

C6522336

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



M2400005421

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

Remington®

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

MODEL 700™ H24

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

SERIAL NO.
C6522336

ORDER NO.
5716

01

UPC

0 47700 25716 7

5716 C6522336

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522336

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	KR
	Magnaflux Bolt		7-17-90	KR
615	Rollmark Caliber		7-17-90	G.S.
617	Drill and Tap Sight Holes		7/23/90	RB
618	Polish Barrel RB		7/24/90	WB
620	Apply Coatings (Barrel Action)		7-16-90	JA
	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		8/27/90	JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			8/24/90	WB
	G) Safety Off Force	2	2	2			8/24/90	WB
	H) Trigger Pull Test & Retainability						8/27/90	94
	I) Firing Pin Indent	.022	.022	.022			8/24/90	WB
	J) Assemble Stock						8/27/90	Rw
	K) Assemble Swivel Studs						8/31/90	958
	L) Attach Front and Rear Sight Assemblies						8/27/90	Rw
	M) Iron Sight Alignment						8/27/90	Rw
	N) Detach Front & Rear Sights & place in numbered container						8/27/90	Rw
	O) Attach Scope to Rifle						8/27/90	Rw
	P) Detach & Attach Scope 20 Times						8/27/90	Rw
640	Gallery Target & Test						8-28-90	NF
	A) Time						8-28-90	NF
	B) Malfunctions						8-28-90	NF
	C) Pierced Primers						8-28-90	NF
	D) Optical Clarity of Scope						8-28-90	NF
645	Inspect for Live Ammo						8/20/90	NF
655	Final Inspection							
	A) Headspace						8/31/90	958
	B) Trigger Pull	2.18	2.15	2.10	2.10	2.20	8/30/90	94
	C) Function						8/31/90	958
660	Pack						12/18/90	NF

SWS TRIGGER PULL TEST

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

SERIAL NO 06522336

DATE 8/21/90

TESTER JUL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.45	2.40	2.55	2.18	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.42	2.45	2.46	2.15	
PULL #3	2.43	2.49	2.50	2.10	
PULL #4	2.42	2.47	2.39	2.10	
PULL #5	2.44	2.48	2.47	2.20	
TOTAL	12.16	12.29	12.37	10.73	
AVG.	2.432	2.458	2.474	2.146	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.52	3.39		
PULL #2	3.50	3.41		
PULL #3	3.21	3.45		
PULL #4	3.10	3.44		
PULL #5	3.49	3.47		
TOTAL	16.82	17.16		
AVG.	3.364	3.432		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.25	4.16		4.31
PULL #2	4.08	4.27		4.13
PULL #3	4.13	4.17		4.13
PULL #4	4.16	4.20		4.22
PULL #5	4.18	4.15		4.18
TOTAL	20.80	20.95		20.97
AVG.	4.16	4.19		4.194

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522336
28 Aug 1990

CENTROIDAL DISTANCES

Ø TO	1	.464321
1 TO	2	1.59665
1 TO	3	1.4143
1 TO	4	.669216
1 TO	5	1.34845

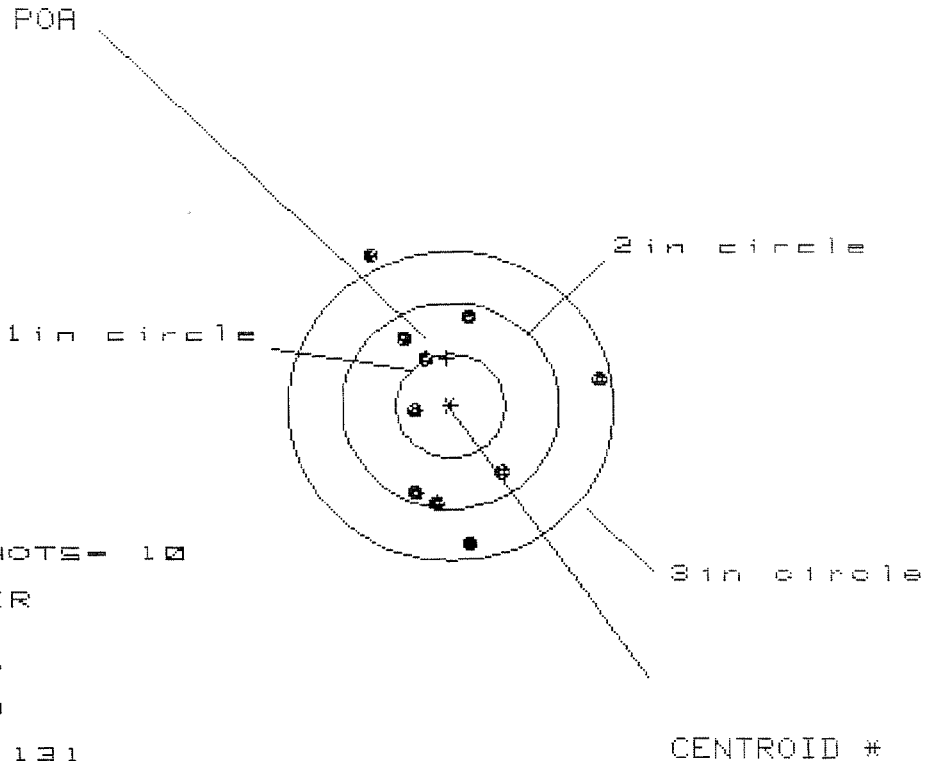
5 2
3
+ 4 <----POA
1

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .7042
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2732
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .755338
THE AMR FOR THIS RIFLE IS: .7846

28 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8522336

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 9

HS= 2.131

VS= 2.863

GS= 2.992

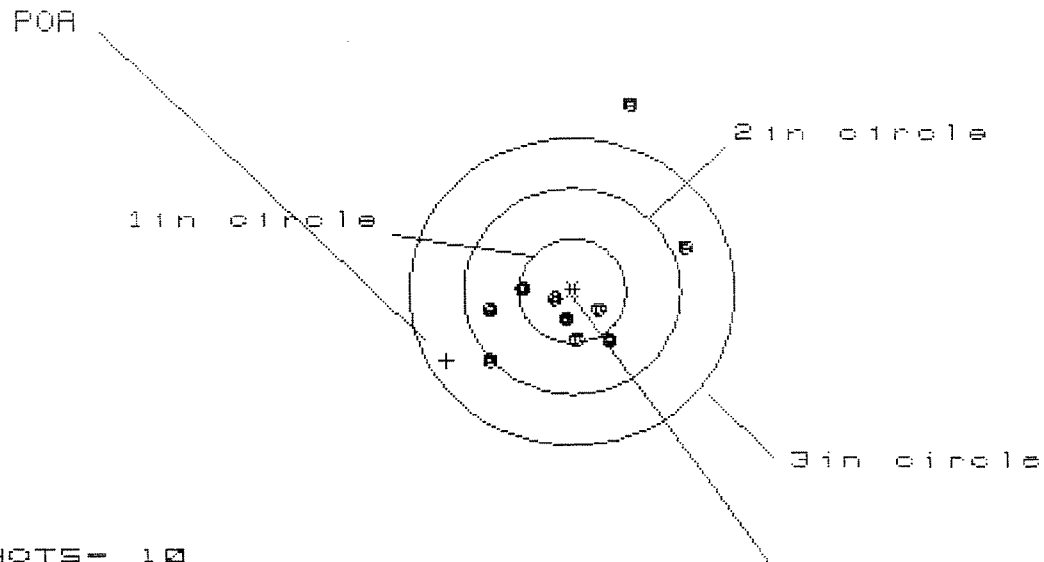
CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.389	1.306	.582
MINIMUM X	:	-.742	-.503	-.340
MAXIMUM Y	:	1.497	1.053	1.112
MINIMUM Y	:	-1.366	-1.200	-1.141
CENTROID X	:	.035	.118	-.045
CENTROID Y	:	-.463	-.629	-.688
POA TO CENTROID in.	:	.464	.640	.690
MIN RADIUS	:	.338	.444	.328
MEAN RADIUS	:	.968	.888	.798
MAX RADIUS	:	1.671	1.389	1.159
HORIZONTAL SPREAD	:	2.131	1.809	.922
VERTICAL SPREAD	:	2.863	2.253	2.253
EXTREME SPREAD	:	2.992	2.253	2.253
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	9		

25 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522336

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 5

2in = 7

3in = 9

HS= 1.872

VS= 2.466

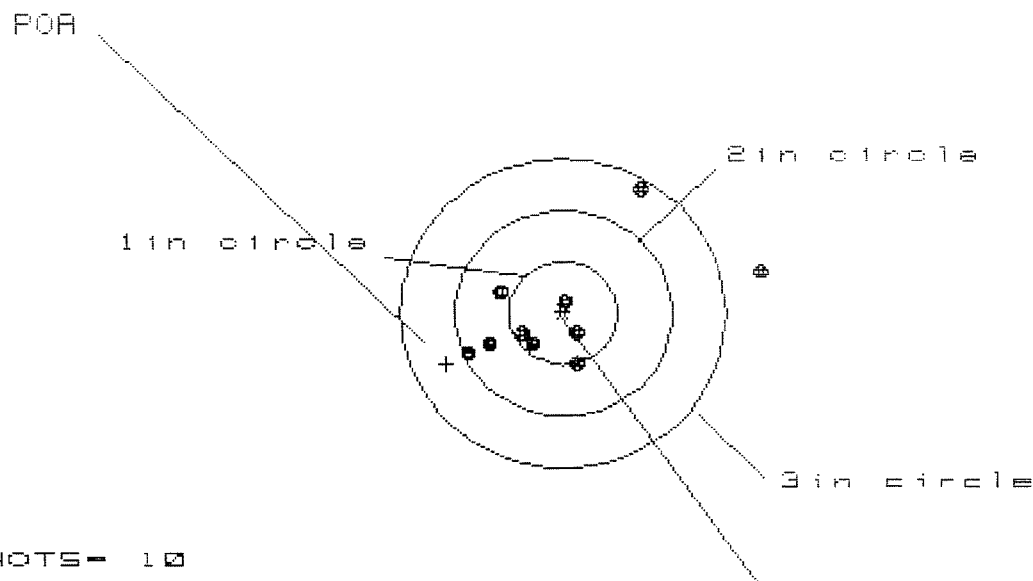
GS= 2.819

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.066	1.129	.571
MINIMUM X	:	-.806	-.743	-.602
MAXIMUM Y	:	1.814	.645	.274
MINIMUM Y	:	-.652	-.451	-.370
CENTROID X	:	1.162	1.099	.958
CENTROID Y	:	.668	.467	.386
POA TO CENTROID in.	:	1.340	1.194	1.033
MIN RADIUS	:	.159	.063	.112
MEAN RADIUS	:	.716	.522	.426
MAX RADIUS	:	1.898	1.300	.707
HORIZONTAL SPREAD	:	1.872	1.872	1.173
VERTICAL SPREAD	:	2.466	1.096	.644
EXTREME SPREAD	:	2.819	2.169	1.181
NUMBER IN ONE INCH CIRCLE =			5	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			9	

28 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8522936

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 4

2in = 8

3in = 9

HS= 2.640

VS= 1.766

GS= 2.773

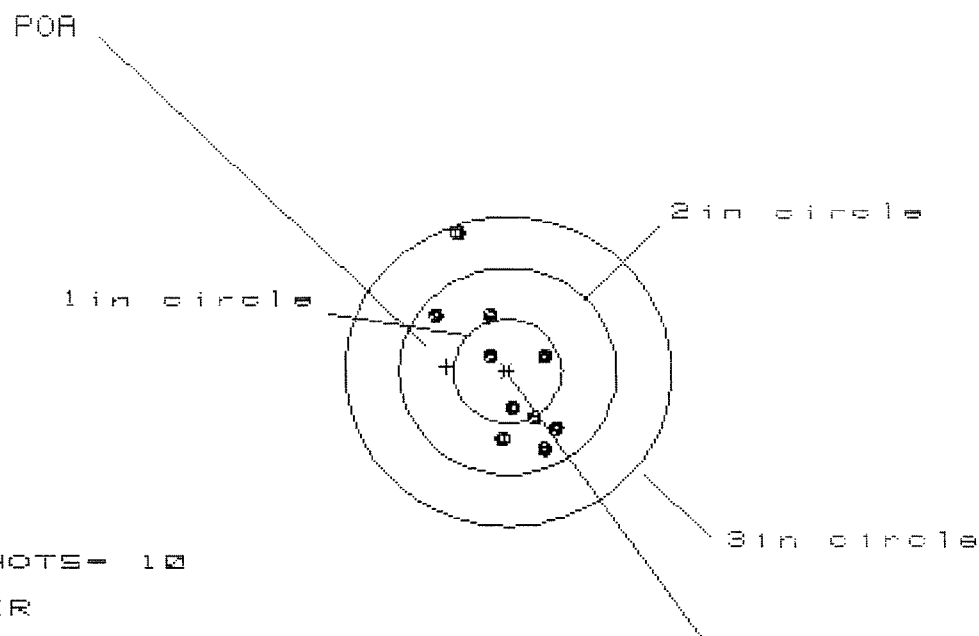
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.771	.910	.465
MINIMUM X	:	-.869	-.672	-.558
MAXIMUM Y	:	1.244	1.290	.454
MINIMUM Y	:	-.522	-.476	-.315
CENTROID X	:	1.080	.883	.769
CENTROID Y	:	.490	.444	.283
POA TO CENTROID in.	:	1.186	.988	.820
MIN RADIUS	:	.083	.261	.104
MEAN RADIUS	:	.728	.562	.386
MAX RADIUS	:	1.819	1.579	.603
HORIZONTAL SPREAD	:	2.640	1.582	1.023
VERTICAL SPREAD	:	1.766	1.766	.769
EXTREME SPREAD	:	2.773	2.306	1.037
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

26 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8522336

CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 9

3 in = 10

HS = 1.087

VS = 2.042

GS = 2.177

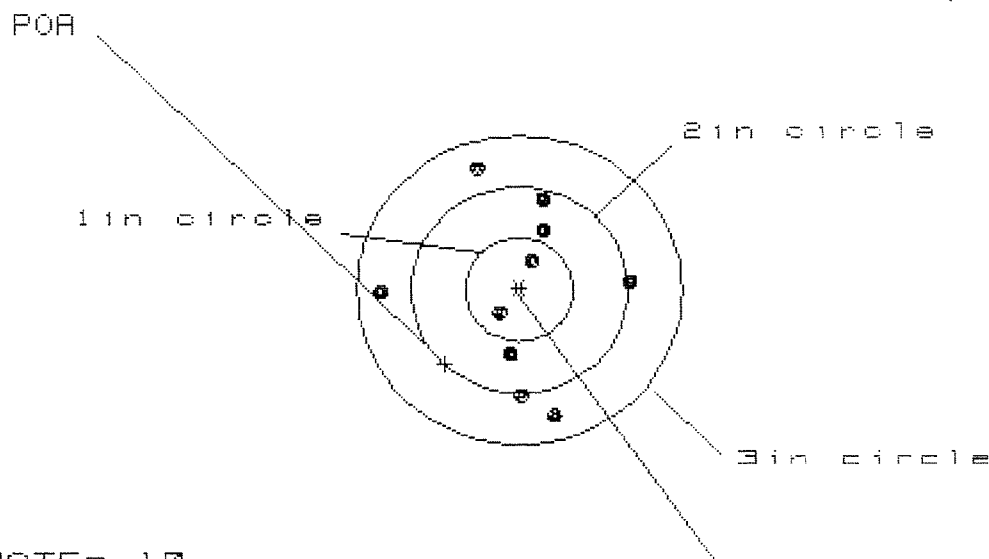
CENTROID #

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.442	.395	.309
MINIMUM X	-.645	-.692	-.334
MAXIMUM Y	1.325	.741	.824
MINIMUM Y	-.717	-.570	-.487
CENTROID X	.560	.607	.693
CENTROID Y	-.048	-.195	-.278
POA TO CENTROID in.	.562	.637	.747
MIN RADIUS	.243	.253	.186
MEAN RADIUS	.650	.538	.457
MAX RADIUS	1.390	.959	.867
HORIZONTAL SPREAD	1.087	1.087	.643
VERTICAL SPREAD	2.042	1.311	1.311
EXTREME SPREAD	2.177	1.576	1.393
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	

28 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522336

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 10

HS= 2.272

VS= 2.425

GS= 2.515

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.030	.990	1.023
MINIMUM X	:	-1.242	-1.282	-1.249
MAXIMUM Y	:	1.211	.999	.864
MINIMUM Y	:	-1.214	-1.080	-.993
CENTROID X	:	.684	.724	.691
CENTROID Y	:	.719	.585	.720
POA TO CENTROID in.	:	.993	.931	.998
MIN RADIUS	:	.318	.258	.319
MEAN RADIUS	:	.861	.810	.762
MAX RADIUS	:	1.263	1.288	1.249
HORIZONTAL SPREAD	:	2.272	2.272	2.272
VERTICAL SPREAD	:	2.425	2.079	1.857
EXTREME SPREAD	:	2.515	2.276	2.276
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			10	