

06587650

MODEL 700™ M24

Model **SWS**™

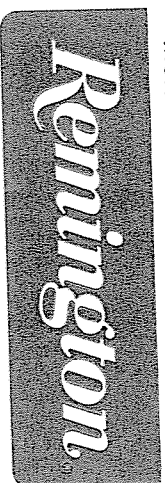
Action

Barrel Length

Capacity

Order No. **5715**

* Includes 1 in chamber.



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

Remington[®]

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

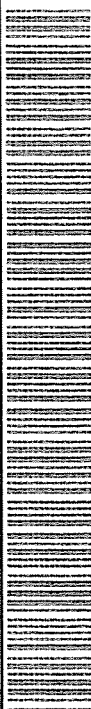
MODEL 700TM M24

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

SERIAL NO.
C6587650

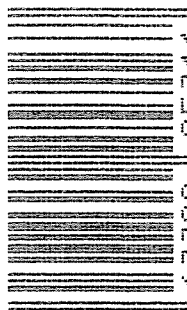
ORDER NO.
5716

20



5716 C6587650

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6587650

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/31/90	Kel
600	Proof		10/31/90	Kel
607	Check Headspace		10/31/90	Kel
610	Dis-assemble Gun		10/31/90	Kel
612	Magnaflux Barrel Action		11/1/90	Kcd
	Magnaflux Bolt		11/1/90	Kcd
615	Rollmark Caliber		11/1/90	KCR
617	Drill and Tap Sight Holes		11/1/90	KCB
618	Polish Barrel <i>RB</i>		11/6/90	WCB
620	Apply Coatings (Barrel Action)		11-26-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		12/28/90	K.S.
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/28/90	K.S.
	C) Inspect Ejector Hole for Chamfer		12/28/90	K.S.
	D) Oil Firing Pin Ass'y		12/28/90	K.S.
	E) Adjust Trigger Pull to Min Setting and Stake		1-3-91	JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4.75	5.0	4.75			1/2/91	KT
	G) Safety Off Force	3.0	3.25	3.25			1/2/91	KT
	H) Trigger Pull Test & Retainability						1-3-91	JL
	I) Firing Pin Indent	.020	.020	.020			1/2/91	KT
	J) Assemble Stock						1/6/91	KS
	K) Assemble Swivel Studs						1-17-91	JL
	L) Attach Front and Rear Sight Assemblies						1/6/91	KS
	M) Iron Sight Alignment						1/6/91	KS
	N) Detach Front & Rear Sights & place in numbered container						1/6/91	KS
	O) Attach Scope to Rifle						1/6/91	KS
	P) Detach & Attach Scope 20 Times						1/6/91	KS
640	Gallery Target & Test						1/16/91	KJ
	A) Time							122
	B) Malfunctions							122
	C) Pierced Primers							122
	D) Optical Clarity of Scope							122
645	Inspect for Live Ammo						1/16/91	122
655	Final Inspection							
	A) Headspace						1-17-91	JL
	B) Trigger Pull	2.26	2.35	2.42	2.41	2.45	1-17-91	JL
	C) Function						1-17-91	JL
660	Pack						3-19-91	VF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6587650

DATE 1-3-91

TESTER JEP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.49	2.45	2.40	2.26	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.27	2.44	2.38	2.35	
PULL #3	2.22	2.36	2.38	2.42	
PULL #4	2.41	2.27	2.36	2.41	
PULL #5	2.40	2.37	2.29	2.45	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.29	3.34		
PULL #2	3.26	3.23		
PULL #3	3.26	3.18		
PULL #4	3.30	3.28		
PULL #5	3.14	3.30		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.25	4.32		4.29
PULL #2	4.23	4.32		4.26
PULL #3	4.20	4.27		4.24
PULL #4	4.20	4.33		4.25
PULL #5	4.37	4.28		4.32
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587650
17 Jan 1991

CENTROIDAL DISTANCES

0 TO 1	.232594
1 TO 2	.381745
1 TO 3	.247202
1 TO 4	.0690652
1 TO 5	.175787

Q# 2 <----POA

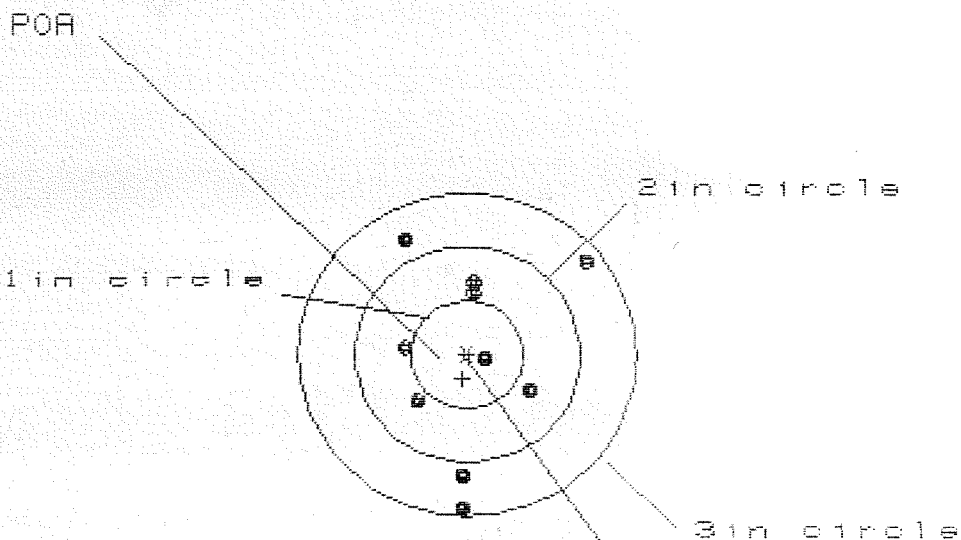
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0386
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0944
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0992357

THE AMR FOR THIS RIFLE IS: 1.086

17 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8587850

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 6

3 in = 10

HS = 1.617

VS = 2.500

GS = 2.550

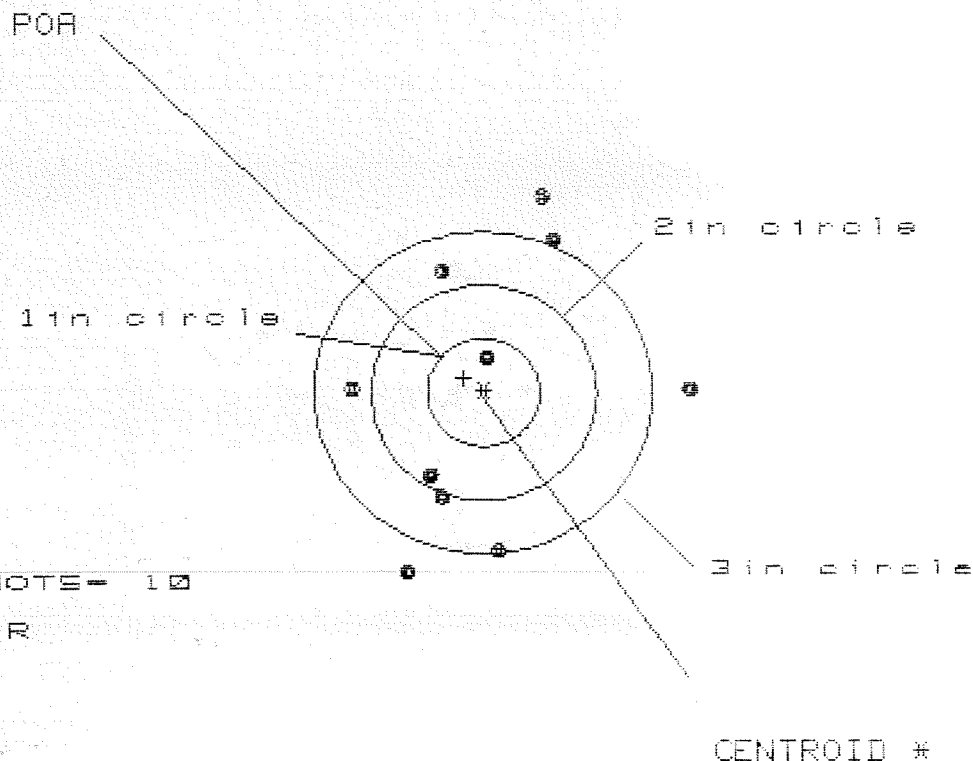
CENTROID *

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.027	1.017	.676
MINIMUM X	:	-.590	-.600	-.472
MAXIMUM Y	:	1.098	.942	1.029
MINIMUM Y	:	-1.402	-1.307	-1.220
CENTROID X	:	.046	.056	-.072
CENTROID Y	:	.228	.384	.297
POA TO CENTROID in.	:	.233	.388	.305
MIN RADIUS	:	.155	.263	.291
MEAN RADIUS	:	.835	.763	.697
MAX RADIUS	:	1.405	1.310	1.220
HORIZONTAL SPREAD	:	1.617	1.617	1.148
VERTICAL SPREAD	:	2.500	2.249	2.249
EXTREME SPREAD	:	2.550	2.304	2.304
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	10		

17 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6587650

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 1

2in = 2

3in = 5

HS= 2.917

VS= 3.506

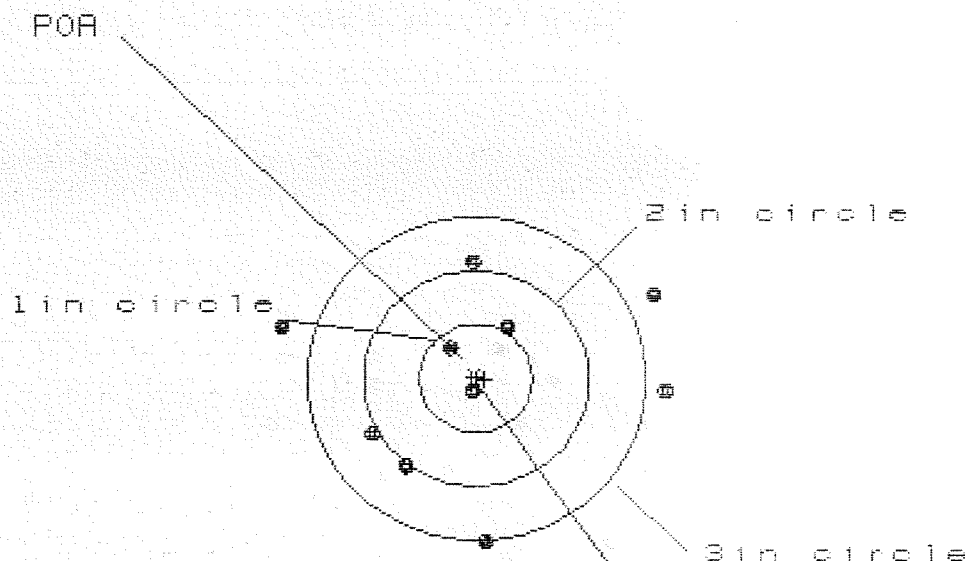
GS= 3.700

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.778	1.833	1.754
MINIMUM X	:	-1.139	-1.084	-1.163
MAXIMUM Y	:	1.842	1.636	1.453
MINIMUM Y	:	-1.664	-1.459	-1.494
CENTROID X	:	.173	.118	.197
CENTROID Y	:	-.132	-.337	-.154
POA TO CENTROID in.	:	.218	.357	.250
MIN RADIUS	:	.355	.564	.378
MEAN RADIUS	:	1.318	1.233	1.187
MAX RADIUS	:	1.908	1.848	1.755
HORIZONTAL SPREAD	:	2.917	2.917	2.917
VERTICAL SPREAD	:	3.506	3.095	2.947
EXTREME SPREAD	:	3.700	3.357	2.987
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		5	

17 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08587650

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 3

3 in = 6

HS= 3.340

VS= 2.657

GS= 3.393

CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.639	1.450	1.618
MINIMUM X	:	-1.701	-1.146	-.978
MAXIMUM Y	:	1.122	1.172	1.270
MINIMUM Y	:	-1.535	-1.485	-1.387
CENTROID X	:	-.076	.113	-.055
CENTROID Y	:	.013	-.037	-.135
POA TO CENTROID in.	:	.077	.119	.146
MIN RADIUS	:	.143	.246	.063
MEAN RADIUS	:	1.098	1.044	.942
MAX RADIUS	:	1.759	1.562	1.618
HORIZONTAL SPREAD	:	3.340	2.596	2.596
VERTICAL SPREAD	:	2.657	2.657	2.657
EXTREME SPREAD	:	3.393	2.782	2.660
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		6	

17 Jan 1991

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CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS = 3.346

VS = 2.215

GS = 3.346

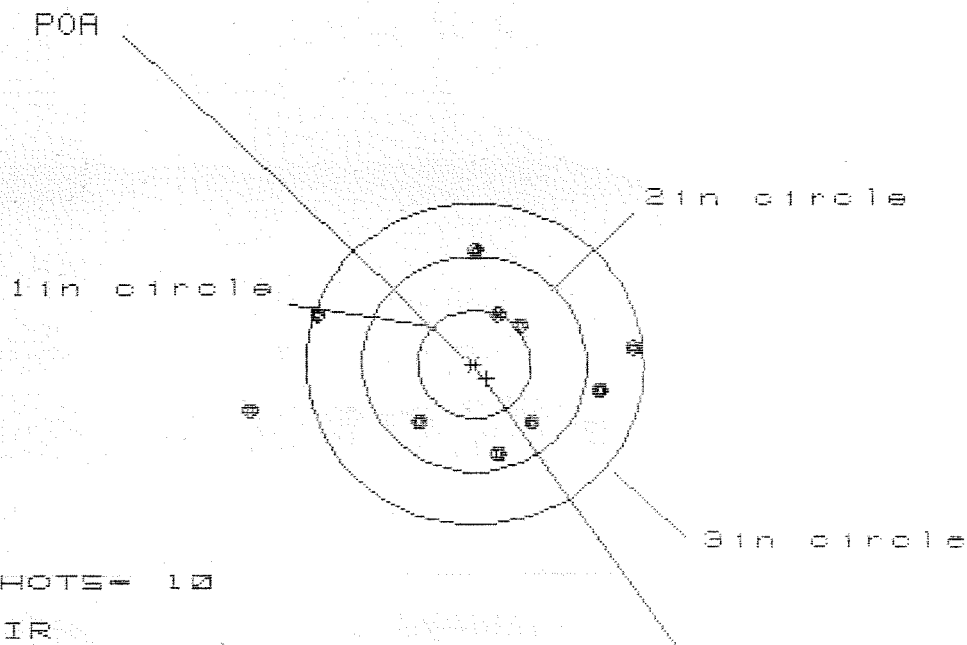
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.287	1.058	1.144
MINIMUM X	:	-2.059	-1.315	-1.229
MAXIMUM Y	:	.771	.781	.601
MINIMUM Y	:	-1.444	-1.434	-1.145
CENTROID X	:	.115	.344	.258
CENTROID Y	:	.225	.215	.395
POA TO CENTROID in.	:	.253	.406	.471
MIN RADIUS	:	.192	.086	.114
MEAN RADIUS	:	1.125	.985	.870
MAX RADIUS	:	2.061	1.591	1.451
HORIZONTAL SPREAD	:	3.346	2.373	2.373
VERTICAL SPREAD	:	2.215	2.215	1.746
EXTREME SPREAD	:	3.346	2.934	2.702
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

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FILE:/PATTERNING/CENTERFIRE_PATT/06587850

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 5

3 in = 9

HS = 3.425

VS = 1.918

GS = 3.475

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.448
MINIMUM X	-1.977
MAXIMUM Y	1.088
MINIMUM Y	-.831
CENTROID X	-.105
CENTROID Y	.138
POA TO CENTROID in.	.173
MIN RADIUS	.536
MEAN RADIUS	1.053
MAX RADIUS	2.016
HORIZONTAL SPREAD	3.425
VERTICAL SPREAD	1.918
EXTREME SPREAD	3.475
NUMBER IN ONE INCH CIRCLE	= 0
NUMBER IN TWO INCH CIRCLE	= 5
NUMBER IN THREE INCH CIRCLE	= 9