SHOTS (BEST OF)	:	10
MAXIMUM X	:	1.297
MINIMUM X	:	-.971
MAXIMUM Y	:	.913
MINIMUM Y	:	-1.349
CENTROID X	:	-.557
CENTROID Y	:	-.127
POA TO CENTROID in.	:	.571
MIN RADIUS	:	.348
MEAN RADIUS	:	.809
MAX RADIUS	:	1.712
HORIZONTAL SPREAD	:	2.268
VERTICAL SPREAD	:	2.262
EXTREME SPREAD	:	3.036
NUMBER IN ONE INCH CIRCLE	=	4
NUMBER IN TWO INCH CIRCLE	=	6
NUMBER IN THREE INCH CIRCLE	=	9

11 May 1989

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 6

3 in = 9

HS= 2.420

VS= 2.111

GS= 3.211

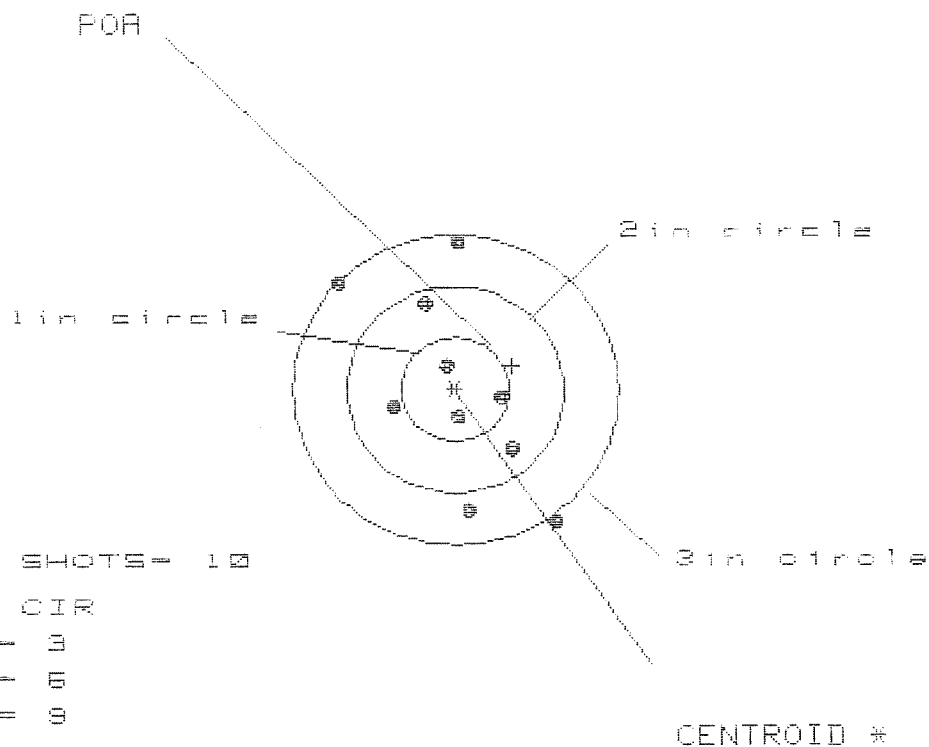
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.414	1.154	1.047
MINIMUM X	:	-1.006	-.849	-.849
MAXIMUM Y	:	.946	.816	.605
MINIMUM Y	:	-1.165	-.766	-.663
CENTROID X	:	-.419	-.576	-.469
CENTROID Y	:	.088	.218	.115
POA TO CENTROID in.	:	.428	.615	.483
MIN RADIUS	:	.186	.373	.240
MEAN RADIUS	:	.968	.864	.808
MAX RADIUS	:	1.832	1.197	1.132
HORIZONTAL SPREAD	:	2.420	2.003	1.897
VERTICAL SPREAD	:	2.111	1.582	1.269
EXTREME SPREAD	:	3.211	2.064	2.045
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

01 May 1989

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CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS = 2.000

VS = 2.705

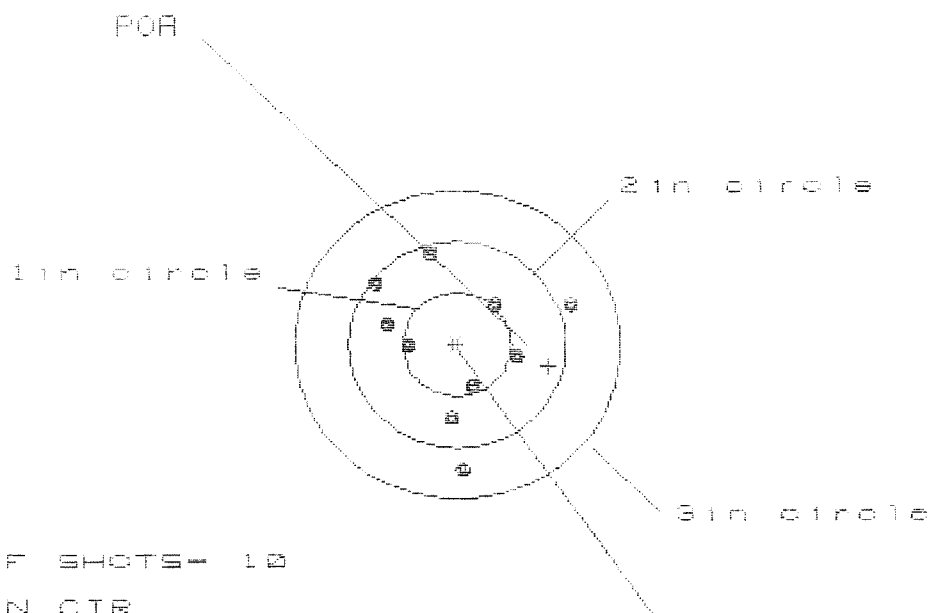
GS = 3.047

PATTERN #	:	4
SHOTS (BEST OF)	:	10
MAXIMUM X	:	.949
MINIMUM X	:	-1.059
MAXIMUM Y	:	1.410
MINIMUM Y	:	-1.287
CENTROID X	:	-.526
CENTROID Y	:	-.234
POA TO CENTROID in.	:	.575
MIN RADIUS	:	.207
MEAN RADIUS	:	.870
MAX RADIUS	:	1.539
HORIZONTAL SPREAD	:	2.008
VERTICAL SPREAD	:	2.705
EXTREME SPREAD	:	3.047
NUMBER IN ONE INCH CIRCLE =	:	3
NUMBER IN TWO INCH CIRCLE =	:	6
NUMBER IN THREE INCH CIRCLE =	:	9

11 May 1988

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 8

3 in = 10

HS= 1.757

VS= 2.108

GS= 2.129

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.050	1.056	.676
MINIMUM X	-.707	-.701	-.569
MAXIMUM Y	.894	.759	.790
MINIMUM Y	-1.214	-.875	-.842
CENTROID X	-.848	-.854	-.986
CENTROID Y	.208	.343	.010
POA TO CENTROID in.	.873	.920	1.034
MIN RADIUS	.417	.483	.350
MEAN RADIUS	.764	.711	.649
MAX RADIUS	1.215	1.088	.845
HORIZONTAL SPREAD	1.757	1.757	1.245
VERTICAL SPREAD	2.108	1.634	1.634
EXTREME SPREAD	2.129	1.771	1.644
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	