

C6498795

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.

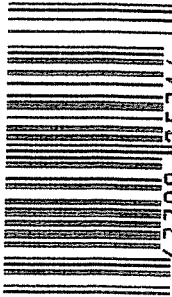
MODEL 700™ H24

SERIAL NO.
C6498795

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 C6498795

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6498795

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	5 17	90	RW
600	Proof	5 17	90	RW
607	Check Headspace	5 17	90	RW
610	Dis-assemble Gun	5 17	90	RW
612	Magnaflux Barrel Action		5/22/90	KCR
	Magnaflux Bolt		5/22/90	KCR
615	Rollmark Caliber		5/22/90	B.S.
617	Drill and Tap Sight Holes		5/23/90	FB
618	Polish Barrel RB		5/24/90	WB
620	Apply Coatings (Barrel Action)		6-4-90	TA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		6/12/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6/12/90	RW
	C) Inspect Ejector Hole for Chamfer		6/12/90	RW
	D) Oil Firing Pin Ass'y		6/12/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/15/90	JH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			7/24/90	RL
	G) Safety Off Force	3	3	3			7/24/90	RL
	H) Trigger Pull Test & Retainability						8/15/90	RL
	I) Firing Pin Indent	.022	.0235	.023			7/24/90	RL
	J) Assemble Stock						7/25/90	RW
	K) Assemble Swivel Studs						8/24/90	LD
	L) Attach Front and Rear Sight Assemblies						7/25/90	RW
	M) Iron Sight Alignment						7/25/90	RW
	N) Detach Front & Rear Sights & place in numbered container						7/25/90	RW
	O) Attach Scope to Rifle						7/25/90	RW
	P) Detach & Attach Scope 20 Times						7/25/90	RW
640	Gallery Target & Test						7-30-90	DH
	A) Time						7-30-90	DH
	B) Malfunctions						7-30-90	DH
	C) Pierced Primers						7-30-90	DH
	D) Optical Clarity of Scope						7-30-90	DH
645	Inspect for Live Ammo						7-30-90	DH
655	Final Inspection							
	A) Headspace						8/29/90	LD
	B) Trigger Pull	2.55	2.50	2.27	2.20	2.39	8/15/90	RL
	C) Function						8/29/90	LD
660	Pack						9/20/90	RF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6498795

DATE 8/15/90

TESTER JJP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.36	2.40	2.59	2.55	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.33	2.46	2.43	2.50	
PULL #3	2.41	2.45	2.50	2.29	
PULL #4	2.44	2.41	2.45	2.20	
PULL #5	2.45	2.45	2.51	2.39	
TOTAL	11.99	12.17	12.48	11.91	
AVG.	2.398	2.434	2.496	2.382	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.29	3.29		
PULL #2	3.33	3.29		
PULL #3	3.28	3.29		
PULL #4	3.27	3.34		
PULL #5	3.29	3.35		
TOTAL	16.46	16.56		
AVG.	3.292	3.312		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.30	4.13		4.20
PULL #2	4.22	4.34		4.38
PULL #3	4.25	4.30		4.28
PULL #4	4.28	4.29		4.31
PULL #5	4.31	4.21		4.35
TOTAL	21.36	21.27		21.52
AVG.	4.272	4.254		4.304

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6498795
30 Jul 1990

CENTROIDAL DISTANCES

0 TO	1	.255566
1 TO	2	.2628
1 TO	3	.705284
1 TO	4	.476038
1 TO	5	.873698

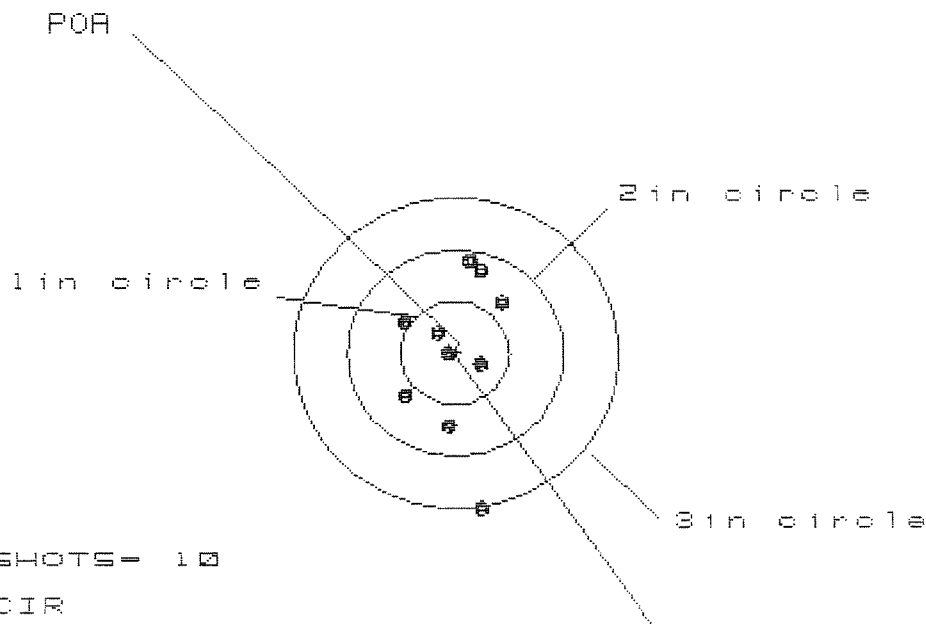
$\frac{24^4}{3} \times \text{---POA}$

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0694
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0406
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0804035
THE AMR FOR THIS RIFLE IS: .7526

30 Jul 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6498795

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 3

2in = 9

3in = 9

HS= .924

VS= 2.387

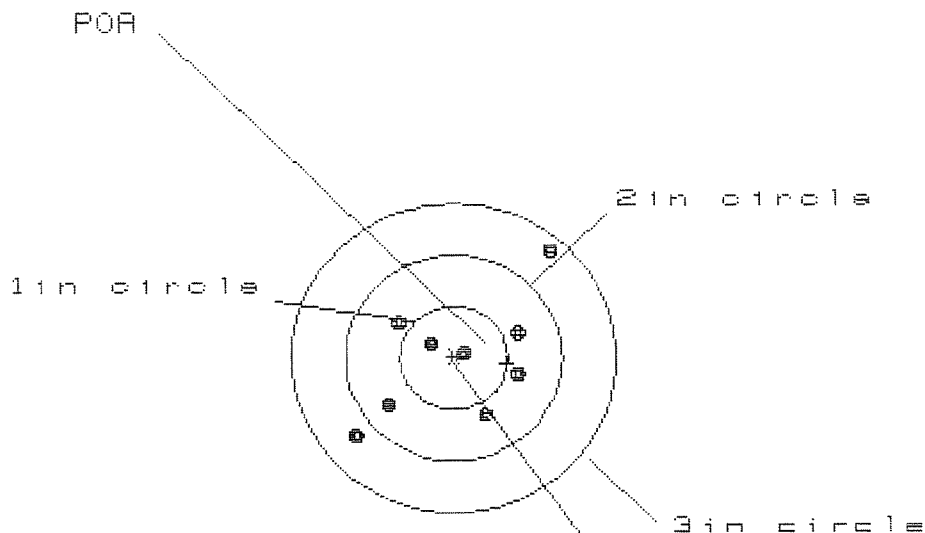
GS= 2.387

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.433	.454	.492
MINIMUM X	-.491	-.470	-.432
MAXIMUM Y	.862	.693	.776
MINIMUM Y	-1.525	-.878	-.795
CENTROID X	-.233	-.254	-.292
CENTROID Y	.105	.274	.191
POA TO CENTROID in.	.256	.374	.349
MIN RADIUS	.100	.117	.062
MEAN RADIUS	.631	.514	.471
MAX RADIUS	1.536	.879	.801
HORIZONTAL SPREAD	.924	.924	.924
VERTICAL SPREAD	2.387	1.571	1.571
EXTREME SPREAD	2.387	1.585	1.585
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	9		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.777

VS= 1.855

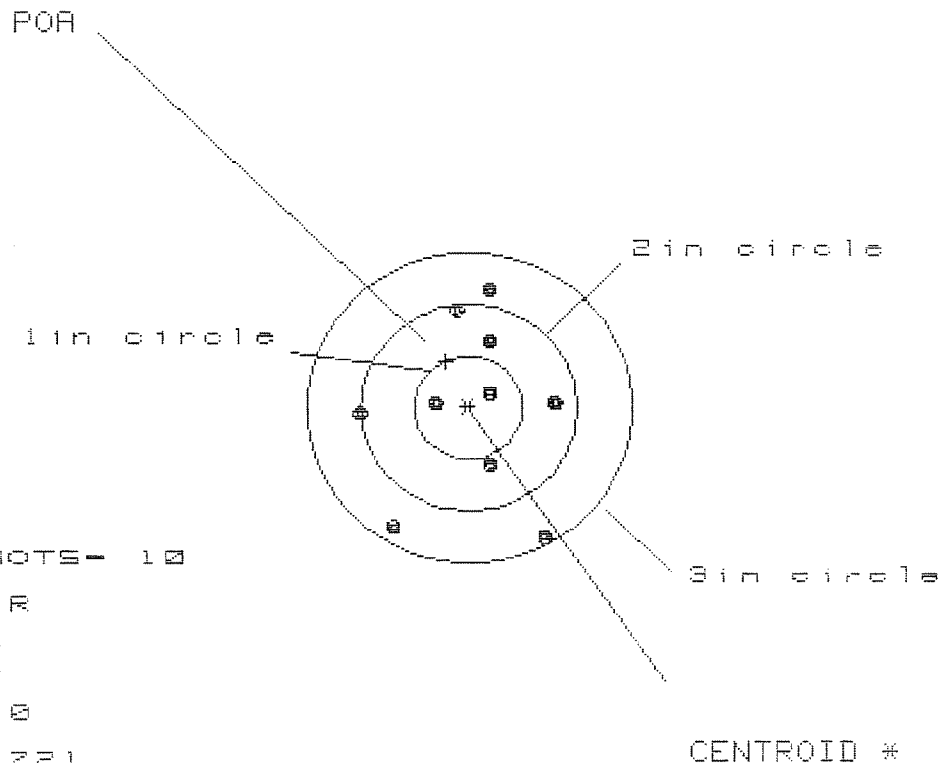
GS= 2.569

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.863	.680	.578
MINIMUM X	:	-.914	-.819	-.660
MAXIMUM Y	:	1.076	.493	.411
MINIMUM Y	:	-.779	-.659	-.540
CENTROID X	:	-.491	-.586	-.484
CENTROID Y	:	.055	-.065	.017
POA TO CENTROID in.	:	.494	.590	.484
MIN RADIUS	:	.113	.238	.111
MEAN RADIUS	:	.648	.579	.491
MAX RADIUS	:	1.379	1.051	.805
HORIZONTAL SPREAD	:	1.777	1.499	1.238
VERTICAL SPREAD	:	1.855	1.152	.951
EXTREME SPREAD	:	2.569	1.825	1.451
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 1.721

VS= 2.391

GS= 2.467

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.746	.822	.740
MINIMUM X	:	-.975	-.899	-.981
MAXIMUM Y	:	1.129	.989	.825
MINIMUM Y	:	-1.262	-1.313	-.845
CENTROID X	:	.206	.130	.212
CENTROID Y	:	-.447	-.307	-.143
POA TO CENTROID in.	:	.492	.333	.255
MIN RADIUS	:	.295	.301	.246
MEAN RADIUS	:	.855	.774	.662
MAX RADIUS	:	1.435	1.467	1.051
HORIZONTAL SPREAD	:	1.721	1.721	1.721
VERTICAL SPREAD	:	2.391	2.302	1.669
EXTREME SPREAD	:	2.467	2.467	1.728
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 10

HS= 2.016

VS= 2.198

GS= 2.415

CENTROID *

PATTERN #

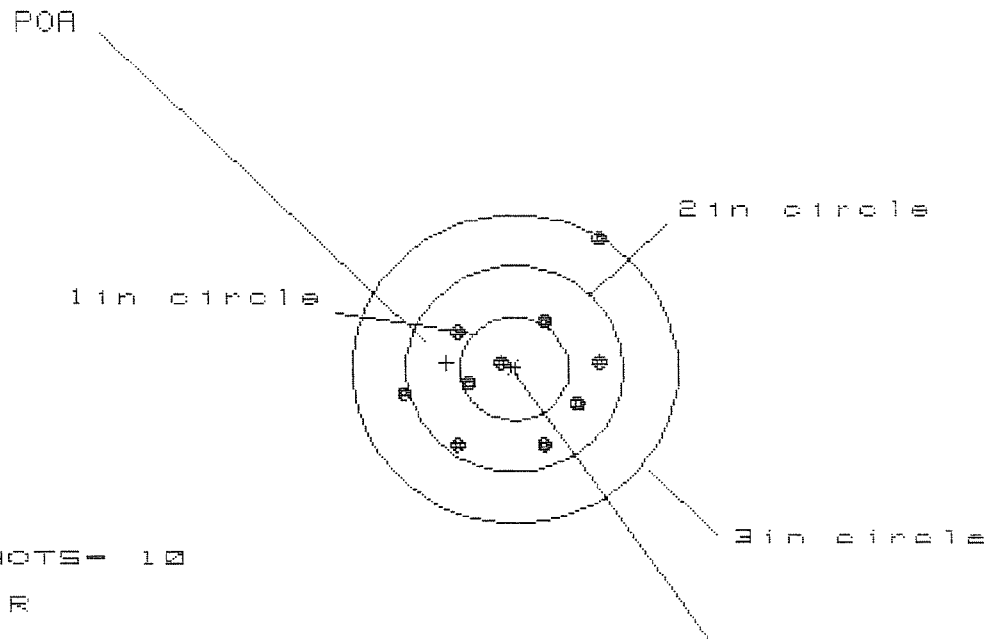
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SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.045	1.069	1.003
MINIMUM X	:	-.971	-.947	-1.013
MAXIMUM Y	:	1.482	1.435	.604
MINIMUM Y	:	-.715	-.551	-.371
CENTROID X	:	.241	.217	.283
CENTROID Y	:	.149	-.015	-.195
POA TO CENTROID in.	:	.283	.218	.343
MIN RADIUS	:	.322	.200	.068
MEAN RADIUS	:	.880	.776	.646
MAX RADIUS	:	1.498	1.528	1.023
HORIZONTAL SPREAD	:	2.016	2.016	2.016
VERTICAL SPREAD	:	2.198	1.986	.975
EXTREME SPREAD	:	2.415	2.415	2.018
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.828

VS= 2.018

GS= 2.416

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.808	.895	.778
MINIMUM X	:	-1.020	-.933	-.588
MAXIMUM Y	:	1.254	.566	.558
MINIMUM Y	:	-.763	-.624	-.632
CENTROID X	:	.624	.537	.654
CENTROID Y	:	-.065	-.204	-.196
POA TO CENTROID in.	:	.627	.575	.683
MIN RADIUS	:	.147	.210	.255
MEAN RADIUS	:	.749	.659	.622
MAX RADIUS	:	1.476	.936	.858
HORIZONTAL SPREAD	:	1.828	1.828	1.366
VERTICAL SPREAD	:	2.018	1.190	1.190
EXTREME SPREAD	:	2.416	1.843	1.573
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			10	