

C6649294

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



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

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

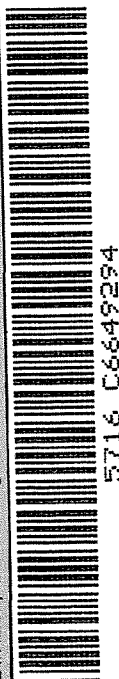
MODEL 700TM M24

SERIAL NO.
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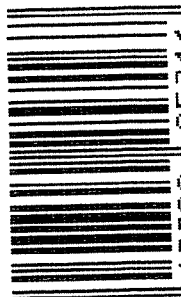
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



5716 C6649294

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649294

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 27 9 1		RW
600	Proof	6 27 9 1		RW
607	Check Headspace	6 27 9 1		RW
610	Dis-assemble Gun	6 27 9 1		RW
612	Magnaflux Barrel Action		JUL 2 1991	KR
	Magnaflux Bolt		JUL 2 1991	KR
615	Rollmark Caliber		JUL 2 1991	GL
617	Drill and Tap Sight Holes		JUL 2 1991	LB
618	Polish Barrel		JUL 7 1991	WB
620	Apply Coatings (Barrel Action)		7-22-91	DA
	Apply Coating (Bolt)			DA
625	Final Assembly A) Clean inside of Bolt Assembly		7/23/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/23/91	RW
	C) Inspect Ejector Hole for Chamfer		7/23/91	RW
	D) Oil Firing Pin Ass'y		7/23/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8-7-91	JH

op. #	BARBER - M24 0067427 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 $\frac{3}{4}$	5	5 $\frac{1}{2}$			8-7-91	D/H
	G) Safety Off Force	3	3	3			8-7-91	D/H
	H) Trigger Pull Test & Retainability						8-7-91	SH
	I) Firing Pin Indent	.020	.021	.021			8-7-91	D/H
	J) Assemble Stock						8/10/91	RW
	K) Assemble Swivel Studs						8-13-91	D/H
	L) Attach Front and Rear Sight Assemblies						8/10/91	RW
	M) Iron Sight Alignment						8/10/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/10/91	RW
	O) Attach Scope to Rifle						8/10/91	RW
	P) Detach & Attach Scope 20 Times						8/10/91	RW
640	Gallery Target & Test						8-12-91	AC
	A) Time						8-12-91	AC
	B) Malfunctions						8-12-91	AC
	C) Pierced Primers						8-12-91	AC
	D) Optical Clarity of Scope						8-12-91	AC
645	Inspect for Live Ammo						8-12-91	AC
655	Final Inspection							
	A) Headspace						8-13-91	D/H
	B) Trigger Pull	2.25	2.19	2.28	2.20	2.25	8-13-91	SH
	C) Function						8-13-91	D/H
660	Pack						9-19-91	RF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50#+ .50#
3.00#+ .75#
4.00#+1.00#

SERIAL NO. C-6649284DATE 8-7-91TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.21	2.30	2.28	2.25	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.28	2.29	2.30	2.19	
PULL #3	2.25	2.34	2.35	2.28	
PULL #4	2.32	2.33	2.25	2.20	
PULL #5	2.31	2.21	2.20	2.25	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.23	3.36		
PULL #2	3.35	3.37		
PULL #3	3.37	3.39		
PULL #4	3.28	3.36		
PULL #5	3.34	3.26		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.16	4.56		4.13
PULL #2	4.42	4.44		4.38
PULL #3	4.45	4.49		4.50
PULL #4	4.46	4.53		4.60
PULL #5	4.48	4.48		4.56
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649294
12 Aug 1991

CENTROIDAL DISTANCES

0 TO 1	.40446
1 TO 2	.940454
1 TO 3	.877023
1 TO 4	.869876
1 TO 5	.5478

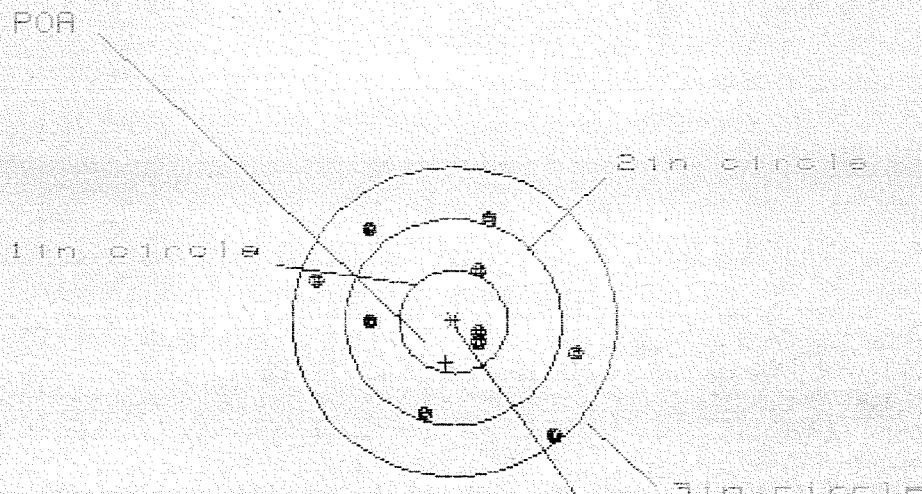
1
5+ ---- POI
2

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.3736
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0216
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .374224
THE AMR FOR THIS RIFLE IS: .9608

(12 Aug 1991)

FILE:/PATTERNING/CENTERFIRE_PATT/C6648294

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 2.436

VS= 2.102

GS= 2.734

CENTROID *

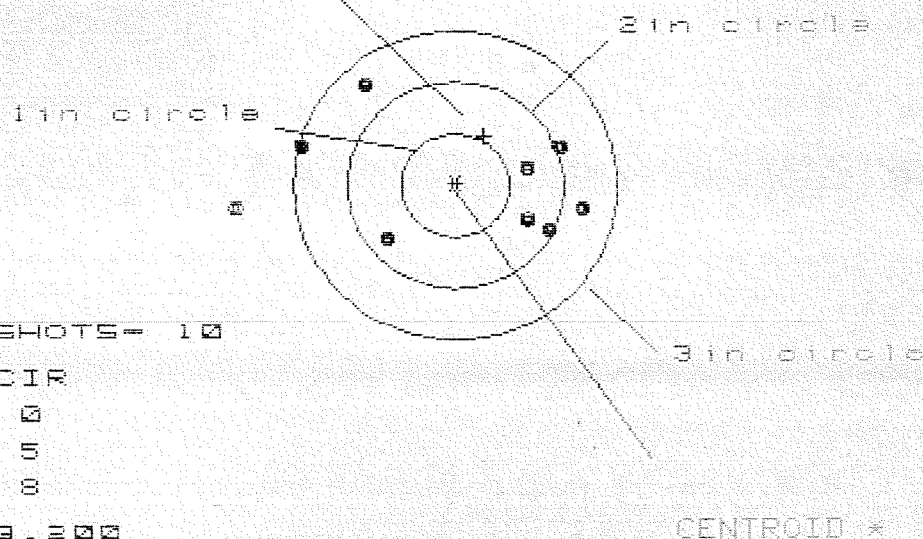
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.156	1.263	1.117
MINIMUM X	-1.280	-1.173	-0.853
MAXIMUM Y	.971	.845	.874
MINIMUM Y	-1.131	-1.058	-1.029
CENTROID X	.072	-.035	.111
CENTROID Y	.398	.524	.495
POA TO CENTROID in.	.405	.525	.568
MIN RADIUS	.275	.435	.311
MEAN RADIUS	.911	.852	.784
MAX RADIUS	1.486	1.327	1.203
HORIZONTAL SPREAD	2.436	2.436	1.970
VERTICAL SPREAD	2.102	1.903	1.903
EXTREME SPREAD	2.734	2.517	2.320
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 2

POR



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 5

3 in = 8

HS = 3.200

VS = 1.489

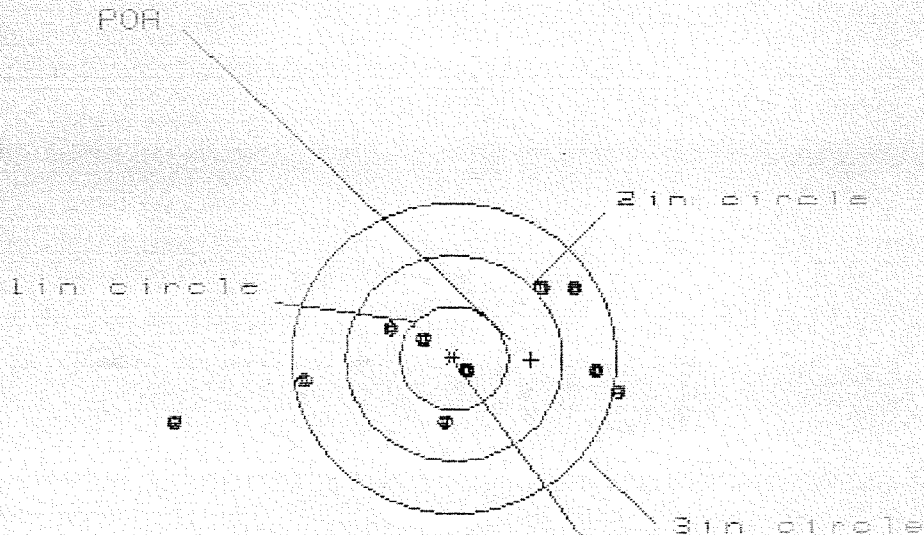
GS = 3.200

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.190	.967	.754
MINIMUM X	-2.010	-1.707	-1.244
MAXIMUM Y	1.002	.973	1.012
MINIMUM Y	-.487	-.516	-.477
CENTROID X	-.265	-.042	.171
CENTROID Y	-.480	-.451	-.490
POR TO CENTROID in.	.548	.453	.519
MIN RADIUS	.684	.487	.322
MEAN RADIUS	1.090	.915	.722
MAX RADIUS	2.026	1.736	1.604
HORIZONTAL SPREAD	3.200	2.674	1.998
VERTICAL SPREAD	1.489	1.489	1.489
EXTREME SPREAD	3.200	2.737	2.353
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		8	

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

HS = 4.108

VS = 1.344

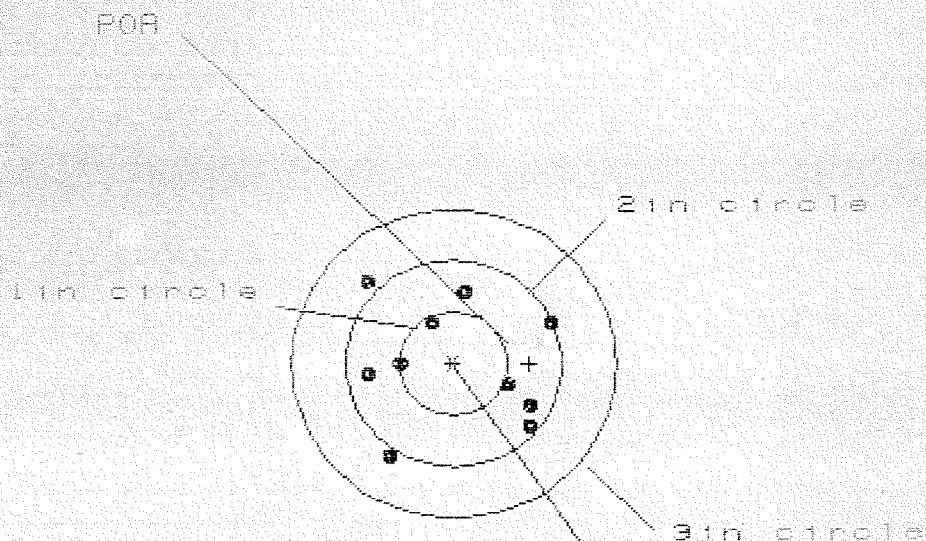
GS = 4.119

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.546	1.261	1.214
MINIMUM X	-2.562	-1.665	-1.507
MAXIMUM Y	.722	.658	.614
MINIMUM Y	-.622	-.686	-.730
CENTROID X	-.716	-.401	-.589
CENTROID Y	.013	.077	.121
POA TO CENTROID in.	.716	.438	.601
MIN RADIUS	.130	.232	.190
MEAN RADIUS	1.104	.931	.861
MAX RADIUS	2.627	1.685	1.538
HORIZONTAL SPREAD	4.108	2.926	2.721
VERTICAL SPREAD	1.344	1.344	1.344
EXTREME SPREAD	4.119	2.927	2.723
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		8	

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CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 8

3 in = 10

HS = 1.730

VS = 1.700

GS = 2.062

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.906	.820	.735
MINIMUM X	-.824	-.910	-.995
MAXIMUM Y	.820	.764	.665
MINIMUM Y	-.880	-.789	-.638
CENTROID X	-.702	-.616	-.531
CENTROID Y	.001	-.099	.009
POA TO CENTROID in.	.702	.623	.531
MIN RADIUS	.464	.474	.443
MEAN RADIUS	.799	.758	.708
MAX RADIUS	1.129	1.044	1.004
HORIZONTAL SPREAD	1.730	1.730	1.730
VERTICAL SPREAD	1.700	1.553	1.303
EXTREME SPREAD	2.062	1.960	1.800
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 8

HS= 1.140

VS= 3.672

GS= 3.681

CENTROID *

PATTERN #	1	3	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.457	.467	.510
MINIMUM X	-.683	-.673	-.630
MAXIMUM Y	1.542	1.305	.810
MINIMUM Y	-2.130	-1.469	-1.306
CENTROID X	-.257	-.267	-.310
CENTROID Y	-.040	.197	.034
POA TO CENTROID in.	.260	.332	.311
MIN RADIUS	.175	.159	.259
MEAN RADIUS	.900	.715	.646
MAX RADIUS	2.132	1.513	1.367
HORIZONTAL SPREAD	1.140	1.140	1.140
VERTICAL SPREAD	3.672	2.774	2.116
EXTREME SPREAD	3.681	2.774	2.203
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	