

C6611468

MODEL 700TM M24

Model **SWS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Sword

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

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

MODEL 700™ M24

SERIAL NO.
C6611468

ORDER NO.
5716

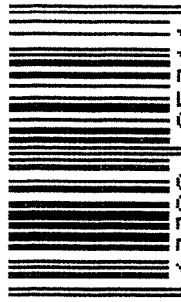
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

20



5716 C6611468

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611468

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 25	91	RW
600	Proof	3 25	91	RW
607	Check Headspace	2 25	91	RW
610	Dis-assemble Gun	3 25	91	RW
612	Magnaflux Barrel Action	3 28	91	KL
	Magnaflux Bolt	3 28	91	KL
615	Rollmark Caliber	3 28	91	KL
617	Drill and Tap Sight Holes	APR	3 1991	LB
618	Polish Barrel	APR	3 1991	LB
620	Apply Coatings (Barrel Action)		4-11-91	LB
	Apply Coating (Bolt)			LB
625	Final Assembly A) Clean inside of Bolt Assembly		4/16/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/16/91	RW
	C) Inspect Ejector Hole for Chamfer		4/16/91	RW
	D) Oil Firing Pin Ass'y		4/16/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/7/91	KL

BARBER - M24 0077426		READINGS					DATE	INIT
op. #	OP. NAME							
625 cont.	F) Safety On Force	6	6	6			5-7-91	DH
	G) Safety Off Force	4	3	3			5-7-91	DH
	H) Trigger Pull Test & Retainability						5/7/91	SP
	I) Firing Pin Indent	.022	.023	.022			5-7-91	DH
	J) Assemble Stock						5/8/91	RW
	K) Assemble Swivel Studs						5-11-91	DH
	L) Attach Front and Rear Sight Assemblies						5/8/91	RW
	M) Iron Sight Alignment						5/8/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/8/91	RW
	O) Attach Scope to Rifle						5/8/91	RW
	P) Detach & Attach Scope 20 Times						5/8/91	RW
640	Gallery Target & Test						5-9-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						5-9-91	AF
655	Final Inspection							
	A) Headspace						5-11-91	DH
	B) Trigger Pull	2.18	2.16	2.14	2.15	2.16	5/10/91	SP
	C) Function						5-11-91	DH
660	Pack						6-18-91	AF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6611468

DATE 5/17/97

TESTER JP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.55	2.46	2.45	2.18	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.48	2.44	2.40	2.16	
PULL #3	2.51	2.44	2.42	2.14	
PULL #4	2.26	2.43	2.46	2.15	
PULL #5	2.22	2.42	2.40	2.16	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.57	3.33		
PULL #2	3.54	3.28		
PULL #3	3.57	3.13		
PULL #4	3.58	3.28		
PULL #5	3.59	3.24		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.24	4.36		4.39
PULL #2	4.35	4.37		4.39
PULL #3	4.35	4.35		4.41
PULL #4	4.34	4.36		4.36
PULL #5	4.34	4.25		4.39
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611468
9 May 1991

CENTROIDAL DISTANCES

0 TO	1	.240354
1 TO	2	.411024
1 TO	3	.470664
1 TO	4	.628029
1 TO	5	.402087

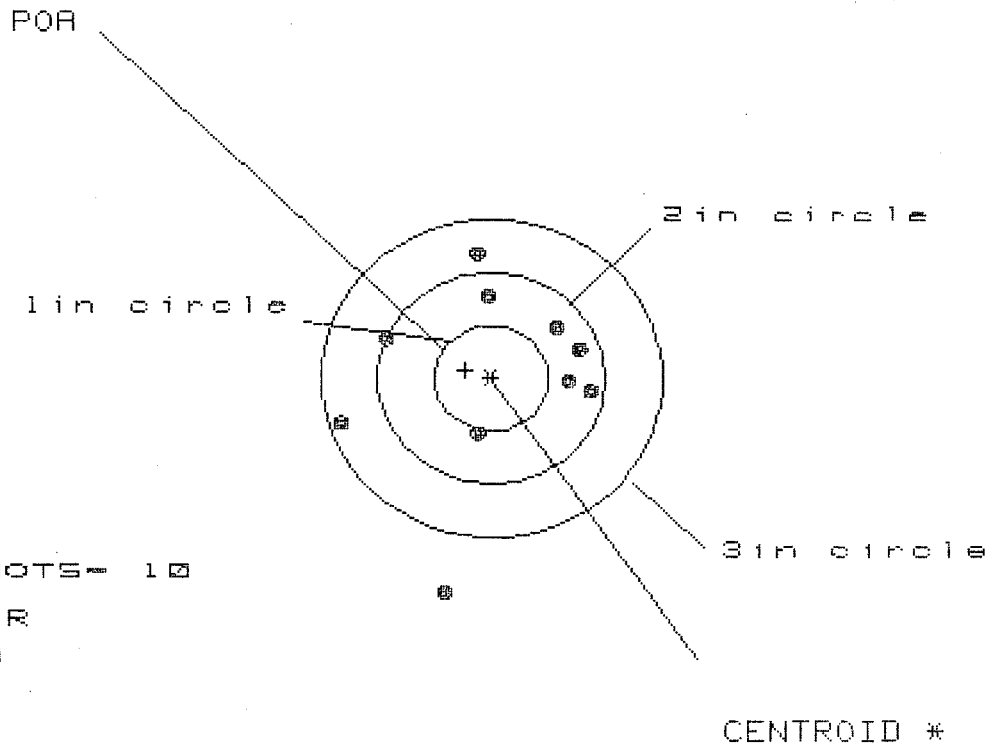
$\frac{4}{41}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0288
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2352
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .236957
THE AMR FOR THIS RIFLE IS: 1.002

9 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611468

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 7

3 in = 9

HS = 2.235

VS = 3.156

GS = 3.170

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.862	.819	.642
MINIMUM X	-1.373	-1.416	-1.097
MAXIMUM Y	1.150	.927	.852
MINIMUM Y	-2.006	-.749	-.824
CENTROID X	.227	.270	.447
CENTROID Y	-.079	.144	.219
POA TO CENTROID in.	.240	.306	.498
MIN RADIUS	.533	.515	.363
MEAN RADIUS	.988	.830	.693
MAX RADIUS	2.044	1.538	1.103
HORIZONTAL SPREAD	2.235	2.235	1.739
VERTICAL SPREAD	3.156	1.676	1.676
EXTREME SPREAD	3.170	2.255	1.805
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

9 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611468

CENTERFIRE PATTERNS

2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 7

HS= 1.939

VS= 3.435

GS= 3.754

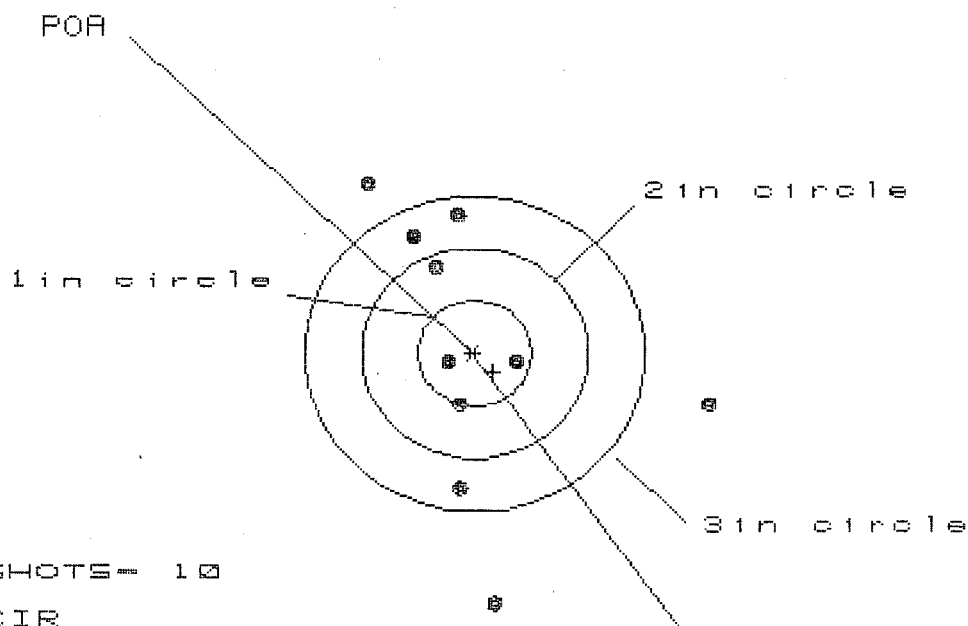
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.937	.873	.953
MINIMUM X	:	-1.002	-1.066	-.957
MAXIMUM Y	:	1.471	1.252	.862
MINIMUM Y	:	-1.964	-1.476	-1.319
CENTROID X	:	.048	.112	.003
CENTROID Y	:	.291	.510	.353
POA TO CENTROID in.	:	.295	.522	.353
MIN RADIUS	:	.374	.370	.303
MEAN RADIUS	:	1.145	1.006	.939
MAX RADIUS	:	2.048	1.700	1.627
HORIZONTAL SPREAD	:	1.939	1.939	1.910
VERTICAL SPREAD	:	3.435	2.728	2.181
EXTREME SPREAD	:	3.754	2.728	2.725
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

9 May 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 4

3 in = 7

HS = 2.988

VS = 3.996

GS = 4.154

CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.043	2.064	.604
MINIMUM X	:	-.945	-.924	-.666
MAXIMUM Y	:	1.585	1.317	1.219
MINIMUM Y	:	-2.411	-1.554	-1.652
CENTROID X	:	-.164	-.185	-.443
CENTROID Y	:	.183	.451	.549
POA TO CENTROID in.	:	.246	.487	.706
MIN RADIUS	:	.291	.436	.442
MEAN RADIUS	:	1.235	1.095	.928
MAX RADIUS	:	2.418	2.209	1.657
HORIZONTAL SPREAD	:	2.988	2.988	1.270
VERTICAL SPREAD	:	3.996	2.871	2.871
EXTREME SPREAD	:	4.154	3.655	2.980
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

9 May 1991

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CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS = 1.984

VS = 2.863

GS = 2.905

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.936	.949	1.028
MINIMUM X	:	-1.048	-1.035	-.956
MAXIMUM Y	:	1.078	.880	.614
MINIMUM Y	:	-1.785	-.599	-.489
CENTROID X	:	-.009	-.022	-.101
CENTROID Y	:	.503	.701	.591
POA TO CENTROID in.	:	.503	.702	.600
MIN RADIUS	:	.280	.199	.152
MEAN RADIUS	:	.809	.668	.608
MAX RADIUS	:	1.789	1.196	1.074
HORIZONTAL SPREAD	:	1.984	1.984	1.984
VERTICAL SPREAD	:	2.863	1.479	1.103
EXTREME SPREAD	:	2.905	2.228	2.058
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

9 May .991

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CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 9

HS= 1.911

VS= 2.334

GS= 3.017

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.909	.923	.810
MINIMUM X	:	-1.002	-.901	-.997
MAXIMUM Y	:	1.327	.668	.561
MINIMUM Y	:	-1.006	-.859	-.764
CENTROID X	:	.042	-.059	.054
CENTROID Y	:	.278	.130	.237
POA TO CENTROID in.	:	.281	.143	.243
MIN RADIUS	:	.258	.315	.251
MEAN RADIUS	:	.835	.747	.667
MAX RADIUS	:	1.609	1.245	1.114
HORIZONTAL SPREAD	:	1.911	1.824	1.807
VERTICAL SPREAD	:	2.334	1.527	1.325
EXTREME SPREAD	:	3.017	2.142	2.142
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	