

06648985

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Call



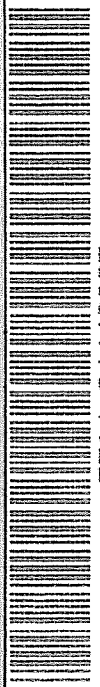
Remington
REG. U.S. PAT. & TM. OFF.

MODEL 700™ H24

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

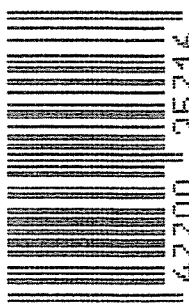
SERIAL NO. C6648985	ORDER NO. 5716
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MADE IN LION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



5716 C6648985

UPC



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6648985

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	7/24/91	KH
600	Proof		7/24/91	KH
607	Check Headspace		7/24/91	KH
610	Dis-assemble Gun		7/24/91	KH
612	Magnaflux Barrel Action		AUG 7 1991	KR
	Magnaflux Bolt		AUG 7 1991	KR
615	Rollmark Caliber		AUG 7 1991	JS
617	Drill and Tap Sight Holes		AUG 7 1991	LB
618	Polish Barrel		AUG 13 1991	WB
620	Apply Coatings (Barrel Action)		8-7-91	AD
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		9/29/91	KH
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/29/91	KH
	C) Inspect Ejector Hole for Chamfer		9/29/91	KH
	D) Oil Firing Pin Ass'y		9/29/91	KH
	E) Adjust Trigger Pull to Min Setting and Stake		8/30/91	JS

op. #	OP. NAME	READINGS			DATE	INIT
625 cont.	F) Safety On Force	6	6	6	8/30/91	JU
	G) Safety Off Force	3	3	3	8/30/91	JU
	H) Trigger Pull Test & Retainability				8/30/91	JU
	I) Firing Pin Indent	.0225	.023	.023	8/30/91	JU
	J) Assemble Stock				8/30/91	KL
	K) Assemble Swivel Studs				9-9-91	AC
	L) Attach Front and Rear Sight Assemblies				8/30/91	KL
	M) Iron Sight Alignment				8/30/91	KL
	N) Detach Front & Rear Sights & place in numbered container				8/30/91	KL
	O) Attach Scope to Rifle				8/30/91	KL
	P) Detach & Attach Scope 20 Times				8/30/91	KL
640	Gallery Target & Test				9-3-91	NF
	A) Time				"	NF
	B) Malfunctions				"	NF
	C) Pierced Primers				"	NF
	D) Optical Clarity of Scope				"	NF
645	Inspect for Live Ammo	ADJUSTED BBL 9/10/91 WBS			9-3-91	NF
655	Final Inspection					
	A) Headspace				9-9-91	AC
	B) Trigger Pull	2.69	2.70	2.58	9/6/91	JU
	C) Function				9-9-91	KL
660	Pack				9-17-91	VF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6648985

DATE 8/30/91

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.42	2.38	2.69	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.43	2.51	2.45	2.70	
PULL #3	2.24	2.49	2.50	2.58	
PULL #4	2.59	2.45	2.48	2.65	
PULL #5	2.48	2.32	2.40	2.69	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.27	3.64		
PULL #2	3.44	3.69		
PULL #3	3.54	3.61		
PULL #4	3.60	3.60		
PULL #5	3.41	3.72		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.41	4.23		4.53
PULL #2	4.54	4.56		4.59
PULL #3	4.35	4.49		4.64
PULL #4	4.39	4.43		4.60
PULL #5	4.60	4.29		4.62
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6648985
4 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.306276
1 TO	2	.479843
1 TO	3	.0503587
1 TO	4	.359201
1 TO	5	.739321

345 <----POR

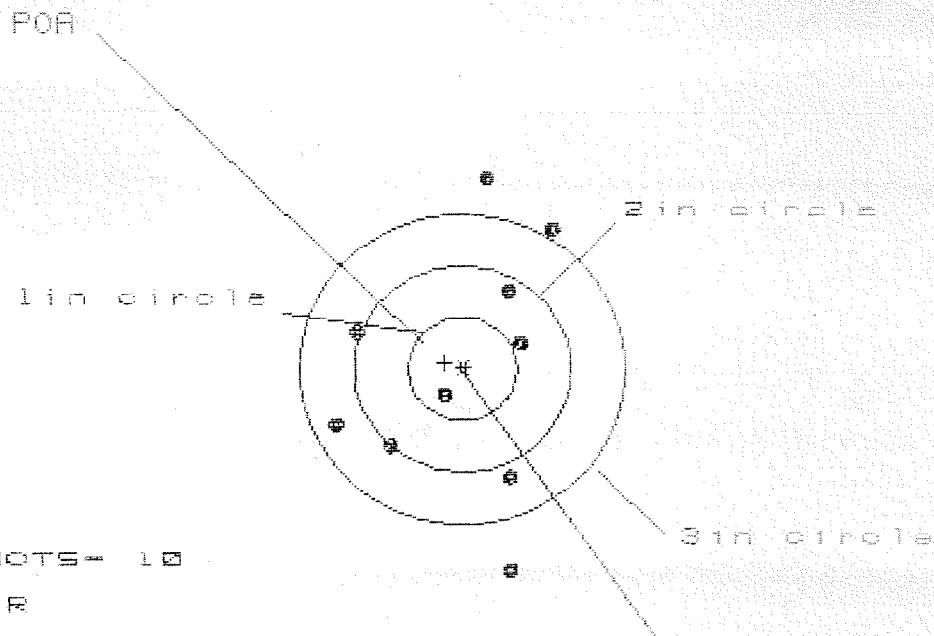
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .007
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0412
THE RESULTING AVERAGE PCI RADIUS FOR THIS RIFLE IS: .0417904

THE RIFLE IS: .9682

3 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8648985

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 1

2in = 3

3in = 7

HS = 2.0320

VS = 3.818

GS = 3.827

PATTERN #	2	3	4
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.880	.932	.964
MINIMUM X	-1.149	-1.098	-1.066
MAXIMUM Y	1.835	1.615	1.372
MINIMUM Y	-1.983	-1.258	-1.056
CENTROID X	.169	.117	.085
CENTROID Y	-.055	.165	-.037
POA TO CENTROID in.	.177	.202	.093
MIN RADIUS	.311	.504	.300
MEAN RADIUS	1.177	1.082	.983
MPY RADIUS	2.037	1.634	1.676
HORIZONTAL SPREAD	2.030	2.030	2.030
VERTICAL SPREAD	3.818	2.873	2.428
EXTREME SPREAD	3.827	2.882	2.778
NUMBER IN ONE INCH CIRCLE	= 1		
NUMBER IN TWO INCH CIRCLE	= 3		
NUMBER IN THREE INCH CIRCLE	= 7		

3 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/0864B385

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 9

3in = 10

HS= 1.936

VS= 1.786

GS= 2.002

CENTROID *

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.811

.686

.692

MINIMUM X

-1.125

-.531

-.525

MAXIMUM Y

.960

.930

.766

MINIMUM Y

-.826

-.856

-.739

CENTROID X

.042

.167

.161

CENTROID Y

.102

.132

.015

POA TO CENTROID in.

.111

.213

.162

MIN RADIUS

.254

.297

.333

MEAN RADIUS

.718

.655

.619

MAX RADIUS

1.155

.932

.818

HORIZONTAL SPREAD

1.936

1.217

1.217

VERTICAL SPREAD

1.786

1.786

1.505

EXTREME SPREAD

2.002

1.832

1.558

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

9

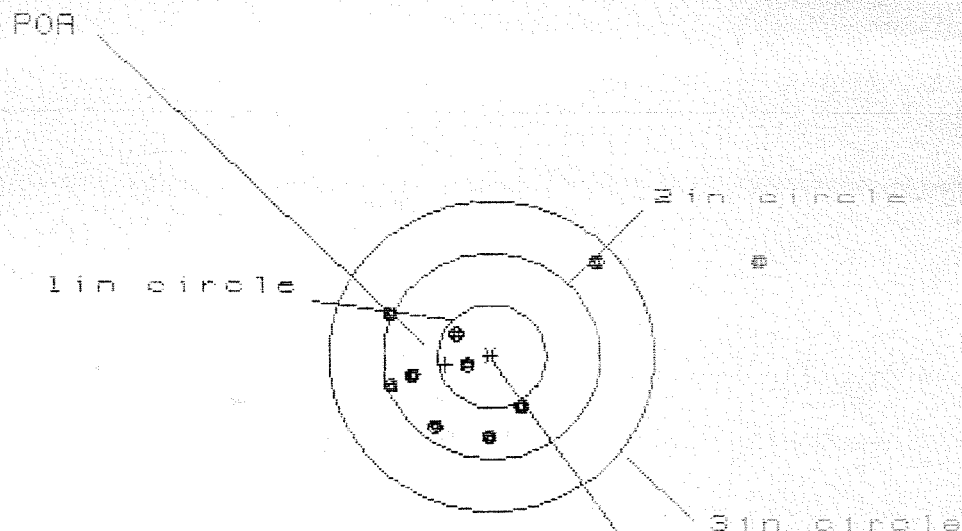
NUMBER IN THREE INCH CIRCLE =

10

3 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6640385

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 3.393

VS= 1.690

CS= 3.563

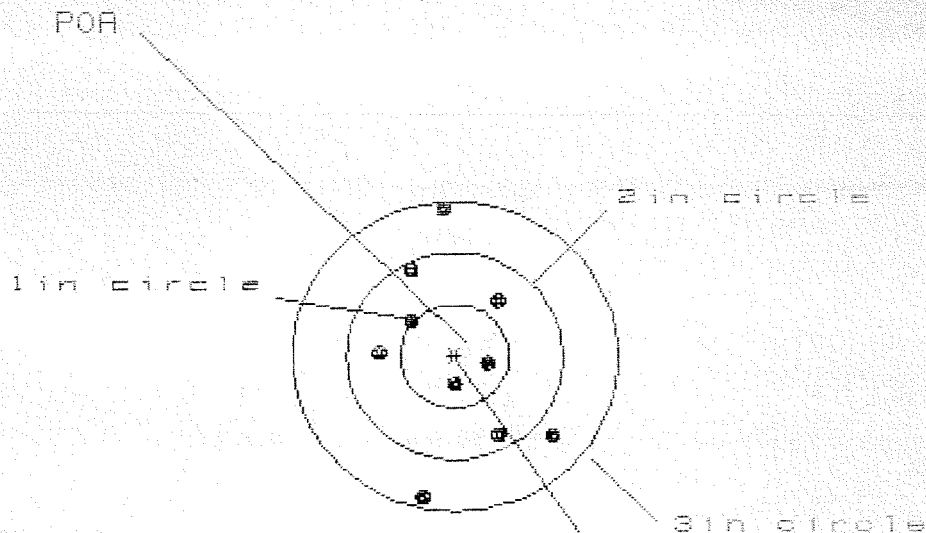
CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.442	1.237	.678
MINIMUM X	:	-.951	-.680	-.525
MAXIMUM Y	:	.916	1.015	.649
MINIMUM Y	:	-.774	-.675	-.548
CENTROID X	:	.430	.159	.004
CENTROID Y	:	.083	-.016	-.143
POA TO CENTROID in.	:	.438	.160	.143
MIN RADIUS	:	.200	.094	.294
MEAN RADIUS	:	.944	.666	.531
MAX RADIUS	:	2.598	1.600	.835
HORIZONTAL SPREAD	:	3.393	1.917	1.203
VERTICAL SPREAD	:	1.690	1.690	1.197
EXTREME SPREAD	:	3.563	2.247	1.533
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

3 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C86483B5

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

CENTROID *

HS= 1.536

VS= 2.801

GS= 2.805

PATTERN #

3

SHOTS (BEST OF)

10

9

8

MAXIMUM X : .857 .841 .801

MINIMUM X : -.679 -.695 -.735

MAXIMUM Y : 1.453 .973 .825

MINIMUM Y : -1.348 -1.187 -.786

CENTROID X : -.300 -.284 -.244

CENTROID Y : .063 -.098 .050

POA TO CENTROID in. : .307 .300 .249

MIN RADIUS : .284 .123 .238

MEAN RADIUS : .832 .748 .682

MAX RADIUS : 1.460 1.229 1.122

HORIZONTAL SPREAD : 1.536 1.536 1.536

VERTICAL SPREAD : 2.801 2.160 1.611

EXTREME SPREAD : 2.805 2.165 2.074

NUMBER IN ONE INCH CIRCLE = 2

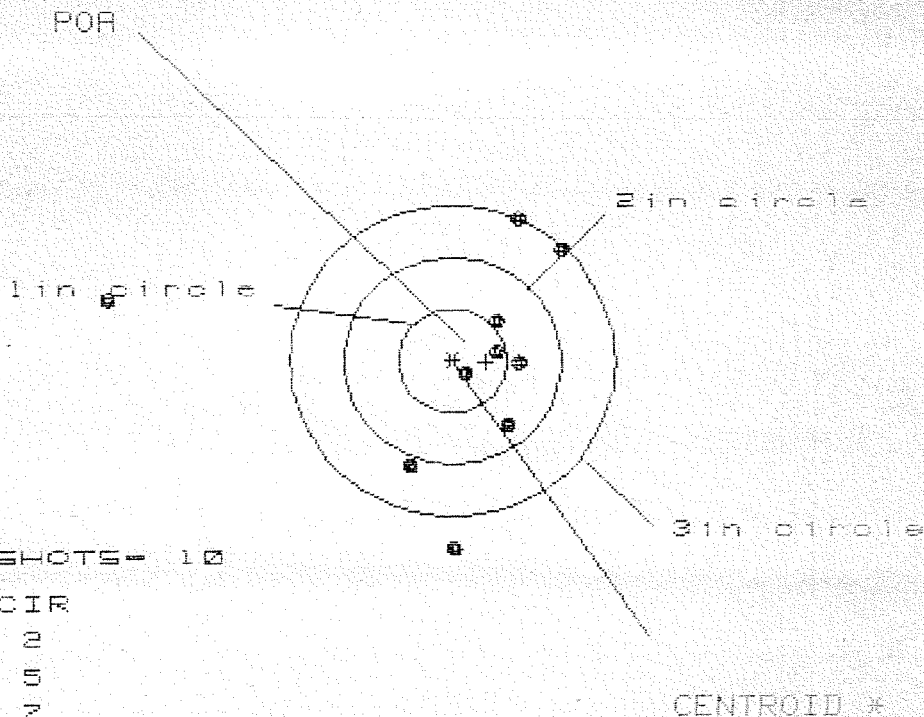
NUMBER IN TWO INCH CIRCLE = 7

NUMBER IN THREE INCH CIRCLE = 10

3 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8548985

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 7

HS- 4.288

VS- 3.241

GS- 4.318

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.045	.685	.639
MINIMUM X	-3.243	-.724	-.770
MAXIMUM Y	1.397	1.459	1.236
MINIMUM Y	-1.844	-1.782	-1.140
CENTROID X	-.306	.054	.100
CENTROID Y	.013	-.049	.173
POA TO CENTROID in.	.306	.073	.200
MIN RADIUS	.152	.193	.054
MEAN RADIUS	1.170	.835	.683
MAX RADIUS	3.292	1.819	1.376
HORIZONTAL SPREAD	4.288	1.409	1.409
VERTICAL SPREAD	3.241	3.241	2.377
EXTREME SPREAD	4.318	3.291	2.553
NUMBER IN ONE INCH CIRCLE	= 2		
NUMBER IN TWO INCH CIRCLE	= 5		
NUMBER IN THREE INCH CIRCLE	= 7		

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06648985
14 Sep 1991

CENTROIDAL DISTANCES

0 TO 1	.0790759
1 TO 2	.297809
1 TO 3	.151793
1 TO 4	.0862148
1 TO 5	.110635

 ----POA

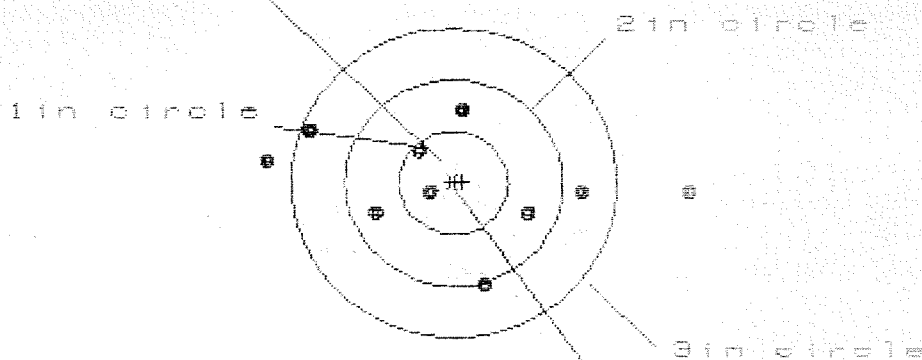
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0304
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .021
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0437671
THE AMR FOR THIS RIFLE IS: .8824

14 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8648905.1

CENTERFIRE PATTERNS # 1

FOR



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 3.909

VS= 1.732

GS= 3.929

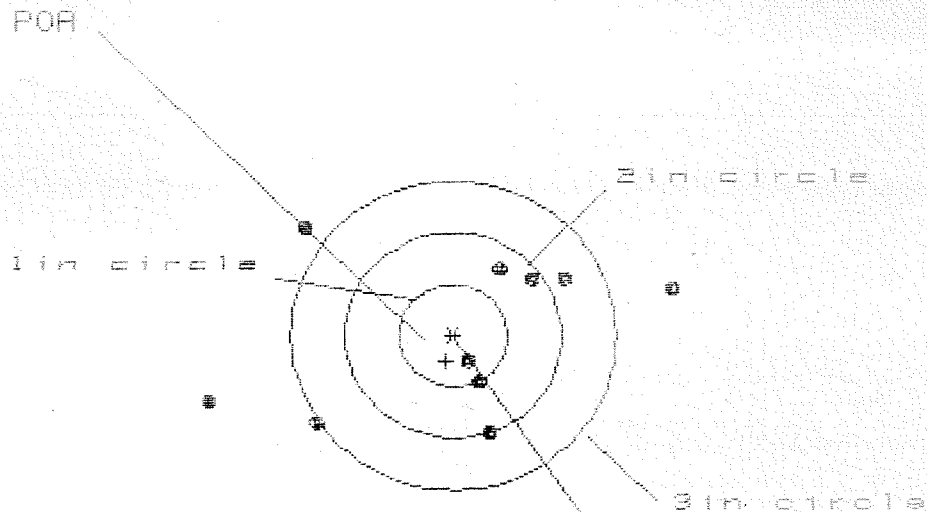
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.177	1.431	1.245
MINIMUM X	-1.732	-1.490	-1.237
MAXIMUM Y	.738	.723	.754
MINIMUM Y	-.994	-1.009	-.970
CENTROID X	-.078	-.320	-.134
CENTROID Y	-.013	.002	-.029
FOR TO CENTROID in.	.079	.320	.137
MIN RADIUS	.269	.111	.212
MEAN RADIUS	1.049	.884	.613
MAX RADIUS	2.181	1.510	1.350
HORIZONTAL SPREAD	3.909	2.921	2.482
VERTICAL SPREAD	1.732	1.732	1.732
EXTREME SPREAD	3.929	2.945	2.568
NUMBER IN ONE INCH CIRCLE	= 2		
NUMBER IN TWO INCH CIRCLE	= 5		
NUMBER IN THREE INCH CIRCLE	= 8		

14 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8848365.1

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 6

HS= 4.302

VS= 1.978

GS= 4.455

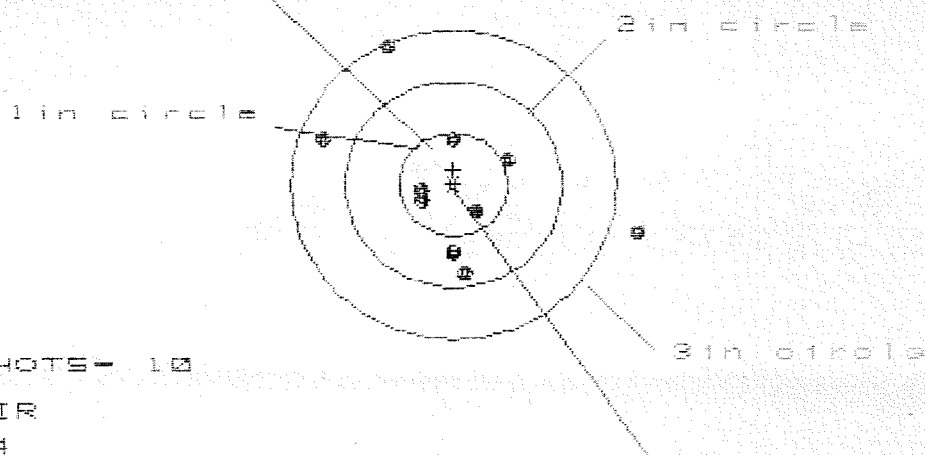
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.019	1.765	.998
MINIMUM X	-2.283	-1.617	-1.396
MAXIMUM Y	1.006	.929	.978
MINIMUM Y	-.972	-1.049	-1.000
CENTROID X	.069	.323	.102
CENTROID Y	.246	.323	.274
POA TO CENTROID in.	.255	.456	.292
MIN RADIUS	.316	.378	.329
MEAN RADIUS	1.246	1.075	.997
MAX RADIUS	2.385	1.865	1.705
HORIZONTAL SPREAD	4.302	3.382	2.394
VERTICAL SPREAD	1.978	1.978	1.978
EXTREME SPREAD	4.455	3.555	2.732
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	6		

14 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C864B9B5.1

CENTERFIRE PATTERNS # 3

POA



OF SHOTS - 10

IN CIR

1 in = 4

2 in = 7

3 in = 9

HS = 2.895

VS = 2.126

GS = 3.033

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.679	.730	.672
MINIMUM X	:	-1.216	-1.029	-1.087
MAXIMUM Y	:	1.317	1.262	.547
MINIMUM Y	:	-.809	-.864	-.706
CENTROID X	:	.002	-.185	-.127
CENTROID Y	:	-.142	-.087	-.245
POA TO CENTROID in.	:	.142	.204	.276
MIN RADIUS	:	.314	.177	.164
MEAN RADIUS	:	.793	.677	.561
MAX RADIUS	:	1.751	1.343	1.200
HORIZONTAL SPREAD	:	2.895	1.759	1.759
VERTICAL SPREAD	:	2.126	2.126	1.253
EXTREME SPREAD	:	3.033	2.260	1.807
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

14 Sep 1931

FILE: PATTERNING/CENTERFIRE_PATT/C664B9B5.1

CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 7

3 in = 10

HS = 2.461

VS = 1.368

GS = 2.463

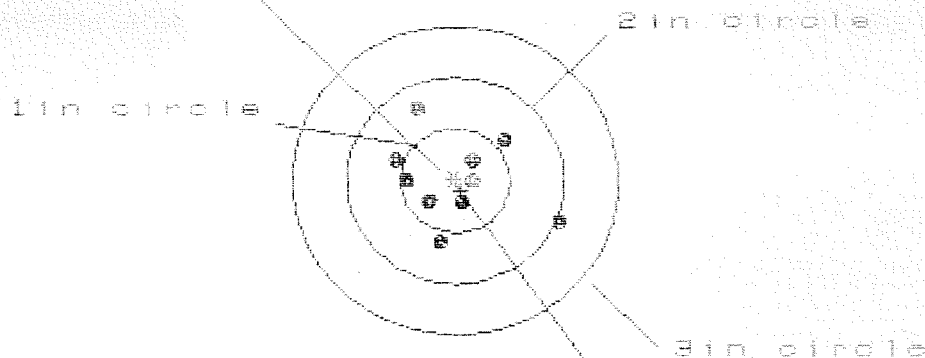
PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.348	.988	.768
MINIMUM X	-1.113	-.963	-.874
MAXIMUM Y	.628	.609	.571
MINIMUM Y	-.740	-.759	-.797
CENTROID X	-.131	-.281	-.161
CENTROID Y	-.081	-.062	-.024
POA TO CENTROID in.	.155	.288	.163
MIN RADIUS	.201	.102	.145
MEAN RADIUS	.834	.753	.719
MAX RADIUS	1.360	1.009	.960
HORIZONTAL SPREAD	2.461	1.851	1.642
VERTICAL SPREAD	1.368	1.368	1.368
EXTREME SPREAD	2.463	1.854	1.854
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

14 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C864B985.1

CENTERFIRE PATTERNS # 5

POB



OF SHOTS = 10

IN CIR

1in = 5

2in = 9

3in = 10

HS = 1.431

VS = 1.317

GS = 1.685

CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.926	.600	.566
MINIMUM X	-.505	-.402	-.436
MAXIMUM Y	.604	.641	.406
MINIMUM Y	-.633	-.676	-.596
CENTROID X	-.054	-.157	-.123
CENTROID Y	.095	.138	.058
POB TO CENTROID in.	.110	.209	.126
MIN RADIUS	.143	.251	.188
MEAN RADIUS	.490	.432	.386
MAX RADIUS	1.004	.696	.697
HORIZONTAL SPREAD	1.431	1.002	1.002
VERTICAL SPREAD	1.317	1.317	1.002
EXTREME SPREAD	1.685	1.335	1.197
NUMBER IN ONE INCH CIRCLE	= 5		
NUMBER IN TWO INCH CIRCLE	= 9		
NUMBER IN THREE INCH CIRCLE	= 10		