

C6522328

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington®

MODEL 700™ M24

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

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

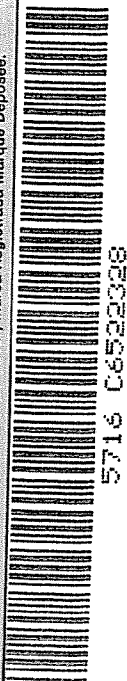
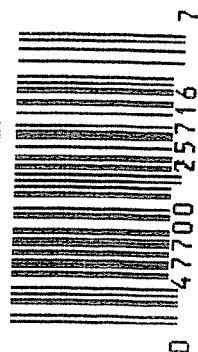
SERIAL NO.
C6522328

ORDER NO.
5716

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

Ø1

UPC



CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522328
30 Jul 1990

CENTROIDAL DISTANCES

0 TO	1	.499009
1 TO	2	.363067
1 TO	3	.275485
1 TO	4	.202921
1 TO	5	.196736

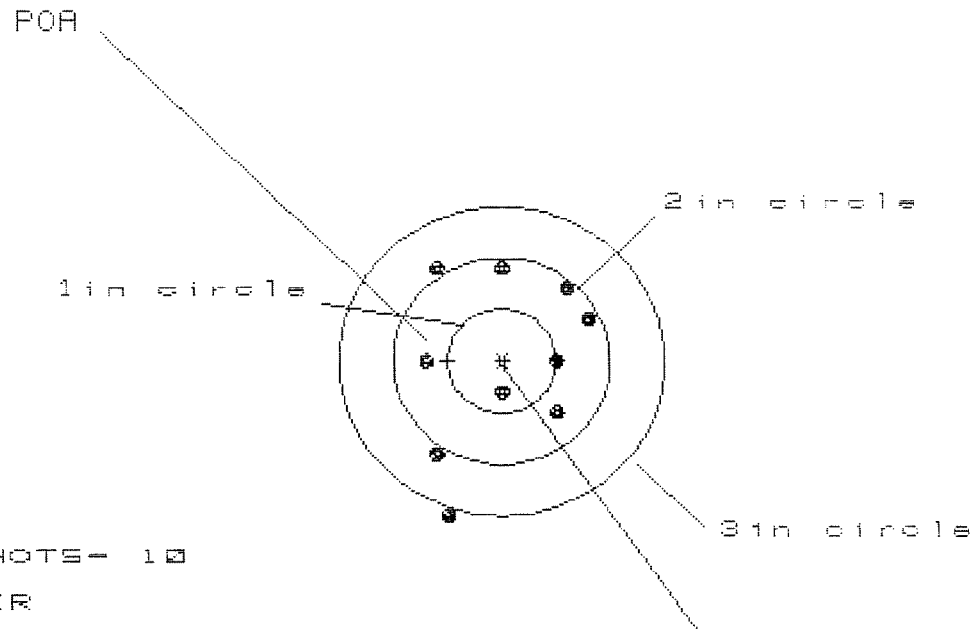
+ $\frac{3}{2}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .5968
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0432
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .598361
THE AMR FOR THIS RIFLE IS: .7972

30 Jul 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6522328

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS= 1.530

VS= 2.388

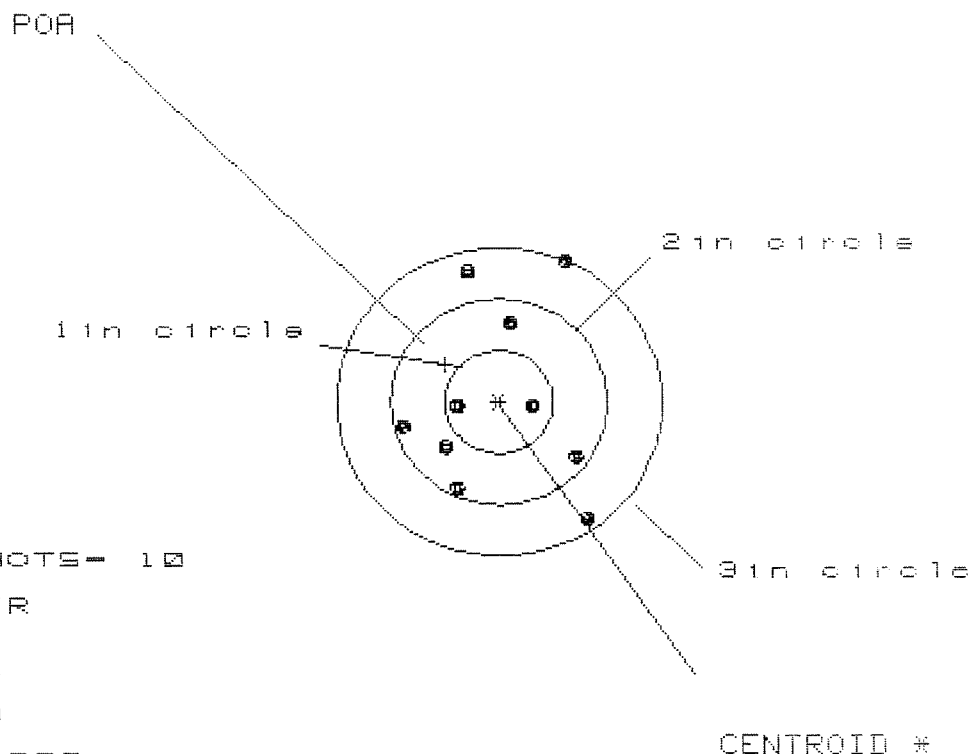
GS= 2.441

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.845	.794	.712
MINIMUM X	-.685	-.736	-.818
MAXIMUM Y	.941	.780	.875
MINIMUM Y	-1.447	-1.021	-.926
CENTROID X	.499	.550	.632
CENTROID Y	-.003	.158	.063
POA TO CENTROID in.	.499	.572	.635
MIN RADIUS	.257	.425	.367
MEAN RADIUS	.864	.785	.738
MAX RADIUS	1.518	1.225	1.197
HORIZONTAL SPREAD	1.530	1.530	1.530
VERTICAL SPREAD	2.388	1.801	1.801
EXTREME SPREAD	2.441	2.027	2.027
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

30 Jul 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522328

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 8

HS= 1.723

VS= 2.497

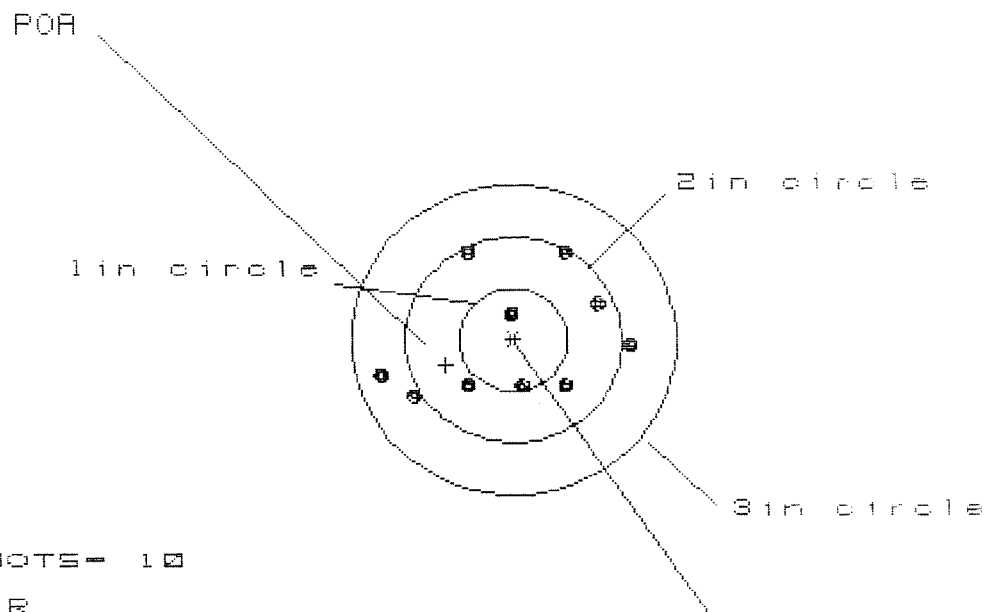
GS= 2.627

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.822	.894	.874
MINIMUM X	:	-.901	-.829	-.717
MAXIMUM Y	:	1.360	1.377	1.253
MINIMUM Y	:	-1.137	-.986	-.827
CENTROID X	:	.492	.420	.308
CENTROID Y	:	-.366	-.517	-.393
POA TO CENTROID in.	:	.613	.666	.500
MIN RADIUS	:	.294	.338	.214
MEAN RADIUS	:	.901	.811	.733
MAX RADIUS	:	1.508	1.400	1.261
HORIZONTAL SPREAD	:	1.723	1.723	1.591
VERTICAL SPREAD	:	2.497	2.363	2.080
EXTREME SPREAD	:	2.627	2.627	2.081
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

30 Jul 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522328

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 2

2in = 6

3in = 10

HS = 2.359

VS = 1.432

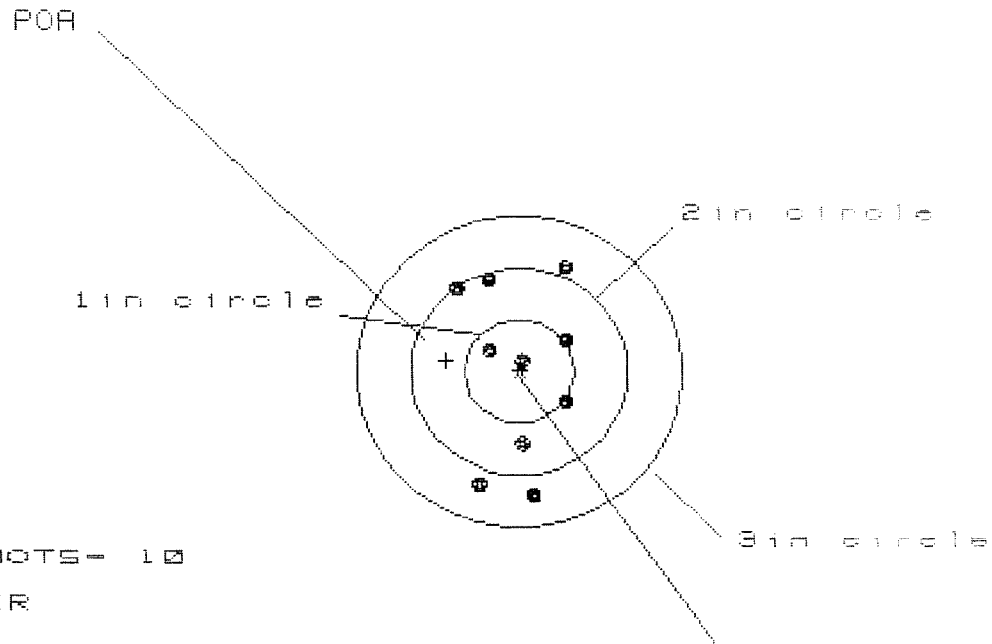
GS = 2.379

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.091	.950	.786
MINIMUM X	:	-1.268	-1.034	-.916
MAXIMUM Y	:	.888	.848	.836
MINIMUM Y	:	-.543	-.584	-.596
CENTROID X	:	.623	.763	.645
CENTROID Y	:	.243	.283	.295
POA TO CENTROID in.	:	.668	.814	.709
MIN RADIUS	:	.284	.295	.236
MEAN RADIUS	:	.831	.767	.736
MAX RADIUS	:	1.319	1.188	1.092
HORIZONTAL SPREAD	:	2.359	1.984	1.702
VERTICAL SPREAD	:	1.432	1.432	1.432
EXTREME SPREAD	:	2.379	2.043	2.006
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

30 Jul 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522328

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 1.020

VS= 2.221

GS= 2.298

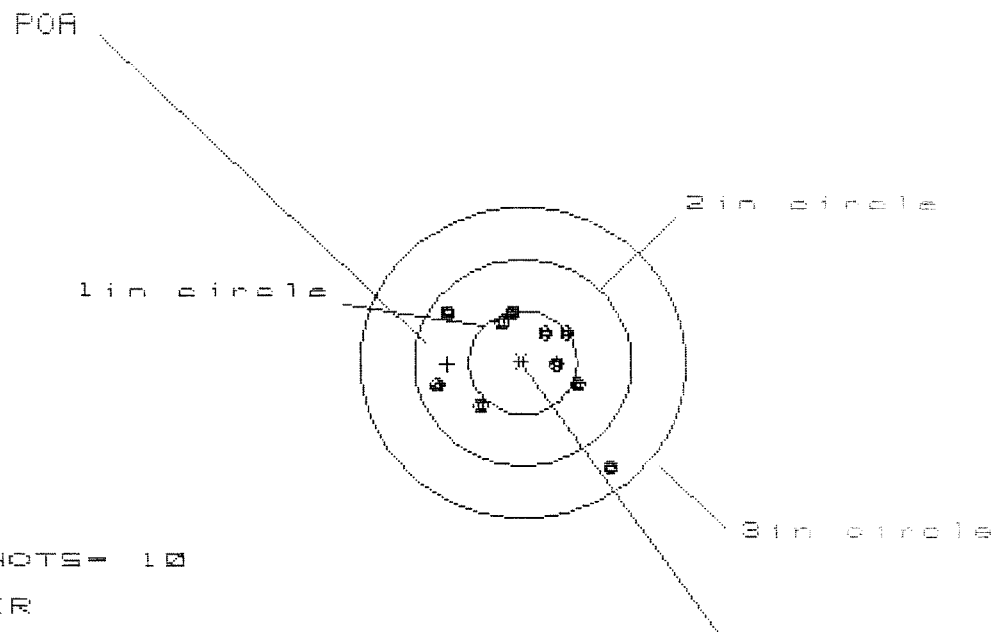
CENTROID #

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.455	.474	.427
MINIMUM X	:	-.565	-.546	-.592
MAXIMUM Y	:	1.016	.882	.726
MINIMUM Y	:	-1.205	-1.254	-.965
CENTROID X	:	.675	.656	.702
CENTROID Y	:	-.104	.030	.186
POA TO CENTROID in.	:	.683	.656	.727
MIN RADIUS	:	.110	.034	.182
MEAN RADIUS	:	.761	.687	.608
MAX RADIUS	:	1.217	1.309	.965
HORIZONTAL SPREAD	:	1.020	1.020	1.020
VERTICAL SPREAD	:	2.221	2.136	1.690
EXTREME SPREAD	:	2.298	2.298	1.738
NUMBER IN ONE INCH CIRCLE =	:	3		
NUMBER IN TWO INCH CIRCLE =	:	7		
NUMBER IN THREE INCH CIRCLE =	:	10		

30 Jul 1990

FILE:/PATTERNING/CENTERFIRE_PATT/06522328

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 9

3 in = 10

HS= 1.628

VS= 1.560

GS= 2.114

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.796	.618	.525
MINIMUM X	:	-.832	-.744	-.704
MAXIMUM Y	:	.507	.390	.351
MINIMUM Y	:	-1.053	-.568	-.607
CENTROID X	:	.695	.607	.700
CENTROID Y	:	.014	.131	.170
POA TO CENTROID in.	:	.695	.621	.720
MIN RADIUS	:	.287	.302	.202
MEAN RADIUS	:	.629	.535	.477
MAX RADIUS	:	1.320	.906	.760
HORIZONTAL SPREAD	:	1.628	1.362	1.229
VERTICAL SPREAD	:	1.560	.958	.958
EXTREME SPREAD	:	2.114	1.379	1.379
NUMBER IN ONE INCH CIRCLE =			3	
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. _____

DATE _____

TESTER _____

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1					MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2					
PULL #3					
PULL #4					
PULL #5					
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1				
PULL #2				
PULL #3				
PULL #4				
PULL #5				
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1				
PULL #2				
PULL #3				
PULL #4				
PULL #5				
TOTAL				
AVG.				

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6522328

DATE 8/22/90

TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.43	2.14	2.16	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.19	2.32	2.37	2.10	
PULL #3	2.35	2.46	2.21	2.11	
PULL #4	2.30	2.23	2.32	2.47	
PULL #5	2.12	2.32	2.30	2.30	
TOTAL	11.36	11.76	11.34	11.13	
AVG.	2.272	2.352	2.268	2.226	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.71	3.40		
PULL #2	3.34	3.23		
PULL #3	3.19	3.35		
PULL #4	3.08	3.19		
PULL #5	3.22	3.27		
TOTAL	15.94	16.44		
AVG.	3.188	3.288		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.17	4.25		4.36
PULL #2	4.49	4.30		4.22
PULL #3	4.50	4.32		4.26
PULL #4	4.32	4.50		4.22
PULL #5	4.19	4.38		4.23
TOTAL	21.67	21.75		21.29
AVG.	4.334	4.35		4.258

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6522328

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/24/90	KJ
600	Proof		6/26/90	KJ
607	Check Headspace		6/26/90	KJ
610	Dis-assemble Gun		6/26/90	KJ
612	Magnaflux Barrel Action		7/10/90	KR
	Magnaflux Bolt		7/10/90	KR
615	Rollmark Caliber		7/10/90	G.S.
617	Drill and Tap Sight Holes		7/4/90	KB
618	Polish Barrel <i>KB</i>		7/13/90	WB
620	Apply Coatings (Barrel Action)		7/23/90	JP
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/25/90	KJ
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/25/90	KJ
	C) Inspect Ejector Hole for Chamfer		7/25/90	KJ
	D) Oil Firing Pin Ass'y		7/25/90	KJ
	E) Adjust Trigger Pull to Min Setting and Stake		8/24/90	GM

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			7/26/90	JK
	G) Safety Off Force	2	3	3			7/26/90	JK
	H) Trigger Pull Test & Retainability						8/22/90	JK
	I) Firing Pin Indent	.0215	.0215	.0215			7/26/90	JK
	J) Assemble Stock						7/27/90	JK
	K) Assemble Swivel Studs						8/29/90	JK
	L) Attach Front and Rear Sight Assemblies						7/27/90	JK
	M) Iron Sight Alignment						7/27/90	JK
	N) Detach Front & Rear Sights & place in numbered container						7/27/90	JK
	O) Attach Scope to Rifle						7/27/90	JK
	P) Detach & Attach Scope 20 Times						7/27/90	JK
640	Gallery Target & Test						7-30-90	AC
	A) Time						7-30-90	AC
	B) Malfunctions						7-30-90	AC
	C) Pierced Primers						7-30-90	AC
	D) Optical Clarity of Scope						7-30-90	AC
645	Inspect for Live Ammo						7-30-90	AC
655	Final Inspection						8/29/90	JK
	A) Headspace						8/29/90	JK
	B) Trigger Pull	2.16	2.10	2.11	2.47	2.30	8/22/90	JK
	C) Function						8/29/90	JK
660	Pack						9/20/90	AF