

C6649092

MODEL 700™ M24

Model SWS™

Action

Barrel Length

Capacity

Order No. 5715

*Includes 1 in chamber.

Remington

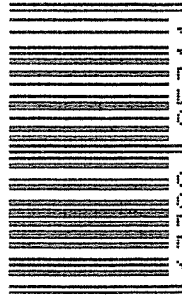
*Still
mead.*

 		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700™ M24		SERIAL NO. C6649092
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.		ORDER NO. 5716



5716 C6649092

LPC



0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649092

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)		8-2-91	LB
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/9/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/9/91	RW
	C) Inspect Ejector Hole for Chamfer		8/9/91	RW
	D) Oil Firing Pin Ass'y		8/9/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8-13-91	GH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6 1/2	6	6			8-13-91	DH
	G) Safety Off Force	3	3	3			8-13-91	DH
	H) Trigger Pull Test & Retainability						8-13-91	DH
	I) Firing Pin Indent	.021	.021	.021			8-13-91	DH
	J) Assemble Stock						8-16-91	RW
	K) Assemble Swivel Studs						8-21-91	A
	L) Attach Front and Rear Sight Assemblies						8-16-91	RW
	M) Iron Sight Alignment						8-16-91	RW
	N) Detach Front & Rear Sights & place in numbered container						8-16-91	RW
	O) Attach Scope to Rifle						8-16-91	RW
	P) Detach & Attach Scope 20 Times						8-16-91	RW
640	Gallery Target & Test						8-20-91	DH
	A) Time						8-20-91	DH
	B) Malfunctions						8-20-91	DH
	C) Pierced Primers						8-20-91	DH
	D) Optical Clarity of Scope						8-20-91	DH
645	Inspect for Live Ammo						8-20-91	DH
655	Final Inspection						8-21-91	A
	A) Headspace						8-20-91	DH
	B) Trigger Pull	2.43	2.53	2.54	2.55	2.61	8-20-91	DH
	C) Function						8-21-91	A
660	Pack						9-19-91	N

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6649092

DATE 8-13-91

TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.64	2.28	2.44	2.43	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.63	2.26	2.38	2.53	
PULL #3	2.60	2.33	2.39	2.54	
PULL #4	2.20	2.29	2.40	2.55	
PULL #5	2.23	2.41	2.43	2.61	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.45	3.47		
PULL #2	3.34	3.49		
PULL #3	3.55	3.43		
PULL #4	3.57	3.52		
PULL #5	3.47	3.49		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.43	4.31		4.46
PULL #2	4.42	4.39		4.43
PULL #3	4.31	4.21		4.40
PULL #4	4.40	4.21		4.39
PULL #5	4.39	4.28		4.29
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649092
22 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.59381
1 TO	2	.883143
1 TO	3	.542163
1 TO	4	.917791
1 TO	5	.395103

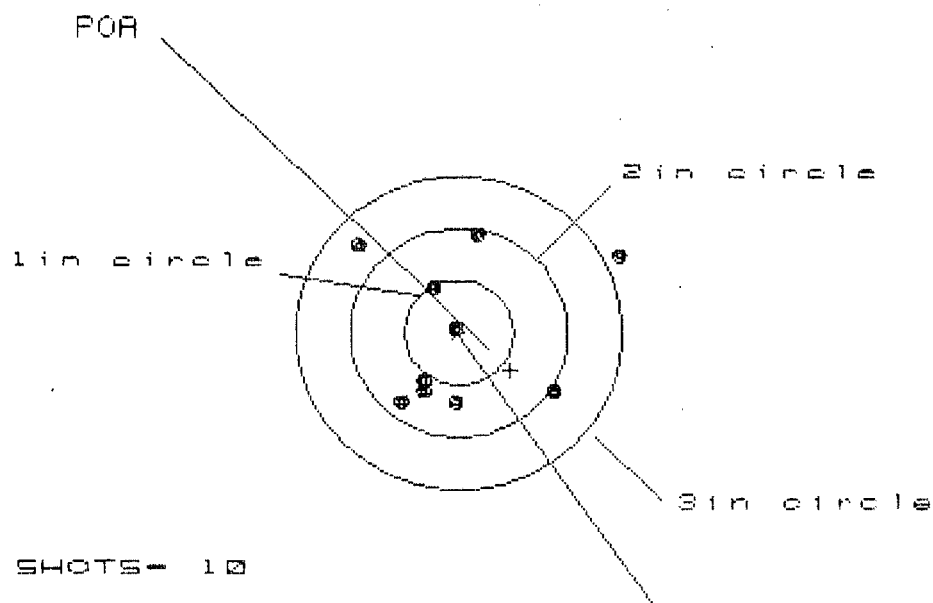
$\frac{1}{5} + \frac{4}{2}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2498
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1008
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .269371
THE AMR FOR THIS RIFLE IS: .9184

Aug 1991

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CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS= 2.326

VS= 1.571

GS= 2.386

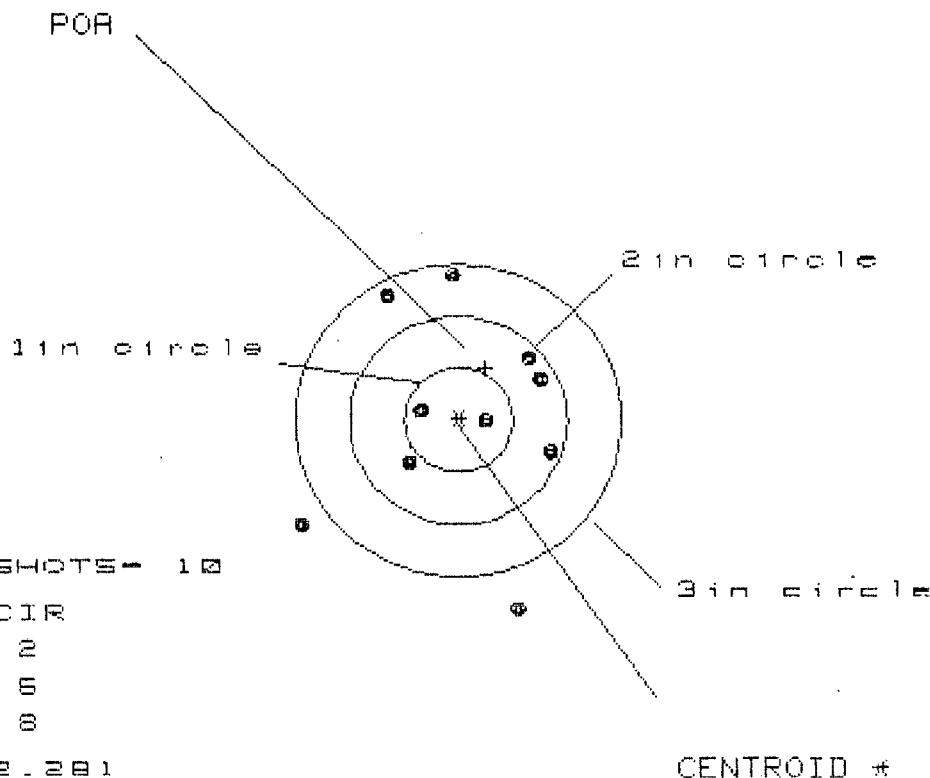
CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.430	1.001	.909
MINIMUM X	-.896	-.737	-.462
MAXIMUM Y	.903	.980	1.089
MINIMUM Y	-.668	-.591	-.482
CENTROID X	-.473	-.632	-.540
CENTROID Y	.359	.282	.173
POA TO CENTROID in.	.594	.692	.567
MIN RADIUS	.049	.155	.212
MEAN RADIUS	.806	.695	.628
MAX RADIUS	1.589	1.140	1.119
HORIZONTAL SPREAD	2.326	1.738	1.371
VERTICAL SPREAD	1.571	1.571	1.571
EXTREME SPREAD	2.386	2.191	1.729
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS # 2



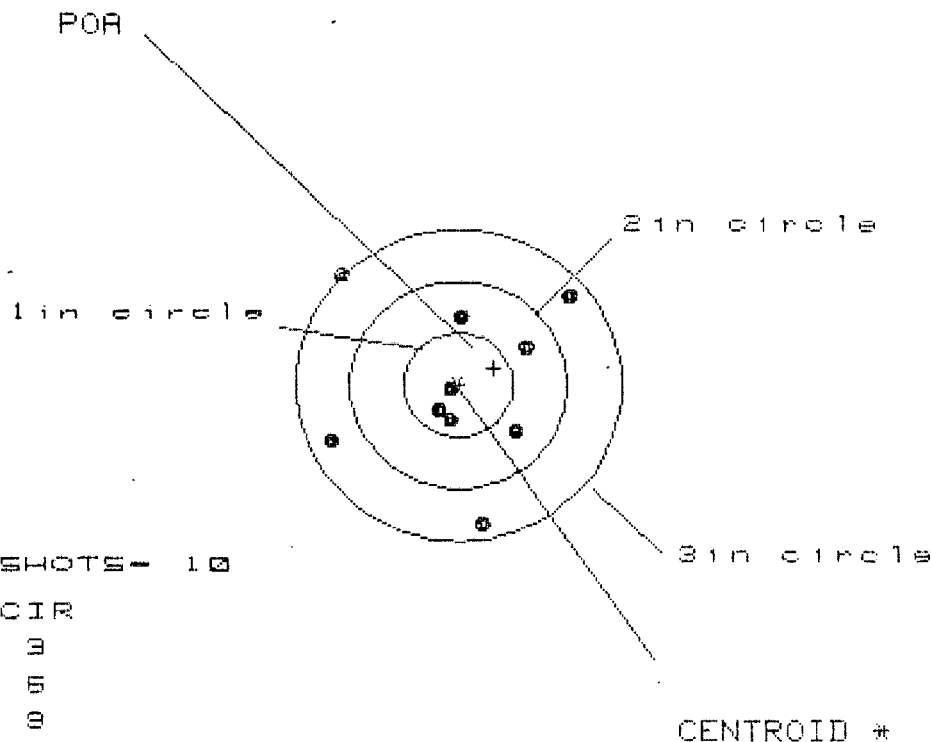
OF SHOTS - 10
 # IN CIR
 1in = 2
 2in = 6
 3in = 8
 HS = 2.281
 VS = 3.188
 GS = 3.242

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.819	.878	.703
MINIMUM X	:	-1.462	-1.403	-.757
MAXIMUM Y	:	1.362	1.159	1.012
MINIMUM Y	:	-1.826	-1.177	-.772
CENTROID X	:	-.248	-.307	-.132
CENTROID Y	:	-.495	-.292	-.145
POA TO CENTROID in.	:	.554	.424	.196
MIN RADIUS	:	.218	.309	.412
MEAN RADIUS	:	1.011	.908	.777
MAX RADIUS	:	1.901	1.831	1.135
HORIZONTAL SPREAD	:	2.281	2.281	1.460
VERTICAL SPREAD	:	3.188	2.336	1.784
EXTREME SPREAD	:	3.242	2.724	2.123
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 5

3 in = 8

HS= 2.216

VS= 2.421

GS= 2.724

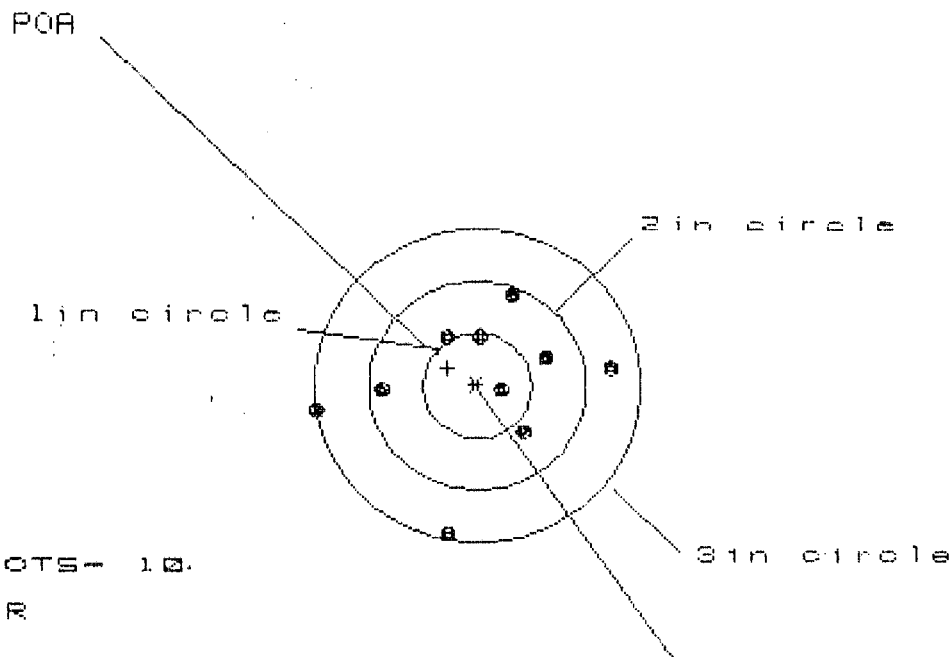
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.062	.944	.643
MINIMUM X	:	-1.154	-1.272	-1.154
MAXIMUM Y	:	1.062	.994	.877
MINIMUM Y	:	-1.359	-1.241	-1.117
CENTROID X	:	-.323	-.205	-.323
CENTROID Y	:	-.162	-.280	-.404
POA TO CENTROID in.	:	.362	.347	.517
MIN RADIUS	:	.038	.191	.143
MEAN RADIUS	:	.830	.751	.651
MAX RADIUS	:	1.506	1.370	1.182
HORIZONTAL SPREAD	:	2.216	2.216	1.797
VERTICAL SPREAD	:	2.421	2.235	1.994
EXTREME SPREAD	:	2.724	2.606	1.998
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			9	

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CENTERFIRE PATTERNS

4



OF SHOTS- 10.

IN CIR

1in = 2

2in = 7

3in = 9

HS= 2.676

VS= 2.320

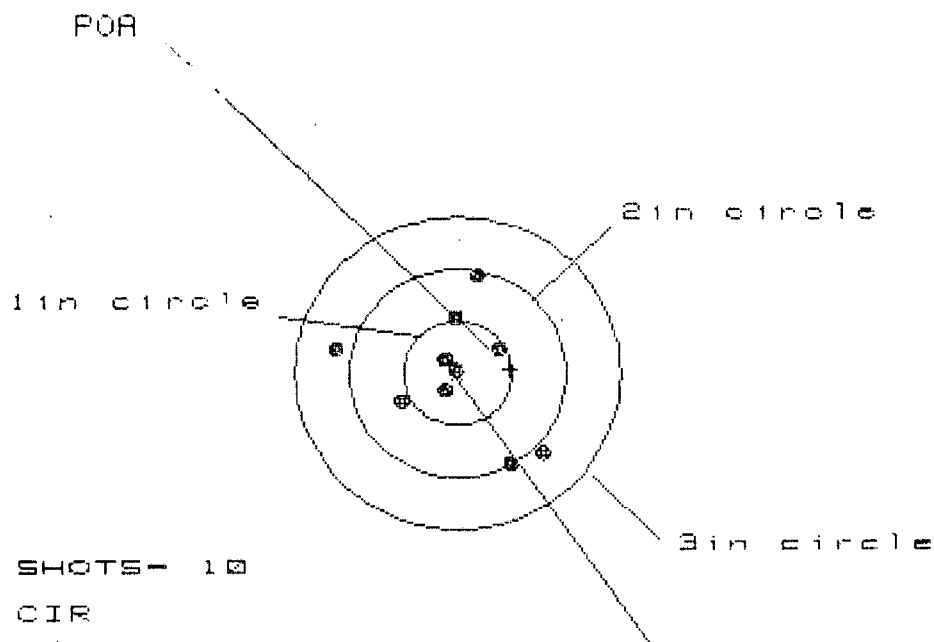
GS= 2.705

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.187	1.021	.971
MINIMUM X	:	-1.489	-1.041	-1.091
MAXIMUM Y	:	.869	.839	.654
MINIMUM Y	:	-1.451	-1.481	-.603
CENTROID X	:	.277	.443	.493
CENTROID Y	:	-.170	-.140	.045
POA TO CENTROID in.	:	.325	.464	.495
MIN RADIUS	:	.197	.084	.266
MEAN RADIUS	:	.845	.734	.613
MAX RADIUS	:	1.514	1.534	1.119
HORIZONTAL SPREAD	:	2.676	2.062	2.062
VERTICAL SPREAD	:	2.320	2.320	1.257
EXTREME SPREAD	:	2.705	2.388	2.068
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10
IN CIR
1in = 4
2in = 8
3in = 10
HS= 1.898
VS= 1.729
GS= 2.157

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.793	.671	.427
MINIMUM X	-1.105	-.591	-.507
MAXIMUM Y	.912	.938	.842
MINIMUM Y	-.317	-.791	-.887
CENTROID X	-.482	-.360	-.444
CENTROID Y	-.036	-.062	.034
POA TO CENTROID in.	.484	.365	.445
MIN RADIUS	.088	.195	.083
MEAN RADIUS	.600	.560	.464
MAX RADIUS	1.129	1.019	.984
HORIZONTAL SPREAD	1.898	1.262	.934
VERTICAL SPREAD	1.729	1.729	1.729
EXTREME SPREAD	2.157	1.809	1.751
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		