

C6649013

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington




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

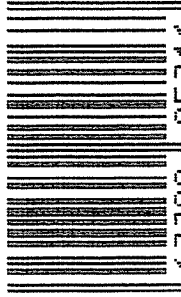
MODEL 700TM H24

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

SERIAL NO.
C6849013

ORDER NO.
5716

UPC



0 47700 25716 2



5716 C6849013

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649013

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	LB
618	Polish Barrel		7/22/91	WB
620	Apply Coatings (Barrel Action)		8-22-91	TS
	Apply Coating (Bolt)		8-22-91	TS
625	Final Assembly			
	A) Clean inside of Bolt Assembly		8/28/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/28/91	RW
	C) Inspect Ejector Hole for Chamfer		8/28/91	RW
	D) Oil Firing Pin Ass'y		8/28/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/31/91	TH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	5 1/2	6			8-31-91	DH
	G) Safety Off Force	2 1/2	2 1/2	2 3/4			8-31-91	DH
	H) Trigger Pull Test & Retainability						8/31/91	RU
	I) Firing Pin Indent	.022	.021	.021			8-31-91	DH
	J) Assemble Stock						8/31/91	RU
	K) Assemble Swivel Studs						8-31-91	DH
	L) Attach Front and Rear Sight Assemblies						8/31/91	RU
	M) Iron Sight Alignment						8/31/91	RU
	N) Detach Front & Rear Sights & place in numbered container						8/31/91	RU
	O) Attach Scope to Rifle						8/31/91	RU
	P) Detach & Attach Scope 20 Times						8/31/91	RU
640	Gallery Target & Test						8-31-91	AC
	A) Time						8-31-91	AC
	B) Malfunctions						8-31-91	AC
	C) Pierced Primers						8-31-91	AC
	D) Optical Clarity of Scope						8-31-91	AC
645	Inspect for Live Ammo						8-31-91	AC
655	Final Inspection						8-31-91	DH
	A) Headspace						8-31-91	DH
	B) Trigger Pull	233	216	219	217	219	8-31-91	DH
	C) Function						8-31-91	DH
660	Pack						9-11-91	RV

SWS TRIGGER PULL TEST

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

SERIAL NO. C6649013

DATE 8-30-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.52	2.57	2.50	233	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.54	2.63	2.45	216	
PULL #3	2.66	2.59	2.58	219	
PULL #4	2.65	2.61	2.50	217	
PULL #5	2.67	2.51	2.55	219	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.30	3.57		
PULL #2	3.48	3.45		
PULL #3	3.58	3.58		
PULL #4	3.60	3.48		
PULL #5	3.60	3.57		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.20	4.53		4.51
PULL #2	4.23	4.51		4.56
PULL #3	4.20	4.55		4.52
PULL #4	4.49	4.45		4.57
PULL #5	4.58	4.49		4.56
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649013
3 Sep 1991

CENTROIDAL DISTANCES

0 TO 1	.166481
1 TO 2	.588634
1 TO 3	.365591
1 TO 4	.0822192
1 TO 5	.0334215

2 <----POI

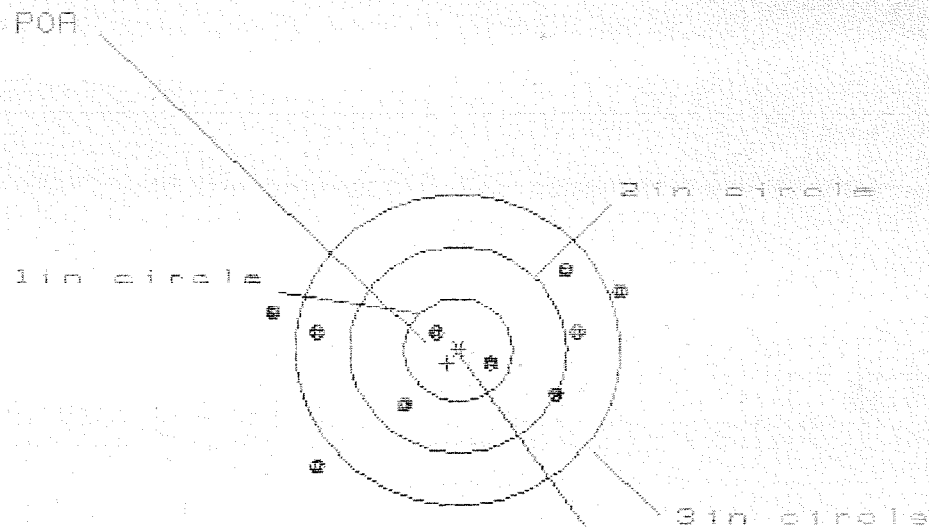
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2758
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1742
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .326267

THE AMR FOR THIS RIFLE IS: .9882

3 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B49013

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 3

3in = 7

HS= 3.248

VS= 1.971

GS= 3.324

CENTROID *

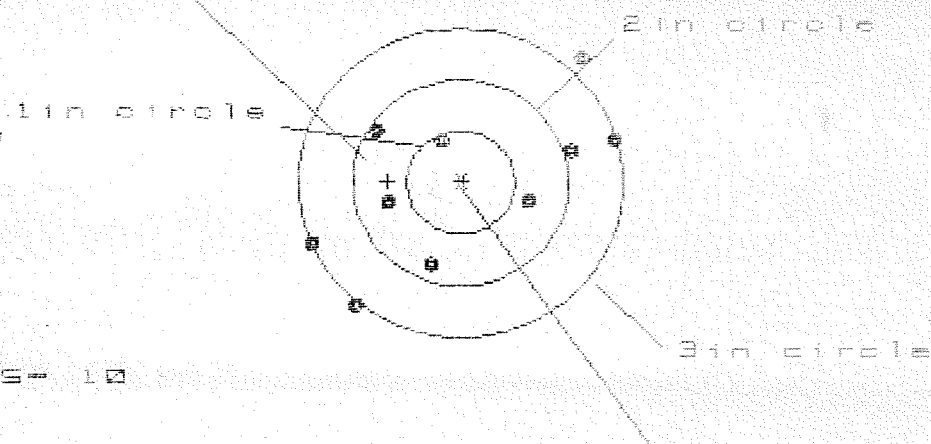
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.536	1.346	1.161
MINIMUM X	-1.712	-1.481	-1.640
MAXIMUM Y	.802	.838	.697
MINIMUM Y	-1.169	-1.133	-1.679
CENTROID X	.104	.294	.479
CENTROID Y	.130	.094	.236
POA TO CENTROID in.	.166	.309	.534
MIN RADIUS	.219	.128	.211
MEAN RADIUS	1.113	1.018	.898
MAX RADIUS	1.742	1.865	1.641
HORIZONTAL SPREAD	3.248	2.827	2.801
VERTICAL SPREAD	1.971	1.971	1.375
EXTREME SPREAD	3.324	3.324	2.832
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	7		

3 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649013

CENTERFIRE PATTERNS # 2

POA



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 7

HS= 2.769

VS= 2.322

GS= 3.147

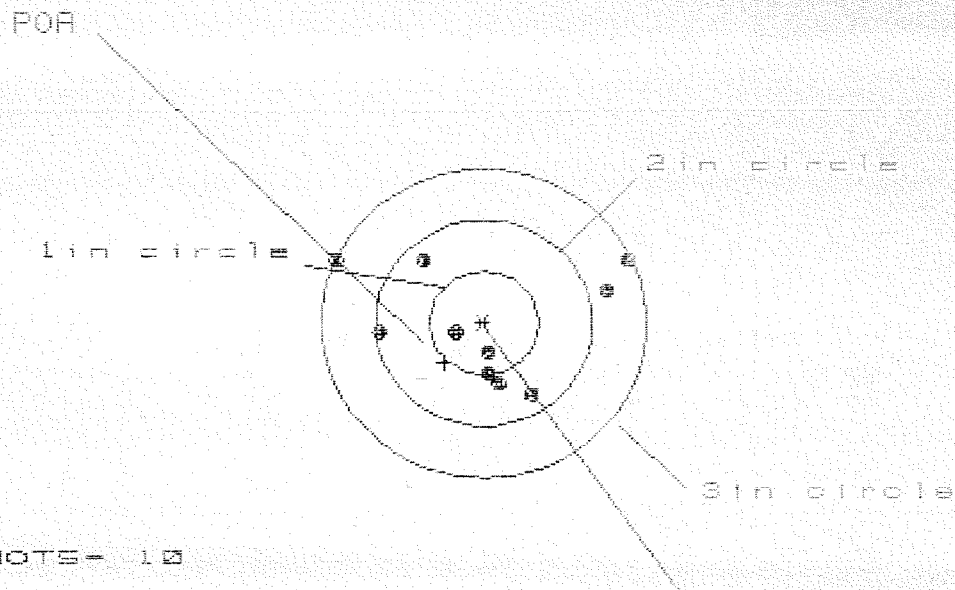
CENTROID *

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.443	1.576	1.328
MINIMUM X	-1.326	-1.199	-1.083
MAXIMUM Y	1.178	.614	.686
MINIMUM Y	-1.144	-1.013	-.941
CENTROID X	.675	.548	.352
CENTROID Y	-.013	-.144	-.216
POA TO CENTROID in.	.675	.587	.413
MIN RADIUS	.489	.516	.317
MEAN RADIUS	1.072	.991	.873
MAX RADIUS	1.641	1.673	1.413
HORIZONTAL SPREAD	2.769	2.769	2.331
VERTICAL SPREAD	2.322	1.627	1.627
EXTREME SPREAD	3.147	2.953	2.484
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		7	

3 Sep 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 8

HS= 2.752

VS= 1.377

GS= 2.752

CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.370	1.297	1.144
MINIMUM X	:	-1.382	-1.230	-0.959
MAXIMUM Y	:	.648	.717	.801
MINIMUM Y	:	-.729	-.657	-.573
CENTROID X	:	.365	.213	.366
CENTROID Y	:	.386	.314	.230
POA TO CENTROID in.	:	.531	.379	.432
MIN RADIUS	:	.297	.129	.189
MEAN RADIUS	:	.859	.753	.644
MAX RADIUS	:	1.516	1.401	1.255
HORIZONTAL SPREAD	:	2.752	2.527	2.103
VERTICAL SPREAD	:	1.377	1.374	1.374
EXTREME SPREAD	:	2.752	2.538	2.140
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			8	

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CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS= 2.357

VS= 2.991

GS= 3.050

CENTROID *

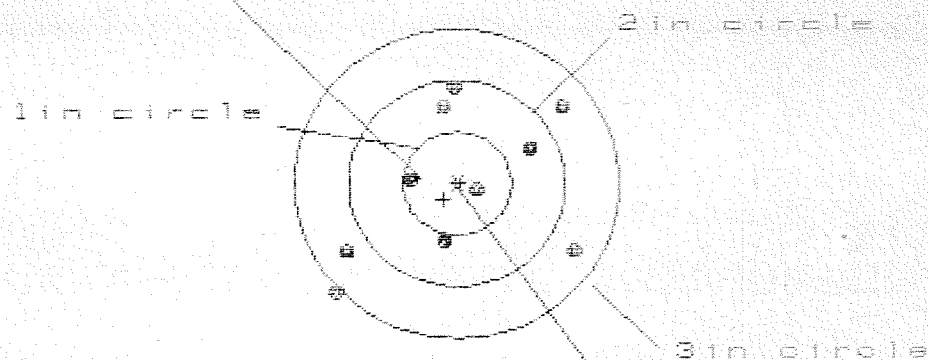
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.361	1.383	1.336
MINIMUM X	:	-1.996	-1.974	-1.021
MAXIMUM Y	:	1.538	1.166	1.006
MINIMUM Y	:	-1.453	-1.282	-1.062
CENTROID X	:	.110	.088	.135
CENTROID Y	:	.212	.041	.201
POA TO CENTROID in.	:	.239	.097	.242
MIN RADIUS	:	.094	.194	.068
MEAN RADIUS	:	1.012	.955	.882
MAX RADIUS	:	1.551	1.409	1.404
HORIZONTAL SPREAD	:	2.357	2.357	2.357
VERTICAL SPREAD	:	2.991	2.440	2.068
EXTREME SPREAD	:	3.050	2.586	2.401
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5

POB



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.197

VS= 1.995

GS= 2.745

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.039
MINIMUM X	-1.158
MAXIMUM Y	.969
MINIMUM Y	-1.026
CENTROID X	.125
CENTROID Y	.156
POB TO CENTROID in.	.200
MIN RADIUS	.189
MEAN RADIUS	.885
MAX RADIUS	1.548
HORIZONTAL SPREAD	2.197
VERTICAL SPREAD	1.995
EXTREME SPREAD	2.745
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	9