

C6522327

MODEL 700™ M24

Model **SWS**™

Action 1 1

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington



MODEL 700TM M24



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

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

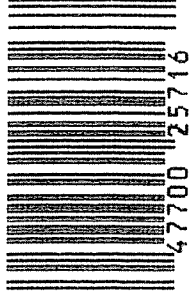
SERIAL NO.
C6522327

ORDER NO.
5716

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

01

UPC



5716 C6522327

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # ;06522327
14 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.254372
1 TO	2	.780641
1 TO	3	.316901
1 TO	4	.289638
1 TO	5	.631709

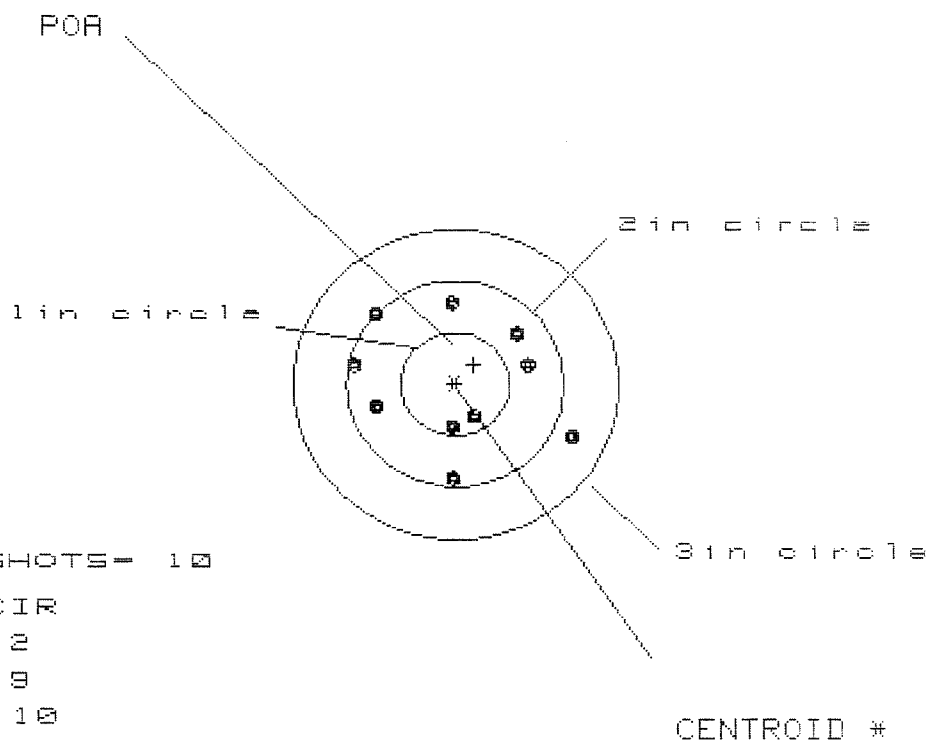
2
3,4
1
5
←----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2164
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1728
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .276927
THE AMR FOR THIS RIFLE IS: .7606

14 Aug 1998

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CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 9

3 in = 10

HS= 1.998

VS= 1.651

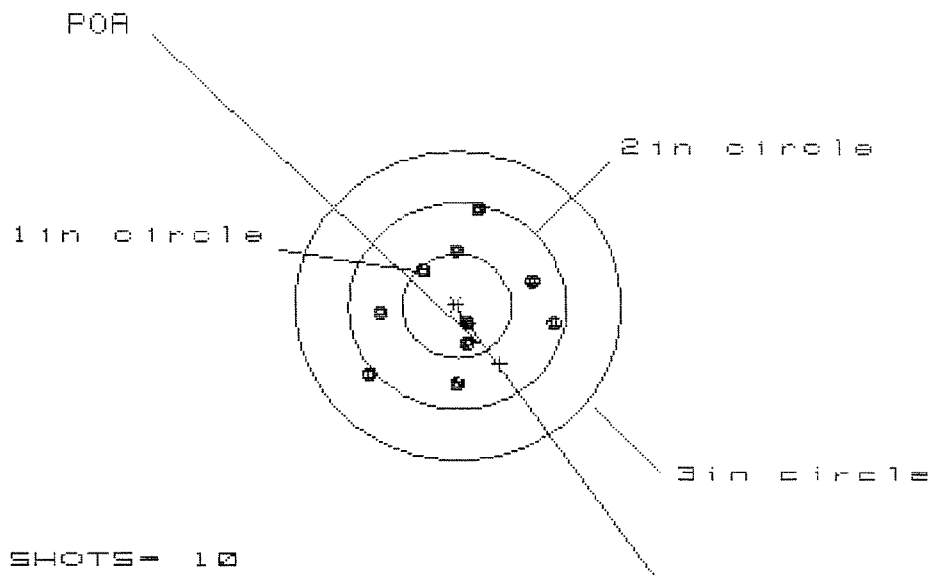
GS= 2.114

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.055	.814	.742
MINIMUM X	:	-.943	-.826	-.898
MAXIMUM Y	:	.762	.709	.791
MINIMUM Y	:	-.889	-.942	-.860
CENTROID X	:	-.168	-.285	-.213
CENTROID Y	:	-.191	-.138	-.220
POA TO CENTROID in.	:	.254	.317	.306
MIN RADIUS	:	.298	.405	.295
MEAN RADIUS	:	.772	.731	.694
MAX RADIUS	:	1.156	.944	.916
HORIZONTAL SPREAD	:	1.998	1.640	1.640
VERTICAL SPREAD	:	1.651	1.651	1.651
EXTREME SPREAD	:	2.114	1.723	1.652
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 3

2in = 9

3in = 10

HS= 1.667

VS= 1.680

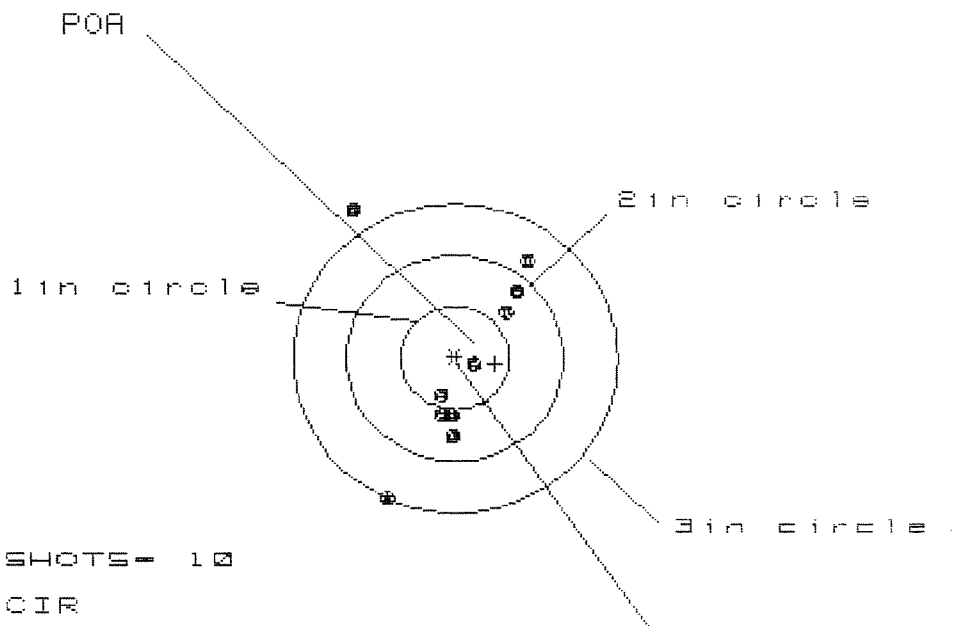
GS= 1.901

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.846	.754	.765
MINIMUM X	:	-.821	-.844	-.833
MAXIMUM Y	:	.955	.881	.617
MINIMUM Y	:	-.725	-.799	-.689
CENTROID X	:	-.388	-.296	-.387
CENTROID Y	:	.558	.632	.522
POA TO CENTROID in.	:	.679	.698	.605
MIN RADIUS	:	.185	.220	.114
MEAN RADIUS	:	.672	.628	.577
MAX RADIUS	:	1.056	.885	.834
HORIZONTAL SPREAD	:	1.667	1.598	1.598
VERTICAL SPREAD	:	1.680	1.680	1.306
EXTREME SPREAD	:	1.901	1.691	1.601
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS= 1.557

VS= 2.819

GS= 2.836

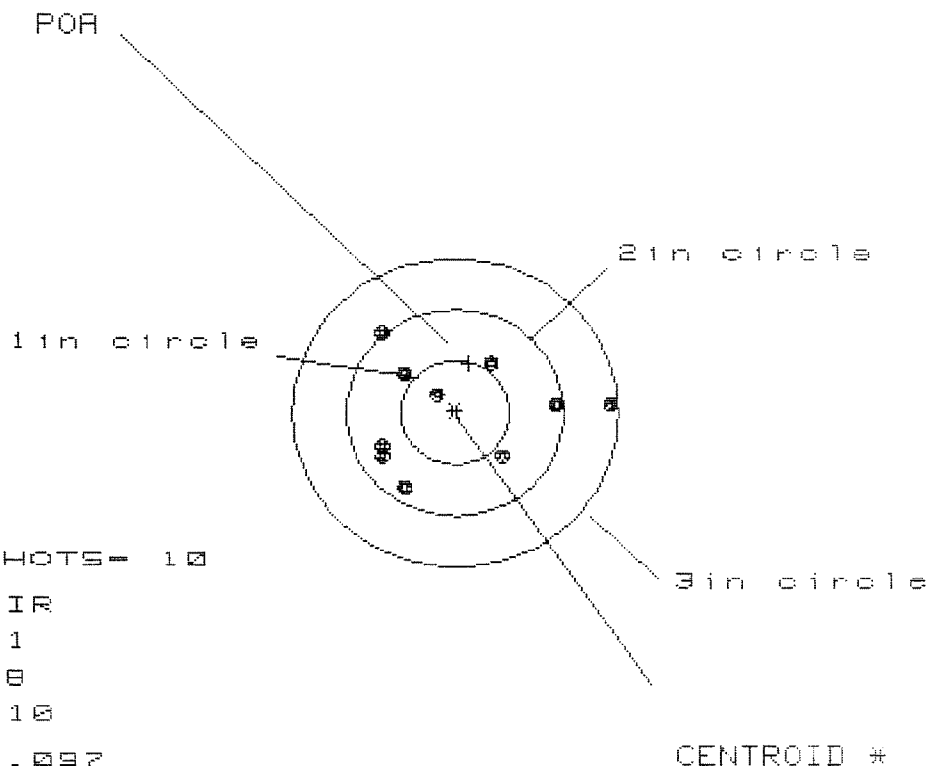
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.656	.556	.470
MINIMUM X	:	-.901	-.694	-.314
MAXIMUM Y	:	1.492	1.102	.957
MINIMUM Y	:	-1.327	-1.161	-.717
CENTROID X	:	-.369	-.269	-.183
CENTROID Y	:	.054	-.112	.033
POA TO CENTROID in.	:	.373	.292	.186
MIN RADIUS	:	.201	.141	.039
MEAN RADIUS	:	.825	.679	.601
MAX RADIUS	:	1.743	1.353	1.066
HORIZONTAL SPREAD	:	1.557	1.250	.784
VERTICAL SPREAD	:	2.819	2.263	1.674
EXTREME SPREAD	:	2.836	2.585	1.818
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 1

2in = 8

3in = 10

HS= 2.097

VS= 1.415

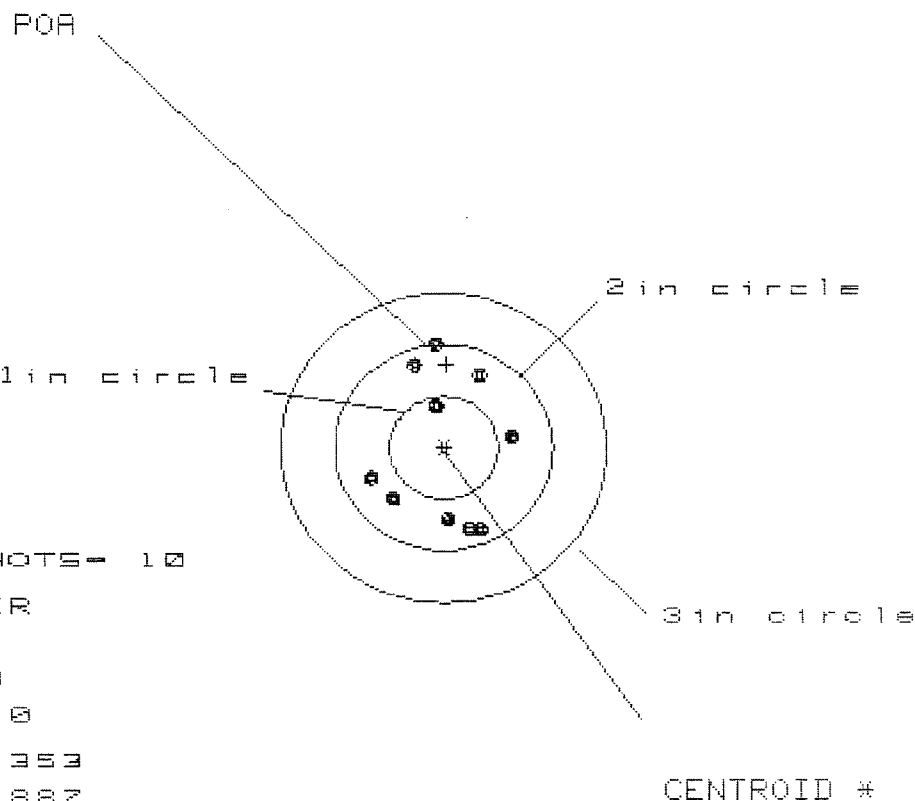
GS= 2.190

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.382	1.099	1.029
MINIMUM X	:	-.715	-.562	-.603
MAXIMUM Y	:	.738	.750	.548
MINIMUM Y	:	-.677	-.665	-.571
CENTROID X	:	-.129	-.282	-.212
CENTROID Y	:	-.478	-.490	-.584
POA TO CENTROID in.	:	.495	.566	.621
MIN RADIUS	:	.256	.212	.315
MEAN RADIUS	:	.782	.690	.665
MAX RADIUS	:	1.386	1.100	1.038
HORIZONTAL SPREAD	:	2.097	1.661	1.632
VERTICAL SPREAD	:	1.415	1.415	1.119
EXTREME SPREAD	:	2.190	1.806	1.666
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



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 9

3 in = 10

HS= 1.353

VS= 1.887

GS= 1.944

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.647	.637	.682
MINIMUM X	:	-.706	-.716	-.671
MAXIMUM Y	:	1.049	.936	.845
MINIMUM Y	:	-.838	-.721	-.733
CENTROID X	:	-.028	-.018	-.063
CENTROID Y	:	-.807	-.924	-.833
POA TO CENTROID in.	:	.807	.924	.836
MIN RADIUS	:	.394	.509	.411
MEAN RADIUS	:	.752	.708	.692
MAX RADIUS	:	1.053	.975	.876
HORIZONTAL SPREAD	:	1.353	1.353	1.353
VERTICAL SPREAD	:	1.887	1.657	1.578
EXTREME SPREAD	:	1.944	1.774	1.648
NUMBER IN ONE INCH CIRCLE	=		1	
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 C6522327

DATE 9-12-90

TESTER JPL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.19	2.30	2.33	2.39	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.21	2.30	2.27	2.39	
PULL #3	2.39	2.32	2.24	2.44	
PULL #4	2.42	2.33	2.29	2.46	
PULL #5	2.27	2.33	2.29	2.50	
TOTAL	11.48	11.58	11.42	12.18	
AVG.	2.296	2.316	2.284	2.436	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.20	3.27		
PULL #2	3.22	3.27		
PULL #3	3.27	3.27		
PULL #4	3.25	3.27		
PULL #5	3.30	3.28		
TOTAL	16.24	16.36		
AVG.	3.248	3.272		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.35	4.28		4.33
PULL #2	4.28	4.15		4.30
PULL #3	4.22	4.27		4.34
PULL #4	4.24	4.34		4.45
PULL #5	4.27	4.31		4.34
TOTAL	21.36	21.35		21.76
AVG.	4.272	4.27		4.352

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522327

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 29	90	RW
600	Proof	6 29	90	RW
607	Check Headspace	6 29	90	RW
610	Dis-assemble Gun	6 29	90	RW
612	Magnaflux Barrel Action		7-12-90	KR
	Magnaflux Bolt		7-12-90	KR
615	Rollmark Caliber		7-12-90	LS
617	Drill and Tap Sight Holes		7/13/90	LB
618	Polish Barrel RB		7/16/90	WB
620	Apply Coatings (Barrel Action)		7-23-90	HA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/25/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/25/90	RW
	C) Inspect Ejector Hole for Chamfer		7/25/90	RW
	D) Oil Firing Pin Ass'y		7/25/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9-12-90	SL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	3	3	3			8/8/90	SL
	G) Safety Off Force	2	2	2			8/8/90	SL
	H) Trigger Pull Test & Retainability						9-12-90	SL
	I) Firing Pin Indent	.0225	.022	.022			8/8/90	SL
	J) Assemble Stock						8/14/90	RW
	K) Assemble Swivel Studs						9/17/90	928
	L) Attach Front and Rear Sight Assemblies						8/14/90	RW
	M) Iron Sight Alignment						8/14/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/14/90	RW
	O) Attach Scope to Rifle						8/14/90	RW
	P) Detach & Attach Scope 20 Times						8/14/90	RW
640	Gallery Target & Test						8/14/90	NE
	A) Time						8/14/90	NE
	B) Malfunctions						8/14/90	NE
	C) Pierced Primers						8/14/90	NE
	D) Optical Clarity of Scope						8/14/90	NE
645	Inspect for Live Ammo						8/14/90	NE
655	Final Inspection							
	A) Headspace						9/13/90	928
	B) Trigger Pull	2.39	2.39	2.44	2.46	2.50	9/12/90	SL
	C) Function						9/13/90	928
660	Pack						9-19-90	DF