

C6594538

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington.



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

MODEL 700™ M24

SERIAL NO.
C6594538

ORDER NO.
5716

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

20



5716 C6594538

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6594538

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		12/27/90	K.S.
600	Proof		12/27/90	K.S.
607	Check Headspace		12/27/90	K.S.
610	Dis-assemble Gun		12/27/90	K.S.
612	Magnaflux Barrel Action		1/9/91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	G.S.
617	Drill and Tap Sight Holes	1 10 91		LB
618	Polish Barrel	1 10 91		WB
620	Apply Coatings (Barrel Action)		1-27-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/4/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/4/91	KA
	C) Inspect Ejector Hole for Chamfer		2/4/91	KA
	D) Oil Firing Pin Ass'y		2/4/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		2/8/91	KA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 3/4	5 3/4	5 3/4			2/8/91	WLB
	G) Safety Off Force	3	3	3			2/8/91	WLB
	H) Trigger Pull Test & Retainability						2/8/91	JH
	I) Firing Pin Indent	.021	.0205	.021			2/8/91	WLB
	J) Assemble Stock						2/8/91	KH
	K) Assemble Swivel Studs						2-26-91	KH
	L) Attach Front and Rear Sight Assemblies						2/8/91	KH
	M) Iron Sight Alignment						2/8/91	KH
	N) Detach Front & Rear Sights & place in numbered container						2/8/91	KH
	O) Attach Scope to Rifle						2/8/91	KH
	P) Detach & Attach Scope 20 Times						2/5/91	KH
640	Gallery Target & Test						2-11-91	DH
	A) Time						2-11-91	DH
	B) Malfunctions						2-11-91	DH
	C) Pierced Primers						2-11-91	DH
	D) Optical Clarity of Scope						2-11-91	DH
645	Inspect for Live Ammo						2-11-91	DH
655	Final Inspection							
	A) Headspace						2-26-91	KH
	B) Trigger Pull	2.18	2.25	2.18	2.22	2.31	2/25/91	JH
	C) Function						2-26-91	KH
660	Pack						3-18-91	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6594538

DATE 2/8/91

TESTER JF

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.33	2.34	2.30	2.18	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.33	2.20	2.38	2.25	
PULL #3	2.52	2.34	2.39	2.18	
PULL #4	2.51	2.39	2.40	2.22	
PULL #5	2.43	2.31	2.40	2.31	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.18	3.41		
PULL #2	3.45	3.49		
PULL #3	3.23	3.42		
PULL #4	3.37	3.50		
PULL #5	3.43	3.45		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.53	4.10		4.14
PULL #2	4.43	4.26		4.36
PULL #3	4.45	4.44		4.29
PULL #4	4.48	4.15		4.45
PULL #5	4.51	4.48		4.45
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594538
12 Feb 1991

CENTROIDAL DISTANCES

0 TO	1	.13369
1 TO	2	.08
1 TO	3	.120308
1 TO	4	.0214709
1 TO	5	.0638122

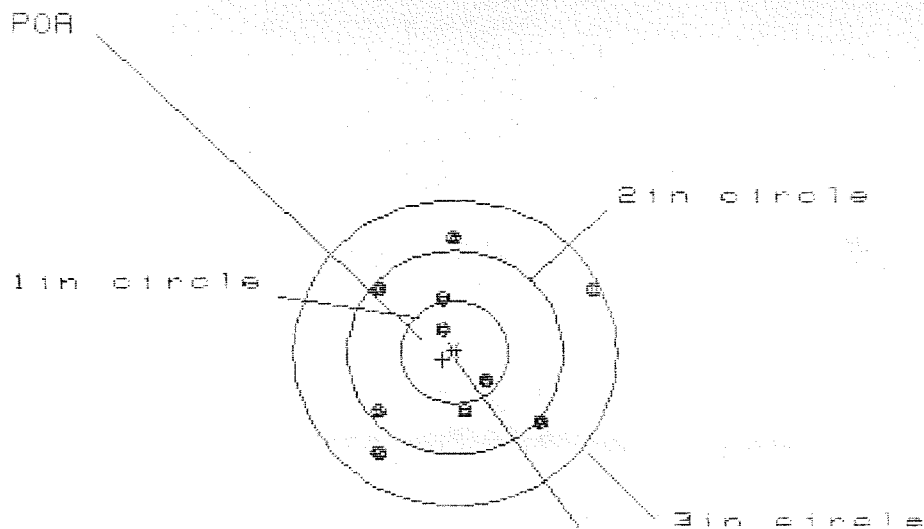
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1446
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0526
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .15387
THE AMR FOR THIS RIFLE IS: .8794

12 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8594538

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 10

HS= 2.009

VS= 2.117

GS= 2.544

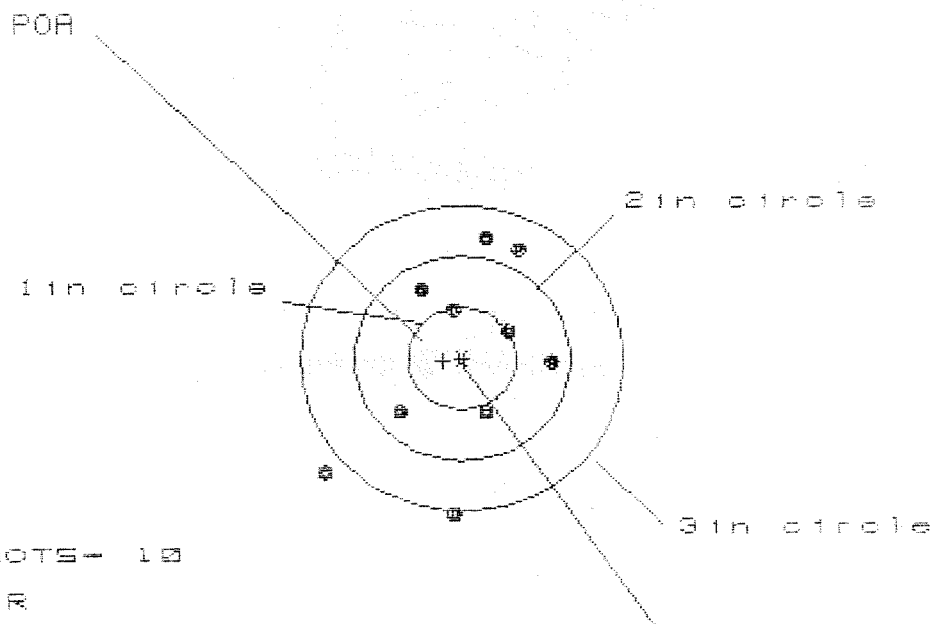
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.261	.891	.815
MINIMUM X	:	-.748	-.608	-.665
MAXIMUM Y	:	1.156	1.223	1.111
MINIMUM Y	:	-.961	-.894	-.731
CENTROID X	:	.112	-.028	.048
CENTROID Y	:	.073	.006	.118
POA TO CENTROID in.	:	.134	.028	.127
MIN RADIUS	:	.233	.267	.165
MEAN RADIUS	:	.833	.765	.709
MAX RADIUS	:	1.396	1.232	1.114
HORIZONTAL SPREAD	:	2.009	1.499	1.480
VERTICAL SPREAD	:	2.117	2.117	1.842
EXTREME SPREAD	:	2.544	2.247	1.987
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			10	

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 2.100

VS= 2.676

GS= 2.836

CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.859	.721	.699
MINIMUM X	:	-1.241	-.687	-.709
MAXIMUM Y	:	1.171	1.047	.844
MINIMUM Y	:	-1.505	-1.629	-.826
CENTROID X	:	.176	.314	.336
CENTROID Y	:	.025	.149	.352
POA TO CENTROID in.	:	.178	.347	.487
MIN RADIUS	:	.475	.349	.251
MEAN RADIUS	:	.951	.838	.704
MAX RADIUS	:	1.670	1.638	1.084
HORIZONTAL SPREAD	:	2.100	1.408	1.408
VERTICAL SPREAD	:	2.676	2.676	1.670
EXTREME SPREAD	:	2.836	2.685	1.920
NUMBER IN ONE INCH CIRCLE =	:		1	

NUMBER IN TWO INCH CIRCLE = 6
 NUMBER IN THREE INCH CIRCLE = 8

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CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 4

2in = 6

3in = 10

HS= 1.883

VS= 2.366

GS= 2.405

CENTROID #

PATTERN #

3

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.666

.732

.762

MINIMUM X

-.927

-.861

-.831

MAXIMUM Y

1.092

.950

.758

MINIMUM Y

-1.274

-.977

-.858

CENTROID X

.167

.101

.071

CENTROID Y

-.034

.108

-.011

POA TO CENTROID in.

.171

.148

.072

MIN RADIUS

.045

.140

.124

MEAN RADIUS

.747

.686

.630

MAX RADIUS

1.409

1.108

1.074

HORIZONTAL SPREAD :	1.593	1.593	1.593
VERTICAL SPREAD :	2.366	1.927	1.616
EXTREME SPREAD :	2.405	2.071	2.047
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

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CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS = 3.671

VS = 1.182

GS = 3.696

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.138	.811	.649
MINIMUM X	-1.533	-1.296	-1.129
MAXIMUM Y	.640	.654	.619
MINIMUM Y	-.542	-.528	-.563
CENTROID X	.102	-.135	.027
CENTROID Y	.092	.078	.113
POA TO CENTROID in.	.137	.156	.116
MIN RADIUS	.323	.412	.311
MEAN RADIUS	.962	.838	.746
MAX RADIUS	2.141	1.327	1.169
HORIZONTAL SPREAD	3.671	2.107	1.778
VERTICAL SPREAD	1.182	1.102	1.182
EXTREME SPREAD	3.696	2.304	1.999
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	8	

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CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in - 3

2 in - 5

3 in - 9

HS= 2.852

VS= 1.920

GS= 2.858

CENTROID *

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.502	1.118	.970
MINIMUM X	-1.350	-1.183	-.668
MAXIMUM Y	.735	.780	.860
MINIMUM Y	-1.185	-1.140	-1.060
CENTROID X	.166	-.001	.147
CENTROID Y	.107	.062	-.018
POA TO CENTROID in.	.197	.062	.148
MIN RADIUS	.224	.261	.107
MEAN RADIUS	.904	.826	.737
MAX RADIUS	1.556	1.363	1.296
HORIZONTAL SPREAD	2.852	2.301	1.638
VERTICAL SPREAD	1.920	1.920	1.920
EXTREME SPREAD	2.858	2.524	2.524
NUMBER IN ONE INCH CIRCLE	=	3	
NUMBER IN TWO INCH CIRCLE	=	5	
NUMBER IN THREE INCH CIRCLE	=	9	