

C6498801

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6498801

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	FB
618	Polish Barrel RB		7/16/90	WB
620	Apply Coatings (Barrel Action)		7-23-90	JA
	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		9-11-90	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			8/9/90	JK
	G) Safety Off Force	3	3	3			8/9/90	JK
	H) Trigger Pull Test & Retainability						9-11-90	JK
	I) Firing Pin Indent	.022	.022	.022			8/9/90	JK
	J) Assemble Stock						8/13/90	RW
	K) Assemble Swivel Studs						9/12/90	JK
	L) Attach Front and Rear Sight Assemblies						8/13/90	RW
	M) Iron Sight Alignment						8/13/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/13/90	RW
	O) Attach Scope to Rifle						8/13/90	RW
	P) Detach & Attach Scope 20 Times						8/13/90	RW
640	Gallery Target & Test						8/13/90	NF
	A) Time						8/13/90	NF
	B) Malfunctions						8/13/90	NF
	C) Pierced Primers						8/13/90	NF
	D) Optical Clarity of Scope						8/13/90	NF
645	Inspect for Live Ammo						8/13/90	NF
655	Final Inspection							
	A) Headspace						9/12/90	JK
	B) Trigger Pull	2-36	2.33	2.39	2.38	2.34	9-11-90	JK
	C) Function						9/12/90	JK
660	Pack						9/19/90	NF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6498801

DATE 9-11-90

TESTER J21

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.21	2.33	2.37	2.36	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.17	2.26	2.35	2.33	
PULL #3	2.34	2.32	2.35	2.39	
PULL #4	2.29	2.35	2.36	2.38	
PULL #5	2.32	2.32	2.23	2.34	
TOTAL	11.33	11.58	11.66	11.80	
AVG.	2.266	2.316	2.332	2.36	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.26	3.24		
PULL #2	3.11	3.24		
PULL #3	3.22	3.26		
PULL #4	3.22	3.24		
PULL #5	3.24	3.24		
TOTAL	16.05	16.22		
AVG.	3.21	3.244		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.18	4.46		4.21
PULL #2	4.17	4.26		4.23
PULL #3	4.19	4.27		4.23
PULL #4	4.45	4.22		4.22
PULL #5	4.43	4.20		4.27
TOTAL	21.42	21.41		21.16
AVG.	4.284	4.282		4.232

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6498801
14 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.122984
1 TO	2	.601739
1 TO	3	.732085
1 TO	4	.159248
1 TO	5	.249281

415 (----POA
2 3

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0096
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.3406
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .340735
THE AMR FOR THIS RIFLE IS: .8066

13 Aug 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6498881

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 5

2 in = 7

3 in = 9

HS= 2.041

VS= 1.842

GS= 2.598

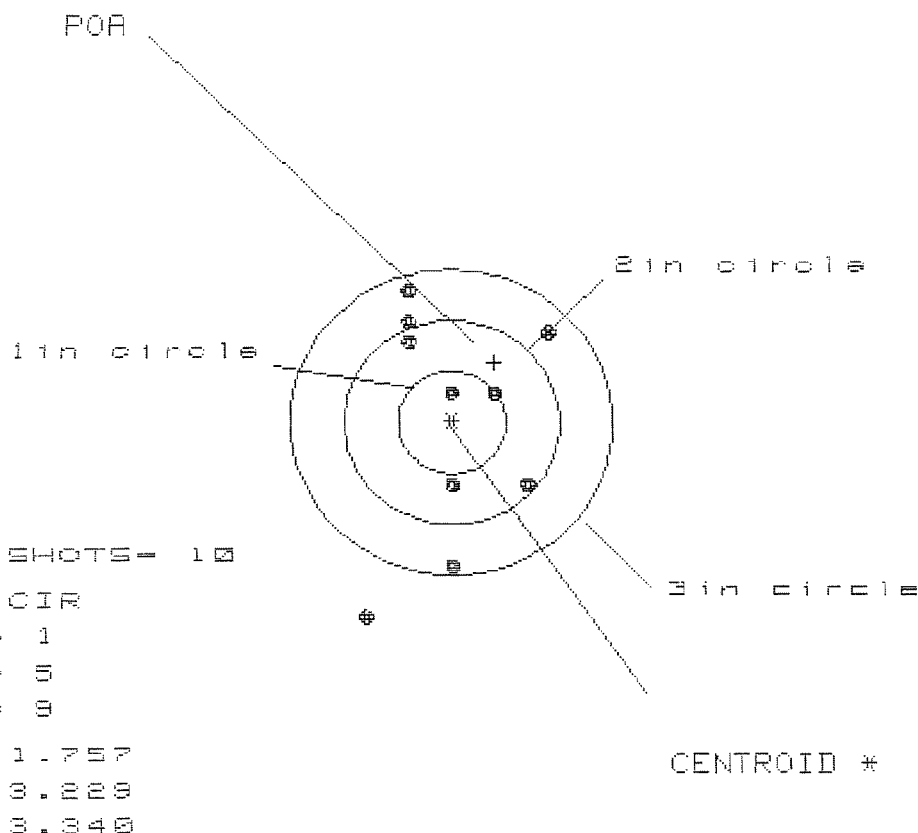
CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.241	.877	.602
MINIMUM X	:	-.800	-.662	-.553
MAXIMUM Y	:	1.136	1.236	.698
MINIMUM Y	:	-.706	-.606	-.452
CENTROID X	:	-.022	-.160	-.269
CENTROID Y	:	-.121	-.221	-.375
POA TO CENTROID in.	:	.123	.272	.462
MIN RADIUS	:	.175	.051	.099
MEAN RADIUS	:	.723	.579	.430
MAX RADIUS	:	1.533	1.515	.714
HORIZONTAL SPREAD	:	2.041	1.539	1.155
VERTICAL SPREAD	:	1.842	1.842	1.150
EXTREME SPREAD	:	2.598	2.400	1.253
NUMBER IN ONE INCH CIRCLE	=	5		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	9		

13 Aug 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8498801

CENTERFIRE PATTERNS # 2



PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.907	.813	.806
MINIMUM X	:	-.850	-.539	-.546
MAXIMUM Y	:	1.303	1.089	.880
MINIMUM Y	:	-1.926	-1.672	-1.019
CENTROID X	:	-.399	-.305	-.298
CENTROID Y	:	-.590	-.376	-.167
POA TO CENTROID in.	:	.713	.484	.342
MIN RADIUS	:	.329	.142	.129
MEAN RADIUS	:	1.056	.887	.762
MAX RADIUS	:	2.105	1.673	1.205
HORIZONTAL SPREAD	:	1.757	1.352	1.352
VERTICAL SPREAD	:	3.229	2.761	1.899
EXTREME SPREAD	:	3.340	2.803	2.241
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

13 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6498381

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 4

2 in = 8

3 in = 10

HS= 1.712

VS= 1.925

GS= 1.925

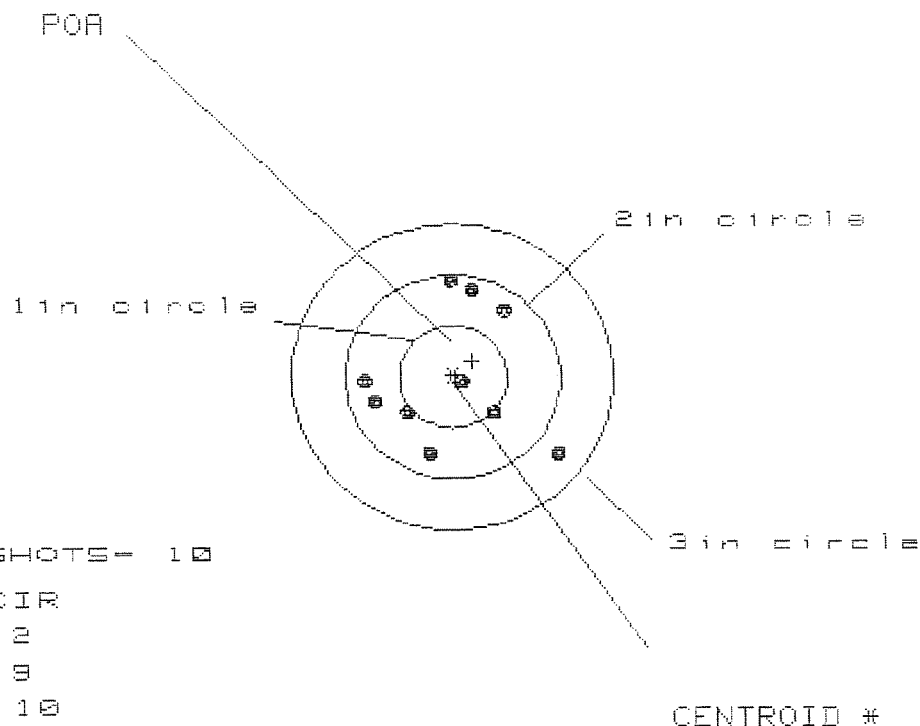
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.899	.444	.465
MINIMUM X	:	-.813	-.713	-.692
MAXIMUM Y	:	1.095	1.169	.696
MINIMUM Y	:	-.830	-.756	-.610
CENTROID X	:	.328	.228	.207
CENTROID Y	:	-.764	-.838	-.984
POA TO CENTROID in.	:	.832	.868	1.005
MIN RADIUS	:	.164	.250	.270
MEAN RADIUS	:	.673	.609	.517
MAX RADIUS	:	1.116	1.181	.809
HORIZONTAL SPREAD	:	1.712	1.157	1.157
VERTICAL SPREAD	:	1.925	1.925	1.306
EXTREME SPREAD	:	1.925	1.925	1.358
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

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FILE:/PATTERNING/CENTERFIRE_PATT/C6498801

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 9

3in = 10

HS= 1.848

VS= 1.763

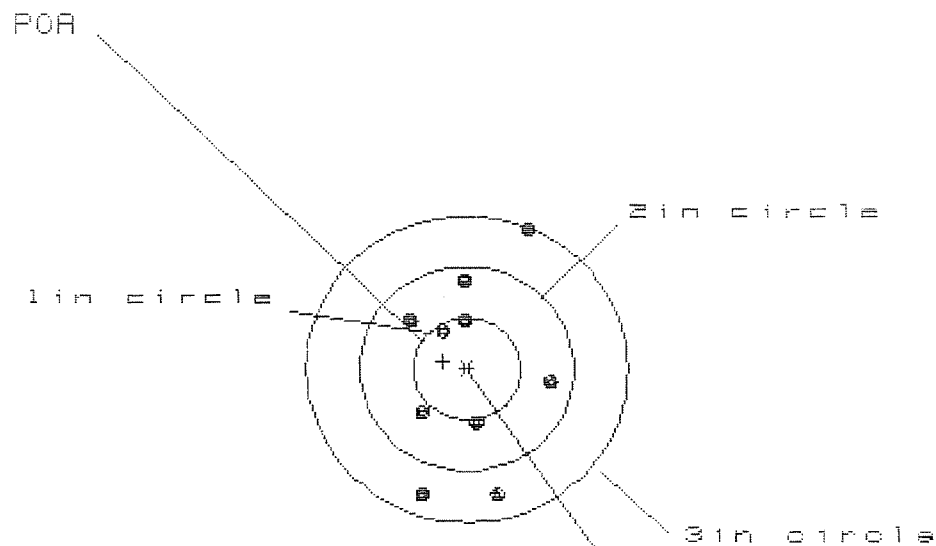
GS= 1.981

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.026	.623	.640
MINIMUM X	:	-.822	-.708	-.691
MAXIMUM Y	:	.996	.916	.845
MINIMUM Y	:	-.768	-.847	-.733
CENTROID X	:	-.178	-.292	-.309
CENTROID Y	:	-.153	-.073	-.188
POA TO CENTROID in.	:	.234	.301	.362
MIN RADIUS	:	.031	.166	.166
MEAN RADIUS	:	.734	.682	.633
MAX RADIUS	:	1.251	.927	.928
HORIZONTAL SPREAD	:	1.848	1.331	1.331
VERTICAL SPREAD	:	1.763	1.763	1.577
EXTREME SPREAD	:	1.981	1.776	1.617
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS= 1.376

VS= 2.644

GS= 2.814

CENTROID *

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.812	.874	.824
MINIMUM X	-.564	-.502	-.552
MAXIMUM Y	1.374	.988	.851
MINIMUM Y	-1.270	-1.117	-1.254
CENTROID X	.223	.161	.211
CENTROID Y	-.075	-.228	-.091
POA TO CENTROID in.	.236	.279	.230
MIN RADIUS	.376	.360	.385
MEAN RADIUS	.847	.772	.707
MAX RADIUS	1.484	1.165	1.283
HORIZONTAL SPREAD	1.376	1.376	1.376
VERTICAL SPREAD	2.644	2.105	2.105
EXTREME SPREAD	2.814	2.130	2.130
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

Remington.



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

MODEL 700TM M24

SERIAL NO.
C6498801

ORDER NO.
5716

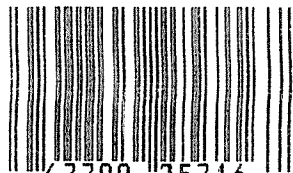
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UPC



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KINZER V. REMINGTON

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