

C6636262

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington



MODEL 700™ N24

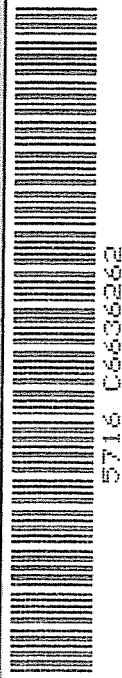
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



REG. U.S. PAT. & T.M. OFF.

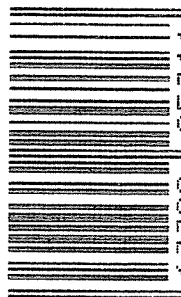
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

SERIAL NO. C6606262	ORDER NO. 5716
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5716 C6606262

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636262

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 25	9 1	RW
600	Proof	6 25	9 1	RW
607	Check Headspace	6 25	9 1	RW
610	Dis-assemble Gun	6 25		RW
612	Magnaflux Barrel Action		JUL 1 1991	KR
	Magnaflux Bolt		JUL 7 1991	KR
615	Rollmark Caliber		JUL 1 1991	GL
617	Drill and Tap Sight Holes		JUL 1 1991	LB
618	Polish Barrel		JUL 2 1991	WB
620	Apply Coatings (Barrel Action)		8/27/91	LB
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/27/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/27/91	RW
	C) Inspect Ejector Hole for Chamfer		8/27/91	RW
	D) Oil Firing Pin Ass'y		8/27/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/27/91	GL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8/28/91	GU
	G) Safety Off Force	4	4	4			8/28/91	GU
	H) Trigger Pull Test & Retainability						8/27/91	GU
	I) Firing Pin Indent	.0205	.0215	.0215			8/28/91	GU
	J) Assemble Stock						8/29/91	RU
	K) Assemble Swivel Studs						8-31-91	D/H
	L) Attach Front and Rear Sight Assemblies						8/29/91	RU
	M) Iron Sight Alignment						8/29/91	RU
	N) Detach Front & Rear Sights & place in numbered container						8/29/91	RU
	O) Attach Scope to Rifle						8/29/91	RU
	P) Detach & Attach Scope 20 Times						8/29/91	RU
640	Gallery Target & Test						8-29-91	VF
	A) Time						"	VF
	B) Malfunctions						"	VF
	C) Pierced Primers						"	VF
	D) Optical Clarity of Scope						"	VF
645	Inspect for Live Ammo						8-29-91	VF
655	Final Inspection							
	A) Headspace						8-31-91	D/H
	B) Trigger Pull	230	247	247	257	263	8-31-91	D/H
	C) Function						8-31-91	D/H
660	Pack						9-18-91	VF

SWS TRIGGER PULL TEST

AU 1

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6636282

DATE 8/27/91

TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.27	2.31	2.31	2.30	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.25	2.35	2.38	2.47	
PULL #3	2.28	2.31	2.35	2.47	
PULL #4	2.31	2.39	2.36	2.57	
PULL #5	2.36	2.32	2.30	2.63	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.43	3.47		
PULL #2	3.44	3.17		
PULL #3	3.41	3.20		
PULL #4	3.47	3.48		
PULL #5	3.45	3.50		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.31	4.34		4.30
PULL #2	4.31	4.31		4.37
PULL #3	4.31	4.31		4.37
PULL #4	4.32	4.36		4.38
PULL #5	4.33	4.40		4.36
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636262
29 Aug 1991

CENTROIDAL DISTANCES

0 TO 1	.101242
1 TO 2	.227058
1 TO 3	.420954
1 TO 4	.742833
1 TO 5	.085

4
3
2
1

←---POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .021
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1354
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .152886
THE AMR FOR THIS RIFLE IS: 1.028

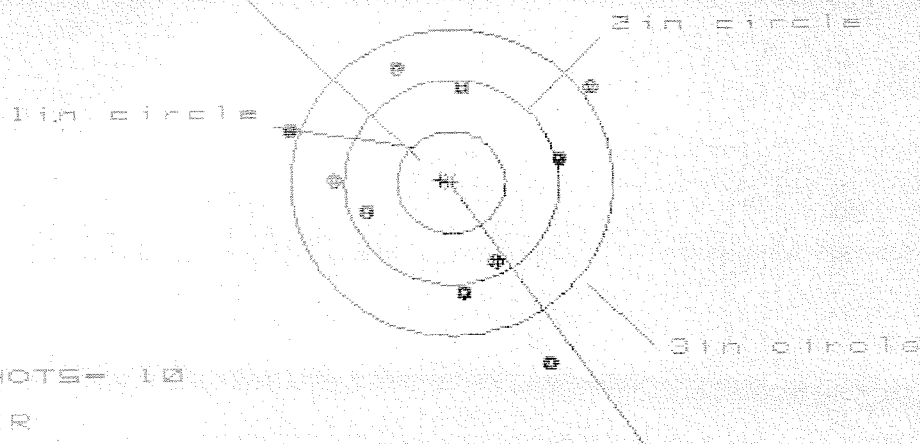
29 Aug 1991

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CENTERFIRE PATTERNS

1

POA



OF SHOTS- 10

IN CIR

1in = 0

2in = 3

3in = 7

HS= 2.824

VS= 2.858

GS= 3.318

CENTROID

PATTERN #

1

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.342

1.446

1.293

MINIMUM X

-1.482

-1.378

-1.197

MAXIMUM Y

1.111

.917

1.014

MINIMUM Y

-1.747

-1.264

-1.167

CENTROID X

.097

-.007

-.188

CENTROID Y

-.029

.165

.068

POA TO CENTROID in.

.102

.166

.200

MIN RADIUS

.808

.753

.590

MEAN RADIUS

1.225

1.123

1.034

MAX RADIUS

1.985

1.643

1.298

HORIZONTAL SPREAD

2.824

2.824

2.490

VERTICAL SPREAD

2.858

2.181

2.181

EXTREME SPREAD

3.318

2.861

2.508

NUMBER IN ONE INCH CIRCLE =

0

NUMBER IN TWO INCH CIRCLE =

3

NUMBER IN THREE INCH CIRCLE =

7

29 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636262

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 1.959

VS= 2.415

GS= 2.785

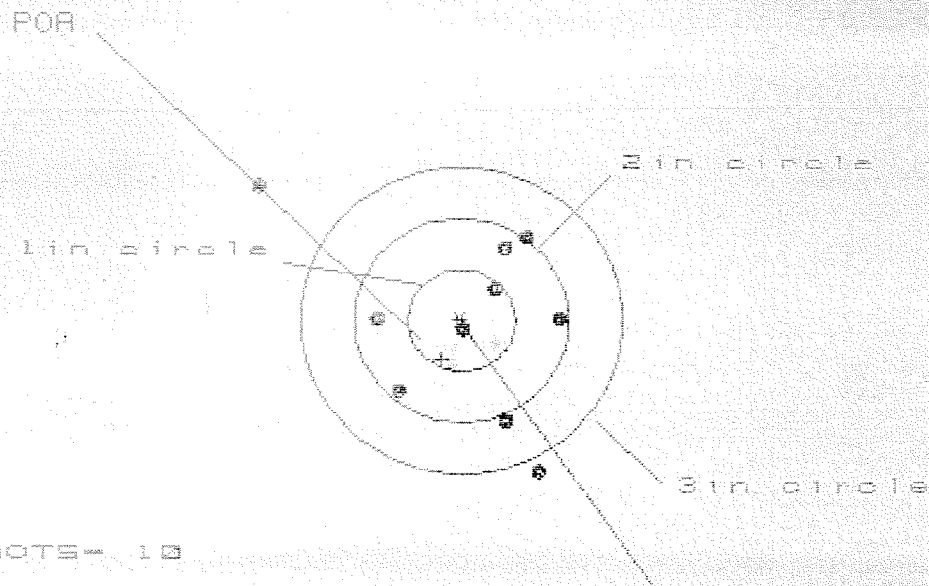
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.028	1.133	1.066
MINIMUM X	-.931	-.826	-.893
MAXIMUM Y	.999	.842	.653
MINIMUM Y	-1.416	-1.513	-1.784
CENTROID X	.215	.110	.177
CENTROID Y	-.223	-.066	.123
POA TO CENTROID in.	.309	.128	.216
MIN RADIUS	.248	.210	.181
MEAN RADIUS	.912	.784	.659
MAX RADIUS	1.700	1.604	1.191
HORIZONTAL SPREAD	1.959	1.959	1.959
VERTICAL SPREAD	2.415	2.355	1.436
EXTREME SPREAD	2.785	2.785	2.359
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	5	
NUMBER IN THREE INCH CIRCLE	=	9	

28 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6535262

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 2

2in = 5

3in = 8

HS = 2.745

VS = 2.778

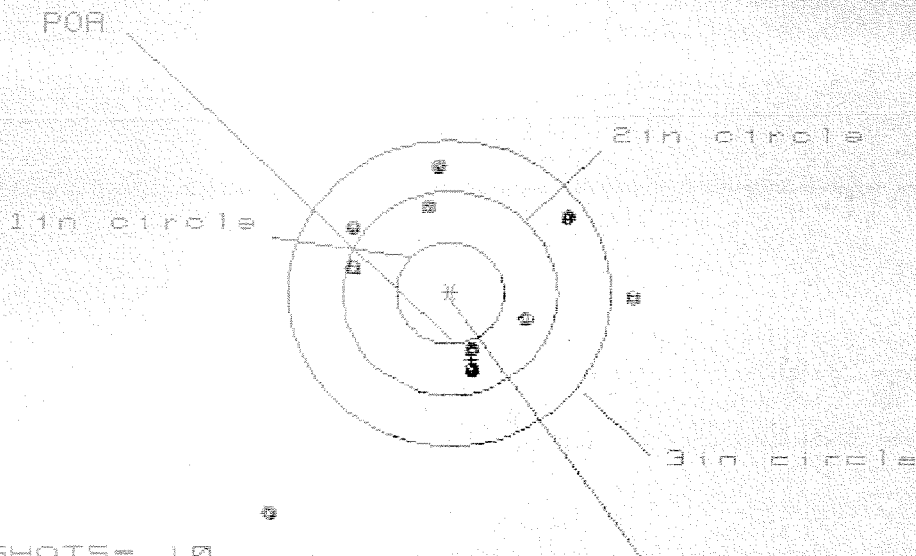
GS = 3.793

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	.904
MINIMUM X	-1.841
MAXIMUM Y	1.323
MINIMUM Y	-1.455
CENTROID X	.188
CENTROID Y	.382
POA TO CENTROID in.	.426
MIN RADIUS	.091
MEAN RADIUS	.994
MAX RADIUS	2.267
HORIZONTAL SPREAD	2.745
VERTICAL SPREAD	2.778
EXTREME SPREAD	3.793
NUMBER IN ONE INCH CIRCLE	2
NUMBER IN TWO INCH CIRCLE	6
NUMBER IN THREE INCH CIRCLE	8

25 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CAB36262

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 0

2in = 5

3in = 8

HS = 3.416

VS = 3.361

GS = 4.027

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.679	1.486	1.070
MINIMUM X	:	-1.737	-1.124	-.938
MAXIMUM Y	:	1.214	.975	.938
MINIMUM Y	:	-2.147	-.950	-.987
CENTROID X	:	-.202	-.009	-.195
CENTROID Y	:	.651	.890	.927
POA TO CENTROID in.	:	.682	.890	.947
MIN RADIUS	:	.618	.679	.612
MEAN RADIUS	:	1.195	.997	.916
MAX RADIUS	:	2.762	1.515	1.164
HORIZONTAL SPREAD	:	3.416	2.610	2.008
VERTICAL SPREAD	:	3.361	1.925	1.925
EXTREME SPREAD	:	4.027	2.699	2.011
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

25 Aug 1991

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 8

HS= 2.367

VS= 2.234

GS= 2.709

CENTROID *

PATTERN #	1	5	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.525	1.609	.638
MINIMUM X	-.842	-.758	-.557
MAXIMUM Y	.773	.610	.591
MINIMUM Y	-1.462	-.605	-.624
CENTROID X	.057	-.027	-.228
CENTROID Y	-.104	.058	.077
POA TO CENTROID in.	.119	.064	.240
MIN RADIUS	.111	.073	.241
MEAN RADIUS	.816	.705	.573
MAX RADIUS	1.644	1.616	.987
HORIZONTAL SPREAD	2.367	2.367	1.187
VERTICAL SPREAD	2.234	1.215	1.215
EXTREME SPREAD	2.709	2.474	1.667
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	7	
NUMBER IN THREE INCH CIRCLE	=	8	