

C6587679

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.

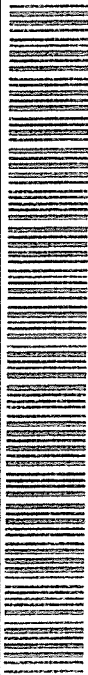
C6587679

ORDER NO.

5716

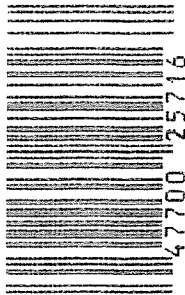
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



5716 C6587679

LPC



0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587679

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10 9	90	RW
600	Proof	10	9 90	RW
607	Check Headspace	10	9 90	RW
610	Dis-assemble Gun	10	90	RW
612	Magnaflux Barrel Action		10/11/90	KR
	Magnaflux Bolt		10/11/90	K.R
615	Rollmark Caliber		10/11/90	J.B.
617	Drill and Tap Sight Holes		10/11/90	FB
618	Polish Barrel <i>WOB</i>		10/12/90	WB
620	Apply Coatings (Barrel Action)		10-18-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/22/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/22/90	RW
	C) Inspect Ejector Hole for Chamfer		10/22/90	RW
	D) Oil Firing Pin Ass'y		10/22/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11-9-90	JM

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	3 3/4	3 1/2	3 1/2			11/9/90	WB
	G) Safety Off Force	2	2	2			11/9/90	WB
	H) Trigger Pull Test & Retainability						11-9-90	JH
	I) Firing Pin Indent	.021	.021	.021			11/9/90	WB
	J) Assemble Stock						11/9/90	RW
	K) Assemble Swivel Studs						11-19-90	DH
	L) Attach Front and Rear Sight Assemblies						11/9/90	RW
	M) Iron Sight Alignment						11/9/90	RW
	N) Detach Front & Rear Sights & place in numbered container						11/9/90	RW
	O) Attach Scope to Rifle						11/9/90	RW
	P) Detach & Attach Scope 20 Times						11/9/90	RW
640	Gallery Target & Test						11/9/90	KT
	A) Time						"	KT
	B) Malfunctions						"	HT
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	KT
645	Inspect for Live Ammo						11/9/90	KT
655	Final Inspection							
	A) Headspace						11-19-90	DH
	B) Trigger Pull	2.72	2.72	2.69	2.71	2.69	11-19-90	DH
	C) Function						11-19-90	DH
660	Pack						12-17-90	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 16587679

DATE 11-9-90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.37	2.50	2.30	2.72	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.14	2.41	2.26	2.72	
PULL #3	2.46	2.46	2.40	2.69	
PULL #4	2.29	2.20	2.39	2.71	
PULL #5	2.46	2.19	2.43	2.69	
TOTAL	11.72	11.76	11.78		
AVG.	2.344	2.352	2.356		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.46	3.48		
PULL #2	3.25	3.48		
PULL #3	3.17	3.47		
PULL #4	3.35	3.50		
PULL #5	3.44	3.49		
TOTAL	16.67	17.42		
AVG.	3.334	3.484		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.31	4.25		4.26
PULL #2	4.39	4.25		4.34
PULL #3	4.36	4.23		4.33
PULL #4	4.38	4.27		4.33
PULL #5	4.41	4.25		4.38
TOTAL	21.85	21.25		21.64
AVG.	4.37	4.25		4.328

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587694
10 Nov 1990

CENTROIDAL DISTANCES

0 TO	1	.149218
1 TO	2	.219447
1 TO	3	.169446
1 TO	4	.231873
1 TO	5	.279732

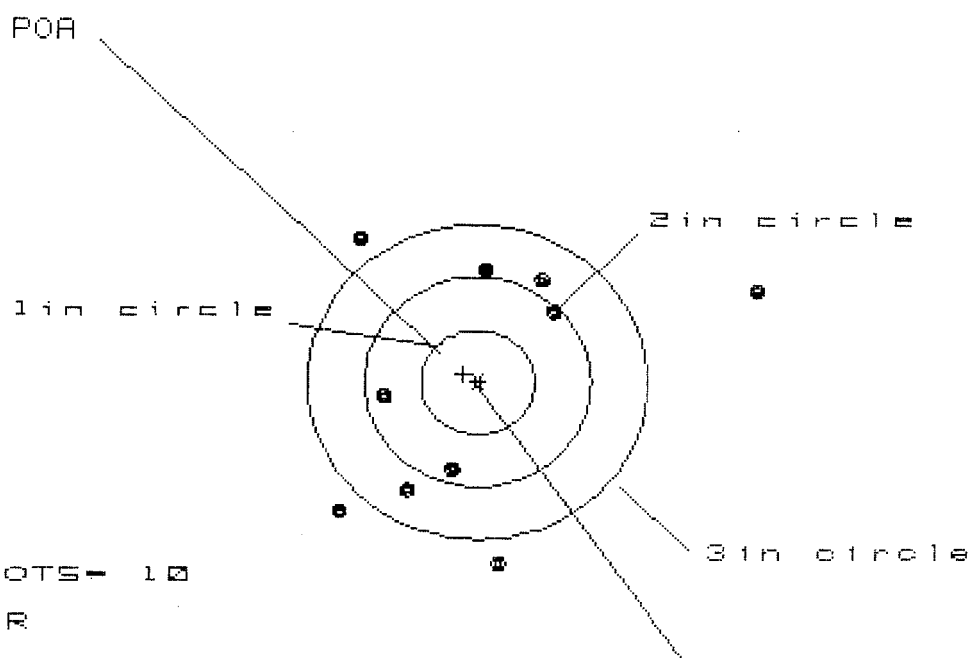
☉ <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0406
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1274
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .133713
THE AMR FOR THIS RIFLE IS: 1.214

9 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587679

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 3

3 in = 6

HS= 3.656

VS= 3.041

GS= 4.200

CENTROID #

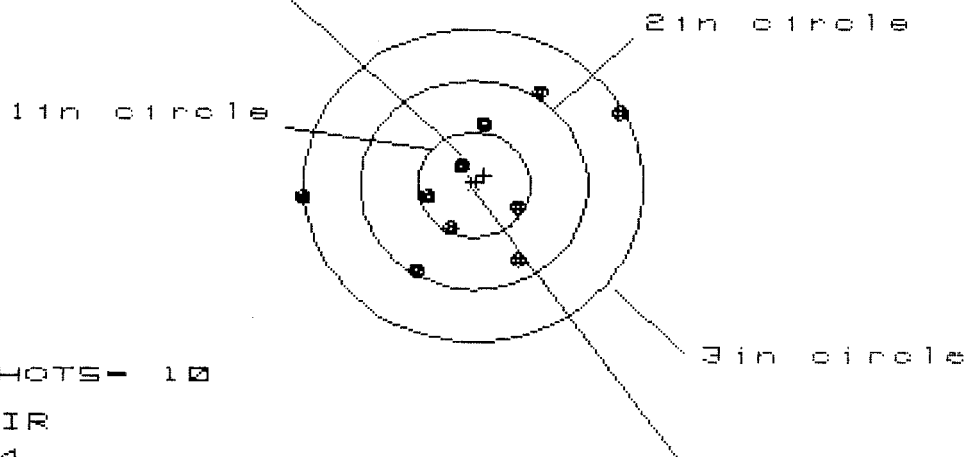
PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.447	.897	.958
MINIMUM X	:	-1.209	-.937	-.876
MAXIMUM Y	:	1.353	1.450	1.251
MINIMUM Y	:	-1.688	-1.591	-1.299
CENTROID X	:	.129	-.143	-.204
CENTROID Y	:	-.075	-.172	.027
POA TO CENTROID in.	:	.149	.224	.206
MIN RADIUS	:	.841	.559	.554
MEAN RADIUS	:	1.370	1.196	1.131
MAX RADIUS	:	2.598	1.664	1.567
HORIZONTAL SPREAD	:	3.656	1.834	1.834
VERTICAL SPREAD	:	3.041	3.041	2.550
EXTREME SPREAD	:	4.200	3.285	2.811
NUMBER IN ONE INCH CIRCLE =			0	
NUMBER IN TWO INCH CIRCLE =			3	
NUMBER IN THREE INCH CIRCLE =			6	

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CENTERFIRE PATTERNS # 2

POA



OF SHOTS - 10

IN CIR

1in = 4

2in = 7

3in = 10

HS = 2.762

VS = 1.646

GS = 2.889

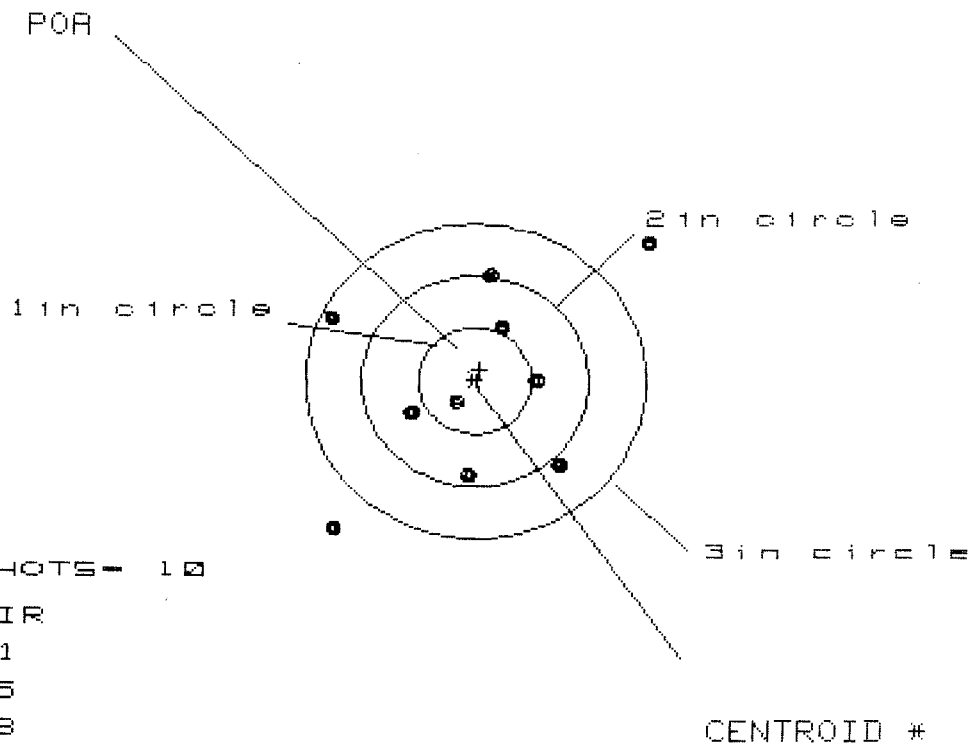
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.290	1.126	.612
MINIMUM X	:	-1.472	-.722	-.581
MAXIMUM Y	:	.842	.825	.910
MINIMUM Y	:	-.804	-.821	-.736
CENTROID X	:	-.090	.074	-.067
CENTROID Y	:	-.089	-.072	-.157
POA TO CENTROID in.	:	.126	.103	.171
MIN RADIUS	:	.206	.269	.276
MEAN RADIUS	:	.796	.723	.625
MAX RADIUS	:	1.480	1.314	1.097
HORIZONTAL SPREAD	:	2.762	1.848	1.193
VERTICAL SPREAD	:	1.646	1.646	1.646
EXTREME SPREAD	:	2.889	2.380	2.033
NUMBER IN ONE INCH CIRCLE =			4	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			10	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in - 1

2in - 5

3in - 8

HS- 2.816

VS- 2.751

GS- 3.915

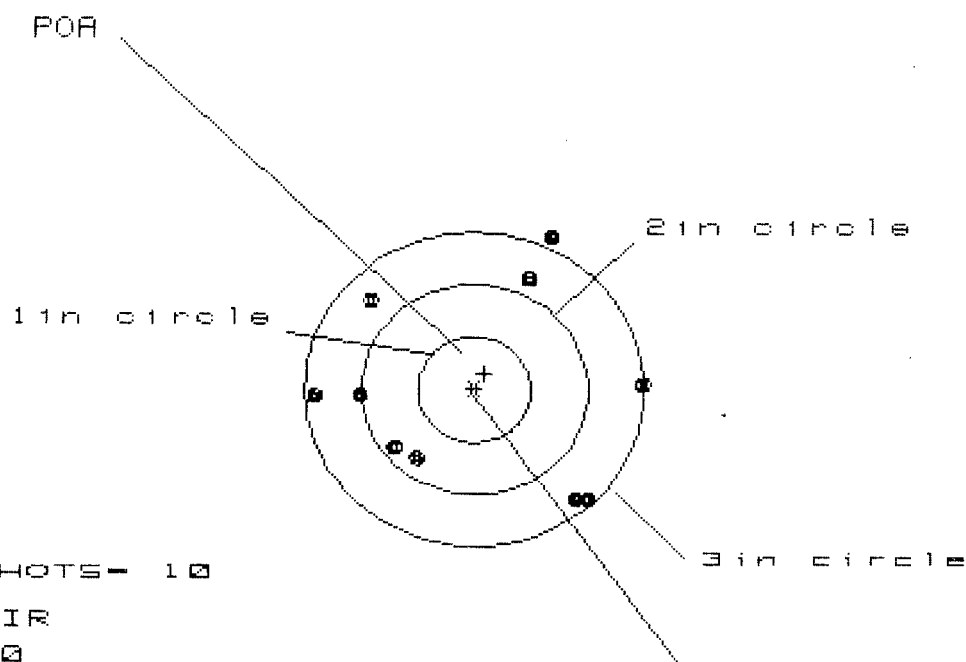
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.557	.893	.761
MINIMUM X	:	-1.259	-1.086	-1.218
MAXIMUM Y	:	1.326	1.170	1.010
MINIMUM Y	:	-1.425	-1.278	-.936
CENTROID X	:	-.037	-.210	-.078
CENTROID Y	:	-.109	-.256	-.096
POA TO CENTROID in.	:	.115	.331	.124
MIN RADIUS	:	.290	.066	.273
MEAN RADIUS	:	1.042	.903	.812
MAX RADIUS	:	2.045	1.657	1.369
HORIZONTAL SPREAD	:	2.816	1.979	1.979
VERTICAL SPREAD	:	2.751	2.448	1.946
EXTREME SPREAD	:	3.915	2.821	2.428
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			8	

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CENTERFIRE PATTERNS

4



OF SHOTS - 10

IN CIR

1in = 0

2in = 3

3in = 8

HS = 2.934

VS = 2.532

GS = 2.936

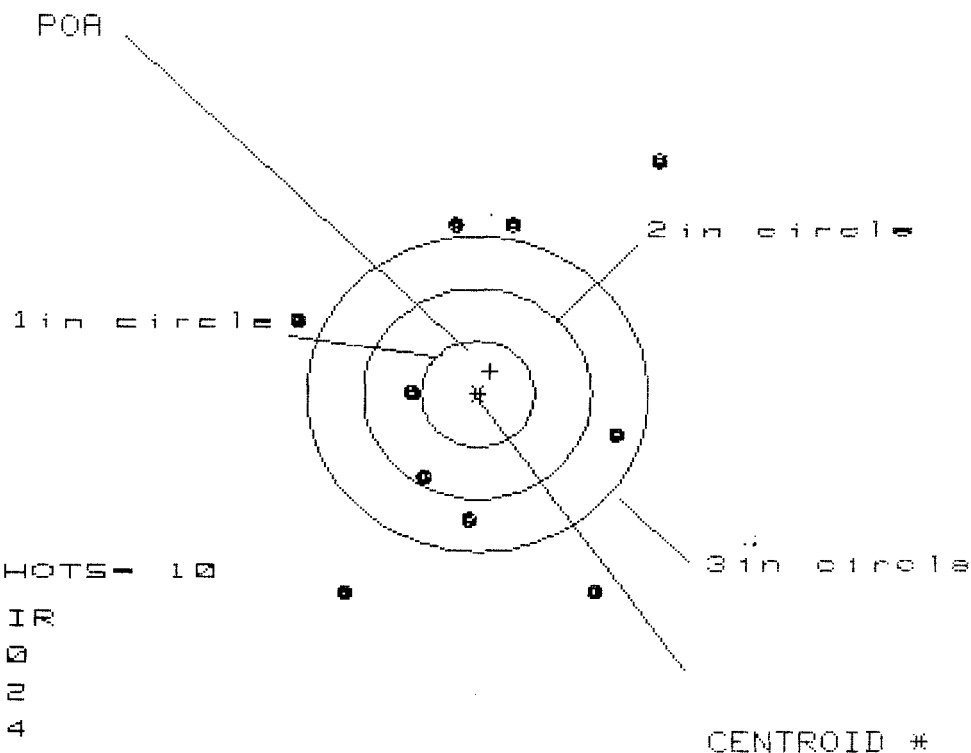
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.514	1.589	1.241
MINIMUM X	:	-1.420	-1.345	-1.146
MAXIMUM Y	:	1.453	1.221	1.251
MINIMUM Y	:	-1.079	-.918	-.888
CENTROID X	:	-.089	-.164	-.363
CENTROID Y	:	-.154	-.316	-.346
POA TO CENTROID in.	:	.178	.356	.502
MIN RADIUS	:	.830	.655	.530
MEAN RADIUS	:	1.250	1.182	1.081
MAX RADIUS	:	1.602	1.608	1.526
HORIZONTAL SPREAD	:	2.934	2.934	2.387
VERTICAL SPREAD	:	2.532	2.139	2.139
EXTREME SPREAD	:	2.936	2.936	2.667
NUMBER IN ONE INCH CIRCLE =			0	
NUMBER IN TWO INCH CIRCLE =			3	
NUMBER IN THREE INCH CIRCLE =			8	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 2

3 in = 4

HS= 3.201

VS= 4.164

GS= 5.022

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.594	1.382	1.253
MINIMUM X	-1.607	-1.430	-1.559
MAXIMUM Y	2.227	1.899	1.688
MINIMUM Y	-1.937	-1.690	-1.836
CENTROID X	-.116	-.293	-.164
CENTROID Y	-.210	-.457	-.246
POA TO CENTROID in.	.240	.543	.296
MIN RADIUS	.535	.421	.487
MEAN RADIUS	1.610	1.429	1.375
MAX RADIUS	2.739	1.989	2.099
HORIZONTAL SPREAD	3.201	2.812	2.812
VERTICAL SPREAD	4.164	3.589	3.524
EXTREME SPREAD	5.022	3.888	3.709
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	4		