

C6523417

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

R 94-18377

Scape S/N 90-0488

NATO

700	7.62
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SHIP TO:

36201-5025

FRT

TOTAL	100
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MAIN FAULT

COMMENTS

- ✓ Trigger Assy
- ✓ Front & Rear Sight Assy

REPAIRMAN	PROOF	CLEAN	TEST	TARGET	PATTERN
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GALLERY TESTER	DATE	DATE	DATE	DATE	DATE
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BD6925 REV 1/94

M2400027755

SWS TRIGGER PULL TEST

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

SERIAL NO. C6523417

DATE 2-23-96

TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.66	2.53	2.78	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.74	2.80	2.60	
PULL #3	2.55	2.90	2.62	
PULL #4	2.54	2.77	2.73	
PULL #5	2.57	2.92	2.63	
TOTAL	13.06	13.92	13.36	
AVG.	2.61	2.78	2.67	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.01	3.00	
PULL #2	3.17	3.07	
PULL #3	3.04	3.00	
PULL #4	2.93	3.00	
PULL #5	3.10	3.00	
TOTAL	15.25	15.07	
AVG.	3.05	3.01	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.29	4.05		4.34
PULL #2	4.35	4.08		4.18
PULL #3	4.31	4.20		4.35
PULL #4	4.38	4.05		4.46
PULL #5	4.31	4.03		4.20
TOTAL	21.64	20.41		21.53
AVG.	4.32	4.08		4.30

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6523417

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock			
600	Proof			
607	Check Headspace			
610	Dis-assemble Gun			
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			7/22/96	WB
	G) Safety Off Force	2 1/4	2 1/4	2 1/4			8/22/96	WB
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent							
	J) Assemble Stock							
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies							
	M) Iron Sight Alignment							
	N) Detach Front & Rear Sights & place in numbered container							
	O) Attach Scope to Rifle							
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test							
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection							
	A) Headspace							
	B) Trigger Pull	2.64	2.59	2.56	2.59	2.61	7/27/96	WB
	C) Function							
660	Pack							

Remington



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

MODEL 700TM H24

SERIAL NO.
C6523417

ORDER NO.
5716

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

Ø1



5716 C6523417

UPC



0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6523417

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/2/90	KJ
600	Proof		10/2/90	KJ
607	Check Headspace		10/2/90	KJ
610	Dis-assemble Gun		10/2/90	KJ
612	Magnaflux Barrel Action		10/5/90	KR
	Magnaflux Bolt		10/5/90	KR
615	Rollmark Caliber		10/5/90	Z.B.
617	Drill and Tap Sight Holes		10/6/90	R.B.
618	Polish Barrel RB		10/7/90	WB
620	Apply Coatings (Barrel Action)		10-20-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/21/90	KJ
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/21/90	KJ
	C) Inspect Ejector Hole for Chamfer		10/21/90	KJ
	D) Oil Firing Pin Ass'y		10/21/90	KJ
	E) Adjust Trigger Pull to Min Setting and Stake		11/3/90	KJ

op. #	OP. NAME	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	4.25	5.25	5.25	11-2-90	KT		
	G) Safety Off Force	2.75	2.50	2.50	11-2-90	KT		
	H) Trigger Pull Test & Retainability				11-3-90	JH		
	I) Firing Pin Indent	.026	.026	.025	11-2-90	KT		
	J) Assemble Stock				11-3-90	KL		
	K) Assemble Swivel Studs				11-20-90	DH		
	L) Attach Front and Rear Sight Assemblies				11-3-90	KL		
	M) Iron Sight Alignment				11-3-90	KL		
	N) Detach Front & Rear Sights & place in numbered container				11-3-90	KL		
	O) Attach Scope to Rifle				11-3-90	KL		
	P) Detach & Attach Scope 20 Times				11-3-90	KL		
640	Gallery Target & Test				11/5/90	AF		
	A) Time				"	AF		
	B) Malfunctions				"	AF		
	C) Pierced Primers				"	AF		
	D) Optical Clarity of Scope				"	AF		
645	Inspect for Live Ammo				11/5/90	AF		
655	Final Inspection							
	A) Headspace				11-20-90	DH		
	B) Trigger Pull	260	264	264	269	285	11-20-90	DH
	C) Function						11-20-90	DH
660	Pack						12/19/91	AF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C6523417

DATE 11/3/90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.34	2.30	260	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.38	2.22	2.36	264	
PULL #3	2.24	2.34	2.40	264	
PULL #4	2.17	2.24	2.24	269	
PULL #5	2.21	2.29	2.33	285	
TOTAL	11.40	11.43	11.63		
AVG.	2.28	2.286	2.326		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.19	3.31		
PULL #2	3.21	3.29		
PULL #3	3.27	3.40		
PULL #4	3.35	3.27		
PULL #5	3.27	3.41		
TOTAL	16.29	16.68		
AVG.	3.258	3.336		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.48	4.49		4.32
PULL #2	4.47	4.46		4.41
PULL #3	4.42	4.47		4.21
PULL #4	4.50	4.18		4.29
PULL #5	4.41	4.27		4.27
TOTAL	22.28	21.87		21.50
AVG.	4.456	4.374		4.3

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523417
6 Nov 1990

CENTROIDAL DISTANCES -

Ø TO	1	.412884
1 TO	2	.375941
1 TO	3	.420096
1 TO	4	.35896
1 TO	5	.327867

1

<----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0474
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1248
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .133498
THE AMR FOR THIS RIFLE IS: .9484

6 Nov 1990

FILE:/PATTERNING/CENTERFIRE_PATT/08523417

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 2

3 in = 5

HS = 2.470

VS = 3.550

GS = 4.111

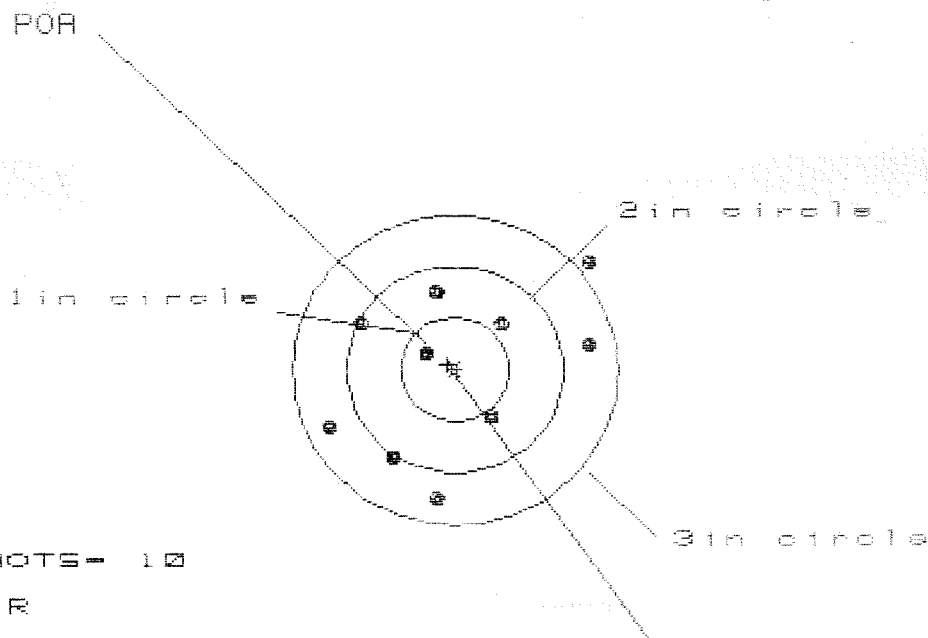
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.452	1.606	1.534
MINIMUM X	:	-1.018	-.864	-.936
MAXIMUM Y	:	1.760	1.953	1.753
MINIMUM Y	:	-1.789	-1.597	-1.615
CENTROID X	:	-.027	-.181	-.108
CENTROID Y	:	-.412	-.604	-.404
POA TO CENTROID in.	:	.412	.630	.418
MIN RADIUS	:	.284	.523	.353
MEAN RADIUS	:	1.470	1.365	1.318
MAX RADIUS	:	2.215	2.113	1.901
HORIZONTAL SPREAD	:	2.470	2.470	2.470
VERTICAL SPREAD	:	3.550	3.550	3.368
EXTREME SPREAD	:	4.111	3.811	3.760
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		5	

6 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523417

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 2.360

VS= 2.294

GS= 2.807

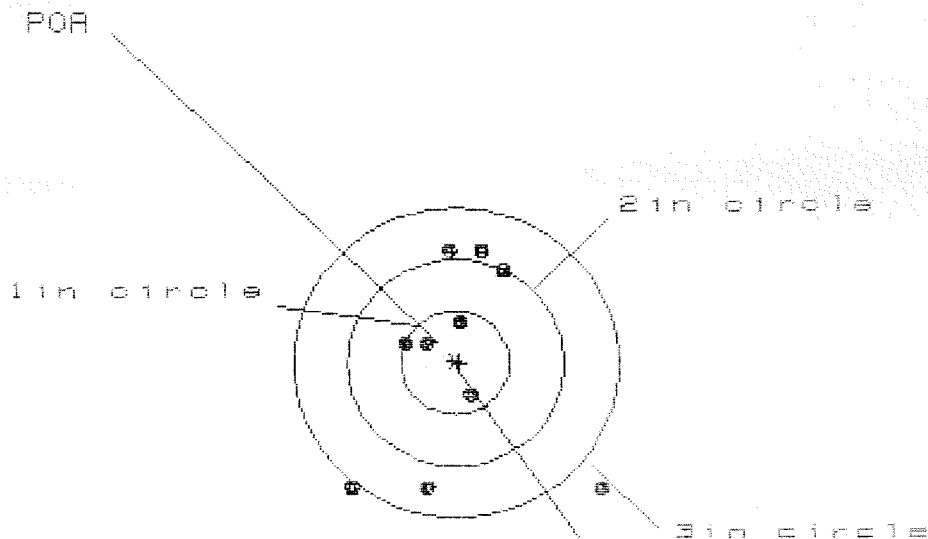
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.203	1.327	1.318
MINIMUM X	:	-1.157	-1.024	-1.033
MAXIMUM Y	:	1.016	.889	.743
MINIMUM Y	:	-1.278	-1.165	-.934
CENTROID X	:	.067	-.066	-.057
CENTROID Y	:	-.048	-.161	-.015
POA TO CENTROID in.	:	.083	.174	.059
MIN RADIUS	:	.348	.336	.227
MEAN RADIUS	:	.970	.895	.839
MAX RADIUS	:	1.574	1.364	1.328
HORIZONTAL SPREAD	:	2.360	2.351	2.351
VERTICAL SPREAD	:	2.294	2.054	1.677
EXTREME SPREAD	:	2.807	2.454	2.454
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

6 Nov 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C8523417

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 5

3 in = 8

HS= 2.266

VS= 2.347

GS= 2.720

CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.312	.537	.436
MINIMUM X	:	-.954	-.808	-.413
MAXIMUM Y	:	1.104	.966	.795
MINIMUM Y	:	-1.243	-1.370	-1.470
CENTROID X	:	-.036	-.182	-.081
CENTROID Y	:	.008	.146	.317
POA TO CENTROID in.	:	.037	.233	.327
MIN RADIUS	:	.274	.085	.122
MEAN RADIUS	:	.929	.783	.656
MAX RADIUS	:	1.807	1.591	1.488
HORIZONTAL SPREAD	:	2.266	1.345	.849
VERTICAL SPREAD	:	2.347	2.336	2.265
EXTREME SPREAD	:	2.720	2.614	2.318
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

6 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06523417

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 10

HS= 1.854

VS= 1.831

GS= 1.935

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.583	.440	.462
MINIMUM X	:	-1.281	-.421	-.399
MAXIMUM Y	:	.803	.799	.670
MINIMUM Y	:	-1.028	-1.032	-1.161
CENTROID X	:	-.073	.070	.048
CENTROID Y	:	-.056	-.052	.076
POA TO CENTROID in.	:	.092	.087	.090
MIN RADIUS	:	.193	.285	.182
MEAN RADIUS	:	.696	.632	.554
MAX RADIUS	:	1.282	1.049	1.172
HORIZONTAL SPREAD	:	1.864	.861	.861
VERTICAL SPREAD	:	1.831	1.831	1.831
EXTREME SPREAD	:	1.935	1.900	1.900
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

6 May 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C8523417

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS - 10

IN CIR

1 in = 4

2 in = 8

3 in = 10

HS = 1.659

VS = 1.708

GS = 2.297

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.989	.928	1.003
MINIMUM X	:	-.670	-.731	-.615
MAXIMUM Y	:	.492	.357	.352
MINIMUM Y	:	-1.216	-.851	-.806
CENTROID X	:	-.168	-.107	-.223
CENTROID Y	:	-.116	.019	-.026
POA TO CENTROID in.	:	.204	.109	.224
MIN RADIUS	:	.218	.161	.148
MEAN RADIUS	:	.677	.596	.509
MAX RADIUS	:	1.333	.994	1.015
HORIZONTAL SPREAD	:	1.659	1.659	1.618
VERTICAL SPREAD	:	1.708	1.208	1.158
EXTREME SPREAD	:	2.297	1.665	1.621
NUMBER IN ONE INCH CIRCLE =			4	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			10	