

C6648991

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

* Includes 1 in chamber.

Remington

Remington[®] **DU PONT**
REG. U.S. PAT. & TM. OFF.

MODEL 700TM 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.

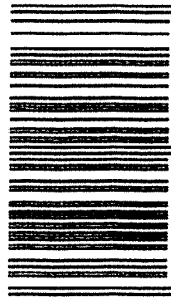
SERIAL NO. C6648991

ORDER NO. 5716



5716 C6648991

UPC



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6648991

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 2	9 1	RW
600	Proof	7 2	9 1	RW
607	Check Headspace	7 2	9 1	RW
610	Dis-assemble Gun	7 2	9 1	RW
612	Magnaflux Barrel Action		JUL 22 1991	GS
	Magnaflux Bolt		JUL 22 1991	GS
615	Rollmark Caliber		JUL 22 1991	GS
617	Drill and Tap Sight Holes		JUL 22 1991	FB
618	Polish Barrel		7/28/91	WB
620	Apply Coatings (Barrel Action)		8-22-91	DA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/29/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/29/91	RW
	C) Inspect Ejector Hole for Chamfer		8/29/91	RW
	D) Oil Firing Pin Ass'y		8/29/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/29/91	DH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			9-7-91	DH
	G) Safety Off Force	3	3 1/4	3 1/4			9-7-91	DH
	H) Trigger Pull Test & Retainability						9-7-91	DH
	I) Firing Pin Indent	.021	.021	.022			9-7-91	DH
	J) Assemble Stock						9/9/91	RW
	K) Assemble Swivel Studs						9-12-91	DH
	L) Attach Front and Rear Sight Assemblies						9/9/91	RW
	M) Iron Sight Alignment						9/9/91	RW
	N) Detach Front & Rear Sights & place in numbered container						9/9/91	RW
	O) Attach Scope to Rifle						9/9/91	RW
	P) Detach & Attach Scope 20 Times						9/9/91	RW
640	Gallery Target & Test						9/9/91	KT
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	KT
645	Inspect for Live Ammo						9/9/91	KT
655	Final Inspection							
	A) Headspace						9-12-91	DH
	B) Trigger Pull	210	216	211	214	211	9-11-91	DH
	C) Function						9-12-91	DH
660	Pack						9-18-91	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. CCG48991

DATE 9-7-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.57	2.42	2.51	210	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.32	2.55	216	
PULL #3	2.56	2.38	2.58	211	
PULL #4	2.44	2.34	2.60	214	
PULL #5	2.39	2.44	2.61	211	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.56		
PULL #2	3.27	3.50		
PULL #3	3.21	3.46		
PULL #4	3.42	3.23		
PULL #5	3.31	3.42		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.07	4.05		4.07
PULL #2	4.12	4.17		4.05
PULL #3	4.24	4.32		4.13
PULL #4	4.21	4.25		4.05
PULL #5	4.00	4.22		4.15
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6648991
9 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.0573847
1 TO	2	.045793
1 TO	3	.0782624
1 TO	4	.109836
1 TO	5	.181025

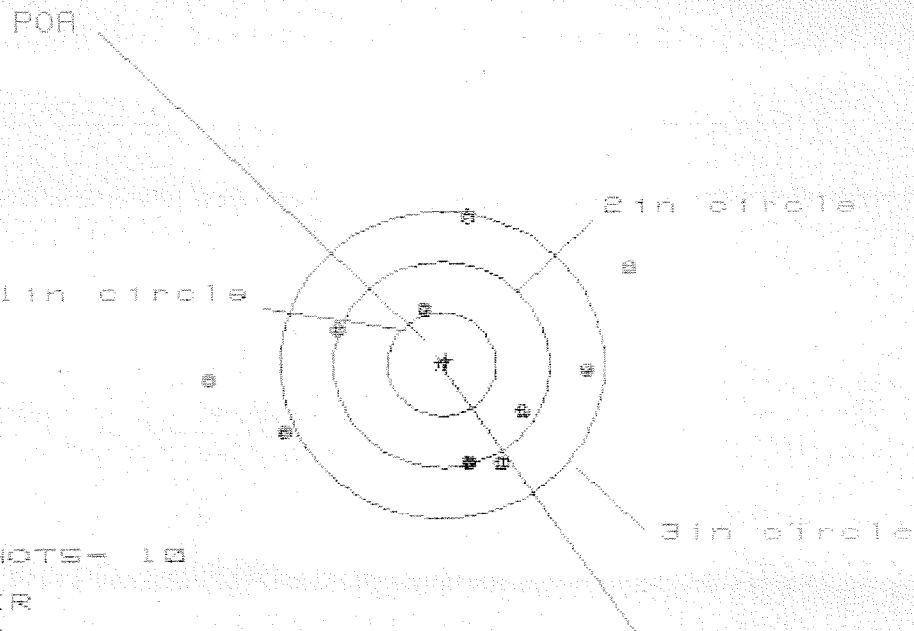
SW <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0578
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0036
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .057912
THE AMP FOR THIS RIFLE IS: .0056

8 Sep 1991

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CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 0

2in = 3

3in = 7

HS= 3.861

VS= 2.390

GS= 4.028

PATTERN #

SHOTS (BEST OF)

MAXIMUM X

MINIMUM X

MAXIMUM Y

MINIMUM Y

CENTROID X

CENTROID Y

POA TO CENTROID in.

MIN RADIUS

MEAN RADIUS

MAX RADIUS

HORIZONTAL SPREAD

VERTICAL SPREAD

EXTREME SPREAD

NUMBER IN ONE INCH CIRCLE =

NUMBER IN TWO INCH CIRCLE =

NUMBER IN THREE INCH CIRCLE =

10

9

8

1.705

1.466

1.244

-2.156

-1.675

-1.492

1.417

1.398

1.519

-1.973

-1.992

-1.071

-1.038

.201

.010

-1.043

-1.024

-1.145

.057

.203

.146

.539

.636

.653

1.296

1.176

1.094

2.162

1.812

1.597

3.861

3.141

2.736

2.390

2.390

2.390

4.028

3.550

2.797

0

3

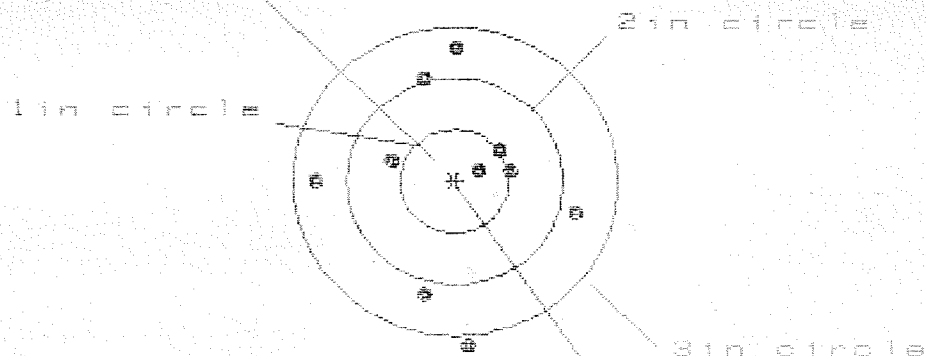
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9 Sep 1991

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CENTERFIRE PATTERNS # 2

POA



OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 9

HS= 2.337

VS= 2.888

GS= 2.889

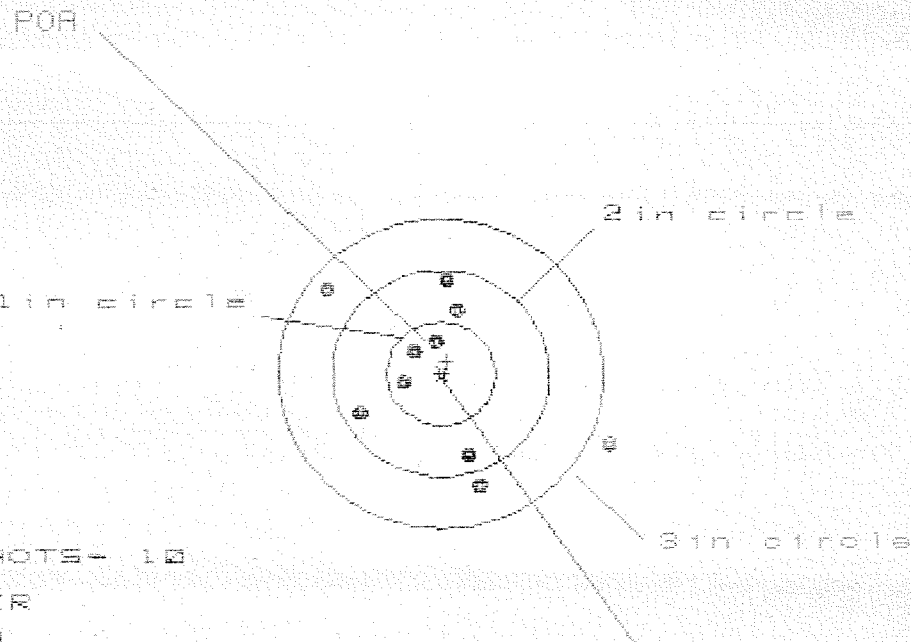
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.094	1.107	1.109
MINIMUM X	-1.243	-1.230	-1.228
MAXIMUM Y	1.293	1.116	1.001
MINIMUM Y	-1.587	-1.319	-1.179
CENTROID X	-.014	-.027	-.029
CENTROID Y	-.004	.173	.033
POA TO CENTROID in.	.014	.175	.044
MIN RADIUS	.202	.234	.208
MEAN RADIUS	.928	.835	.798
MAX RADIUS	1.592	1.337	1.228
HORIZONTAL SPREAD	2.337	2.337	2.337
VERTICAL SPREAD	2.888	2.435	2.180
EXTREME SPREAD	2.883	2.446	2.358
NUMBER IN ONE INCH CIRCLE =	1	1	1
NUMBER IN TWO INCH CIRCLE =	4	4	4
NUMBER IN THREE INCH CIRCLE =	9	9	9

9 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6648991

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 2.619

VS= 2.017

GS= 3.011

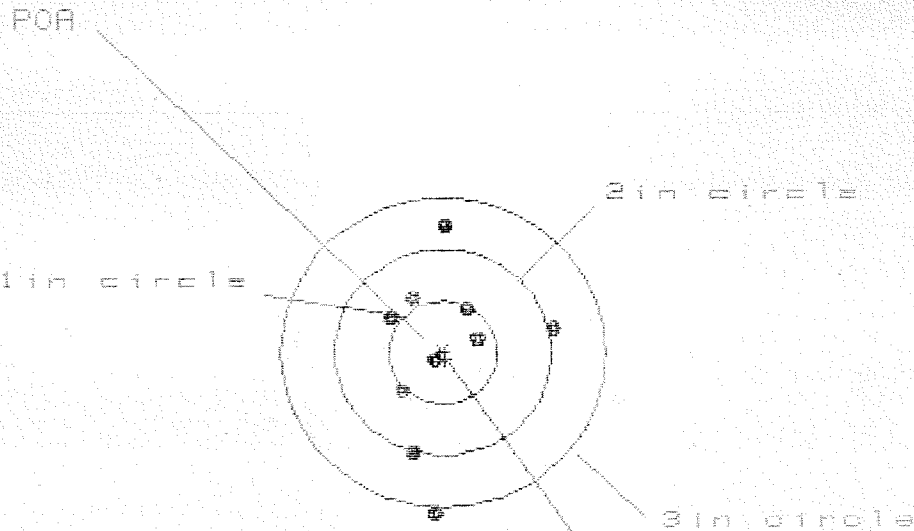
CENTROID *

PATTERN #	1	3	9
SHOTS (BEST OF)	10	9	9
MAXIMUM X	1.568	.489	.379
MINIMUM X	-1.051	-.877	-.697
MAXIMUM Y	.941	.869	.964
MINIMUM Y	-1.077	-1.148	-1.053
CENTROID X	-.052	-.226	-.116
CENTROID Y	-.120	-.048	-.143
POA TO CENTROID in.	.130	.231	.185
MIN RADIUS	.291	.123	.253
MEAN RADIUS	.839	.699	.660
MAX RADIUS	1.696	1.248	1.119
HORIZONTAL SPREAD	2.619	1.366	1.076
VERTICAL SPREAD	2.017	2.017	2.017
EXTREME SPREAD	3.011	2.352	2.038
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

9 Sep 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 1.538

VS= 2.794

GS= 2.798

CENTROID *

PATTERN #

4

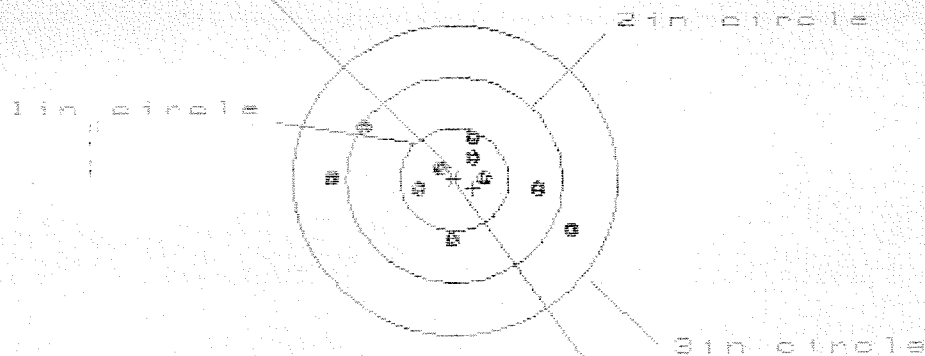
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.049	1.035	1.036
MINIMUM X	-1.489	-1.503	-1.582
MAXIMUM Y	1.233	1.060	.514
MINIMUM Y	-1.561	-1.101	-1.969
CENTROID X	-.018	-.004	-.005
CENTROID Y	.065	.238	.106
POA TO CENTROID in.	.067	.238	.106
MIN RADIUS	.125	.268	.160
MEAN RADIUS	.758	.651	.596
MAX RADIUS	1.566	1.145	1.051
HORIZONTAL SPREAD	1.538	1.538	1.538
VERTICAL SPREAD	2.794	2.161	1.483
EXTREME SPREAD	2.798	2.184	1.769
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

5 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8848991

CENTERFIRE PATTERNS # 5

POA



OF SHOTS= 10

IN CIR

1in = 5

2in = 8

3in = 10

CENTROID #

HS= 2.252

VS= 1.120

GS= 2.326

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.082	.846	.714
MINIMUM X	:	-1.171	-1.050	-.800
MAXIMUM Y	:	.539	.480	.480
MINIMUM Y	:	-.581	-.640	-.640
CENTROID X	:	-.167	-.288	-.156
CENTROID Y	:	.084	.143	.143
POA TO CENTROID in.	:	.187	.321	.212
MIN RADIUS	:	.160	.062	.133
MEAN RADIUS	:	.607	.537	.453
MAX RADIUS	:	1.203	1.050	.933
HORIZONTAL SPREAD	:	2.252	1.896	1.514
VERTICAL SPREAD	:	1.120	1.120	1.120
EXTREME SPREAD	:	2.326	1.904	1.653
NUMBER IN ONE INCH CIRCLE	=	5		
NUMBER IN TWO INCH CIRCLE	=	8		
NUMBER IN THREE INCH CIRCLE	=	10		