

C6522324

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington




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

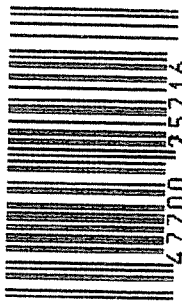
MODEL 700™ H24

SERIAL NO.
C6522324

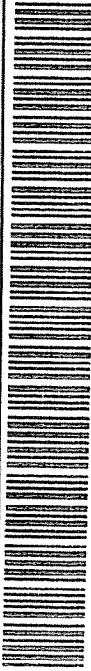
ORDER NO.
5716

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

UPC



0 47700 25716 7



5716 C6522324

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522324
7 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.357246
1 TO	2	.230653
1 TO	3	.234696
1 TO	4	.11908
1 TO	5	.434687

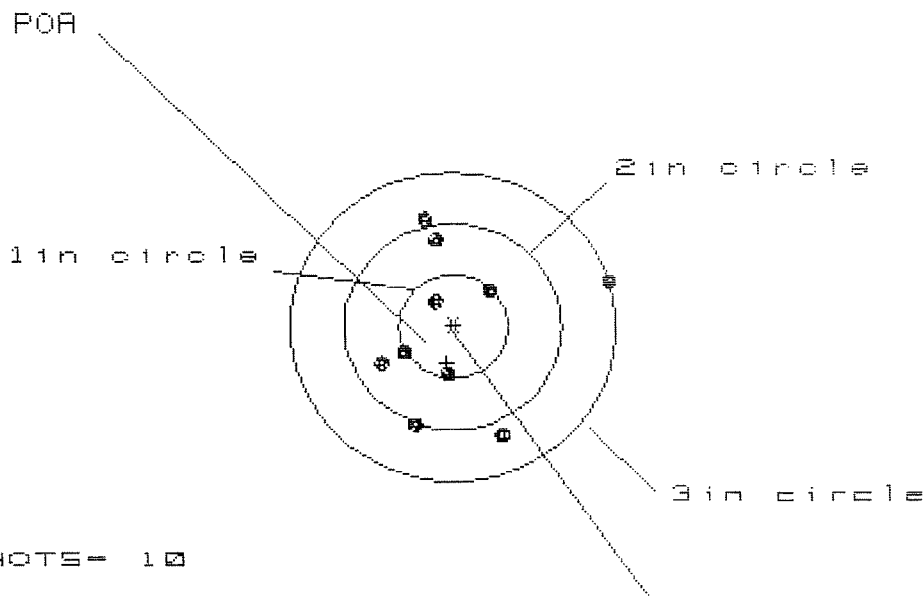
SP <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0194
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .168
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .169116
THE AMR FOR THIS RIFLE IS: .6646

7 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8522324

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 4

2in = 6

3in = 10

HS= 2.060

VS= 2.118

GS= 2.264

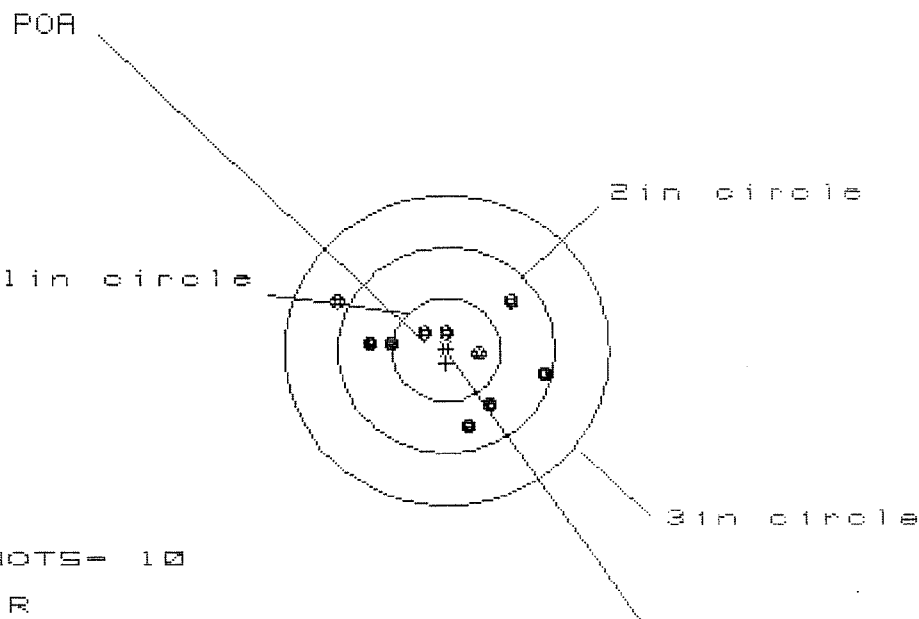
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.405	.595	.531
MINIMUM X	:	-.655	-.499	-.425
MAXIMUM Y	:	1.080	1.129	1.006
MINIMUM Y	:	-1.038	-.989	-1.056
CENTROID X	:	.061	-.095	-.169
CENTROID Y	:	.352	.303	.426
POA TO CENTROID in.	:	.358	.317	.458
MIN RADIUS	:	.297	.299	.187
MEAN RADIUS	:	.810	.710	.643
MAX RADIUS	:	1.475	1.154	1.063
HORIZONTAL SPREAD	:	2.060	1.094	.956
VERTICAL SPREAD	:	2.118	2.118	2.062
EXTREME SPREAD	:	2.264	2.224	2.065
NUMBER IN ONE INCH CIRCLE =			4	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			10	

7 Sep 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8522324

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 3

2in = 9

3in = 10

HS= 1.967

VS= 1.175

GS= 2.104

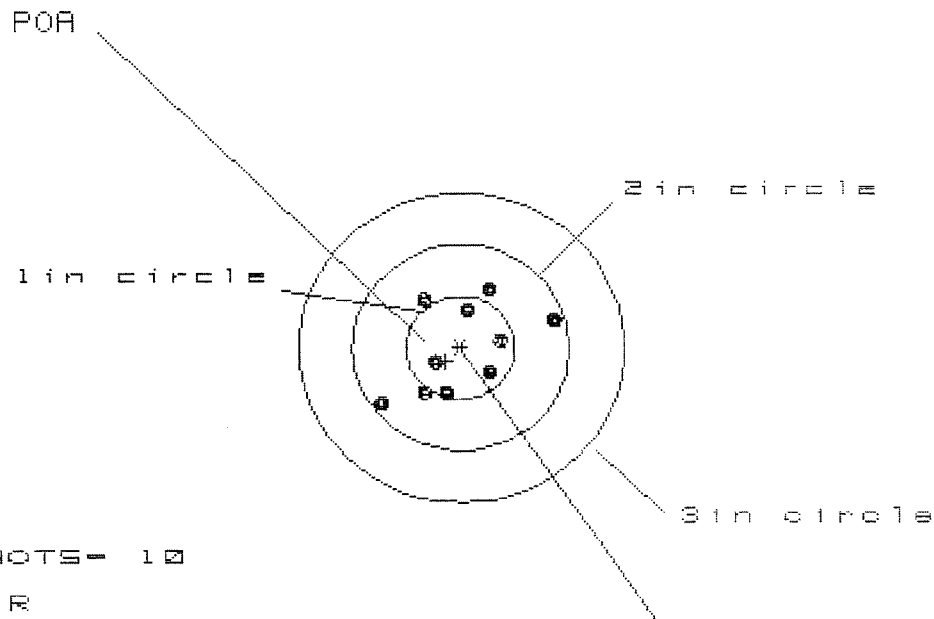
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.942	.829	.583
MINIMUM X	:	-1.025	-.832	-.729
MAXIMUM Y	:	.487	.539	.513
MINIMUM Y	:	-.688	-.633	-.659
CENTROID X	:	.006	.119	.016
CENTROID Y	:	.128	.073	.099
POR TO CENTROID in.	:	.128	.140	.100
MIN RADIUS	:	.179	.146	.205
MEAN RADIUS	:	.616	.554	.509
MAX RADIUS	:	1.135	.854	.777
HORIZONTAL SPREAD	:	1.967	1.661	1.312
VERTICAL SPREAD	:	1.175	1.172	1.172
EXTREME SPREAD	:	2.104	1.697	1.370
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			9	
NUMBER IN THREE INCH CIRCLE =			10	

7 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8522324

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 5

2 in = 10

3 in = 10

HS= 1.672

VS= 1.086

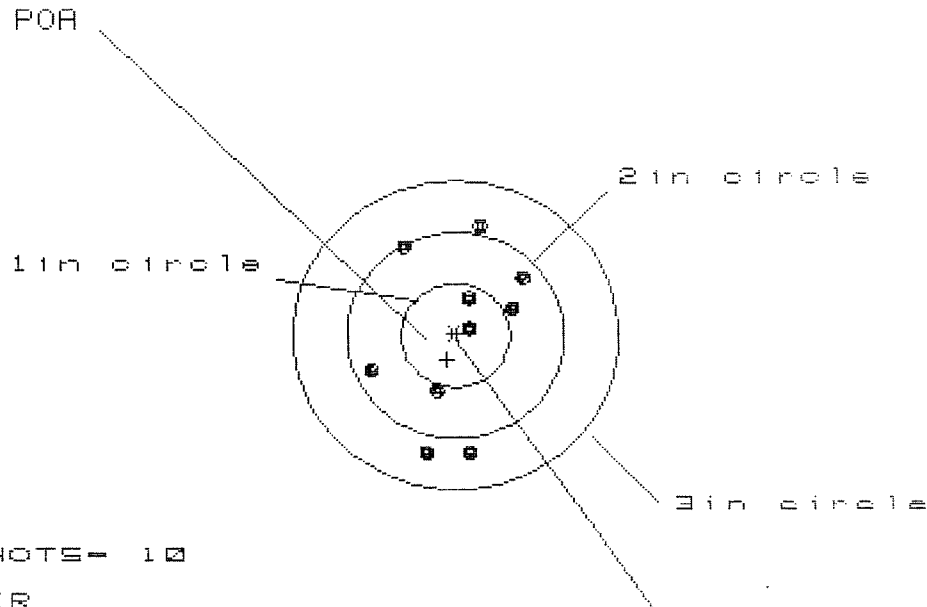
GS= 1.861

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.900	.503	.419
MINIMUM X	:	-.772	-.672	-.370
MAXIMUM Y	:	.585	.620	.562
MINIMUM Y	:	-.501	-.466	-.475
CENTROID X	:	.140	.040	.124
CENTROID Y	:	.131	.096	.154
POA TO CENTROID in.	:	.192	.104	.198
MIN RADIUS	:	.279	.173	.275
MEAN RADIUS	:	.551	.499	.455
MAX RADIUS	:	.954	.818	.620
HORIZONTAL SPREAD	:	1.672	1.175	.789
VERTICAL SPREAD	:	1.086	1.086	1.037
EXTREME SPREAD	:	1.861	1.488	1.214
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		10	
NUMBER IN THREE INCH CIRCLE	=		10	

7 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522324

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 1.461

VS= 2.205

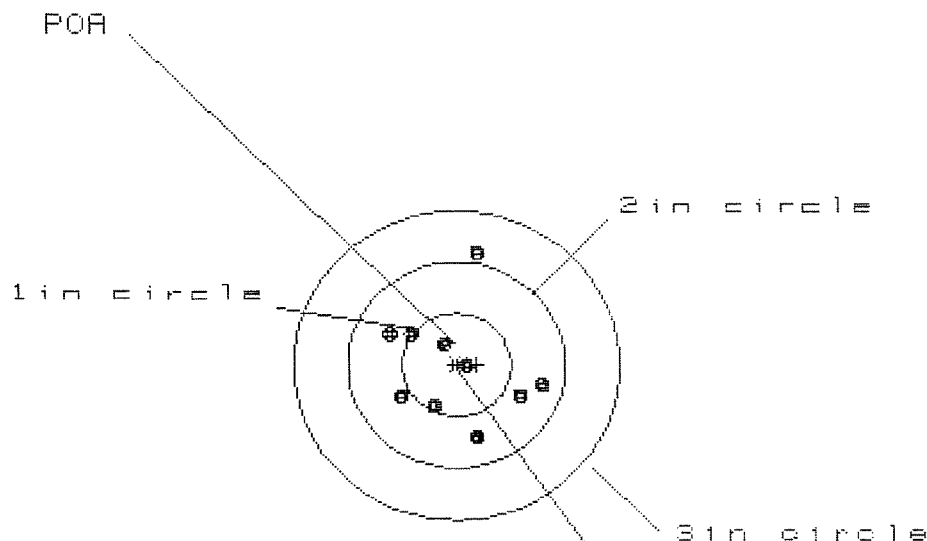
GS= 2.273

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.664	.629	.638
MINIMUM X	-.797	-.832	-.823
MAXIMUM Y	1.048	.919	.761
MINIMUM Y	-1.157	-1.261	-.780
CENTROID X	.077	.112	.103
CENTROID Y	.234	.363	.521
POA TO CENTROID in.	.247	.380	.531
MIN RADIUS	.147	.128	.145
MEAN RADIUS	.772	.701	.616
MAX RADIUS	1.200	1.263	1.021
HORIZONTAL SPREAD	1.461	1.461	1.461
VERTICAL SPREAD	2.205	2.180	1.541
EXTREME SPREAD	2.273	2.183	1.711
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

7 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08522324

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 4

2 in = 9

3 in = 10

HS= 1.419

VS= 1.779

GS= 1.780

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.806	.824	.670
MINIMUM X	:	-.613	-.595	-.492
MAXIMUM Y	:	1.099	.455	.447
MINIMUM Y	:	-.679	-.557	-.566
CENTROID X	:	-.187	-.205	-.308
CENTROID Y	:	-.005	-.127	-.119
POA TO CENTROID in.	:	.187	.241	.330
MIN RADIUS	:	.071	.108	.191
MEAN RADIUS	:	.574	.508	.462
MAX RADIUS	:	1.112	.827	.699
HORIZONTAL SPREAD	:	1.419	1.419	1.162
VERTICAL SPREAD	:	1.779	1.012	1.012
EXTREME SPREAD	:	1.780	1.511	1.329
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

SWS TRIGGER PULL TEST

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

SERIAL NO. 06522324

DATE 8/30/90

TESTER J.P.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.36	2.37	2.21	2.46	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.29	2.43	2.20	2.43	
PULL #3	2.42	2.44	2.22	2.42	
PULL #4	2.45	2.47	2.19	2.42	
PULL #5	2.45	2.35	2.22	2.44	
TOTAL	11.97	12.06	11.04		
AVG.	2.394	2.412	2.21		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.40	3.41		
PULL #2	3.39	3.49		
PULL #3	3.44	3.42		
PULL #4	3.42	3.43		
PULL #5	3.40	3.39		
TOTAL	17.03	17.14		
AVG.	3.406	3.428		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.24	4.23		4.08
PULL #2	4.14	4.12		4.09
PULL #3	4.24	4.21		4.07
PULL #4	4.20	4.21		4.07
PULL #5	4.22	4.16		4.05
TOTAL	21.04	20.93		20.36
AVG.	4.208	4.19		4.07

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522324

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 12 90		RW
600	Proof	7 12 90		RW
607	Check Headspace	7 12 90		RW
610	Dis-assemble Gun	7 12 90		RW
612	Magnaflux Barrel Action		7-17-90	KP
	Magnaflux Bolt		7-17-90	KP
615	Rollmark Caliber		7-17-90	GL
617	Drill and Tap Sight Holes		7/27/90	FB
618	Polish Barrel RB		7/24/90	WB
620	Apply Coatings (Barrel Action)		7/6/90	JS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/8/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/8/90	RW
	C) Inspect Ejector Hole for Chamfer		8/8/90	RW
	D) Oil Firing Pin Ass'y		8/8/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/30/90	JO

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 ³ / ₄	4 ³ / ₄	4 ³ / ₄			8/30/90	WB
	G) Safety Off Force	2 ¹ / ₄	2 ¹ / ₄	2 ¹ / ₄			8/30/90	WB
	H) Trigger Pull Test & Retainability						8/30/90	fu
	I) Firing Pin Indent	.022	.022	.022			8/30/90	WB
	J) Assemble Stock						9/4/90	RW
	K) Assemble Swivel Studs						9/9/90	JS
	L) Attach Front and Rear Sight Assemblies						9/4/90	RW
	M) Iron Sight Alignment						9/4/90	RW
	N) Detach Front & Rear Sights & place in numbered container						9/4/90	RW
	O) Attach Scope to Rifle						9/4/90	RW
	P) Detach & Attach Scope 20 Times						9/4/90	RW
640	Gallery Target & Test						9-7-90	DH
	A) Time						9-7-90	DH
	B) Malfunctions						9-7-90	DH
	C) Pierced Primers						9-7-90	DH
	D) Optical Clarity of Scope						9-7-90	DH
645	Inspect for Live Ammo						9-7-90	DH
655	Final Inspection							
	A) Headspace						9/9/90	JS
	B) Trigger Pull	246	243	242	242	244	9/9/90	JS
	C) Function						9/9/90	JS
660	Pack						9/19-90	DH