

C6649081

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 700™

24

SERIAL NO.
C6649081

ORDER NO.
5716

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

LPC

0 47700 25716 7

5716 C6649081

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6649081

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/26/91	KV
600	Proof		6/26/91	KV
607	Check Headspace		6/26/91	KV
610	Dis-assemble Gun		6/26/91	KV
612	Magnaflux Barrel Action		JUL 1 8 1991	CS
	Magnaflux Bolt		JUL 1 8 1991	CS
615	Rollmark Caliber		JUL 1 8 1991	CS
617	Drill and Tap Sight Holes		JUL 1 8 1991	FB
618	Polish Barrel		JUL 2 0 1991	WB
620	Apply Coatings (Barrel Action)		8-7-91	FB
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/22/91	KV
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/22/91	KV
	C) Inspect Ejector Hole for Chamfer		8/22/91	KV
	D) Oil Firing Pin Ass'y		8/22/91	KV
	E) Adjust Trigger Pull to Min Setting and Stake		8/23/91	JP

op. #	OP. NAME	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	5 1/2	5	5 3/4	8-23-91	DH		
	G) Safety Off Force	2	2	2	8-23-91	DH		
	H) Trigger Pull Test & Retainability				8/23/91	JH		
	I) Firing Pin Indent	.020	.022	.020	8-23-91	DH		
	J) Assemble Stock				8/27/91	KH		
	K) Assemble Swivel Studs				8-29-91	DH		
	L) Attach Front and Rear Sight Assemblies				8/27/91	KH		
	M) Iron Sight Alignment				8/27/91	KH		
	N) Detach Front & Rear Sights & place in numbered container				8/27/91	KH		
	O) Attach Scope to Rifle				8/27/91	KH		
	P) Detach & Attach Scope 20 Times				8/27/91	KH		
640	Gallery, Target & Test				8-28-91	AC		
	A) Time				8-28-91	AC		
	B) Malfunctions				8-28-91	AC		
	C) Pierced Primers				8-28-91	AC		
	D) Optical Clarity of Scope				8-28-91	AC		
645	Inspect for Live Ammo				8-28-91	AC		
655	Final Inspection				8-29-91	DH		
	A) Headspace							
	B) Trigger Pull	2.48	2.38	2.36	2.39	2.39	8-28-91	DH
	C) Function						8-29-91	DH
660	Pack				9-15-91	NF		

SWS TRIGGER PULL TEST

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

SERIAL NO. C6649081
DATE 8/23/91
TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.57	2.48	2.48	2.48	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.60	2.53	2.50	2.38	
PULL #3	2.48	2.66	2.53	2.36	
PULL #4	2.45	2.41	2.55	2.39	
PULL #5	2.49	2.53	2.55	2.39	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.41	3.38		
PULL #2	3.35	3.23		
PULL #3	3.20	3.40		
PULL #4	3.24	3.46		
PULL #5	3.41	3.28		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.38	4.43		4.48
PULL #2	4.48	4.49		4.42
PULL #3	4.43	4.46		4.40
PULL #4	4.43	4.44		4.46
PULL #5	4.36	4.48		4.43
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06649081
28 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.305941
1 TO	2	.257498
1 TO	3	.371034
1 TO	4	.0706116
1 TO	5	.436249

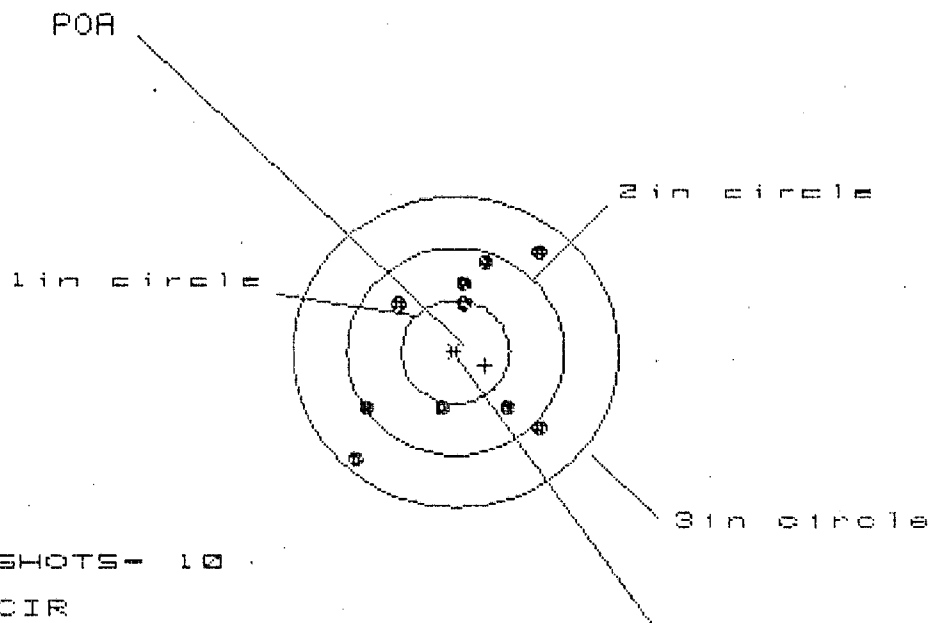
gtr <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.371
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0134
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .371242
THE AMR FOR THIS RIFLE IS: .8936

28 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66490B1

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 6

3 in = 10

HS= 1.771

VS= 1.971

GS= 2.592

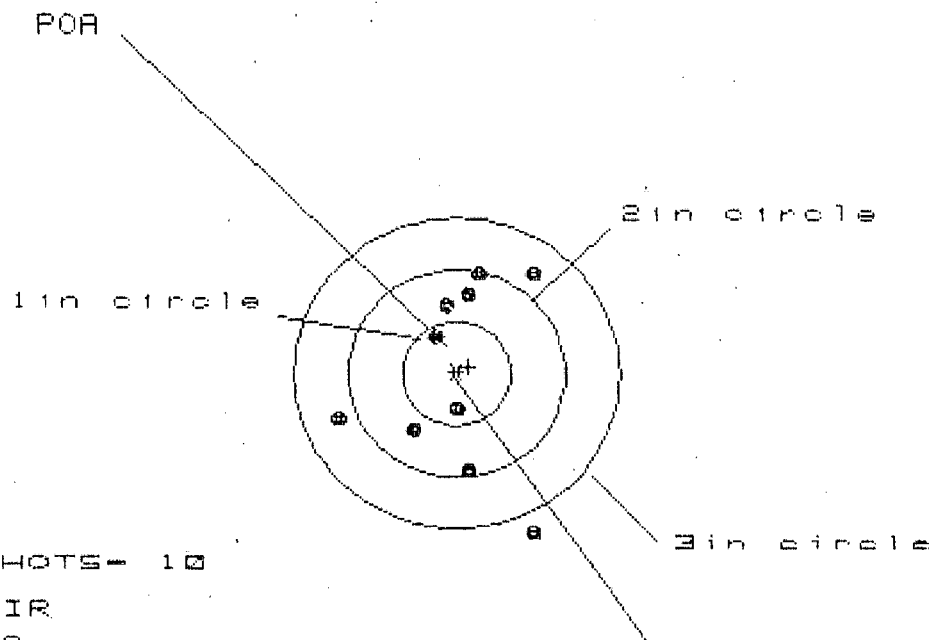
CENTROID +

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.814	.787	.785
MINIMUM X	:	-.957	-.948	-.870
MAXIMUM Y	:	.953	.840	.866
MINIMUM Y	:	-1.018	-.840	-.735
CENTROID X	:	-.276	-.169	-.247
CENTROID Y	:	.132	.245	.140
POA TO CENTROID in.	:	.306	.298	.284
MIN RADIUS	:	.487	.378	.477
MEAN RADIUS	:	.876	.798	.769
MAX RADIUS	:	1.397	1.172	1.075
HORIZONTAL SPREAD	:	1.771	1.655	1.655
VERTICAL SPREAD	:	1.971	1.680	1.601
EXTREME SPREAD	:	2.592	2.189	1.822
NUMBER IN ONE INCH CIRCLE =	:		1	
NUMBER IN TWO INCH CIRCLE =	:		6	
NUMBER IN THREE INCH CIRCLE =	:		10	

28 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66490B1

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS= 1.803

VS= 2.516

GS= 2.555

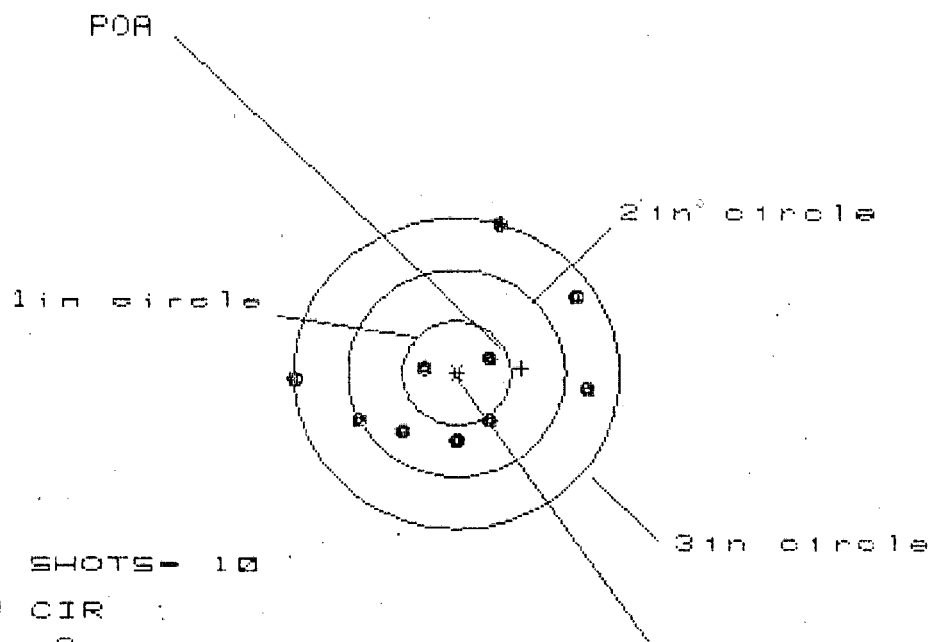
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.682	.748	.618
MINIMUM X	:	-1.121	-1.046	-.451
MAXIMUM Y	:	.983	.813	.735
MINIMUM Y	:	-1.533	-1.151	-1.229
CENTROID X	:	-.109	-.184	-.054
CENTROID Y	:	-.064	.106	.184
POA TO CENTROID in.	:	.126	.213	.191
MIN RADIUS	:	.329	.182	.227
MEAN RADIUS	:	.892	.774	.708
MAX RADIUS	:	1.678	1.214	1.231
HORIZONTAL SPREAD	:	1.803	1.794	1.069
VERTICAL SPREAD	:	2.516	1.964	1.964
EXTREME SPREAD	:	2.555	2.286	2.023
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

28 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66490B1

CENTERFIRE PATTERNS # 3



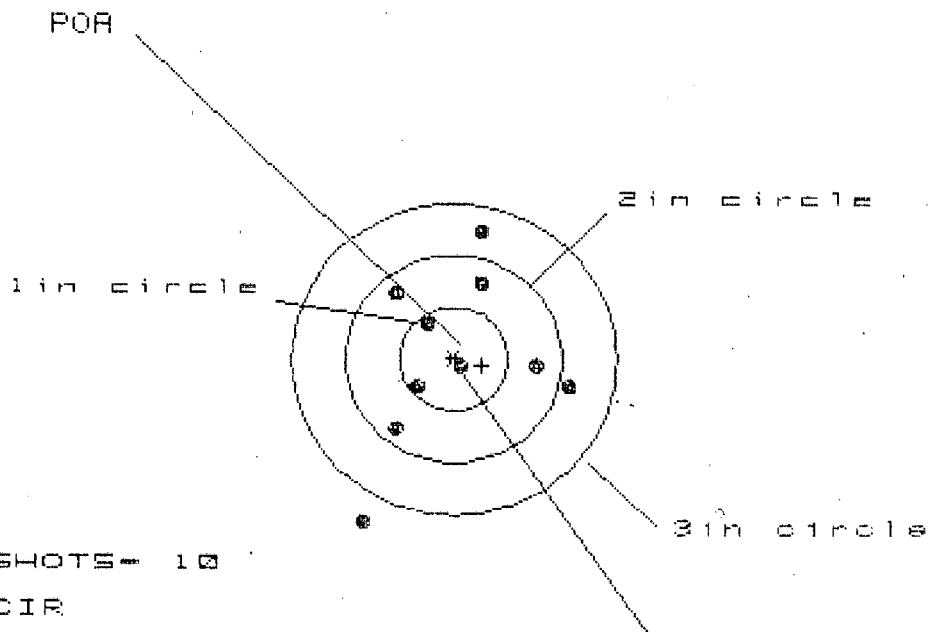
HS= 2.618
VS= 2.015
GS= 2.673

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.167	1.210	1.034
MINIMUM X	-1.451	-1.408	-1.059
MAXIMUM Y	1.411	.898	.907
MINIMUM Y	-.604	-.447	-.438
CENTROID X	-.601	-.644	-.468
CENTROID Y	-.047	-.204	-.213
POA TO CENTROID in.	.603	.675	.514
MIN RADIUS	.278	.293	.294
MEAN RADIUS	.897	.809	.727
MAX RADIUS	1.462	1.446	1.319
HORIZONTAL SPREAD	2.618	2.618	2.093
VERTICAL SPREAD	2.015	1.345	1.345
EXTREME SPREAD	2.673	2.673	2.365
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

28 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66490B1

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 1.971

VS= 2.803

GS= 3.040

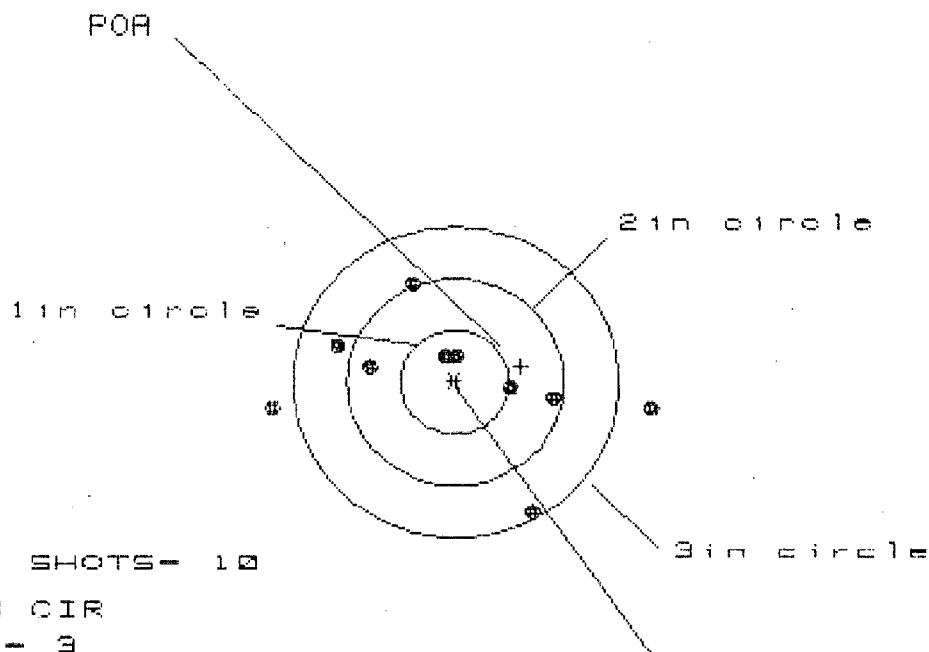
CENTROID #

PATTERN #	1	2	3	4
SHOTS (BEST OF)	10	9	8	
MAXIMUM X	1.089	.992	1.016	
MINIMUM X	-.881	-.598	-.574	
MAXIMUM Y	1.200	1.022	.694	
MINIMUM Y	-1.603	-.860	-.732	0
CENTROID X	-.261	-.163	-.187	
CENTROID Y	.063	.241	.113	
POA TO CENTROID in.	.268	.291	.219	
MIN RADIUS	.063	.234	.104	
MEAN RADIUS	.817	.702	.643	
MAX RADIUS	1.829	1.078	1.058	
HORIZONTAL SPREAD	1.971	1.590	1.590	
VERTICAL SPREAD	2.803	1.882	1.426	
EXTREME SPREAD	3.040	2.043	1.798	
NUMBER IN ONE INCH CIRCLE =		3		
NUMBER IN TWO INCH CIRCLE =		7		
NUMBER IN THREE INCH CIRCLE =		9		

26 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649081

CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1in = 3

2in = 5

3in = 8

HS = 3.495

VS = 2.226

GS = 3.495

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.780	1.151	.961
MINIMUM X	-1.715	-1.517	-1.046
MAXIMUM Y	.991	.959	.925
MINIMUM Y	-1.235	-1.267	-1.301
CENTROID X	-.608	-.806	-.616
CENTROID Y	-.151	-.119	-.085
POA TO CENTROID in.	.627	.815	.622
MIN RADIUS	.243	.261	.178
MEAN RADIUS	.986	.888	.773
MAX RADIUS	1.803	1.571	1.497
HORIZONTAL SPREAD	3.495	2.668	2.007
VERTICAL SPREAD	2.226	2.226	2.226
EXTREME SPREAD	3.495	2.670	2.475
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		8	