

C6636219

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.

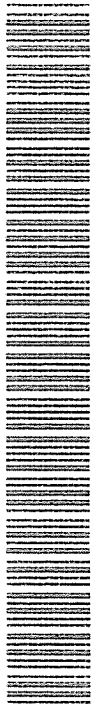
MODEL 700™ M24

SERIAL NO.
C6636219

20

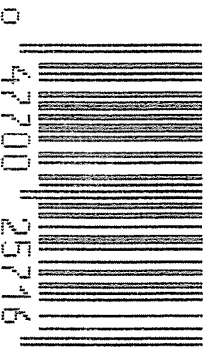
ORDER NO.
5716

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



5716 C6636219

UPC



0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636219

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 30	91	RW
600	Proof	4 30	91	RW
607	Check Headspace	4 30	91	RW
610	Dis-assemble Gun	4 30	91	RW
612	Magnaflux Barrel Action	5 6	91	KCR
	Magnaflux Bolt	5 6	91	KCR
615	Rollmark Caliber	5 6	91	GS
617	Drill and Tap Sight Holes	5 10	91	LB
618	Polish Barrel	5 10	91	LB
620	Apply Coatings (Barrel Action)		5-30-91	JA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		6/19/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6/19/91	RW
	C) Inspect Ejector Hole for Chamfer		6/19/91	RW
	D) Oil Firing Pin Ass'y		6/19/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		7-16-91	JL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			7-17-91	SL
	G) Safety Off Force	5	5	5			7-17-91	SL
	H) Trigger Pull Test & Retainability						7-16-91	SL
	I) Firing Pin Indent	.0205	.020	.020			7-17-91	SL
	J) Assemble Stock						7/19/91	RW
	K) Assemble Swivel Studs						7-23-91	DH
	L) Attach Front and Rear Sight Assemblies						7/19/91	RW
	M) Iron Sight Alignment						7/19/91	RW
	N) Detach Front & Rear Sights & place in numbered container						7/19/91	RW
	O) Attach Scope to Rifle						7/19/91	RW
	P) Detach & Attach Scope 20 Times						7/19/91	RW
640	Gallery Target & Test						7-22-91	DH
	A) Time						7-22-91	DH
	B) Malfunctions						7-22-91	DH
	C) Pierced Primers						7-22-91	DH
	D) Optical Clarity of Scope						7-22-91	DH
645	Inspect for Live Ammo						7-22-91	DH
655	Final Inspection						7-23-91	DH
	A) Headspace						7-23-91	SL
	B) Trigger Pull	2.36	2.36	2.42	2.42	2.45	7-23-91	SL
	C) Function						7-23-91	DH
660	Pack						9-18-91	AF

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6636219

DATE 7-16-91

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.52	2.39	2.40	2.36	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.38	2.41	2.44	2.36	
PULL #3	2.22	2.29	2.33	2.42	
PULL #4	2.39	2.37	2.36	2.42	
PULL #5	2.27	2.39	2.36	2.45	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.66	3.62		
PULL #2	3.41	3.23		
PULL #3	3.36	3.31		
PULL #4	3.50	3.20		
PULL #5	3.28	3.33		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.49	4.40		4.49
PULL #2	4.49	4.31		4.45
PULL #3	4.26	4.47		4.36
PULL #4	4.41	4.39		4.36
PULL #5	4.47	4.19		4.50
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636219
23 Jul 1991

CENTROIDAL DISTANCES

0 TO	1	.228974
1 TO	2	.0428019
1 TO	3	.333492
1 TO	4	.237143
1 TO	5	.471785

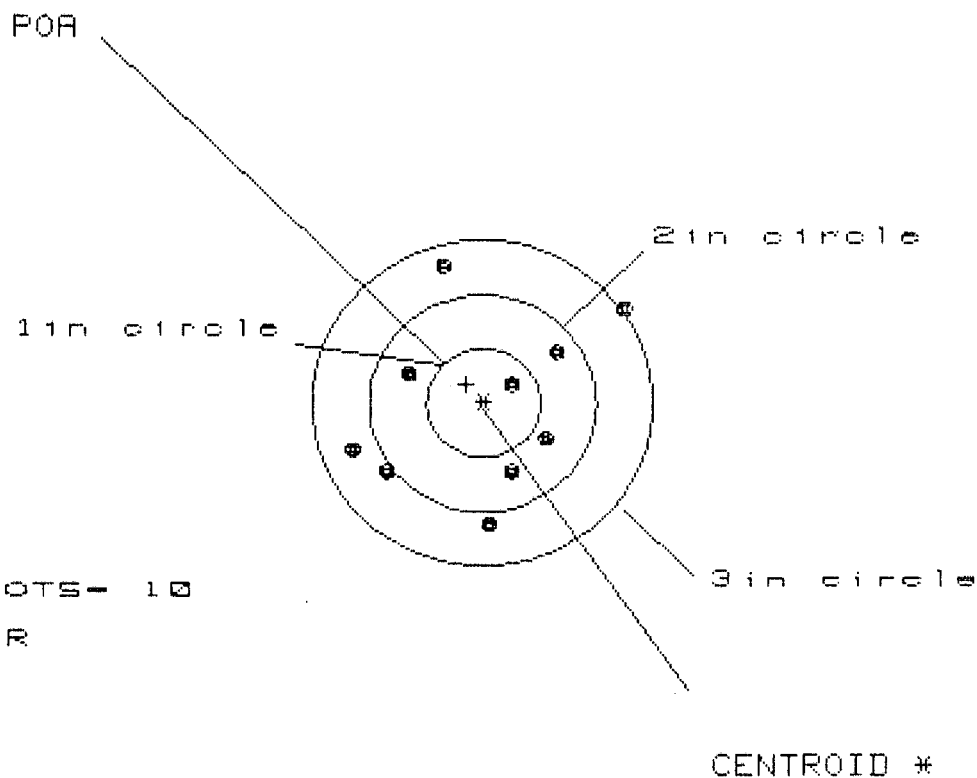
 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2252
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0588
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .23275
THE AMR FOR THIS RIFLE IS: .8512

23 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636219

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 2.405

VS= 2.321

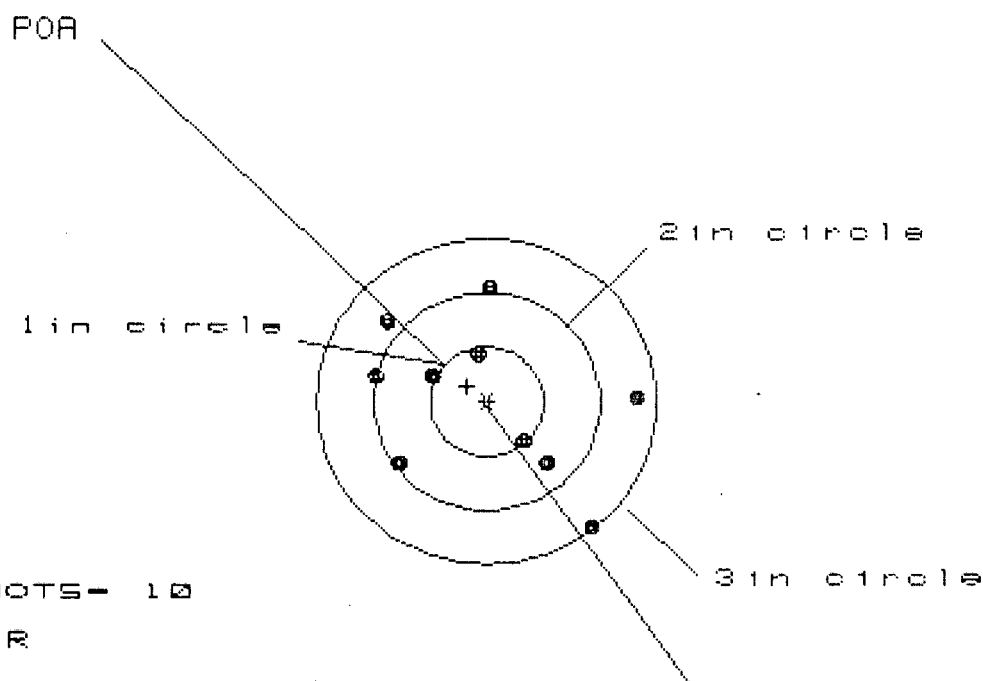
GS= 2.757

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.247	.782	.755
MINIMUM X	:	-1.158	-1.019	-1.046
MAXIMUM Y	:	1.226	1.327	.740
MINIMUM Y	:	-1.095	-.994	-.828
CENTROID X	:	.150	.011	.038
CENTROID Y	:	-.173	-.274	-.440
POA TO CENTROID in.	:	.229	.274	.442
MIN RADIUS	:	.264	.435	.520
MEAN RADIUS	:	.933	.865	.790
MAX RADIUS	:	1.543	1.344	1.060
HORIZONTAL SPREAD	:	2.405	1.801	1.801
VERTICAL SPREAD	:	2.321	2.321	1.568
EXTREME SPREAD	:	2.757	2.363	2.019
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

23 Jul 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 10

HS= 2.345

VS= 2.237

GS= 2.576

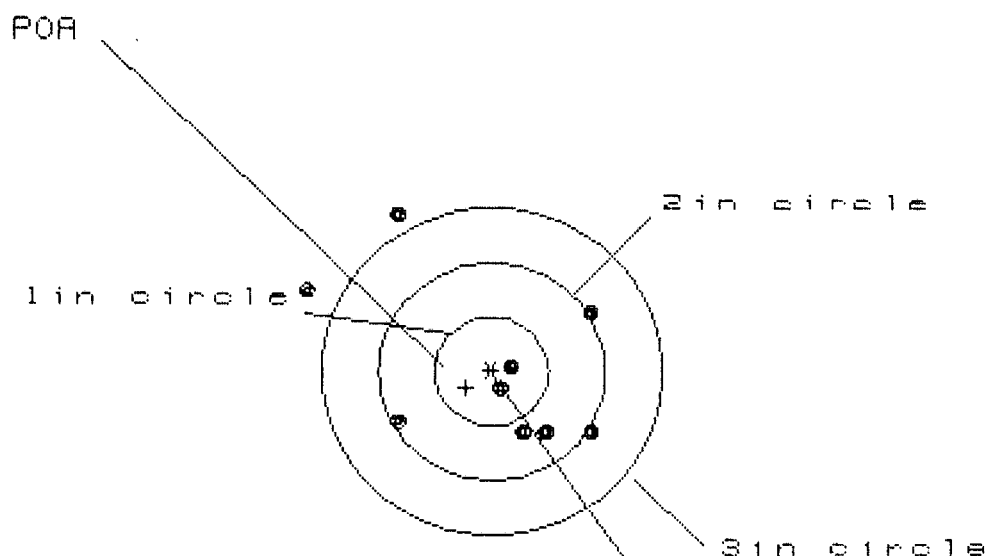
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.361	1.461	.782
MINIMUM X	:	-.984	-.884	-.702
MAXIMUM Y	:	1.059	.928	.916
MINIMUM Y	:	-1.178	-.723	-.735
CENTROID X	:	.176	.076	-.106
CENTROID Y	:	-.139	-.008	.004
POA TO CENTROID in.	:	.224	.077	.106
MIN RADIUS	:	.410	.272	.255
MEAN RADIUS	:	.923	.836	.728
MAX RADIUS	:	1.479	1.464	1.059
HORIZONTAL SPREAD	:	2.345	2.345	1.484
VERTICAL SPREAD	:	2.237	1.651	1.651
EXTREME SPREAD	:	2.576	2.351	1.864
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

23 Jul 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 8

HS= 2.480

VS= 2.083

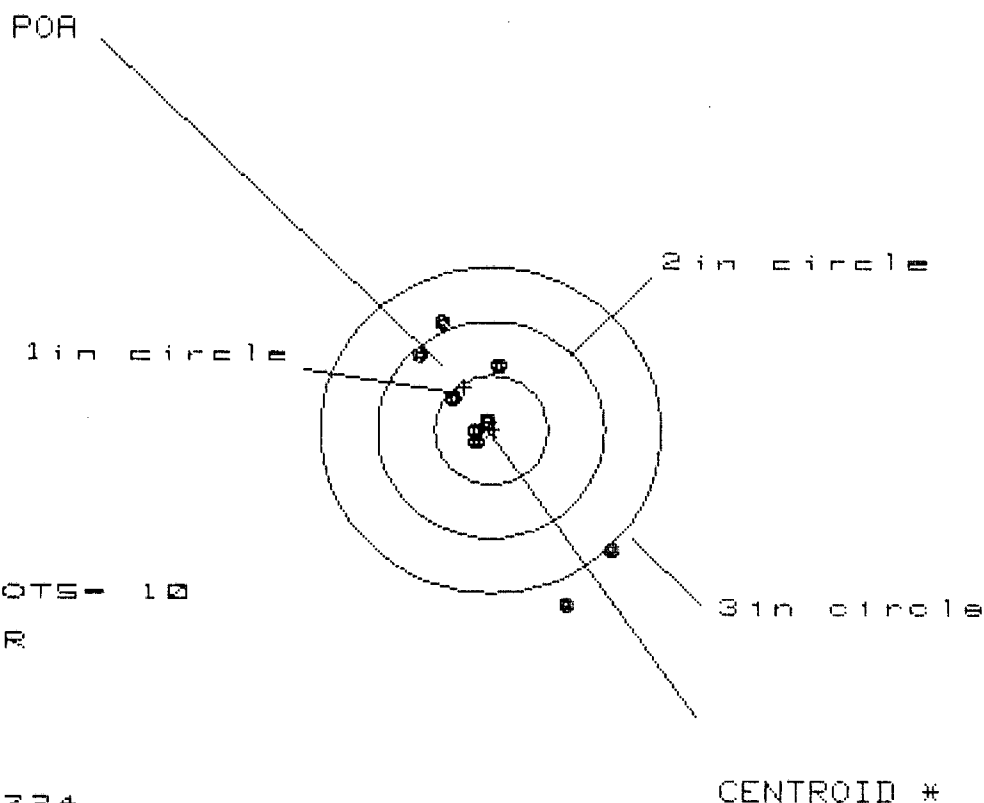
GS= 2.783

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.860	.680	.559
MINIMUM X	:	-1.620	-.966	-1.081
MAXIMUM Y	:	1.498	1.585	.841
MINIMUM Y	:	-.585	-.498	-.300
CENTROID X	:	.229	.409	.530
CENTROID Y	:	.151	.064	-.134
POA TO CENTROID in.	:	.275	.414	.547
MIN RADIUS	:	.209	.122	.251
MEAN RADIUS	:	.894	.724	.529
MAX RADIUS	:	1.801	1.856	1.090
HORIZONTAL SPREAD	:	2.480	1.646	1.640
VERTICAL SPREAD	:	2.083	2.083	1.141
EXTREME SPREAD	:	2.783	2.593	1.910
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

23 Jul 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 5

2in = 7

3in = 8

HS= 1.724

VS= 2.603

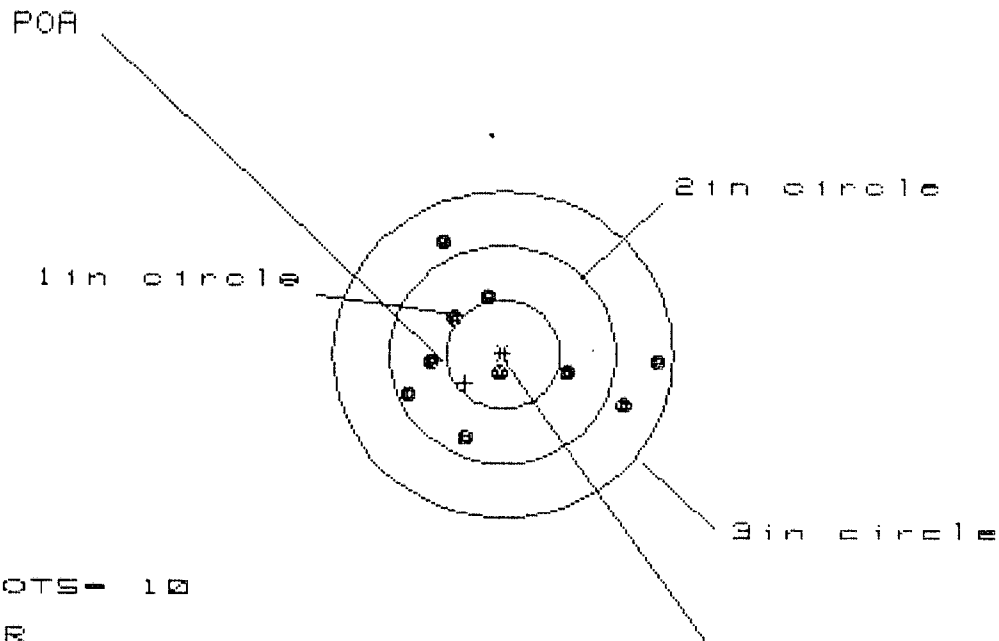
GS= 2.821

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.067	1.144	.239
MINIMUM X	:	-.657	-.580	-.436
MAXIMUM Y	:	1.005	.827	.669
MINIMUM Y	:	-1.598	-1.268	-.463
CENTROID X	:	.236	.159	.016
CENTROID Y	:	-.394	-.216	-.058
POA TO CENTROID in.	:	.459	.268	.060
MIN RADIUS	:	.107	.083	.138
MEAN RADIUS	:	.697	.540	.400
MAX RADIUS	:	1.743	1.708	.690
HORIZONTAL SPREAD	:	1.724	1.724	.676
VERTICAL SPREAD	:	2.603	2.095	1.132
EXTREME SPREAD	:	2.821	2.552	1.161
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 10

HS= 2.273

VS= 1.806

GS= 2.299

CENTROID #

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.393	1.199	1.154
MINIMUM X	:	-.880	-.725	-.770
MAXIMUM Y	:	1.041	1.039	.687
MINIMUM Y	:	-.765	-.767	-.637
CENTROID X	:	.335	.180	.225
CENTROID Y	:	.261	.263	.133
POA TO CENTROID in.	:	.425	.318	.261
MIN RADIUS	:	.210	.229	.095
MEAN RADIUS	:	.809	.719	.662
MAX RADIUS	:	1.393	1.272	1.192
HORIZONTAL SPREAD	:	2.273	1.924	1.924
VERTICAL SPREAD	:	1.806	1.806	1.324
EXTREME SPREAD	:	2.299	2.137	1.925
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	