

C6649153

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington[®]

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

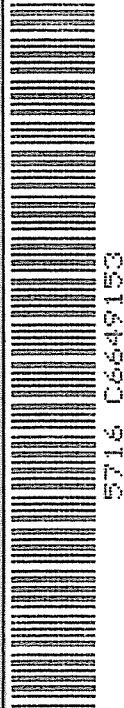
MODEL 700TM M24

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

SERIAL NO.
C6649153

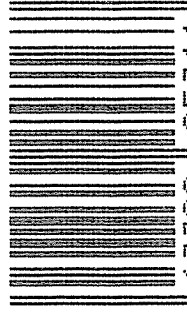
ORDER NO.
5716

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



5716 C6649153

UPC



0 47700 25716 7

MOD. _____ GA. CAL. _____ GUN # 9153

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st		
KT	8/14/91	Ejector Sticks	KB
	2nd		
	8/14	Rammed/Eject hole cleaned face of batt	KS
	3rd		
	4th		
		FUNCTION	RD 6654 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF	Test OK 8-15-91 D.H	
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6649153**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/26/91	KA
600	Proof		6/26/91	KA
607	Check Headspace		6/26/91	KA
610	Dis-assemble Gun		6/26/91	KA
612	Magnaflux Barrel Action		JUL 1 8 1991	CS
	Magnaflux Bolt		JUL 1 8 1991	CS
615	Rollmark Caliber		JUL 1 8 1991	CS
617	Drill and Tap Sight Holes		JUL 1 8 1991	CS
618	Polish Barrel		JUL 2 0 1991	WB
620	Apply Coatings (Barrel Action)		7-01	KA
	Apply Coating (Bolt)		8	KA
625	Final Assembly A) Clean inside of Bolt Assembly		8/8/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/8/91	KA
	C) Inspect Ejector Hole for Chamfer		8/8/91	KA
	D) Oil Firing Pin Ass'y		8/8/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		8-10-91	D/H

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7	7	7			8-10-91	DH
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			8-10-91	DH
	H) Trigger Pull Test & Retainability						8-10-91	DH
	I) Firing Pin Indent	1.022	.021	.020			8-10-91	DH
	J) Assemble Stock						8/13/91	KT
	K) Assemble Swivel Studs						8-17-91	DH
	L) Attach Front and Rear Sight Assemblies						8/13/91	KT
	M) Iron Sight Alignment						8/13/91	KT
	N) Detach Front & Rear Sights & place in numbered container						8/13/91	KT
	O) Attach Scope to Rifle						8/13/91	KT
	P) Detach & Attach Scope 20 Times						8/13/91	KT
640	Gallery Target & Test						8/14/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers						L1	KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						8/14/91	KT
655	Final Inspection							
	A) Headspace						8-17-91	DH
	B) Trigger Pull	2.27	2.31	2.22	2.23	2.32	8-15-91	921
	C) Function						8-17-91	DH
660	Pack						9-18-91	NF

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649153
23 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.25224
1 TO	2	.108005
1 TO	3	.126289
1 TO	4	.28381
1 TO	5	.0856037



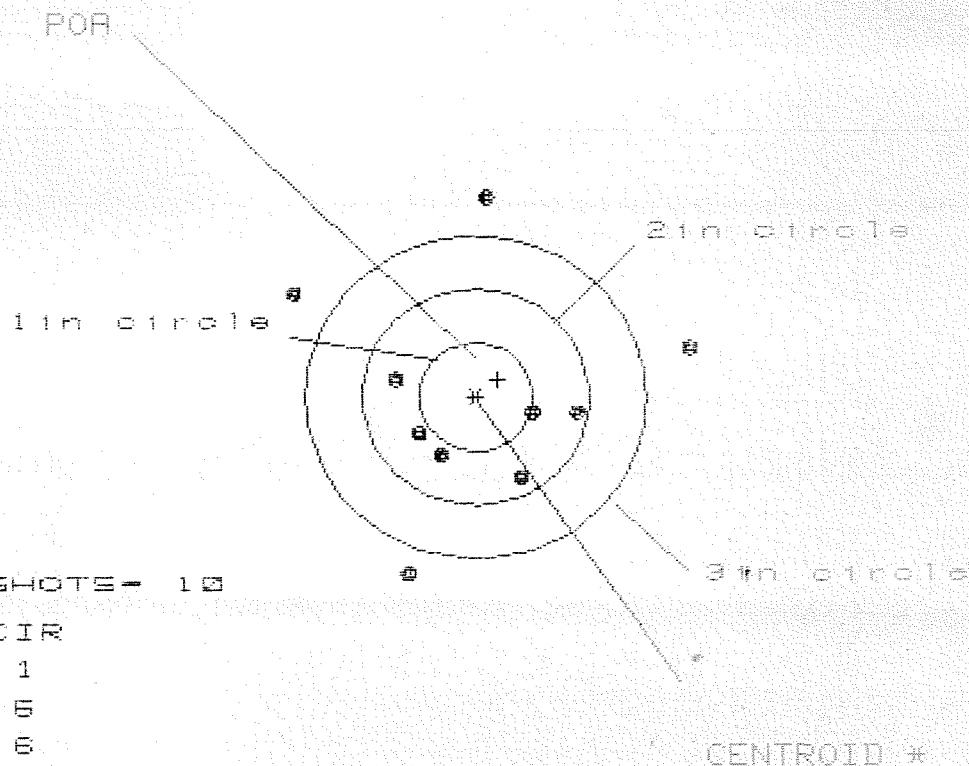
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1328
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1122
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .173852
THE AMR FOR THIS RIFLE IS: 1.027

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8549153

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 1

2in = 6

3in = 6

HS = 3.485

VS = 3.532

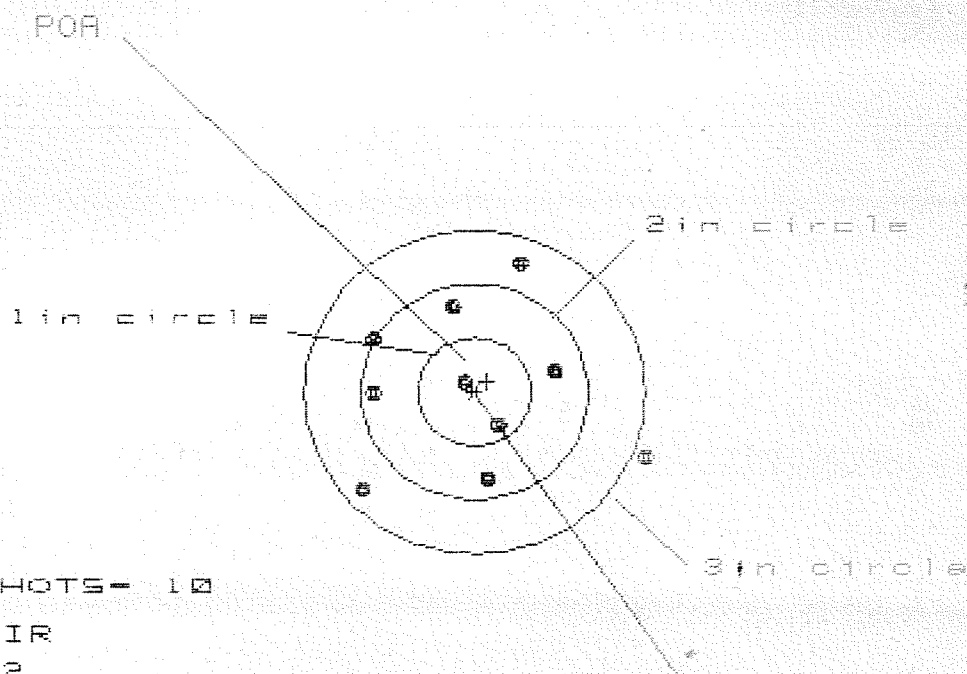
GS = 3.602

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.892	1.061	.888
MINIMUM X	-1.593	-1.383	-.711
MAXIMUM Y	1.872	1.921	2.051
MINIMUM Y	-1.660	-1.611	-1.481
CENTROID X	-.195	-.405	-.232
CENTROID Y	-.160	-.209	-.339
POA TO CENTROID in.	.252	.456	.411
MIN RADIUS	.481	.408	.463
MEAN RADIUS	1.164	1.055	.939
MAX RADIUS	1.942	1.951	2.058
HORIZONTAL SPREAD	3.485	2.444	1.599
VERTICAL SPREAD	3.532	3.532	3.532
EXTREME SPREAD	3.602	3.602	3.602
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	6		

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS= 2.447

VS= 2.078

GS= 2.569

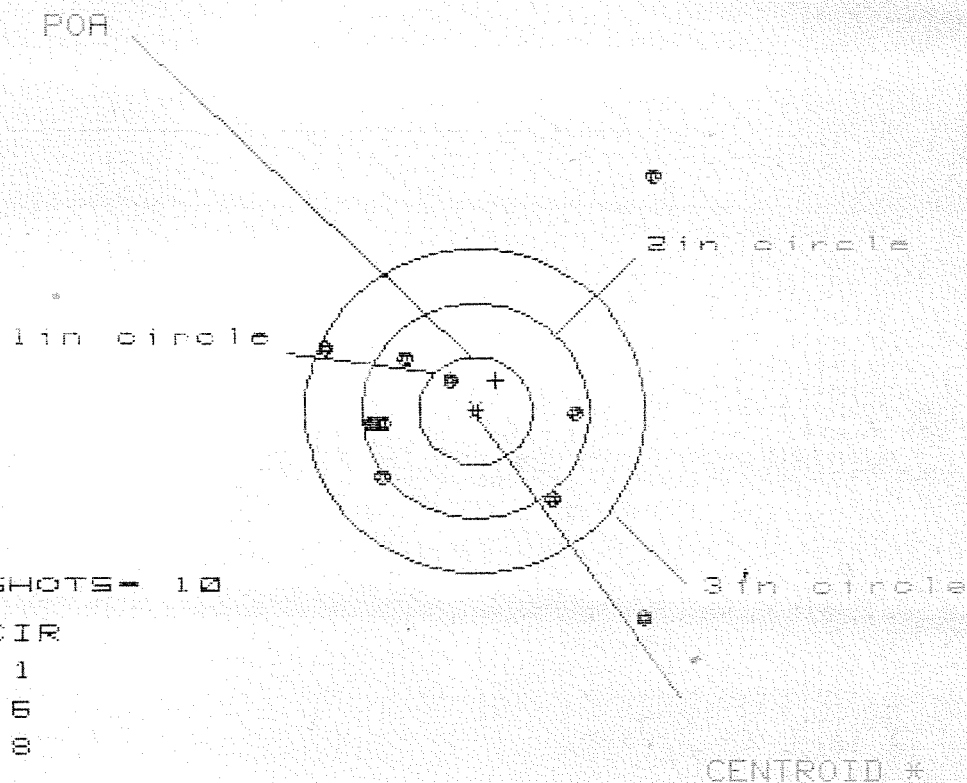
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.458	.903	.799
MINIMUM X	-.989	-.826	-.808
MAXIMUM Y	1.146	1.077	.952
MINIMUM Y	-.932	-1.001	-.981
CENTROID X	-.108	-.270	-.166
CENTROID Y	-.096	-.027	.099
POA TO CENTROID in.	.144	.271	.193
MIN RADIUS	.102	.080	.137
MEAN RADIUS	.891	.803	.738
MAX RADIUS	1.588	1.298	1.076
HORIZONTAL SPREAD	2.447	1.729	1.607
VERTICAL SPREAD	2.078	2.078	1.932
EXTREME SPREAD	2.569	2.524	1.961
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 8

HS= 2.953

VS= 4.042

GS= 4.043

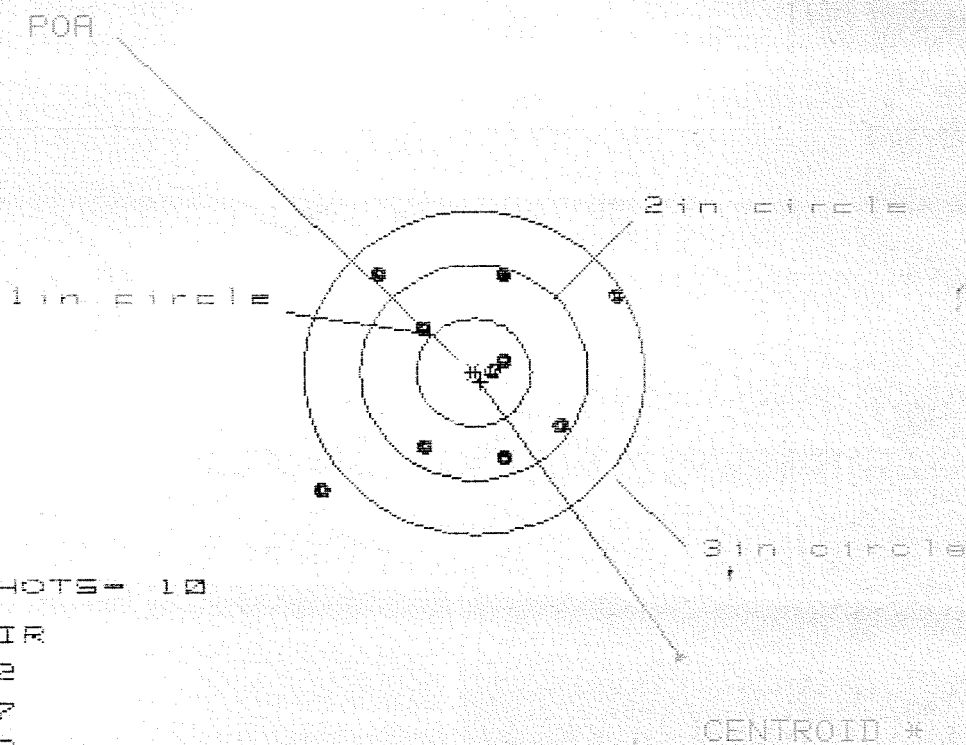
CENTROID #

PATTERN #	1	3	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.617	1.701	1.293
MINIMUM X	-1.337	-1.157	-.944
MAXIMUM Y	2.148	.845	.638
MINIMUM Y	-1.894	-1.655	-.829
CENTROID X	-.177	-.357	-.570
CENTROID Y	-.285	-.524	-.317
POA TO CENTROID in.	.336	.634	.652
MIN RADIUS	.380	.561	.402
MEAN RADIUS	1.247	1.050	.797
MAX RADIUS	2.688	2.374	1.331
HORIZONTAL SPREAD	2.953	2.958	2.237
VERTICAL SPREAD	4.042	2.500	1.467
EXTREME SPREAD	4.043	3.797	2.469
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 7

3 in = 8

HS = 2.585

VS = 2.006

GS = 3.145

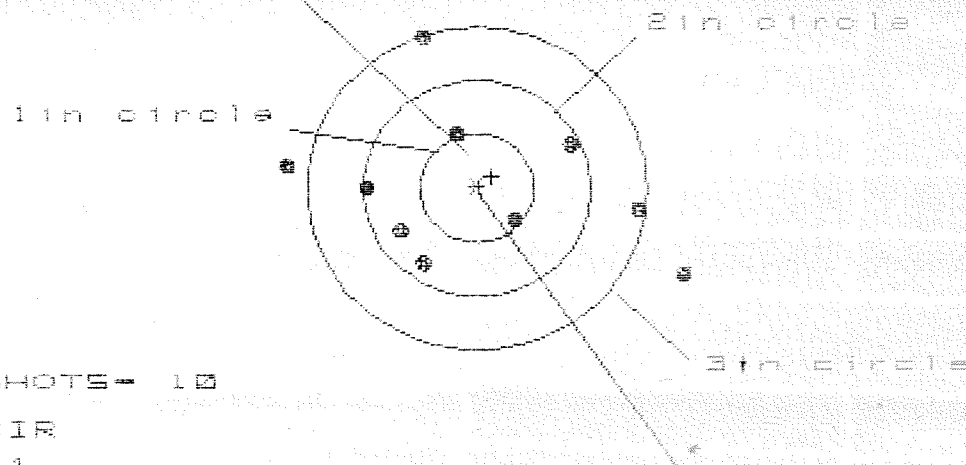
PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.288	1.143	.727
MINIMUM X	-1.297	-.980	-.837
MAXIMUM Y	.910	.788	.860
MINIMUM Y	-1.096	-.923	-.851
CENTROID X	-.057	.088	-.055
CENTROID Y	.088	.210	.138
POA TO CENTROID in.	.104	.227	.149
MIN RADIUS	.182	.112	.184
MEAN RADIUS	.903	.784	.731
MAX RADIUS	1.698	1.279	1.200
HORIZONTAL SPREAD	2.585	2.123	1.564
VERTICAL SPREAD	2.006	1.711	1.711
EXTREME SPREAD	3.145	2.236	2.073
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 5

POR



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HE= 3.453

VS= 2.200

GS= 3.594

CENTROID *

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.794	1.609	1.426
MINIMUM X	-1.658	-1.459	-0.956
MAXIMUM Y	1.396	1.305	1.317
MINIMUM Y	-0.812	-0.828	-0.816
CENTROID X	-0.127	-0.326	-0.144
CENTROID Y	-0.108	-0.017	-0.029
POR TO CENTROID in.	.166	.326	.146
MIN RADIUS	.490	.411	.433
MEAN RADIUS	1.109	.994	.930
MAX RADIUS	1.970	1.635	1.453
HORIZONTAL SPREAD	3.453	3.068	2.382
VERTICAL SPREAD	2.200	2.133	2.133
EXTREME SPREAD	3.594	3.092	2.491
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6649153

DATE 8-9-91

TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.37	2.49	2.53	2.27	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.35	2.32	2.50	2.31	
PULL #3	2.19	2.30	2.63	2.22	
PULL #4	2.27	2.27	2.52	2.23	
PULL #5	2.40	2.36	2.23	2.32	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.30	3.34		
PULL #2	3.33	3.26		
PULL #3	3.32	3.33		
PULL #4	3.27	3.25		
PULL #5	3.38	3.19		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.19		4.19
PULL #2	4.07	4.17		4.16
PULL #3	4.06	4.18		4.38
PULL #4	4.29	4.13		4.29
PULL #5	4.08	4.19		4.00
TOTAL				
AVG.				