

C6522296

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington



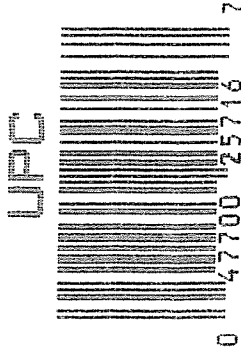
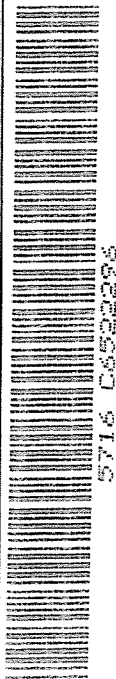

VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700TM M24

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

SERIAL NO.
C6522296

ORDER NO.
5716



Not
Scanned
in

SWS TRIGGER PULL TEST

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

SERIAL NO. C6522296
DATE 9-14-95
TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	237	236	259	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	238	234	258	
PULL #3	240	236	259	
PULL #4	235	234	253	
PULL #5	232	232	257	
TOTAL	1182	1172	1286	
AVG.	236	234	257	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	328	334	
PULL #2	333	336	
PULL #3	325	318	
PULL #4	330	339	
PULL #5	335	336	
TOTAL	1651	1663	
AVG.	330	332	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	400	393	410	
PULL #2	395	390	414	
PULL #3	395	385	414	
PULL #4	390	394	409	
PULL #5	395	395	400	
TOTAL	1975	1957	2047	
AVG.	395	391	409	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6527796

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

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 3/4	5 1/2	5 1/2			11/28	WB
	G) Safety Off Force	2 3/4	3	3			11/28	WB
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent							
	J) Assemble Stock							
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies							
	M) Iron Sight Alignment							
	N) Detach Front & Rear Sights & place in numbered container							
	O) Attach Scope to Rifle							
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test							
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection							
	A) Headspace							
	B) Trigger Pull	2.10	2.37	2.33	2.28	2.27	11/28	WB
	C) Function							
660	Pack							

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4		4		4	8/13/90	JP
	G) Safety Off Force	2		2		2	8/13/90	JP
	H) Trigger Pull Test & Retainability						8/15/90	JP
	I) Firing Pin Indent	.0215		.0215		.0215	8/13/90	JP
	J) Assemble Stock						8/15/90	KS
	K) Assemble Swivel Studs						10/30/90	LS
	L) Attach Front and Rear Sight Assemblies						8/15/90	KS
	M) Iron Sight Alignment						8/15/90	KS
	N) Detach Front & Rear Sights & place in numbered container						8/15/90	KS
	O) Attach Scope to Rifle						8/15/90	KS
	P) Detach & Attach Scope 20 Times						8/15/90	KS
640	Gallery Target & Test						8/16/90	A
	A) Time						8/16/90	A
	B) Malfunctions						8/16/90	A
	C) Pierced Primers						8/16/90	A
	D) Optical Clarity of Scope						8/16/90	A
645	Inspect for Live Ammo						8/16/90	A
655	Final Inspection							
	A) Headspace						10/30/90	LS
	B) Trigger Pull	252	239	235	226	221	10/30/90	JP
	C) Function						10/30/90	JP
660	Pack						12-7890	D/H

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6522296

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		7/10/90	KL
600	Proof		7/10/90	KL
607	Check Headspace		7/10/90	KL
610	Dis-assemble Gun		7/10/90	KL
612	Magnaflux Barrel Action		7/17/90	RR
	Magnaflux Bolt		7/17/90	RR
615	Rollmark Caliber		7/17/90	LS
617	Drill and Tap Sight Holes		7/23/90	FB
618	Polish Barrel RB		7/24/90	WB
620	Apply Coatings (Barrel Action)		8/6/90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/14/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/14/90	KS
	C) Inspect Ejector Hole for Chamfer		8/14/90	KS
	D) Oil Firing Pin Ass'y		8/14/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		8/15/90	JA

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6522296

DATE 8/15/90

TESTER JPL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.37	2.31	2.52	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.40	2.32	2.36	2.39	
PULL #3	2.33	2.42	2.37	2.35	
PULL #4	2.35	2.35	2.39	2.26	
PULL #5	2.38	2.36	2.44	2.21	
TOTAL	11.87	11.82	11.87		
AVG.	2.374	2.364	2.374		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.29	3.33		
PULL #2	3.22	3.36		
PULL #3	3.20	3.30		
PULL #4	3.37	3.33		
PULL #5	3.36	3.32		
TOTAL	16.44	16.64		
AVG.	3.288	3.328		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.34	4.22		4.43
PULL #2	4.28	4.25		4.40
PULL #3	4.20	4.13		4.40
PULL #4	4.21	4.28		4.39
PULL #5	4.21	4.24		4.43
TOTAL	21.24	21.12		22.05
AVG.	4.248	4.224		4.41

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522296
17 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.412044
1 TO	2	.599401
1 TO	3	.608205
1 TO	4	.426602
1 TO	5	.33455

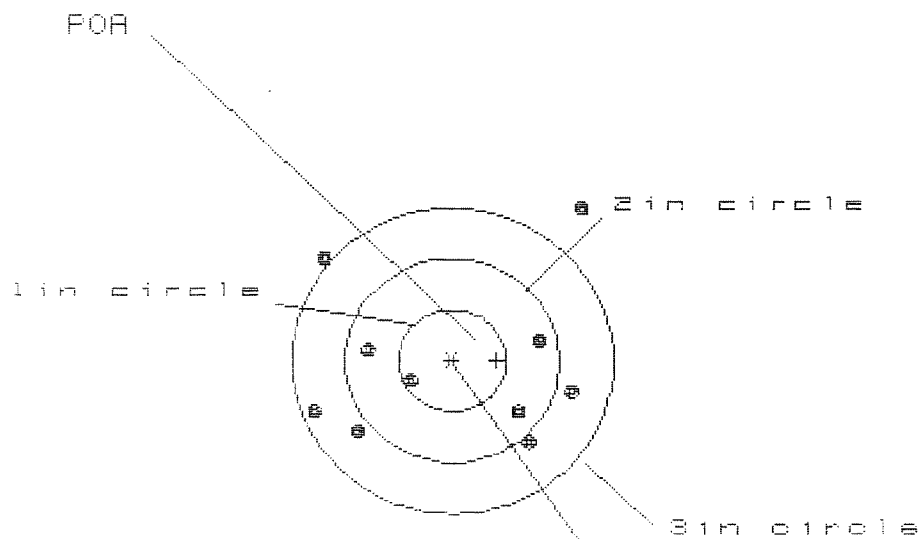
$\frac{49}{12}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0902
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .144
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .169918
THE AMP FOR THIS RIFLE IS: .8598

18 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06522296

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS= 2.538

VS= 2.354

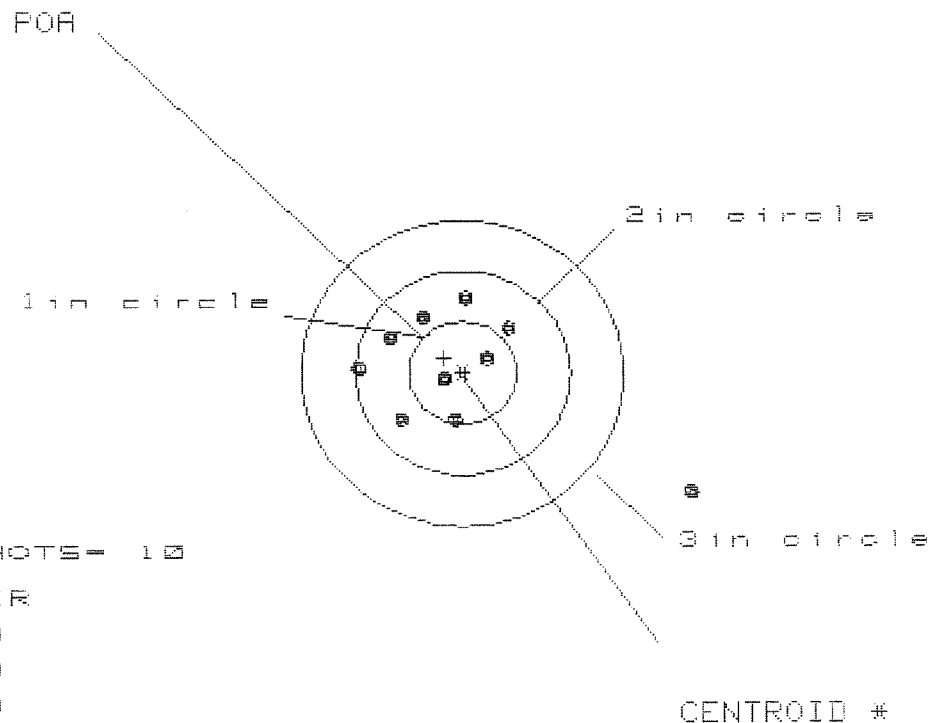
GS= 3.237

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.252	1.278	1.143
MINIMUM X	-1.286	-1.147	-1.282
MAXIMUM Y	1.555	1.206	.552
MINIMUM Y	-.799	-.626	-.476
CENTROID X	-.412	-.551	-.416
CENTROID Y	-.006	-.179	-.329
FOR TO CENTROID in.	.412	.580	.530
MIN RADIUS	.454	.271	.424
MEAN RADIUS	1.112	.978	.890
MAX RADIUS	1.996	1.622	1.289
HORIZONTAL SPREAD	2.538	2.425	2.425
VERTICAL SPREAD	2.354	1.832	1.028
EXTREME SPREAD	3.237	2.727	2.428
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

16 Aug 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C8522296

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 9

HS= 3.087

VS= 1.843

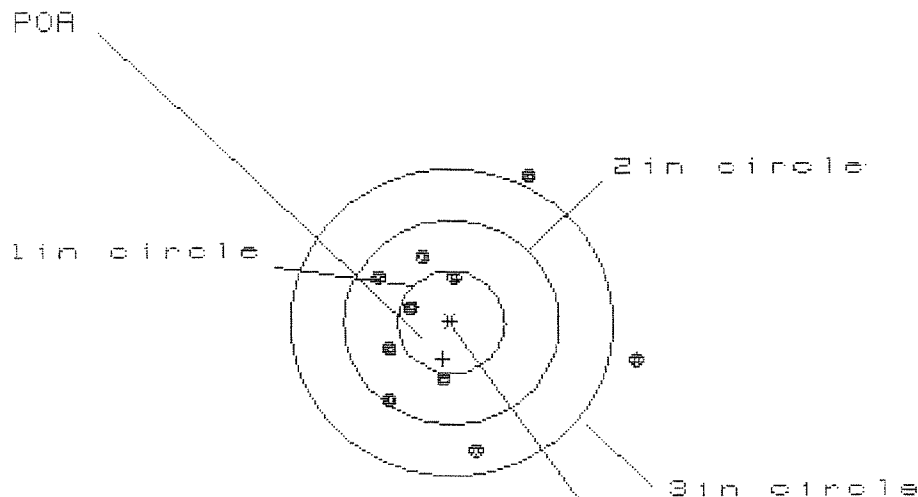
GS= 3.295

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.122	.702	.611
MINIMUM X	:	-.965	-.729	-.507
MAXIMUM Y	:	.715	.590	.577
MINIMUM Y	:	-1.128	-.598	-.611
CENTROID X	:	.172	-.064	.028
CENTROID Y	:	-.141	-.016	-.003
POA TO CENTROID in.	:	.223	.066	.028
MIN RADIUS	:	.216	.193	.213
MEAN RADIUS	:	.772	.551	.521
MAX RADIUS	:	2.403	.750	.775
HORIZONTAL SPREAD	:	3.087	1.431	1.118
VERTICAL SPREAD	:	1.843	1.188	1.188
EXTREME SPREAD	:	3.295	1.477	1.389
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		9	

16 Aug 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6522296

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 8

HS = 2.330

VS = 2.691

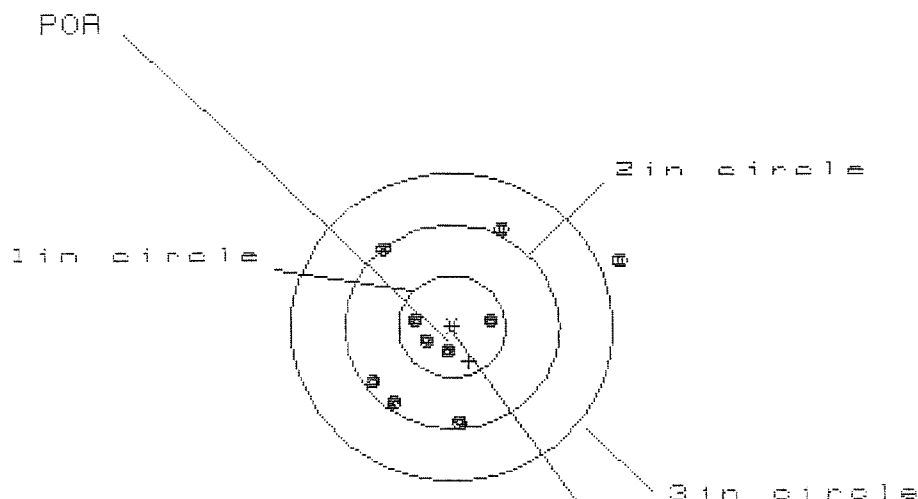
GS = 2.736

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.684
MINIMUM X	-.646
MAXIMUM Y	1.449
MINIMUM Y	-1.242
CENTROID X	.076
CENTROID Y	.357
POA TO CENTROID in.	.365
MIN RADIUS	.427
MEAN RADIUS	.907
MAX RADIUS	1.713
HORIZONTAL SPREAD	2.330
VERTICAL SPREAD	2.691
EXTREME SPREAD	2.736
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	7
NUMBER IN THREE INCH CIRCLE =	8

16 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08522296

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 4

2 in = 8

3 in = 9

HS = 2.321

VS = 1.955

GS = 2.603

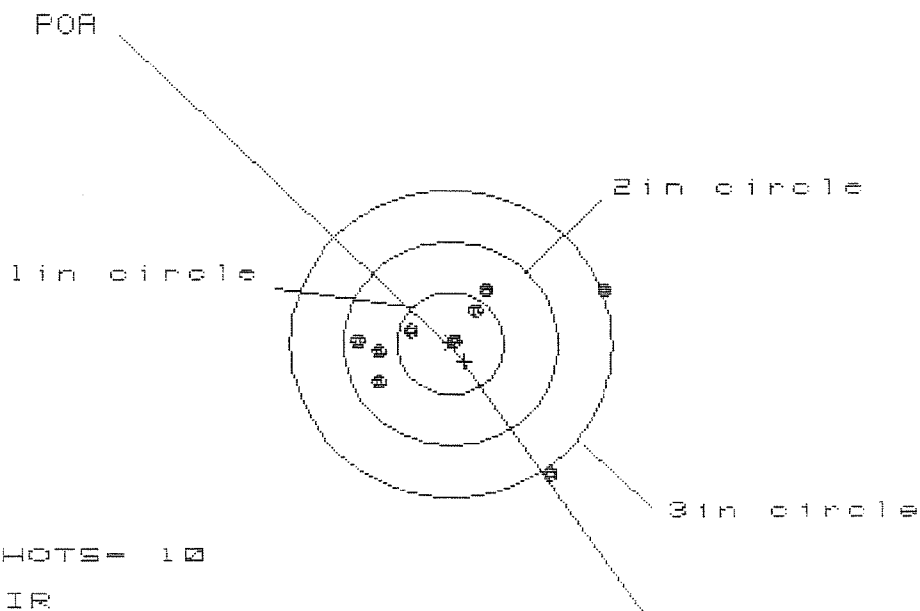
CENTROID #

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.573	.676	.640
MINIMUM X	-.748	-.573	-.488
MAXIMUM Y	1.008	1.083	.987
MINIMUM Y	-.947	-.872	-.737
CENTROID X	-.157	-.332	-.417
CENTROID Y	.336	.261	.126
POA TO CENTROID in.	.371	.423	.435
MIN RADIUS	.192	.067	.094
MEAN RADIUS	.779	.630	.542
MAX RADIUS	1.789	1.276	1.053
HORIZONTAL SPREAD	2.321	1.249	1.128
VERTICAL SPREAD	1.955	1.955	1.724
EXTREME SPREAD	2.603	2.060	1.854
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		9	

16 Aug 1998

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 4

2 in = 8

3 in = 9

HS= 2.245

VS= 1.799

GS= 2.295

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.379	1.487	.601
MINIMUM X	-.865	-.758	-.573
MAXIMUM Y	.545	.406	.453
MINIMUM Y	-1.254	-.522	-.475
CENTROID X	-.130	-.237	-.423
CENTROID Y	.174	.313	.266
POA TO CENTROID in.	.217	.392	.499
MIN RADIUS	.072	.238	.093
MEAN RADIUS	.729	.604	.439
MAX RADIUS	1.582	1.534	.753
HORIZONTAL SPREAD	2.245	2.245	1.173
VERTICAL SPREAD	1.799	.928	.928
EXTREME SPREAD	2.295	2.295	1.378
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	9		