

C6523461

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™ M24

SERIAL NO.
C6523461

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 C6523461

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523461

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 9	90	RW
612	Magnaflux Barrel Action		10/17/90	KR
	Magnaflux Bolt		10/17/90	KR
615	Rollmark Caliber		10/17/90	LS
617	Drill and Tap Sight Holes		10/18/90	KUB
618	Polish Barrel <i>KUB</i>		10/19/90	KUB
620	Apply Coatings (Barrel Action)		11-5-90	TA
	Apply Coating (Bolt)			TA
625	Final Assembly A) Clean inside of Bolt Assembly		11/7/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/7/90	RW
	C) Inspect Ejector Hole for Chamfer		11/7/90	RW
	D) Oil Firing Pin Ass'y		11/7/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11-12-90	JH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	3 3/4	3 3/4	3 3/4			11/12/90	WB
	G) Safety Off Force	2	2	2			11/12/90	WB
	H) Trigger Pull Test & Retainability						11-12-90	JH
	I) Firing Pin Indent	.020	.020	.020			11/12/90	WB
	J) Assemble Stock						11/14/90	RW
	K) Assemble Swivel Studs						11-20-90	DH
	L) Attach Front and Rear Sight Assemblies						11/14/90	RW
	M) Iron Sight Alignment						11/14/90	RW
	N) Detach Front & Rear Sights & place in numbered container						11/14/90	RW
	O) Attach Scope to Rifle						11/14/90	RW
	P) Detach & Attach Scope 20 Times						11/14/90	RW
640	Gallery Target & Test						11-16-90	DH
	A) Time						11-16-90	DH
	B) Malfunctions						11-16-90	DH
	C) Pierced Primers						11-16-90	DH
	D) Optical Clarity of Scope						11-16-90	DH
645	Inspect for Live Ammo						11-16-90	DH
655	Final Inspection							
	A) Headspace						11-20-90	DH
	B) Trigger Pull	2.72	2.54	2.49	2.49	2.36	11-20-90	DH
	C) Function						11-20-90	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. 06523461

DATE 11-12-98

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.38	2.43	2.23	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.44	2.35	2.30	2.54	
PULL #3	2.38	2.32	2.35	2.49	
PULL #4	2.36	2.43	2.41	2.49	
PULL #5	2.41	2.38	2.39	2.36	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.29	3.28		
PULL #2	3.32	3.32		
PULL #3	3.31	3.28		
PULL #4	3.33	3.37		
PULL #5	3.29	3.35		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.29	4.42		4.29
PULL #2	4.25	4.40		4.35
PULL #3	4.15	4.33		4.29
PULL #4	4.33	4.37		4.32
PULL #5	4.28	4.30		4.26
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523461
16 Nov 1990

CENTROIDAL DISTANCES

0 TO	1	.241207
1 TO	2	.204788
1 TO	3	.210238
1 TO	4	.181893
1 TO	5	.365218

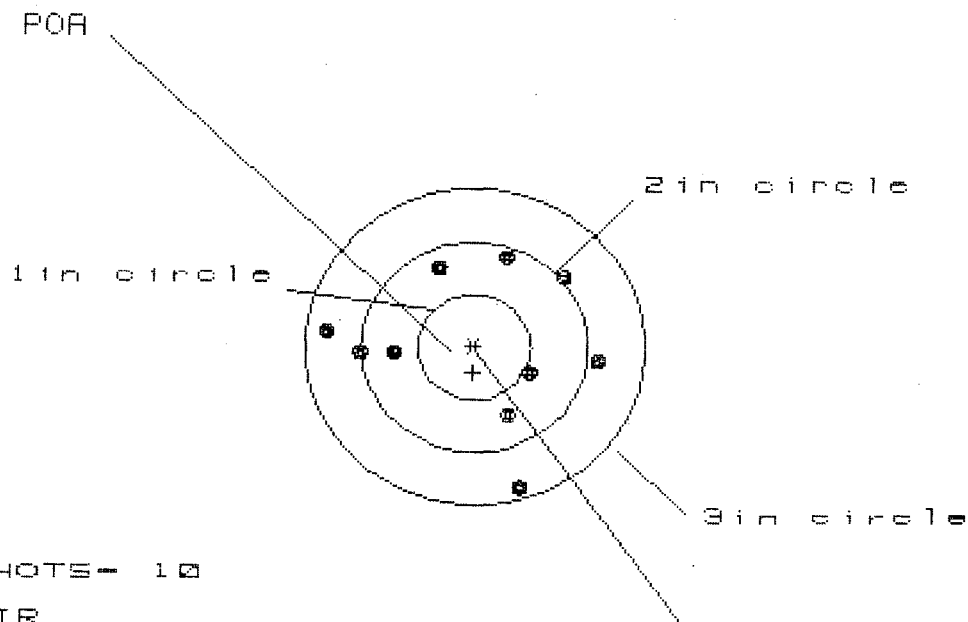
54¹² <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0198
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .131
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .132488
THE AMR FOR THIS RIFLE IS: .8684

16 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523461

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 0

2in = 5

3in = 10

HS = 2.352

VS = 2.155

GS = 2.364

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.080	1.119	.965
MINIMUM X	-1.272	-1.233	-1.139
MAXIMUM Y	.810	.661	.658
MINIMUM Y	-1.345	-.789	-.792
CENTROID X	.010	-.029	.125
CENTROID Y	.241	.390	.393
POA TO CENTROID in.	.241	.391	.412
MIN RADIUS	.586	.694	.592
MEAN RADIUS	.953	.895	.837
MAX RADIUS	1.389	1.233	1.152
HORIZONTAL SPREAD	2.352	2.352	2.104
VERTICAL SPREAD	2.155	1.450	1.450
EXTREME SPREAD	2.364	2.364	2.106
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

16 Nov 1938

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CENTERFIRE PATTERNS # 2

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= 2.089

VS= 1.550

GS= 2.284

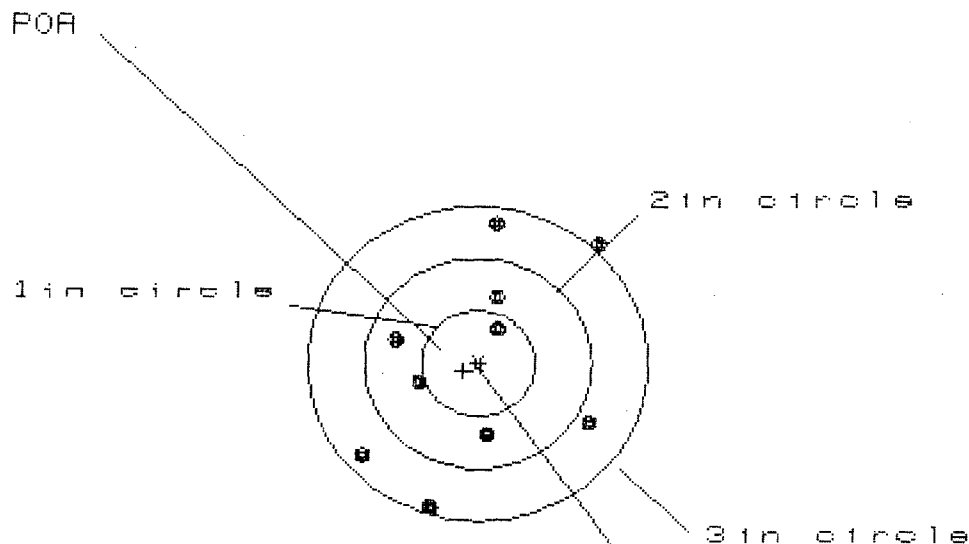
CENTROID #

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.415	.515	.469
MINIMUM X	-.674	-.517	-.563
MAXIMUM Y	.929	.899	.766
MINIMUM Y	-.620	-.651	-.539
CENTROID X	.213	.056	.102
CENTROID Y	.268	.299	.187
POA TO CENTROID in.	.343	.304	.213
MIN RADIUS	.198	.126	.064
MEAN RADIUS	.626	.534	.448
MAX RADIUS	1.442	.971	.791
HORIZONTAL SPREAD	2.089	1.032	1.032
VERTICAL SPREAD	1.550	1.550	1.305
EXTREME SPREAD	2.284	1.783	1.465
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	8		
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= 2.066

VS= 2.664

GS= 2.892

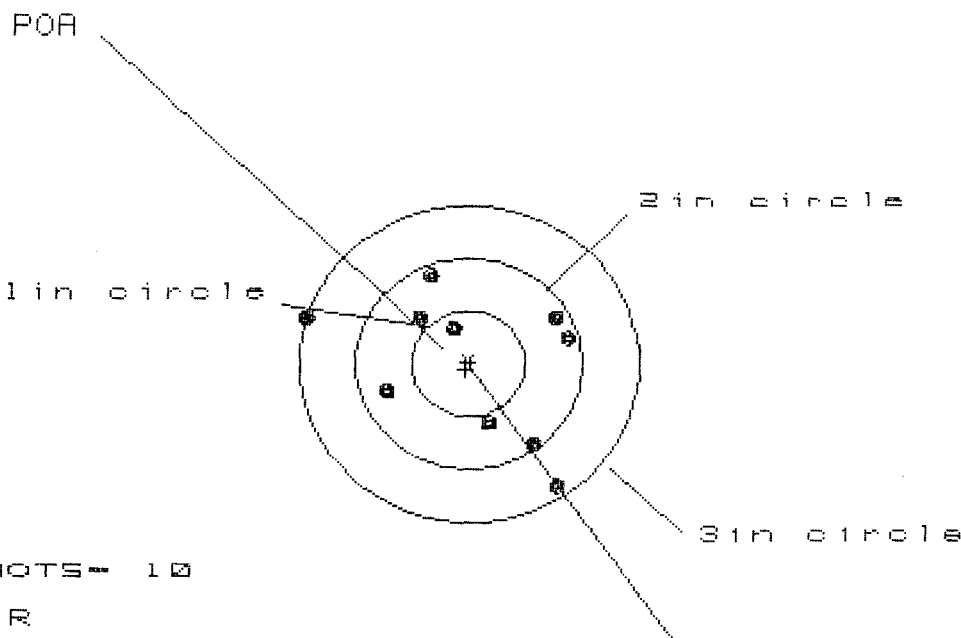
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.055	1.128	1.095
MINIMUM X	:	-1.011	-.894	-.927
MAXIMUM Y	:	1.301	1.428	1.273
MINIMUM Y	:	-1.363	-1.236	-.898
CENTROID X	:	.128	.011	.044
CENTROID Y	:	.067	-.060	.095
POA TO CENTROID in.	:	.144	.061	.104
MIN RADIUS	:	.367	.401	.392
MEAN RADIUS	:	.977	.903	.842
MAX RADIUS	:	1.558	1.463	1.305
HORIZONTAL SPREAD	:	2.066	2.022	2.022
VERTICAL SPREAD	:	2.664	2.664	2.171
EXTREME SPREAD	:	2.892	2.727	2.486
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			9	

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CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 8

3 in = 10

HS = 2.310

VS = 1.920

GS = 2.664

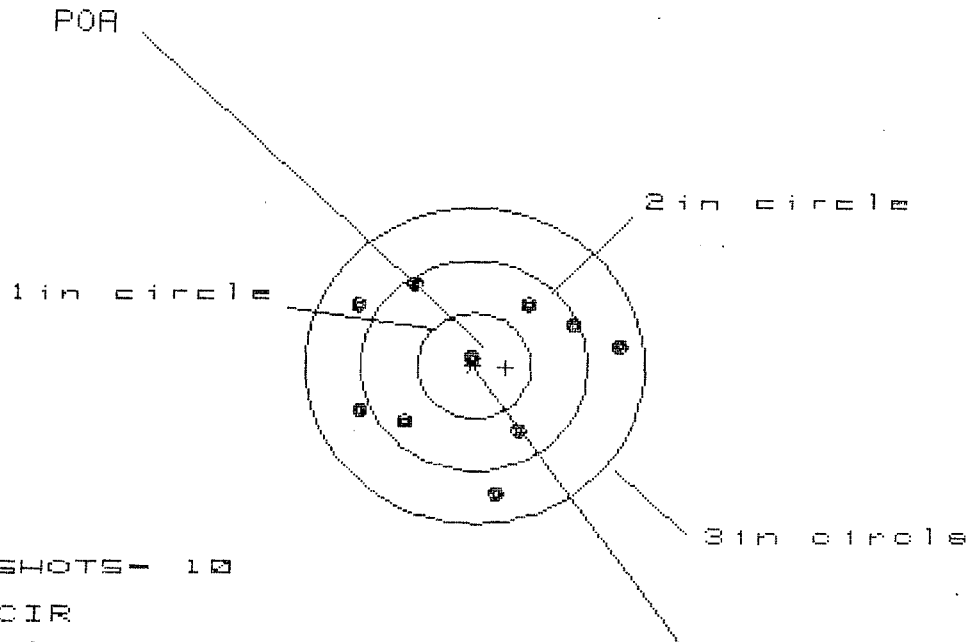
CENTROID #

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.884	.724	.797
MINIMUM X	:	-1.434	-.932	-.859
MAXIMUM Y	:	.796	.842	.708
MINIMUM Y	:	-1.124	-1.078	-.853
CENTROID X	:	.028	.188	.115
CENTROID Y	:	.060	.014	.148
POA TO CENTROID in.	:	.066	.188	.188
MIN RADIUS	:	.340	.457	.306
MEAN RADIUS	:	.878	.806	.733
MAX RADIUS	:	1.493	1.224	1.006
HORIZONTAL SPREAD	:	2.318	1.656	1.656
VERTICAL SPREAD	:	1.920	1.920	1.561
EXTREME SPREAD	:	2.664	2.207	1.837
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	8		
NUMBER IN THREE INCH CIRCLE	=	10		

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 6

3 in = 10

HS= 2.319

VS= 2.000

GS= 2.399

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.262	1.011	1.056
MINIMUM X	:	-1.057	-.917	-.872
MAXIMUM Y	:	.814	.833	.688
MINIMUM Y	:	-1.186	-1.167	-.700
CENTROID X	:	-.280	-.420	-.465
CENTROID Y	:	.019	-.000	.145
POA TO CENTROID in.	:	.281	.420	.487
MIN RADIUS	:	.106	.187	.185
MEAN RADIUS	:	.908	.866	.813
MAX RADIUS	:	1.274	1.219	1.088
HORIZONTAL SPREAD	:	2.319	1.928	1.928
VERTICAL SPREAD	:	2.000	2.000	1.387
EXTREME SPREAD	:	2.399	2.152	2.100
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	