

C6636225

MODEL 700™ M24

Model SWS™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.



Remington®



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

MODEL 700™ M24

SERIAL NO.
C6636225

ORDER NO.
5716

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

06



5716 C6636225

UPC



0 47700 25716 7

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

M2400031967

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636225

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		Ked
	Magnaflux Bolt	5 6 91		Ked
615	Rollmark Caliber	5 6 91		GB
617	Drill and Tap Sight Holes	5 10 91		LB
618	Polish Barrel	5 10 91		WB
620	Apply Coatings (Barrel Action)		5/30/91	TA
	Apply Coating (Bolt)		5/30/91	TA
625	Final Assembly			
	A) Clean inside of Bolt Assembly		5/30/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/91	RW
	C) Inspect Ejector Hole for Chamfer		5/30/91	RW
	D) Oil Firing Pin Ass'y		5/30/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		6-11-91	TA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			6-12-91	DH
	G) Safety Off Force	3	2	3			6-12-91	DH
	H) Trigger Pull Test & Retainability						6-11-91	JH
	I) Firing Pin Indent	.021	.021	.022			6-12-91	DH
	J) Assemble Stock						6/12/91	RW
	K) Assemble Swivel Studs						6-14-91	JH
	L) Attach Front and Rear Sight Assemblies						6/12/91	RW
	M) Iron Sight Alignment						6/12/91	RW
	N) Detach Front & Rear Sights & place in numbered container						6/12/91	RW
	O) Attach Scope to Rifle						6/12/91	RW
	P) Detach & Attach Scope 20 Times						6/12/91	RW
640	Gallery Target & Test						6-13-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						6-13-91	NF
655	Final Inspection							
	A) Headspace						6-14-91	JH
	B) Trigger Pull	2.15	2.23	2.26	2.23	2.24	6-14-91	JH
	C) Function						6-14-91	JH
660	Pack						6-20-91	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6636225

DATE 6-11-91

TESTER JY

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.20	2.55	2.30	2.15	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.18	2.40	2.35	2.23	
PULL #3	2.20	2.47	2.44	2.26	
PULL #4	2.35	2.44	2.48	2.23	
PULL #5	2.20	2.47	2.46	2.24	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.61	3.56		
PULL #2	3.53	3.57		
PULL #3	3.60	3.58		
PULL #4	3.50	3.59		
PULL #5	3.62	3.61		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.48	4.46		4.47
PULL #2	4.18	4.34		4.45
PULL #3	4.33	4.49		4.51
PULL #4	4.43	4.49		4.50
PULL #5	4.42	4.52		4.41
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636225
13 Jun 1991

CENTROIDAL DISTANCES

Ø TO	1	.182822
1 TO	2	.473677
1 TO	3	.331266
1 TO	4	.272406
1 TO	5	.213321

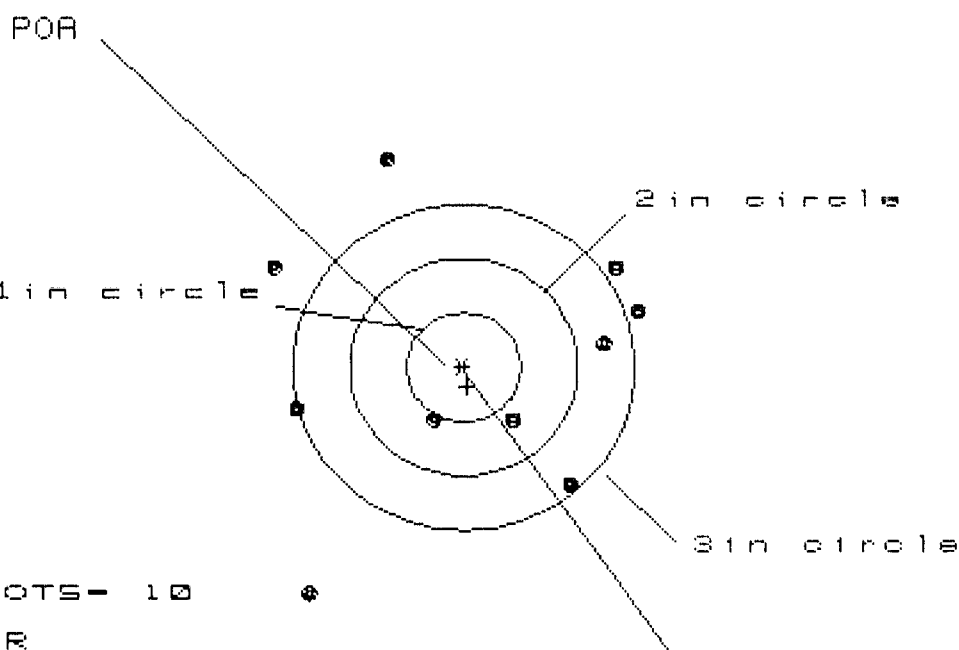
1
2 ←----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0064
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0556
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0559671
THE AMR FOR THIS RIFLE IS: 1.095

13 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08636225

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 0

2in = 2

3in = 4

HS= 3.134

VS= 4.073

GS= 4.134

CENTROID *

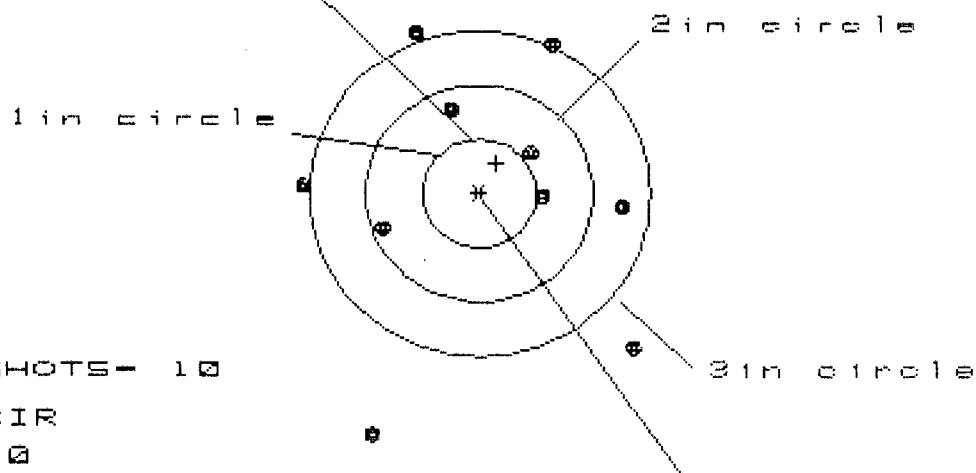
PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.515	1.361	1.257
MINIMUM X	:	-1.619	-1.773	-1.877
MAXIMUM Y	:	1.952	1.716	.934
MINIMUM Y	:	-2.121	-1.361	-1.146
CENTROID X	:	-.032	.122	.226
CENTROID Y	:	.180	.416	.201
POA TO CENTROID in.	:	.183	.433	.303
MIN RADIUS	:	.516	.757	.521
MEAN RADIUS	:	1.505	1.388	1.268
MAX RADIUS	:	2.532	1.907	2.075
HORIZONTAL SPREAD	:	3.134	3.134	3.134
VERTICAL SPREAD	:	4.073	3.077	2.080
EXTREME SPREAD	:	4.134	3.480	3.274
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		4	

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CENTERFIRE PATTERNS # 2

POA



OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 5

HS= 2.944

VS= 3.665

GS= 3.923

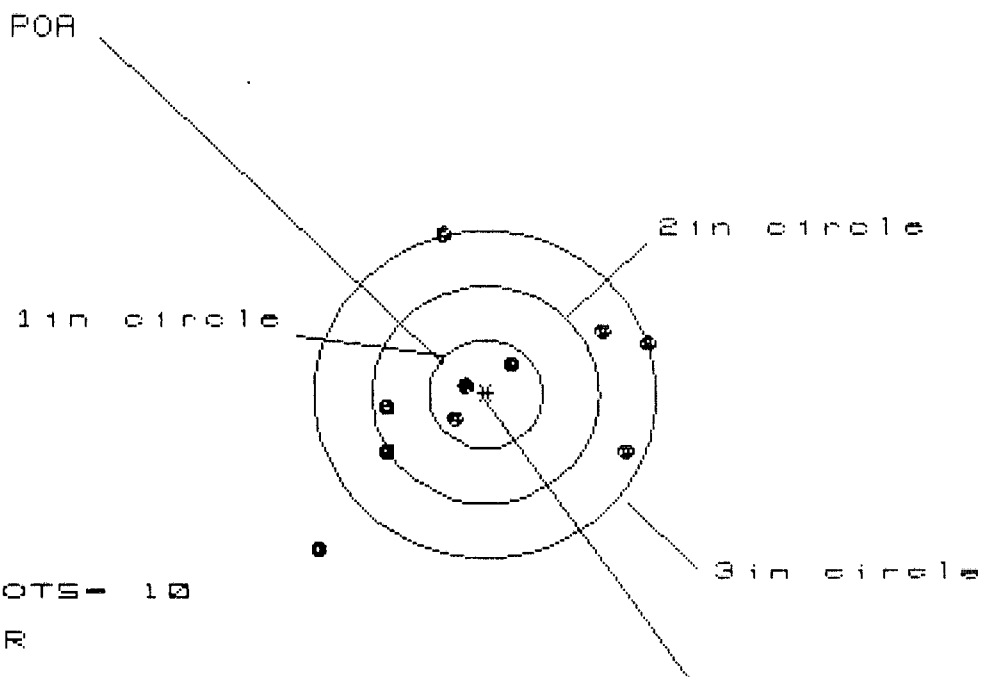
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.358	1.253	1.275
MINIMUM X	:	-1.586	-1.691	-1.534
MAXIMUM Y	:	1.451	1.205	1.002
MINIMUM Y	:	-2.214	-1.623	-1.746
CENTROID X	:	-.149	-.044	-.201
CENTROID Y	:	-.279	-.033	.170
POA TO CENTROID in.	:	.316	.055	.263
MIN RADIUS	:	.503	.356	.344
MEAN RADIUS	:	1.297	1.119	.986
MAX RADIUS	:	2.406	2.051	1.579
HORIZONTAL SPREAD	:	2.944	2.944	2.809
VERTICAL SPREAD	:	3.665	2.828	1.748
EXTREME SPREAD	:	3.923	3.428	2.819
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		5	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 4

3in = 9

HS= 2.818

VS= 2.845

GS= 3.402

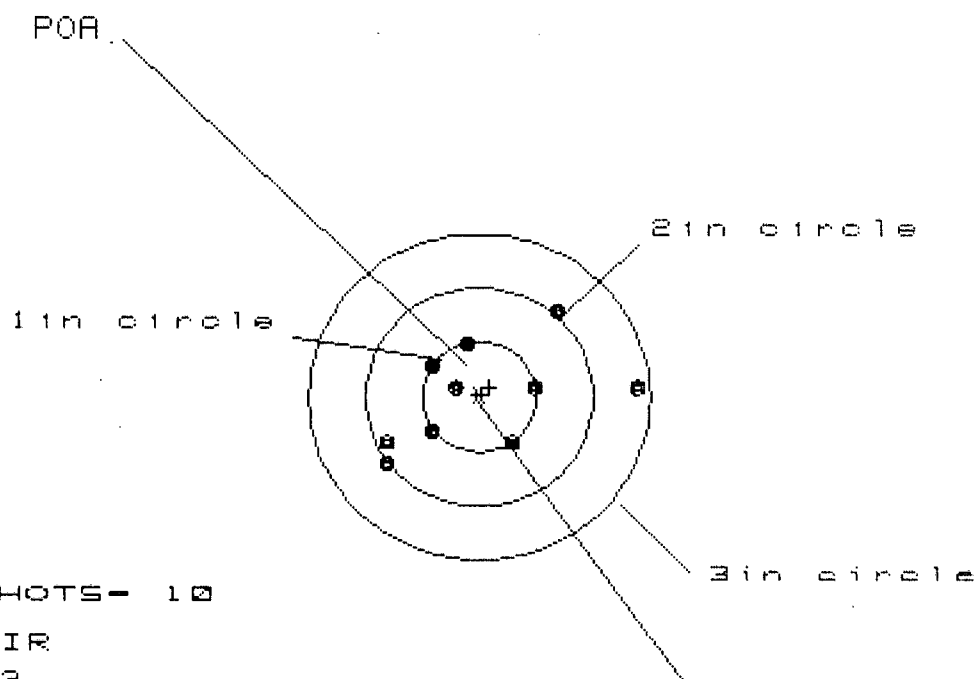
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.385	1.225	1.165
MINIMUM X	:	-1.433	-.992	-1.052
MAXIMUM Y	:	1.439	1.283	.569
MINIMUM Y	:	-1.406	-.713	-.553
CENTROID X	:	.172	.332	.392
CENTROID Y	:	-.081	.075	-.085
POA TO CENTROID in.	:	.190	.340	.401
MIN RADIUS	:	.160	.115	.272
MEAN RADIUS	:	1.006	.895	.843
MAX RADIUS	:	2.008	1.371	1.270
HORIZONTAL SPREAD	:	2.818	2.217	2.217
VERTICAL SPREAD	:	2.845	1.996	1.122
EXTREME SPREAD	:	3.402	2.501	2.456
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 2.242

VS= 1.385

GS= 2.352

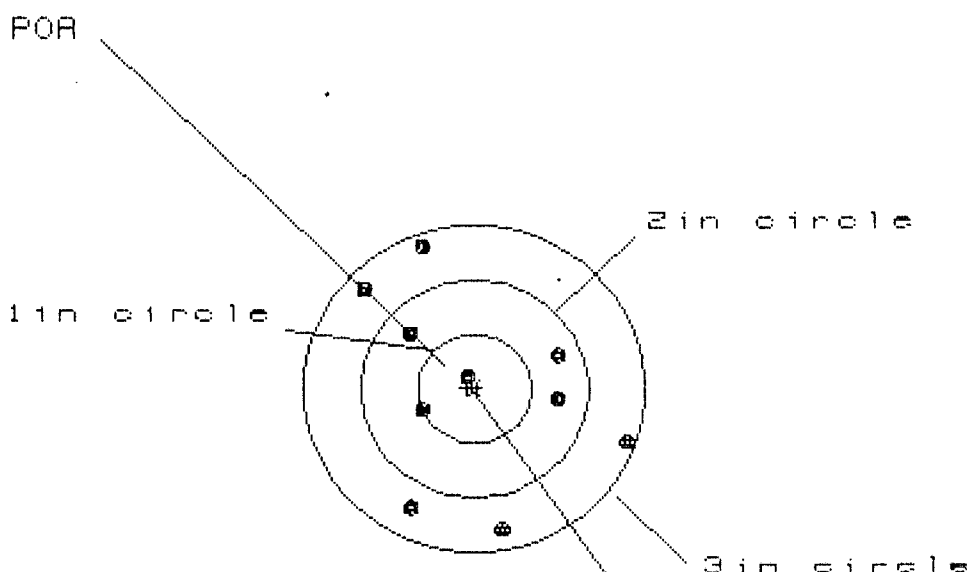
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.423	.829	.786
MINIMUM X	:	-.819	-.661	-.557
MAXIMUM Y	:	.771	.783	.607
MINIMUM Y	:	-.614	-.602	-.504
CENTROID X	:	-.086	-.244	-.348
CENTROID Y	:	-.087	-.099	-.197
POA TO CENTROID in.	:	.122	.263	.400
MIN RADIUS	:	.278	.152	.211
MEAN RADIUS	:	.720	.610	.533
MAX RADIUS	:	1.427	1.140	.804
HORIZONTAL SPREAD	:	2.242	1.490	1.343
VERTICAL SPREAD	:	1.385	1.385	1.111
EXTREME SPREAD	:	2.352	2.032	1.500
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 2.302

VS= 2.592

GS= 2.682

CENTROID #

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.358	.882	.842
MINIMUM X	:	-.944	-.793	-.833
MAXIMUM Y	:	1.290	1.235	.985
MINIMUM Y	:	-1.302	-1.357	-1.202
CENTROID X	:	.063	-.088	-.048
CENTROID Y	:	-.011	.044	-.111
POA TO CENTROID in.	:	.064	.098	.121
MIN RADIUS	:	.081	.120	.191
MEAN RADIUS	:	.948	.880	.833
MAX RADIUS	:	1.444	1.402	1.290
HORIZONTAL SPREAD	:	2.302	1.675	1.675
VERTICAL SPREAD	:	2.592	2.592	2.187
EXTREME SPREAD	:	2.682	2.678	2.470
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	10		