

06523491

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington[®]

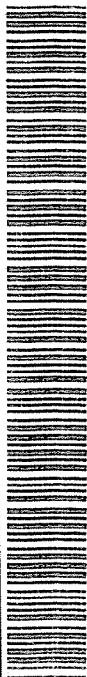
MODEL 700[™] M24

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

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

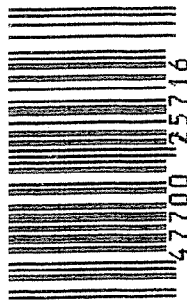
UPPONT
REGISTERED TRADE MARK

SERIAL NO. 06523491	ORDER NO. 5716
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06523491

UPC



047700257167

SWS TRIGGER PULL TEST

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

SERIAL NO. C6523491
DATE 9/5/90
TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.15	2.51	287	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.42	2.16	2.42	283	
PULL #3	2.30	2.29	2.52	291	
PULL #4	2.36	2.29	2.41	294	
PULL #5	2.26	2.34	2.51	292	
TOTAL	11.74	11.23	12.37		
AVG.	2.35	2.24	2.47		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.19	3.36		
PULL #2	3.22	3.29		
PULL #3	3.26	3.29		
PULL #4	3.30	3.31		
PULL #5	3.26	3.34		
TOTAL	16.23	16.59		
AVG.	3.24	3.32		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.12	4.14		4.22
PULL #2	4.20	4.23		4.08
PULL #3	4.16	4.19		4.22
PULL #4	4.09	4.20		4.25
PULL #5	4.09	4.15		4.23
TOTAL	21.66	20.91		21.00
AVG.	4.33	4.18		4.20

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523491
8 Sep 1990

CENTROIDAL DISTANCES

0	TO	1	.163132
1	TO	2	.552963
1	TO	3	.0353412
1	TO	4	.317057
1	TO	5	.39697

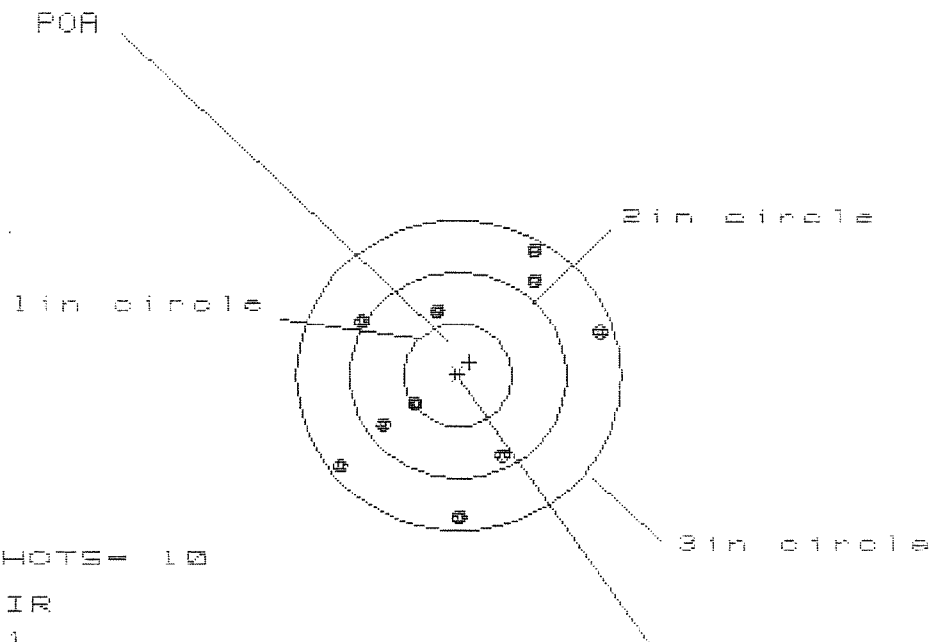
$\frac{53}{34}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0882
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0064
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0884319
THE AMR FOR THIS RIFLE IS: .8814

8 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523491

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 10

HS= 0.374

VS= 2.620

GS= 2.804

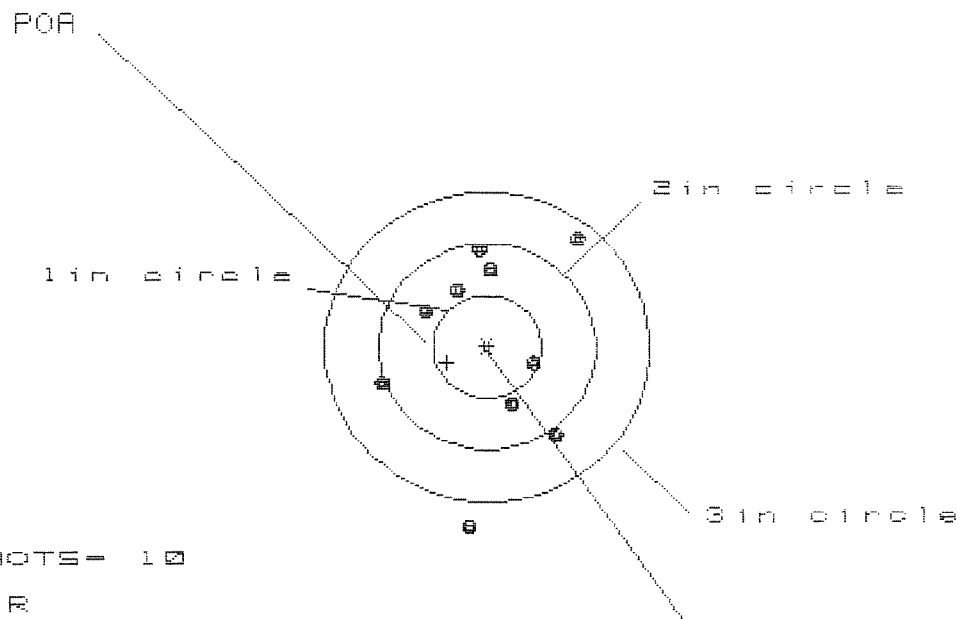
CENTROID *

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.311	1.392	1.269
MINIMUM X	:	-1.063	-.982	-.913
MAXIMUM Y	:	1.263	1.042	.947
MINIMUM Y	:	-1.357	-1.216	-1.311
CENTROID X	:	-.106	-.187	-.064
CENTROID Y	:	-.124	-.265	-.170
POA TO CENTROID in.	:	.164	.324	.182
MIN RADIUS	:	.480	.344	.494
MEAN RADIUS	:	1.049	.979	.958
MAX RADIUS	:	1.457	1.503	1.354
HORIZONTAL SPREAD	:	2.374	2.374	2.182
VERTICAL SPREAD	:	2.620	2.258	2.258
EXTREME SPREAD	:	2.804	2.718	2.363
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	10		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 6

3 in = 9

HS= 1.839

VS= 2.807

GS= 3.000

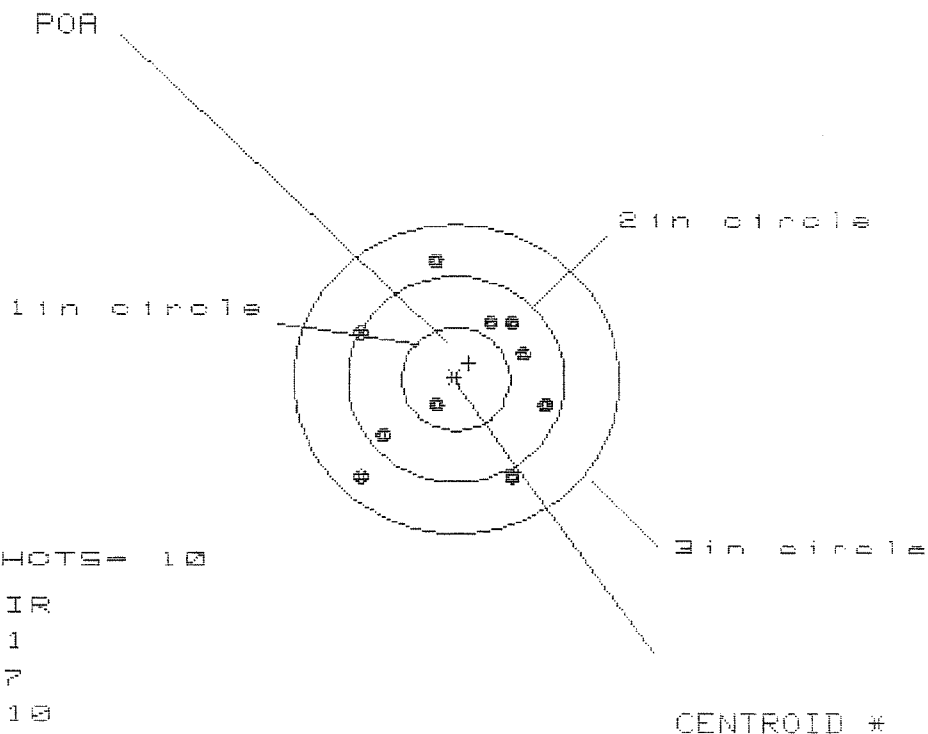
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.836	.811	.678
MINIMUM X	:	-1.003	-1.028	-.926
MAXIMUM Y	:	1.068	.875	.880
MINIMUM Y	:	-1.739	-1.033	-.923
CENTROID X	:	.372	.397	.295
CENTROID Y	:	.154	.347	.237
POA TO CENTROID in.	:	.402	.527	.379
MIN RADIUS	:	.430	.438	.474
MEAN RADIUS	:	.911	.791	.738
MAX RADIUS	:	1.753	1.194	1.145
HORIZONTAL SPREAD	:	1.839	1.839	1.604
VERTICAL SPREAD	:	2.807	1.908	1.803
EXTREME SPREAD	:	3.000	2.322	1.934
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 10

HS= 1.702

VS= 2.170

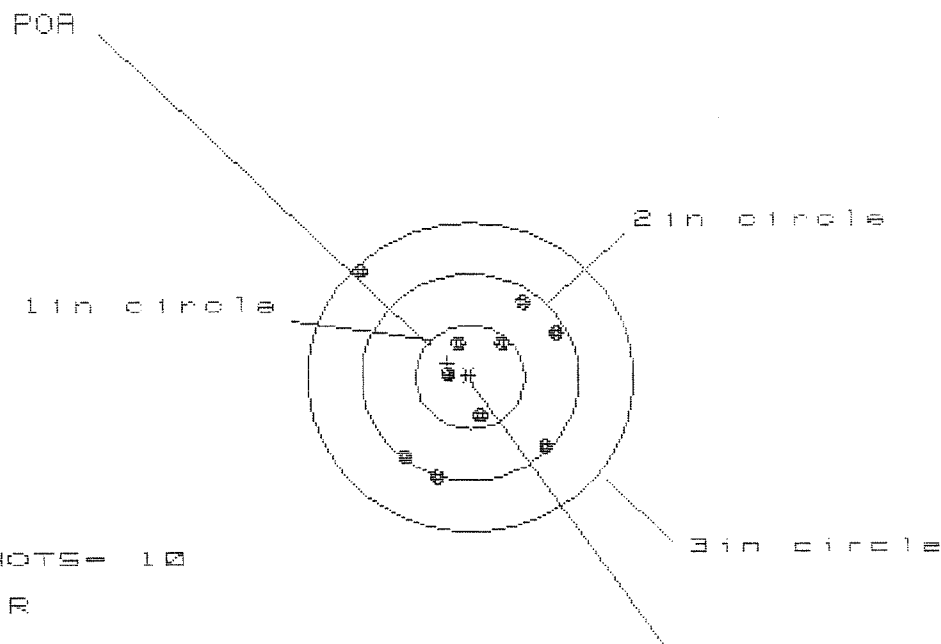
GS= 2.301

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.811	.712	.672
MINIMUM X	:	-.891	-.966	-1.006
MAXIMUM Y	:	1.194	1.094	.592
MINIMUM Y	:	-.976	-1.076	-.939
CENTROID X	:	-.121	-.022	.018
CENTROID Y	:	-.156	-.056	-.193
POA TO CENTROID in.	:	.197	.060	.193
MIN RADIUS	:	.249	.387	.323
MEAN RADIUS	:	.856	.794	.745
MAX RADIUS	:	1.266	1.165	1.110
HORIZONTAL SPREAD	:	1.702	1.678	1.678
VERTICAL SPREAD	:	2.170	2.170	1.531
EXTREME SPREAD	:	2.301	2.301	1.994
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 8

3 in = 10

HS= 1.869

VS= 1.987

GS= 2.360

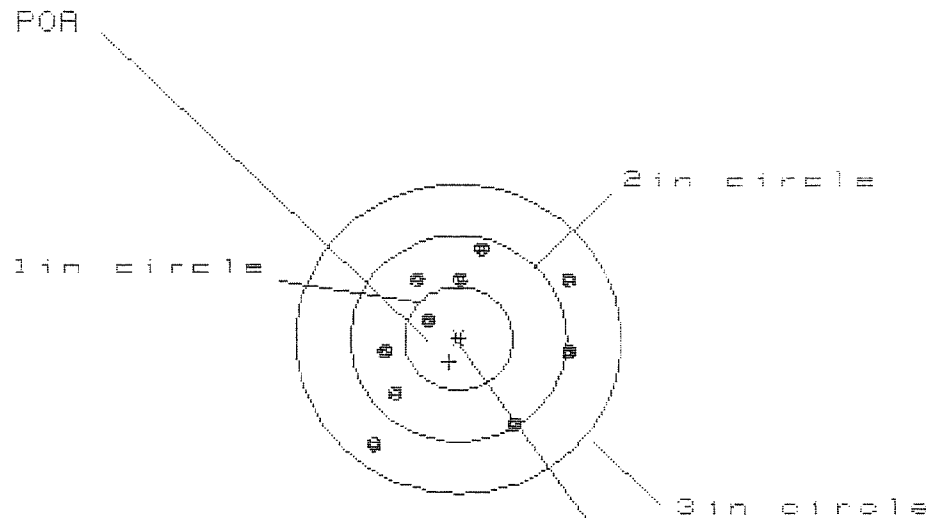
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.835	.720	.666
MINIMUM X	:	-1.034	-.721	-.775
MAXIMUM Y	:	.992	.859	.749
MINIMUM Y	:	-.995	-.885	-.743
CENTROID X	:	.211	.326	.380
CENTROID Y	:	-.130	-.240	-.130
POA TO CENTROID in.	:	.248	.405	.401
MIN RADIUS	:	.252	.292	.304
MEAN RADIUS	:	.760	.684	.636
MAX RADIUS	:	1.433	.985	1.074
HORIZONTAL SPREAD	:	1.869	1.441	1.441
VERTICAL SPREAD	:	1.987	1.744	1.492
EXTREME SPREAD	:	2.360	1.929	1.886
NUMBER IN ONE INCH CIRCLE	=		4	
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 = 8

3 in = 10

HS = 1.817

VS = 1.902

GS = 2.414

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.005	.915	1.014
MINIMUM X	-.812	-.765	-.650
MAXIMUM Y	.839	.721	.772
MINIMUM Y	-1.063	-.975	-.924
CENTROID X	.085	.175	.060
CENTROID Y	.224	.342	.291
POA TO CENTROID in.	.239	.384	.297
MIN RADIUS	.303	.349	.250
MEAN RADIUS	.831	.764	.715
MAX RADIUS	1.337	1.046	1.048
HORIZONTAL SPREAD	1.817	1.680	1.664
VERTICAL SPREAD	1.902	1.696	1.696
EXTREME SPREAD	2.414	1.868	1.716
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6523491

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		8-21-90	DB
600	Proof		8-21-90	DB
607	Check Headspace		8-21-90	DB
610	Dis-assemble Gun		8-21-90	DB
612	Magnaflux Barrel Action		8/22/90	KCR
	Magnaflux Bolt		8/22/90	KCR
615	Rollmark Caliber		8/22/90	GS
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)		8/22/90	TA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/31/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/31/90	RW
	C) Inspect Ejector Hole for Chamfer		8/31/90	RW
	D) Oil Firing Pin Ass'y		8/31/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9/5/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			9/6/90	WB
	G) Safety Off Force	2	2	2			9/6/90	WB
	H) Trigger Pull Test & Retainability						9/5/90	WB
	I) Firing Pin Indent	.0225	.0225	.0225			9/6/90	WB
	J) Assemble Stock						9/7/90	RW
	K) Assemble Swivel Studs						9/9/90	JS
	L) Attach Front and Rear Sight Assemblies						9/7/90	RW
	M) Iron Sight Alignment						9/2/90	RW
	N) Detach Front & Rear Sights & place in numbered container						9/7/90	RW
	O) Attach Scope to Rifle						9/7/90	RW
	P) Detach & Attach Scope 20 Times						9/7/90	RW
640	Gallery Target & Test						9-8-90	DH
	A) Time						9-8-90	DH
	B) Malfunctions						9-8-90	DH
	C) Pierced Primers						9-8-90	DH
	D) Optical Clarity of Scope						9-8-90	DH
645	Inspect for Live Ammo						9-8-90	DH
655	Final Inspection							
	A) Headspace						9/9/90	JS
	B) Trigger Pull	287	283	291	294	292	9/9/90	JS
	C) Function						9/9/90	JS
660	Pack						9-18-90	JS