

C6611695

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

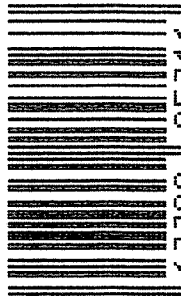
SERIAL NO.
C6611695

ORDER NO.
5716

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

20

LPC



0 47700 25716 2



5716 C6611695

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611695

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	GB
617	Drill and Tap Sight Holes	5 10	91	WB
618	Polish Barrel	5 10	91	WB
620	Apply Coatings (Barrel Action)		5/30/91	WB
	Apply Coating (Bolt)		5/30/91	WB
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		6/6/91	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5/2	5/2	5/2			6/6/91	WB
	G) Safety Off Force	3	3	3			6/6/91	WB
	H) Trigger Pull Test & Retainability						6/6/91	WB
	I) Firing Pin Indent	.022	.0225	.022			6/6/91	WB
	J) Assemble Stock						6/7/91	RW
	K) Assemble Swivel Studs						6-12-91	A
	L) Attach Front and Rear Sight Assemblies						6/7/91	RW
	M) Iron Sight Alignment						6/7/91	RW
	N) Detach Front & Rear Sights & place in numbered container						6/7/91	RW
	O) Attach Scope to Rifle						6/7/91	RW
	P) Detach & Attach Scope 20 Times						6/7/91	RW
640	Gallery Target & Test						6-10-91	AC
	A) Time						6-10-91	AC
	B) Malfunctions						6-10-91	AC
	C) Pierced Primers						6-10-91	AC
	D) Optical Clarity of Scope						6-10-91	AC
645	Inspect for Live Ammo						6-10-91	AC
655	Final Inspection							
	A) Headspace						6-12-91	A
	B) Trigger Pull	2.22	2.18	2.21	2.21	2.23	6-12-91	RW
	C) Function						6-12-91	A
660	Pack						6-20-91	RF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6611695
DATE 6/6/91
TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.48	2.34	2.35	2.22	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.50	2.35	2.35	2.18	
PULL #3	2.44	2.34	2.30	2.21	
PULL #4	2.43	2.33	2.33	2.21	
PULL #5	2.43	2.32	2.30	2.23	
TOTAL	12.28	11.68	11.63		
AVG.	2.45	2.33	2.32		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.02	3.23		
PULL #2	3.17	3.15		
PULL #3	3.22	3.15		
PULL #4	3.22	3.13		
PULL #5	3.10	3.14		
TOTAL	15.73	15.80		
AVG.	3.15	3.16		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.07	4.03		4.09
PULL #2	4.00	4.00		4.05
PULL #3	4.09	4.01		4.12
PULL #4	4.02	4.00		3.95
PULL #5	4.13	3.97		4.05
TOTAL	20.31	20.01		20.26
AVG.	4.06	4.00		4.05

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06611695
10 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.0912688
1 TO	2	.159289
1 TO	3	.258008
1 TO	4	.0751665
1 TO	5	.209022

✱ ←---POA

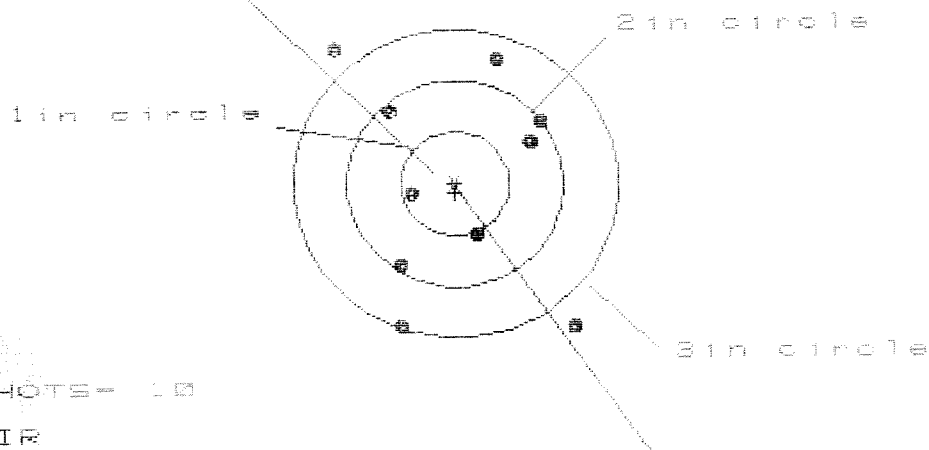
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .089
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1616
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .184487
THE AMP FOR THIS RIFLE IS: .6356

18 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08811695

CENTERFIRE PATTERNS # 1

POB



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 7

HS= 2.193

VS= 2.683

GS= 3.447

CENTROID #

PATTERN #

1

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.083

.918

.795

MINIMUM X

-1.110

-.990

-.611

MAXIMUM Y

1.270

1.115

1.173

MINIMUM Y

-1.413

-1.568

-1.428

CENTROID X

.007

-.113

.010

CENTROID Y

.091

.246

.106

POB TO CENTROID in.

.091

.271

.107

MIN RADIUS

.450

.398

.456

MEAN RADIUS

1.094

1.010

.937

MAX RADIUS

1.762

1.622

1.527

HORIZONTAL SPREAD

2.193

1.908

1.406

VERTICAL SPREAD

2.683

2.683

2.601

EXTREME SPREAD

3.447

2.772

2.772

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

5

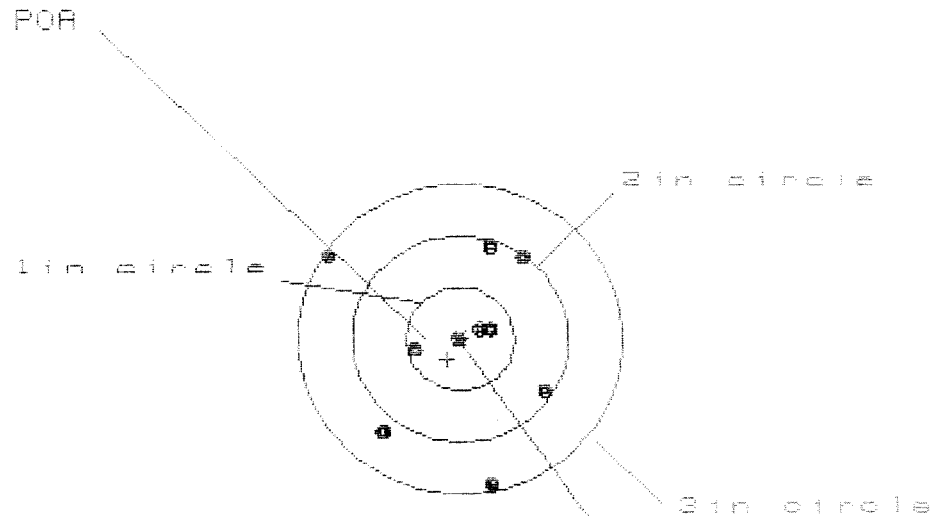
NUMBER IN THREE INCH CIRCLE =

7

18 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08611695

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 4

2in = 6

3in = 9

HS = 2.015

VS = 2.317

GS = 2.685

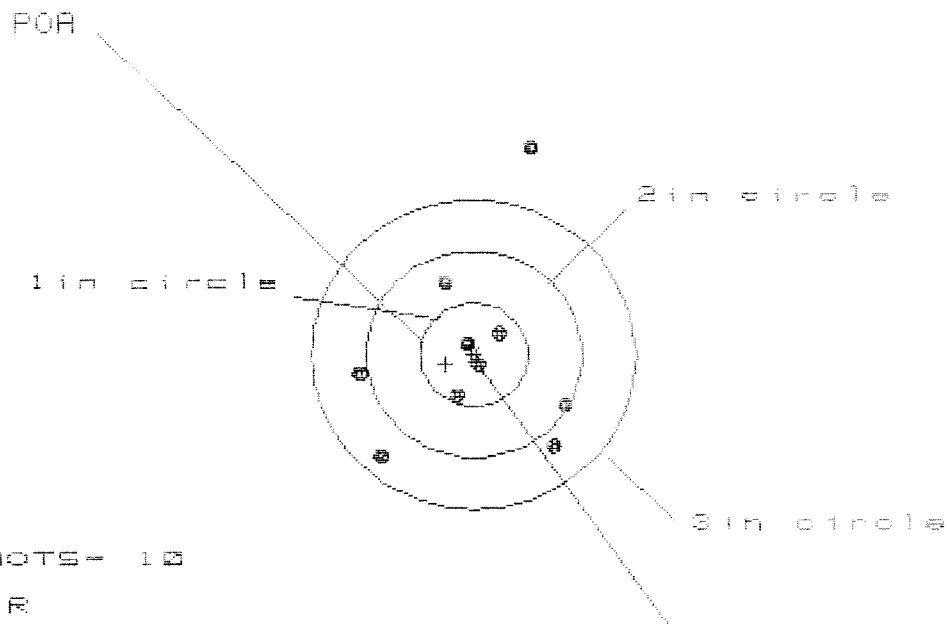
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.749	.609	.621
MINIMUM X	:	-1.266	-.817	-.804
MAXIMUM Y	:	.938	1.032	.871
MINIMUM Y	:	-1.379	-1.285	-.972
CENTROID X	:	.125	.265	.253
CENTROID Y	:	.198	.104	.265
POA TO CENTROID in.	:	.234	.285	.366
MIN RADIUS	:	.020	.188	.050
MEAN RADIUS	:	.793	.716	.605
MAX RADIUS	:	1.520	1.290	1.262
HORIZONTAL SPREAD	:	2.015	1.426	1.426
VERTICAL SPREAD	:	2.317	2.317	1.843
EXTREME SPREAD	:	2.685	2.318	2.161
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

18 Jun 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 6

3 in = 9

HE= 1.898

VS= 2.923

GS= 3.231

CENTROID #

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.819	.876	.775
MINIMUM X	-1.079	-1.022	-1.123
MAXIMUM Y	1.968	.912	.820
MINIMUM Y	-.955	-.736	-.767
CENTROID X	.265	.208	.309
CENTROID Y	.089	-.130	-.038
POA TO CENTROID in.	.279	.245	.312
MIN RADIUS	.120	.159	.024
MEAN RADIUS	.893	.698	.620
MAX RADIUS	2.033	1.095	1.125
HORIZONTAL SPREAD	1.898	1.898	1.898
VERTICAL SPREAD	2.923	1.648	1.587
EXTREME SPREAD	3.231	1.977	1.977
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

10 Jun 1981

FILE:/PATTERNING/CENTERFIRE_PATT/C6611695

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 1

2 in = 6

3 in = 8

HS= 1.575

VS= 3.051

GS= 3.186

CENTROID *

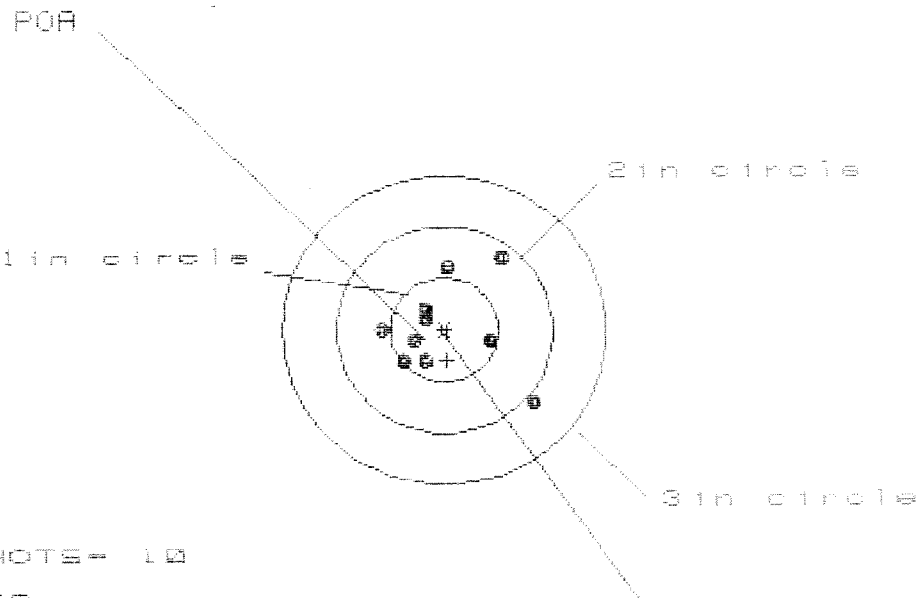
PATTERN #

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.735	.744	.640
MINIMUM X	-.840	-.931	-.629
MAXIMUM Y	1.650	.748	.596
MINIMUM Y	-1.401	-1.217	-1.252
CENTROID X	.070	.061	.165
CENTROID Y	.132	-.052	.100
POA TO CENTROID in.	.149	.080	.193
MIN RADIUS	.447	.565	.386
MEAN RADIUS	.930	.874	.746
MAX RADIUS	1.652	1.474	1.266
HORIZONTAL SPREAD	1.575	1.575	1.269
VERTICAL SPREAD	3.051	1.965	1.848
EXTREME SPREAD	3.186	2.366	1.872
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

10 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611695

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 5

2in = 9

3in = 10

HS= 1.352

VS= 1.411

GS= 1.541

CENTROID *

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.782	.614	.631
MINIMUM X	:	-.570	-.483	-.406
MAXIMUM Y	:	.679	.598	.610
MINIMUM Y	:	-.732	-.409	-.334
CENTROID X	:	-.022	-.109	-.186
CENTROID Y	:	.298	.379	.304
POA TO CENTROID in.	:	.298	.394	.356
MIN RADIUS	:	.203	.162	.072
MEAN RADIUS	:	.528	.438	.360
MAX RADIUS	:	1.071	.857	.649
HORIZONTAL SPREAD	:	1.352	1.097	1.037
VERTICAL SPREAD	:	1.411	1.007	.944
EXTREME SPREAD	:	1.541	1.351	1.044
NUMBER IN ONE INCH CIRCLE	=	5		
NUMBER IN TWO INCH CIRCLE	=	9		
NUMBER IN THREE INCH CIRCLE	=	10		