

C6611686

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

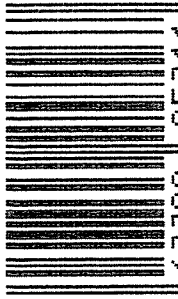
Remington

Remington®  REG. U.S. PAT. & TM. OFF.		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700™ M24		SERIAL NO. C6611686
MADE IN U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.		ORDER NO. 5716



5716 C6611686

UPC



0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611686

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 28 91		RW
600	Proof	3 28 91		RW
607	Check Headspace	3 28 91		RW
610	Dis-assemble Gun	3 28 91		RW
612	Magnaflux Barrel Action	APR 2 1991		KR
	Magnaflux Bolt	APR 2 1991		U
615	Rollmark Caliber	APR 2 1991		28
617	Drill and Tap Sight Holes	APR 5 1991		LB
618	Polish Barrel	APR 5 1991		WB
620	Apply Coatings (Barrel Action)	4-9-91		JA
	Apply Coating (Bolt)			JA
625	Final Assembly A) Clean inside of Bolt Assembly		4/10/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/10/91	RW
	C) Inspect Ejector Hole for Chamfer		4/10/91	RW
	D) Oil Firing Pin Ass'y		4/10/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4/22/91	MM

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7	7	7			4-22-91	DH
	G) Safety Off Force	4	3½	3½			4-22-91	DH
	H) Trigger Pull Test & Retainability						4/22/91	JH
	I) Firing Pin Indent	.021	.020	.022			4-22-91	DH
	J) Assemble Stock						4/30/91	RW
	K) Assemble Swivel Studs						5-1-91	DH
	L) Attach Front and Rear Sight Assemblies						4/30/91	RW
	M) Iron Sight Alignment						4/30/91	RW
	N) Detach Front & Rear Sights & place in numbered container						4/30/91	RW
	O) Attach Scope to Rifle						4/30/91	RW
	P) Detach & Attach Scope 20 Times						4/30/91	RW
640	Gallery Target & Test						4-30-91	DH
	A) Time						4-30-91	DH
	B) Malfunctions						4-30-91	DH
	C) Pierced Primers						4-30-91	DH
	D) Optical Clarity of Scope						4-30-91	DH
645	Inspect for Live Ammo						4-30-91	DH
655	Final Inspection							
	A) Headspace						5-11-91	DH
	B) Trigger Pull	2.27	2.26	2.28	2.30	2.31	5/10/91	JH
	C) Function						5-11-91	DH
660	Pack						6-15-91	RW

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6611686

DATE 4/22/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.33	2.40	2.27	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.29	2.26	2.26	
PULL #3	2.25	2.35	2.23	2.28	
PULL #4	2.26	2.28	2.24	2.30	
PULL #5	2.33	2.32	2.26	2.31	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.53	3.33		
PULL #2	3.57	3.35		
PULL #3	3.37	3.55		
PULL #4	3.25	3.26		
PULL #5	3.33	3.29		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.29	4.24		4.49
PULL #2	4.16	4.19		4.53
PULL #3	4.21	4.18		4.56
PULL #4	4.17	4.14		4.57
PULL #5	4.22	4.15		4.49
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06611686
30 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.159211
1 TO	2	.122577
1 TO	3	.172131
1 TO	4	.321604
1 TO	5	.335574

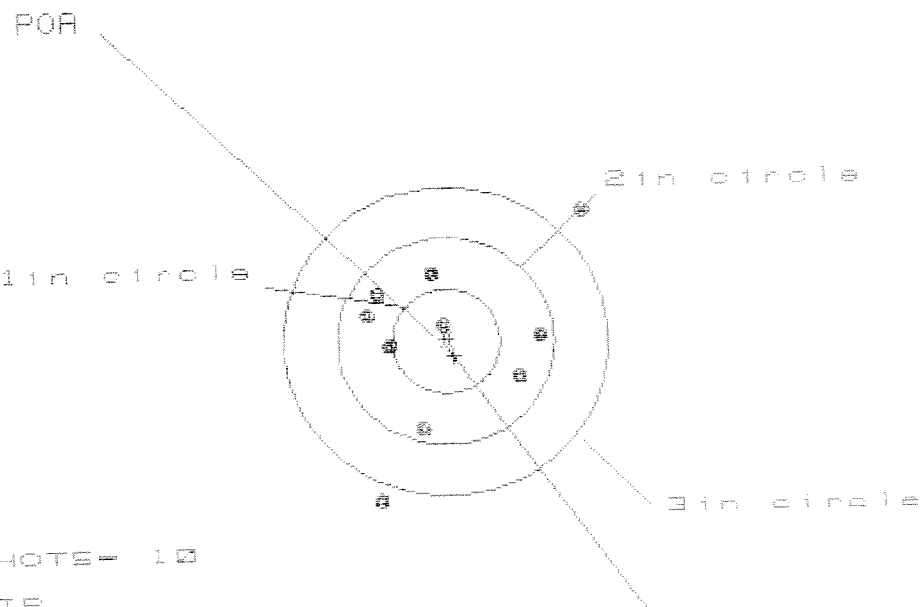
50' (---)POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0018
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0124
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .01253
THE AMR FOR THIS RIFLE IS: 1.002

30 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611686

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 1

2in = 8

3in = 8

HS= 1.935

VS= 2.827

GS= 3.382

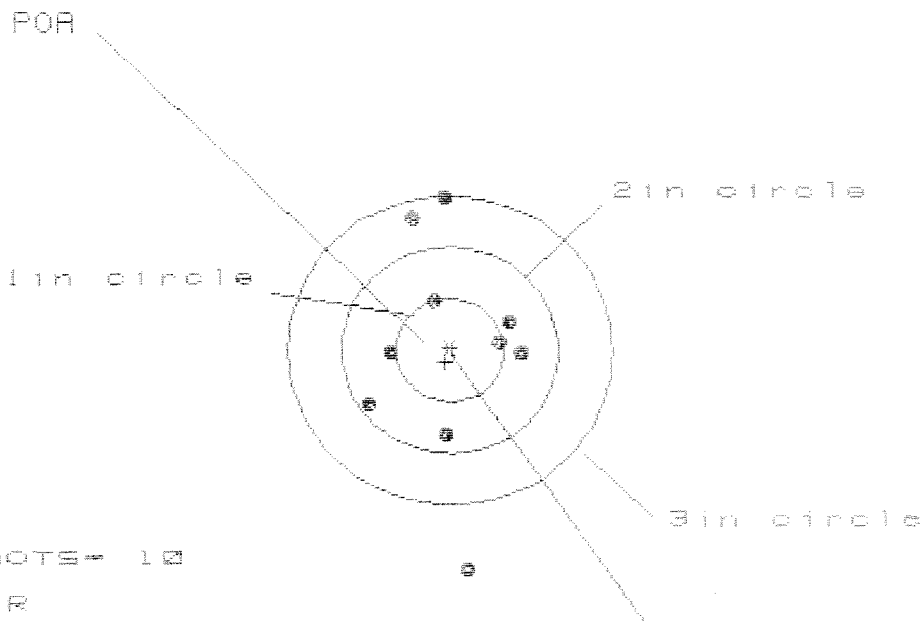
CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.245	1.040	.981
MINIMUM X	-.690	-.552	-.611
MAXIMUM Y	1.283	.798	.623
MINIMUM Y	-1.544	-1.401	-.851
CENTROID X	-.072	-.210	-.151
CENTROID Y	.142	-.001	.174
POA TO CENTROID in.	.159	.210	.231
MIN RADIUS	.205	.356	.172
MEAN RADIUS	.892	.787	.667
MAX RADIUS	1.788	1.479	.981
HORIZONTAL SPREAD	1.935	1.592	1.592
VERTICAL SPREAD	2.827	2.199	1.474
EXTREME SPREAD	3.382	2.262	1.605
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 1.410

VS= 3.569

GS= 3.576

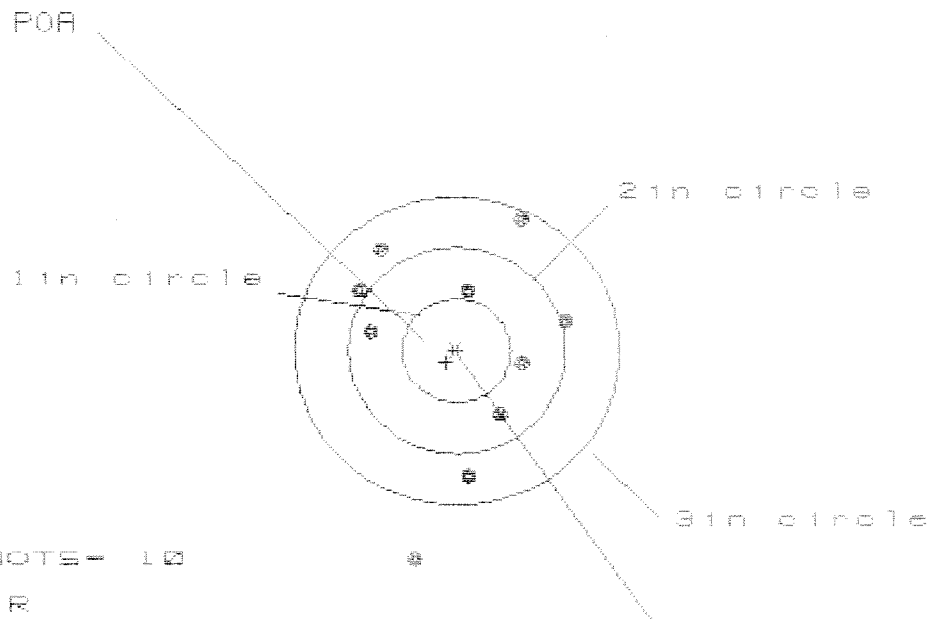
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.689	.709	.706
MINIMUM X	:	-.721	-.701	-.704
MAXIMUM Y	:	1.440	1.203	1.162
MINIMUM Y	:	-2.129	-1.004	-.853
CENTROID X	:	.048	.028	.031
CENTROID Y	:	.117	.354	.203
POA TO CENTROID in.	:	.126	.355	.206
MIN RADIUS	:	.475	.262	.390
MEAN RADIUS	:	.941	.785	.725
MAX RADIUS	:	2.137	1.204	1.216
HORIZONTAL SPREAD	:	1.410	1.410	1.410
VERTICAL SPREAD	:	3.569	2.207	2.015
EXTREME SPREAD	:	3.576	2.207	2.047
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 0

2in = 4

3in = 9

HS= 1.892

VS= 3.314

GS= 3.443

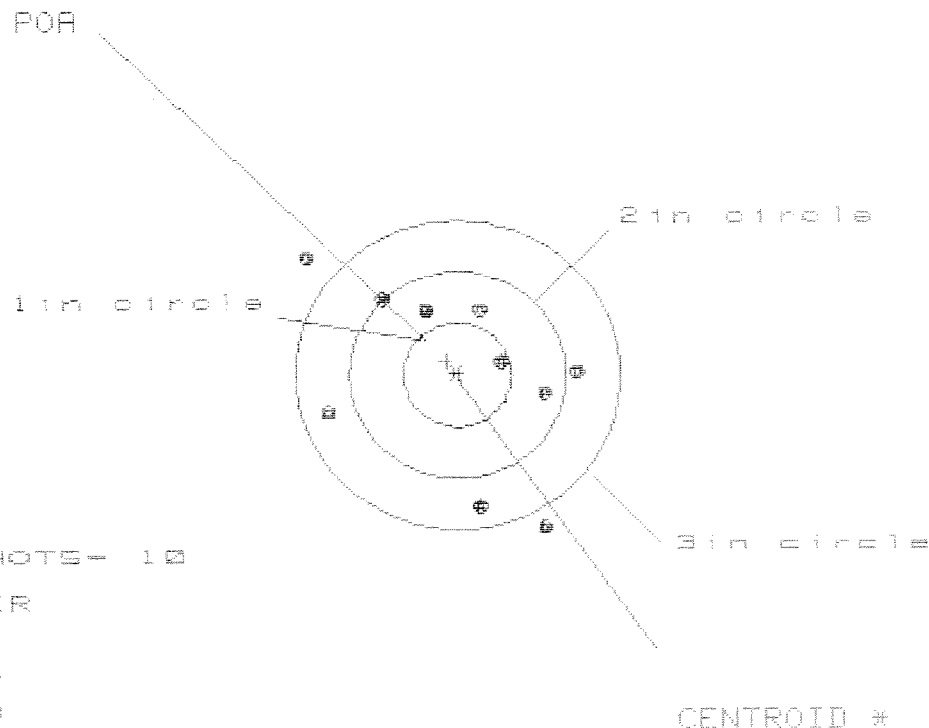
CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.003	.961	1.025
MINIMUM X	-.889	-.931	-.867
MAXIMUM Y	1.308	1.085	.862
MINIMUM Y	-2.006	-1.389	-1.253
CENTROID X	.098	.140	.076
CENTROID Y	.115	.338	.203
POA TO CENTROID in.	.151	.366	.216
MIN RADIUS	.571	.345	.487
MEAN RADIUS	1.062	.922	.888
MAX RADIUS	2.042	1.392	1.263
HORIZONTAL SPREAD	1.892	1.892	1.892
VERTICAL SPREAD	3.314	2.474	2.116
EXTREME SPREAD	3.443	2.509	2.270
NUMBER IN ONE INCH CIRCLE	=	0	
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 = 1

2in = 4

3in = 8

HS= 2.528

VS= 2.638

GS= 3.425

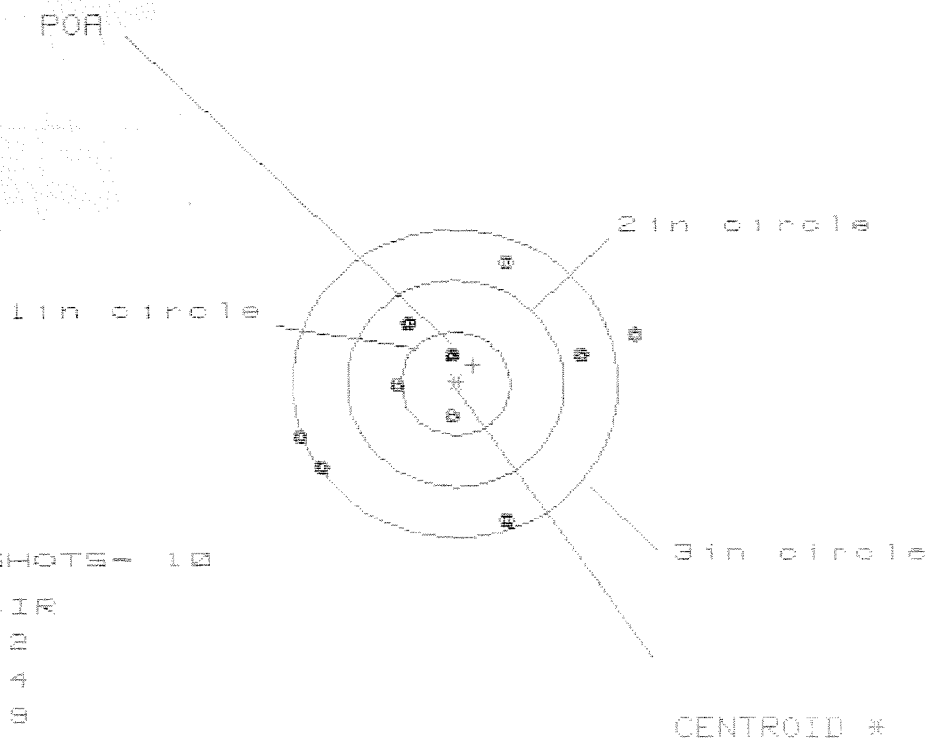
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.129	.973	1.052
MINIMUM X	:	-1.399	-1.366	-1.227
MAXIMUM Y	:	1.145	.852	.681
MINIMUM Y	:	-1.493	-1.366	-1.315
CENTROID X	:	.098	.254	.175
CENTROID Y	:	-.131	-.258	-.087
POA TO CENTROID in.	:	.164	.362	.196
MIN RADIUS	:	.383	.331	.296
MEAN RADIUS	:	1.080	.987	.894
MAX RADIUS	:	1.808	1.504	1.324
HORIZONTAL SPREAD	:	2.528	2.279	2.279
VERTICAL SPREAD	:	2.638	2.218	1.996
EXTREME SPREAD	:	3.425	2.678	2.316
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 9

HS= 3.023

VS= 2.447

GS= 3.195

PATTERN #

5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.614	1.378	1.224
MINIMUM X	-1.409	-1.230	-1.208
MAXIMUM Y	1.140	1.199	1.143
MINIMUM Y	-1.307	-1.248	-1.304
CENTROID X	-.163	-.342	-.188
CENTROID Y	-.181	-.240	-.184
POA TO CENTROID in.	.243	.418	.263
MIN RADIUS	.273	.278	.271
MEAN RADIUS	1.036	.943	.893
MAX RADIUS	1.698	1.429	1.448
HORIZONTAL SPREAD	3.023	2.608	2.432
VERTICAL SPREAD	2.447	2.447	2.447
EXTREME SPREAD	3.195	2.736	2.678
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	9		