

C6349117

MODEL 700TM M24

Model **SWS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington
SWSTM

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

MODEL 700™ M24

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

SERIAL NO.
 C6349117

ORDER NO.
 5716

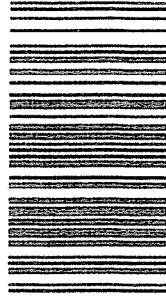
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off. Marca Registrada Marque Deposee.

Q1



5716 C6349117

UPC



0 47700 125716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6349117

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 31	90	RW
600	Proof	2 31	90	RW
607	Check Headspace	2 31	90	RW
610	Dis-assemble Gun	2 31	90	RW
612	Magnaflux Barrel Action	4-2-90		KCR
	Magnaflux Bolt	4-2-90		KCR
615	Rollmark Caliber	4-2-90		SL
617	Drill and Tap Sight Holes		4/4/90	FB
618	Polish Barrel RB		4/5/90	WB
620	Apply Coatings (Barrel Action)		4-9-90	TA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		4/18/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/18/90	RW
	C) Inspect Ejector Hole for Chamfer		4/18/90	RW
	D) Oil Firing Pin Ass'y		4/18/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4/26/90	SL

BARBER - M24 0108142

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			4/27/90	JU
	G) Safety Off Force	4	4	4			4/27/90	JU
	H) Trigger Pull Test & Retainability						4/26/90	JU
	I) Firing Pin Indent	.0215	.022	.0215			4/27/90	JU
	J) Assemble Stock						4/30/90	RW
	K) Assemble Swivel Studs						5/8/90	WB
	L) Attach Front and Rear Sight Assemblies						4/30/90	RW
	M) Iron Sight Alignment						4/30/90	RW
	N) Detach Front & Rear Sights & place in numbered container						4/30/90	RW
	O) Attach Scope to Rifle						4/30/90	WB
	P) Detach & Attach Scope 20 Times						4/30/90	WB
640	Gallery Target & Test						4-30-90	DH
	A) Time						4-30-90	AC
	B) Malfunctions						4-30-90	AC
	C) Pierced Primers						4-30-90	AC
	D) Optical Clarity of Scope						4-30-90	AC
645	Inspect for Live Ammo						4-30-90	AC
655	Final Inspection						5/8/90	WB
	A) Headspace						5/8/90	WB
	B) Trigger Pull	2.17	2.18	2.14	2.19	2.21	5/8/90	WB
	C) Function						5/8/90	WB
660	Pack						6-9-90	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. 06349117

DATE 4/26/90

TESTER 991

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.55	2.45	2.30	2.17	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.40	2.53	2.32	2.18	
PULL #3	2.41	2.28	2.40	2.14	
PULL #4	2.32	2.33	2.33	2.19	
PULL #5	2.42	2.32	2.45	2.21	
TOTAL	12.10	11.91	11.80		
AVG.	2.42	2.382	2.36		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.50	3.49		
PULL #2	3.51	3.43		
PULL #3	3.44	3.27		
PULL #4	3.44	3.41		
PULL #5	3.50	3.39		
TOTAL	17.39	16.99		
AVG.	3.478	3.398		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.29	4.25		4.44
PULL #2	4.16	4.20		4.39
PULL #3	4.21	4.25		4.20
PULL #4	4.15	4.31		4.45
PULL #5	4.17	4.33		4.32
TOTAL	20.98	21.34		21.80
AVG.	4.196	4.268		4.36

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06349117
1 May 1990

CENTROIDAL DISTANCES

0 TO	1	.352755
1 TO	2	.284016
1 TO	3	.358041
1 TO	4	.438737
1 TO	5	.280492

$\frac{0}{4}$ <----POH

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .163
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0262
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .165092
THE AMR FOR THIS RIFLE IS: .8642

1 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8345117

CENTERFIRE PATTERNS

1

FOR

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 1

2 in = 8

3 in = 10

HS = 1.509

VS = 1.855

GS = 2.096

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.797	.859	.794
MINIMUM X	-.712	-.650	-.715
MAXIMUM Y	.911	.955	.861
MINIMUM Y	-.944	-.843	-.937
CENTROID X	.340	.278	.343
CENTROID Y	-.094	-.195	-.101
FOR TO CENTROID in.	.352	.339	.357
MIN RADIUS	.497	.576	.495
MEAN RADIUS	.835	.805	.783
MAX RADIUS	1.067	1.026	.987
HORIZONTAL SPREAD	1.509	1.509	1.509
VERTICAL SPREAD	1.855	1.798	1.798
EXTREME SPREAD	2.096	1.923	1.909
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

1 May 1999

FILE:/PATTERNING/CENTERFIRE_PATT/CS349117

CENTERFIRE PATTERNS

2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

HS= 2.351

VS= 1.498

GS= 2.461

CENTROID *

PATTERN #

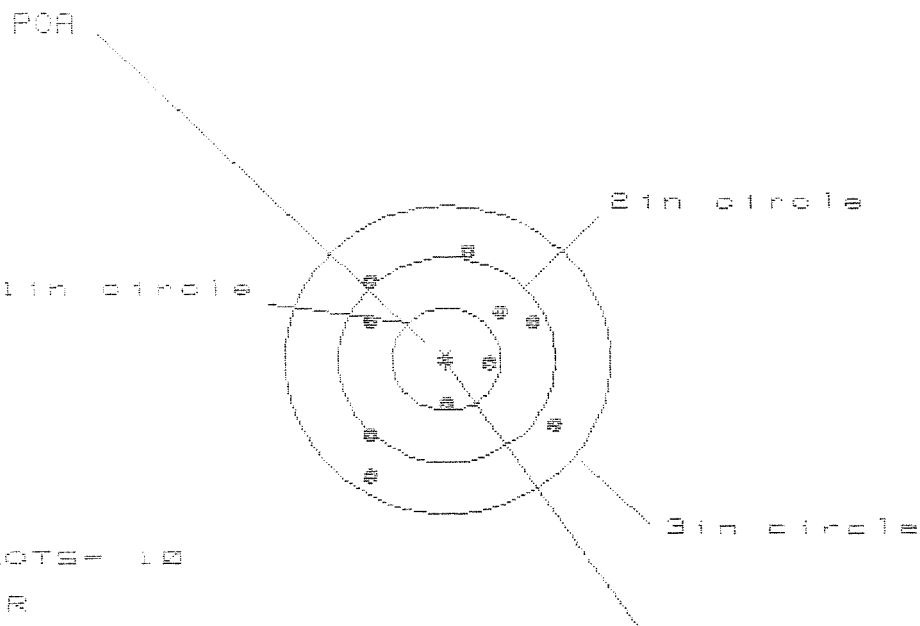
2

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.101	.962	.799
MINIMUM X	:	-1.250	-1.300	-.959
MAXIMUM Y	:	.523	.571	.584
MINIMUM Y	:	-.975	-.927	-.914
CENTROID X	:	.111	.249	.412
CENTROID Y	:	.074	.026	.013
POA TO CENTROID in.	:	.133	.251	.412
MIN RADIUS	:	.382	.242	.084
MEAN RADIUS	:	.832	.745	.625
MAX RADIUS	:	1.323	1.304	1.123
HORIZONTAL SPREAD	:	2.351	2.262	1.758
VERTICAL SPREAD	:	1.498	1.498	1.498
EXTREME SPREAD	:	2.461	2.288	1.939
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

1 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08349117

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 1.694

VS= 2.182

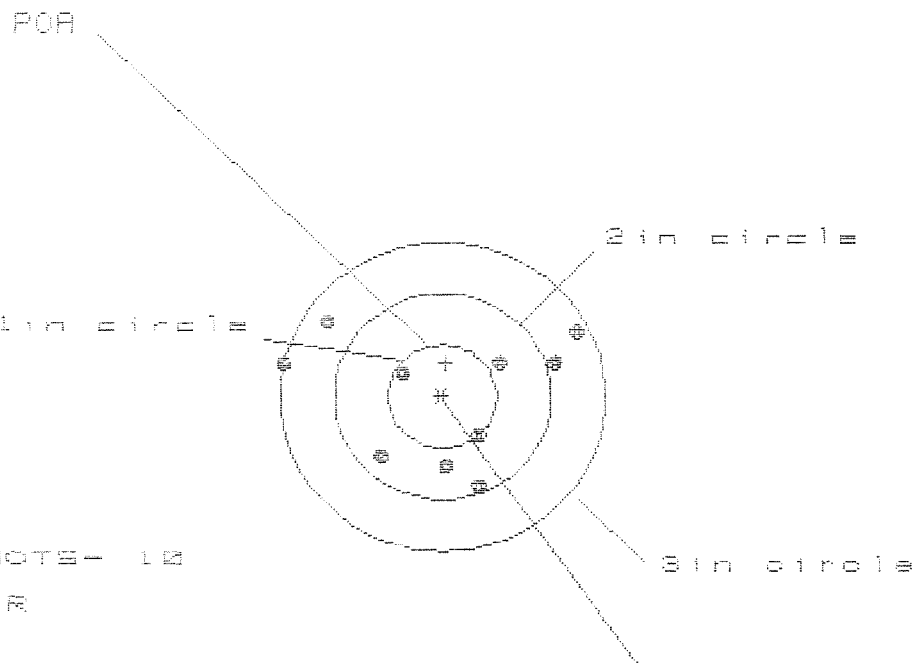
GS= 2.358

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.961	.832	.802
MINIMUM X	-.733	-.812	-.702
MAXIMUM Y	1.032	.905	.813
MINIMUM Y	-1.150	-.895	-.987
CENTROID X	.087	.086	-.024
CENTROID Y	.032	.159	.251
POA TO CENTROID in.	.032	.181	.252
MIN RADIUS	.430	.389	.524
MEAN RADIUS	.876	.805	.765
MAX RADIUS	1.353	1.159	1.169
HORIZONTAL SPREAD	1.694	1.694	1.504
VERTICAL SPREAD	2.182	1.800	1.800
EXTREME SPREAD	2.358	2.145	1.985
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

1 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06349117

CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HSE = 2.740

VSE = 1.677

GSE = 2.754

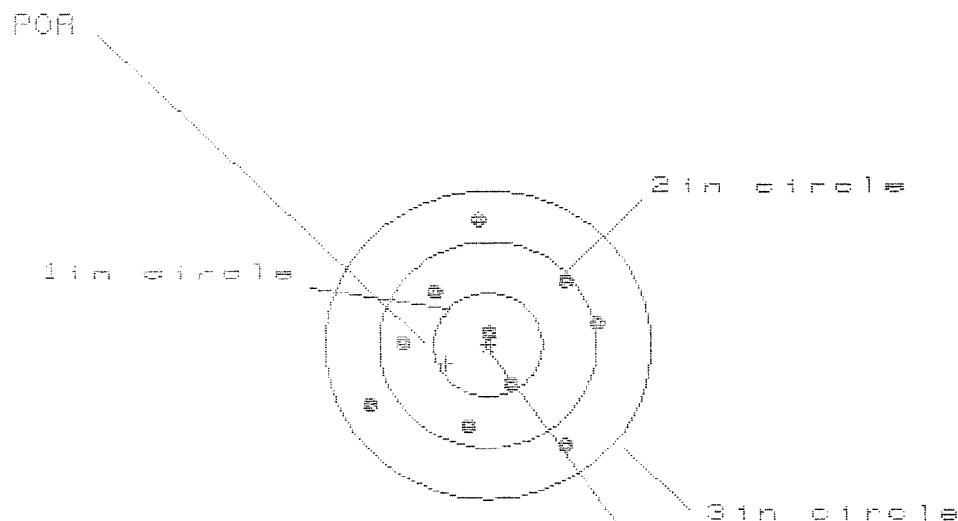
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.253	1.088	.954
MINIMUM X	-1.487	-1.225	-1.089
MAXIMUM Y	.760	.798	.880
MINIMUM Y	-.917	-.879	-.797
CENTROID X	-.033	.132	-.004
CENTROID Y	-.325	-.363	-.445
POA TO CENTROID in.	.327	.387	.445
MIN RADIUS	.421	.336	.353
MEAN RADIUS	.923	.836	.768
MAX RADIUS	1.526	1.462	1.400
HORIZONTAL SPREAD	2.740	2.313	2.043
VERTICAL SPREAD	1.677	1.677	1.677
EXTREME SPREAD	2.754	2.318	2.172
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

1 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08349117

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 10

1st = 2.084

V8 = 2.138

G8 = 2.276

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.025
MINIMUM X	-1.069
MAXIMUM Y	1.189
MINIMUM Y	-0.949
CENTROID X	.390
CENTROID Y	.182
POR TO CENTROID in.	.430
MIN RADIUS	.137
MEAN RADIUS	.855
MAX RADIUS	1.220
HORIZONTAL SPREAD	2.094
VERTICAL SPREAD	2.138
EXTREME SPREAD	2.276
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	10