

C6611665

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.

REG. U.S. PAT. & TM. OFF.

MODEL 700™ M24

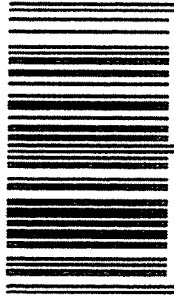
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off. Marca Registrada Marque Deposee.

SERIAL NO.
C6611665

ORDER NO.
5716

20

UPC



0 47700 25716 7



5716 C6611665

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611665

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 16	91	RW
600	Proof	1 16	91	RW
607	Check Headspace	1 16	91	RW
610	Dis-assemble Gun	1 16	91	RW
612	Magnaflux Barrel Action	1 18	91	KR
	Magnaflux Bolt	1 18	91	KR
615	Rollmark Caliber	1 18	91	YB
617	Drill and Tap Sight Holes	1 24	91	FB
618	Polish Barrel	1 24	91	WB
620	Apply Coatings (Barrel Action)		2-15-91	TA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/18/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/18/91	RW
	C) Inspect Ejector Hole for Chamfer		2/18/91	RW
	D) Oil Firing Pin Ass'y		2/18/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		3-1-91	JL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 ³ / ₄	4 ³ / ₄	4 ³ / ₄			3/1/91	WB
	G) Safety Off Force	2 ¹ / ₄	2 ¹ / ₄	2 ¹ / ₄			3/1/91	WB
	H) Trigger Pull Test & Retainability						3-1-91	JH
	I) Firing Pin Indent	.023	.023	.023			3/1/91	WB
	J) Assemble Stock						3/4/91	RW
	K) Assemble Swivel Studs						3/3/91	WB
	L) Attach Front and Rear Sight Assemblies						3/4/91	RW
	M) Iron Sight Alignment						3/4/91	RW
	N) Detach Front & Rear Sights & place in numbered container						3/4/91	RW
	O) Attach Scope to Rifle						3/4/91	RW
	P) Detach & Attach Scope 20 Times						3/4/91	RW
640	Gallery Target & Test						3/4/91	12
	A) Time							12
	B) Malfunctions							12
	C) Pierced Primers							18
	D) Optical Clarity of Scope							18
645	Inspect for Live Ammo						3/4/91	19
655	Final Inspection						3/5/91	WB
	A) Headspace							
	B) Trigger Pull	2.29	2.27	2.30	2.34	2.33	3-5-91	JH
	C) Function						3/5/91	WB
660	Pack						3-5-91	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6611665

DATE 3-1-91

TESTER JP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.34	2.24	2.25	2.29	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.44	2.20	2.33	2.27	
PULL #3	2.41	2.29	2.30	2.30	
PULL #4	2.36	2.37	2.28	2.34	
PULL #5	2.34	2.29	2.38	2.33	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.42	3.28		
PULL #2	3.36	3.27		
PULL #3	3.45	3.27		
PULL #4	3.49	3.35		
PULL #5	3.53	3.36		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.33	4.27		4.21
PULL #2	4.25	4.21		4.33
PULL #3	4.24	4.19		4.16
PULL #4	4.26	4.36		4.26
PULL #5	4.32	4.30		4.31
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06611665
5 Mar 1991

CENTROIDAL DISTANCES

0 TO	1	.184762
1 TO	2	.193706
1 TO	3	.214189
1 TO	4	.236916
1 TO	5	.128413

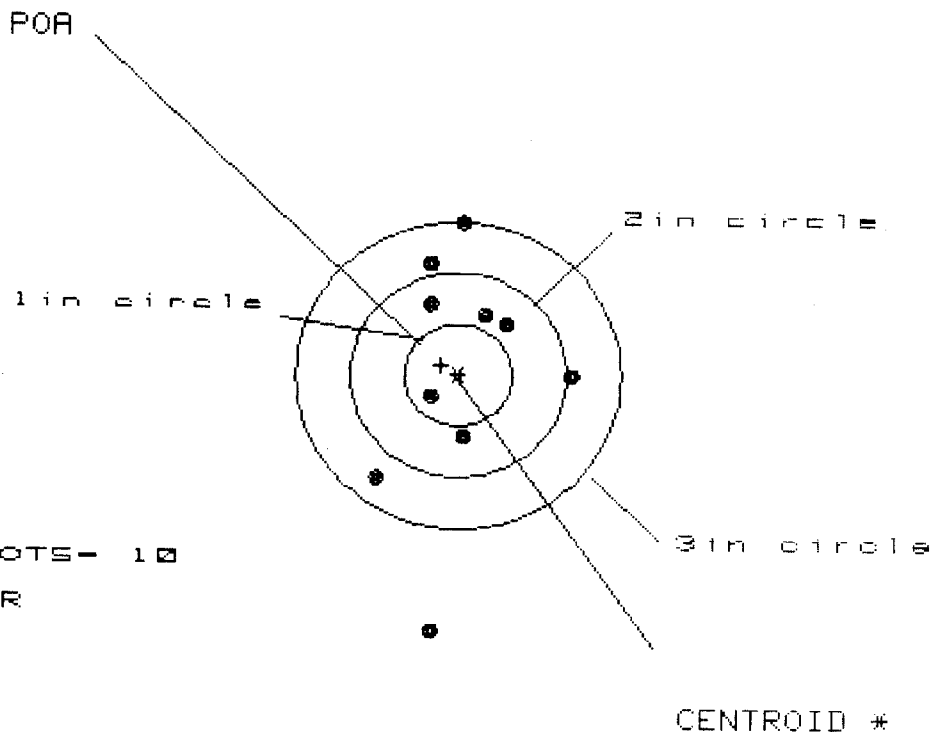
$\bar{x}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0426
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1304
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .137182
THE AME FOR THIS RIFLE IS: 1.008

5 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611665

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 1

2in = 5

3in = 9

HS = 1.814

VS = 4.036

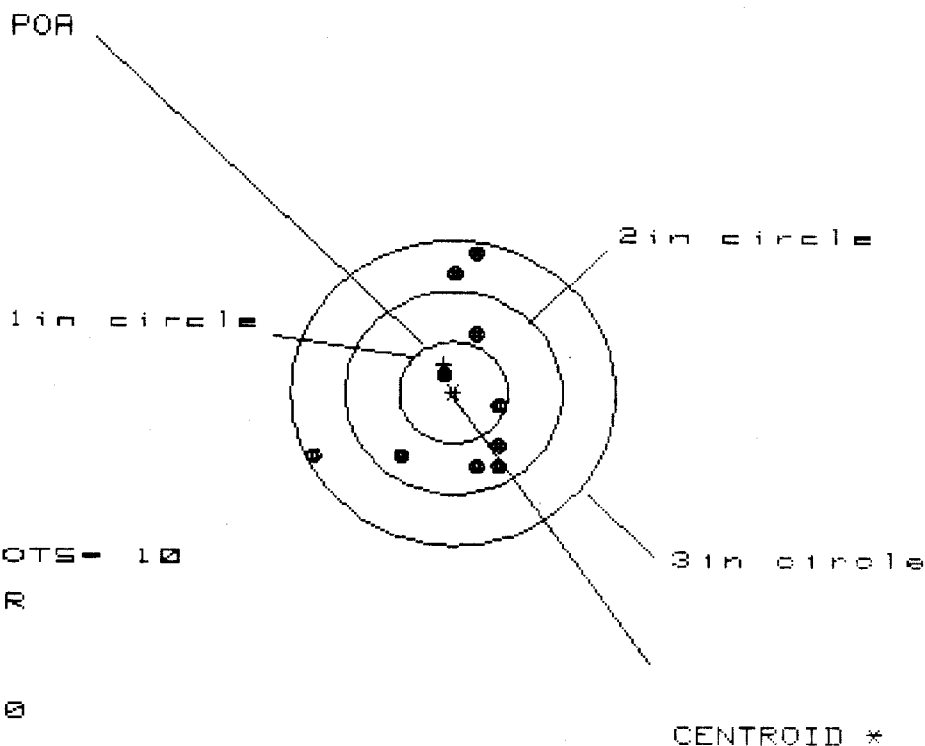
GS = 4.045

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.031	1.006	1.008
MINIMUM X	-.783	-.808	-.806
MAXIMUM Y	1.489	1.206	.936
MINIMUM Y	-2.547	-1.271	-1.120
CENTROID X	.156	.181	.179
CENTROID Y	-.099	.184	.033
POA TO CENTROID in.	.185	.258	.182
MIN RADIUS	.365	.379	.475
MEAN RADIUS	1.046	.825	.785
MAX RADIUS	2.557	1.506	1.380
HORIZONTAL SPREAD	1.814	1.814	1.814
VERTICAL SPREAD	4.036	2.477	2.056
EXTREME SPREAD	4.045	2.611	2.134
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

5 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B11685

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 1.750

VS= 2.109

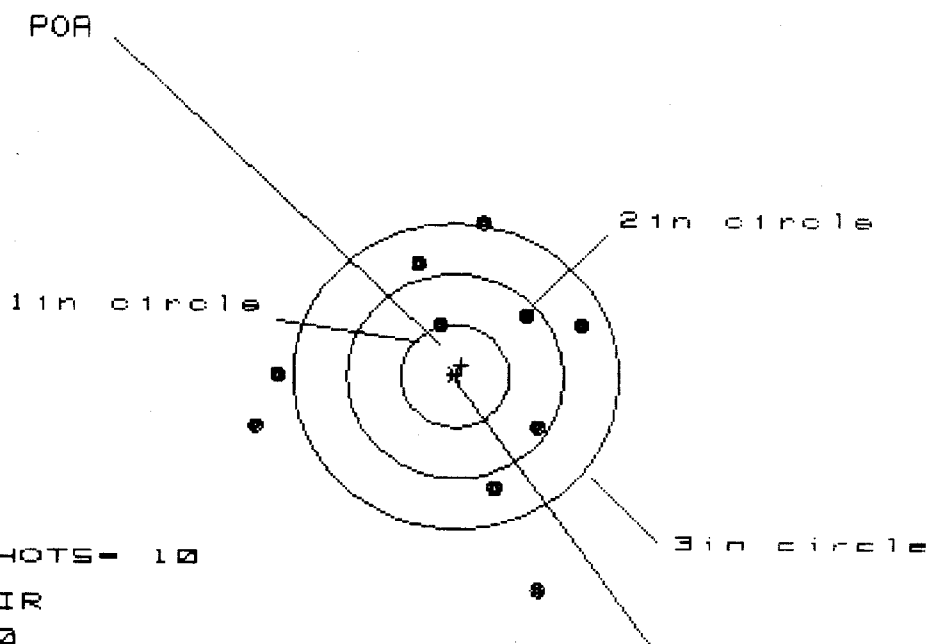
GS= 2.495

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.447	.302	.316
MINIMUM X	:	-1.303	-.673	-.659
MAXIMUM Y	:	1.357	1.291	1.275
MINIMUM Y	:	-.752	-.818	-.657
CENTROID X	:	.087	.232	.218
CENTROID Y	:	-.280	-.214	-.375
POA TO CENTROID in.	:	.293	.315	.434
MIN RADIUS	:	.189	.221	.278
MEAN RADIUS	:	.826	.743	.652
MAX RADIUS	:	1.431	1.295	1.286
HORIZONTAL SPREAD	:	1.750	.975	.975
VERTICAL SPREAD	:	2.109	2.109	1.932
EXTREME SPREAD	:	2.495	2.139	1.946
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

5 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611665

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 0

2in = 3

3in = 6

HS = 3.019

VS = 3.600

GS = 3.626

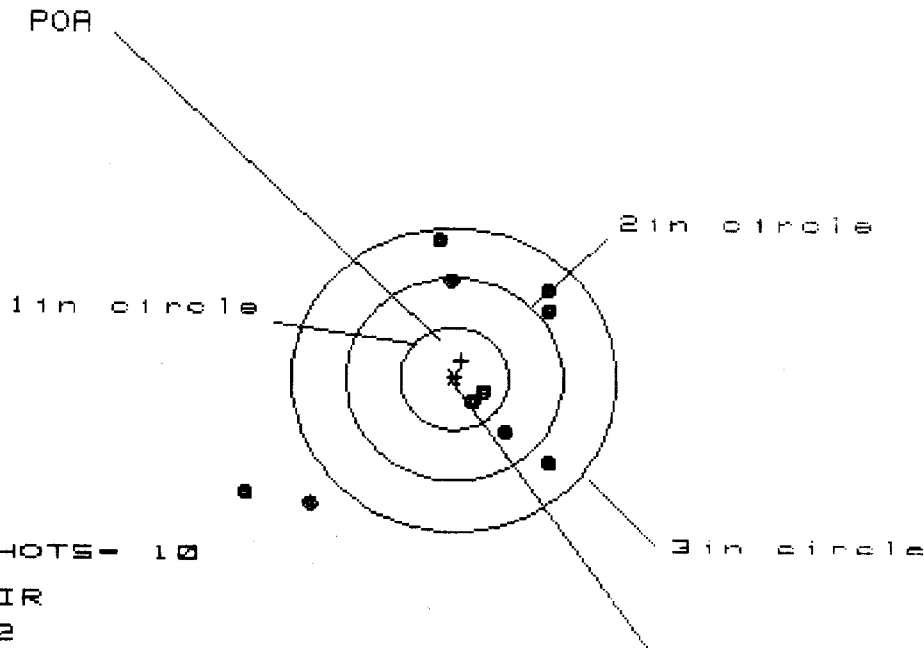
CENTROID *

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.146	1.227	1.003
MINIMUM X	:	-1.873	-1.792	-1.765
MAXIMUM Y	:	1.480	1.245	1.156
MINIMUM Y	:	-2.120	-1.278	-1.367
CENTROID X	:	-.058	-.139	.085
CENTROID Y	:	-.108	.127	.216
POA TO CENTROID in.	:	.123	.189	.232
MIN RADIUS	:	.505	.255	.341
MEAN RADIUS	:	1.320	1.178	1.042
MAX RADIUS	:	2.243	1.926	1.796
HORIZONTAL SPREAD	:	3.019	3.019	2.768
VERTICAL SPREAD	:	3.600	2.523	2.523
EXTREME SPREAD	:	3.626	3.163	2.810
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		6	

5 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6811685

CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 2.802

VS= 2.660

GS= 3.379

CENTROID *

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.872	.658	.461
MINIMUM X	:	-1.930	-1.576	-.507
MAXIMUM Y	:	1.413	1.294	1.123
MINIMUM Y	:	-1.247	-1.366	-1.065
CENTROID X	:	-.067	.147	.344
CENTROID Y	:	-.179	-.060	.111
POA TO CENTROID in.	:	.192	.159	.361
MIN RADIUS	:	.227	.250	.428
MEAN RADIUS	:	1.107	.934	.777
MAX RADIUS	:	2.209	2.086	1.232
HORIZONTAL SPREAD	:	2.802	2.234	.968
VERTICAL SPREAD	:	2.660	2.660	2.188
EXTREME SPREAD	:	3.379	3.048	2.393
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

5 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611665

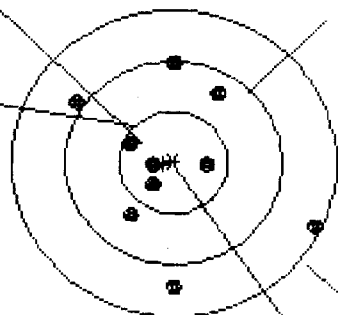
CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle



OF SHOTS- 10

IN CIR

1 in - 4

2 in - 6

3 in = 10

HS- 2.200

VS- 2.200

GS- 2.519

CENTROID #

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.344	.601	.614
MINIMUM X	:	-.864	-.714	-.701
MAXIMUM Y	:	1.014	.944	.787
MINIMUM Y	:	-1.186	-1.256	-.697
CENTROID X	:	.095	-.055	-.068
CENTROID Y	:	.014	.084	.241
POA TO CENTROID in.	:	.096	.100	.250
MIN RADIUS	:	.175	.094	.243
MEAN RADIUS	:	.741	.632	.568
MAX RADIUS	:	1.483	1.261	.814
HORIZONTAL SPREAD	:	2.208	1.315	1.315
VERTICAL SPREAD	:	2.200	2.200	1.484
EXTREME SPREAD	:	2.519	2.202	1.547
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	