

C6611814

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.

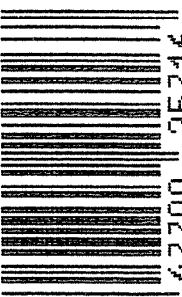
MODEL 700TM M24

SERIAL NO.
C6611814

ORDER NO.
5716

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

UPC



0 47700 25716 7



5716 C6611814

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # *C6611814*

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 28	91	<i>RW</i>
600	Proof	3 28	91	<i>RW</i>
607	Check Headspace	3 28	91	<i>RW</i>
610	Dis-assemble Gun	3 28	91	<i>RW</i>
612	Magnaflux Barrel Action	APR	2 1991	<i>K.R</i>
	Magnaflux Bolt	APR	2 1991	<i>"</i>
615	Rollmark Caliber	APR	2 1991	<i>JS</i>
617	Drill and Tap Sight Holes	APR	5 1991	<i>LB</i>
618	Polish Barrel	APR	5 1991	<i>LB</i>
620	Apply Coatings (Barrel Action)		<i>4-9-91</i>	<i>JS</i>
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		<i>4/10/91</i>	<i>RW</i>
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		<i>4/10/91</i>	<i>RW</i>
	C) Inspect Ejector Hole for Chamfer		<i>4/10/91</i>	<i>RW</i>
	D) Oil Firing Pin Ass'y		<i>4/10/91</i>	<i>RW</i>
	E) Adjust Trigger Pull to Min Setting and Stake		<i>4/30/91</i>	<i>JS</i>

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5/1/91	SM
	G) Safety Off Force	3	3	3			5/1/91	SM
	H) Trigger Pull Test & Retainability						4/30/91	SM
	I) Firing Pin Indent	.0225	.0225	.0225			5/1/91	SM
	J) Assemble Stock						5/1/91	RW
	K) Assemble Swivel Studs						5-1-91	D/H
	L) Attach Front and Rear Sight Assemblies						5/1/91	RW
	M) Iron Sight Alignment						5/1/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/1/91	RW
	O) Attach Scope to Rifle						5/1/91	RW
	P) Detach & Attach Scope 20 Times						5/1/91	RW
640	Gallery Target & Test						5/1/91	KT
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	KT
645	Inspect for Live Ammo						5/1/91	KT
655	Final Inspection							
	A) Headspace						5-1-91	D/H
	B) Trigger Pull	2.35	2.26	2.29	2.30	2.30	5/1/91	SM
	C) Function						5-1-91	D/H
660	Pack						6-19-91	VF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6611814

DATE 4/30/91

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.24	2.26	2.30	2.35	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.23	2.37	2.36	2.26	
PULL #3	2.28	2.48	2.38	2.29	
PULL #4	2.25	2.42	2.45	2.30	
PULL #5	2.23	2.20	2.40	2.30	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.58	3.40		
PULL #2	3.54	3.50		
PULL #3	3.58	3.50		
PULL #4	3.57	3.50		
PULL #5	3.58	3.56		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.23	4.29		4.37
PULL #2	4.27	4.39		4.40
PULL #3	4.27	4.32		4.37
PULL #4	4.29	4.30		4.40
PULL #5	4.32	4.36		4.39
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06611814
1 May 1991

CENTROIDAL DISTANCES

0 TO	1	.229428
1 TO	2	.588623
1 TO	3	.189497
1 TO	4	.172699
1 TO	5	.147628

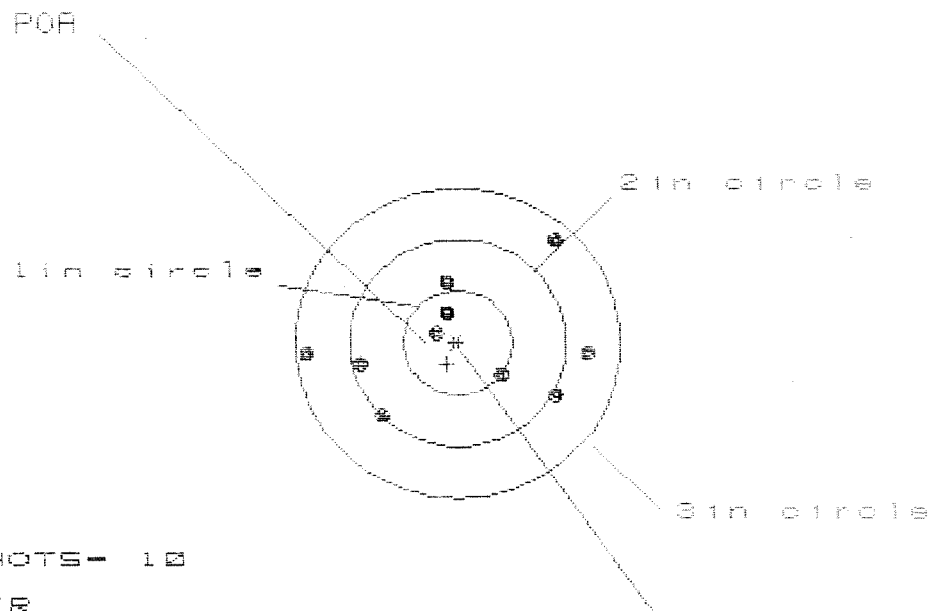
←----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0412
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .046
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0617531
THE AMR FOR THIS RIFLE IS: .7864

1 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611814

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 6

3 in = 10

HS = 2.644

VS = 1.654

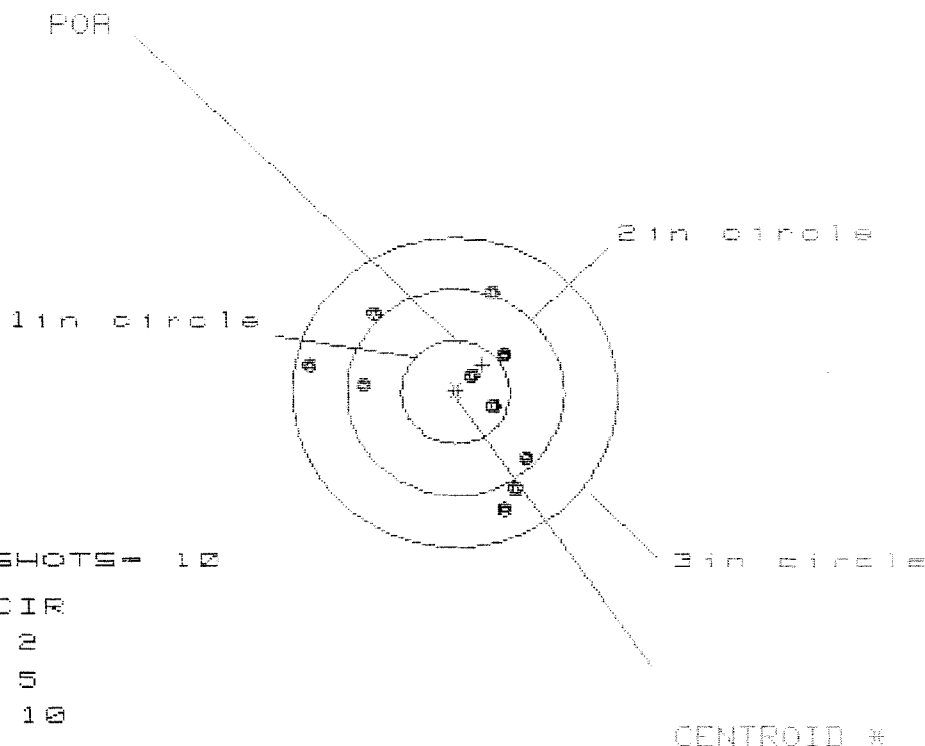
GS = 2.645

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.207	1.047	1.138
MINIMUM X	-1.437	-1.015	-0.924
MAXIMUM Y	.993	.976	.677
MINIMUM Y	-.661	-.678	-.556
CENTROID X	.101	.261	.170
CENTROID Y	.206	.223	.101
POA TO CENTROID in.	.229	.343	.198
MIN RADIUS	.194	.349	.299
MEAN RADIUS	.849	.789	.725
MAX RADIUS	1.445	1.214	1.138
HORIZONTAL SPREAD	2.644	2.062	2.062
VERTICAL SPREAD	1.654	1.654	1.233
EXTREME SPREAD	2.645	2.291	2.064
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

1 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CAB11814

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 2.0009

VS= 2.163

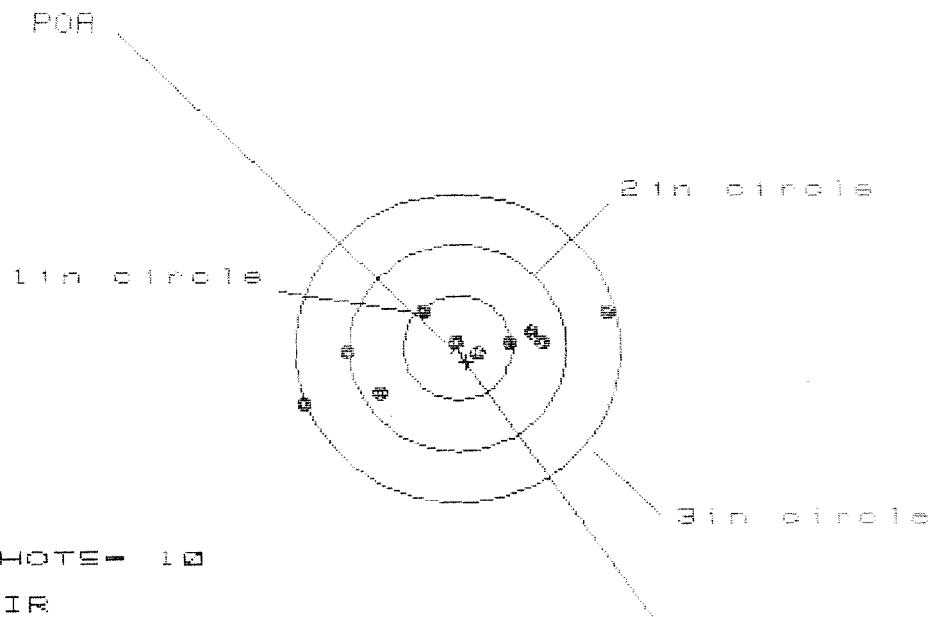
GS= 2.295

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.644	.493	.530
MINIMUM X	:	-1.365	-1.027	-.990
MAXIMUM Y	:	1.009	1.037	.896
MINIMUM Y	:	-1.154	-1.126	-1.013
CENTROID X	:	-.248	-.097	-.134
CENTROID Y	:	-.268	-.296	-.155
POB TO CENTROID in.	:	.365	.311	.205
MIN RADIUS	:	.226	.215	.074
MEAN RADIUS	:	.879	.793	.727
MAX RADIUS	:	1.388	1.190	1.105
HORIZONTAL SPREAD	:	2.009	1.520	1.520
VERTICAL SPREAD	:	2.163	2.163	1.909
EXTREME SPREAD	:	2.295	2.267	2.114
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

1 May 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 2.842

VS= .840

GS= 2.964

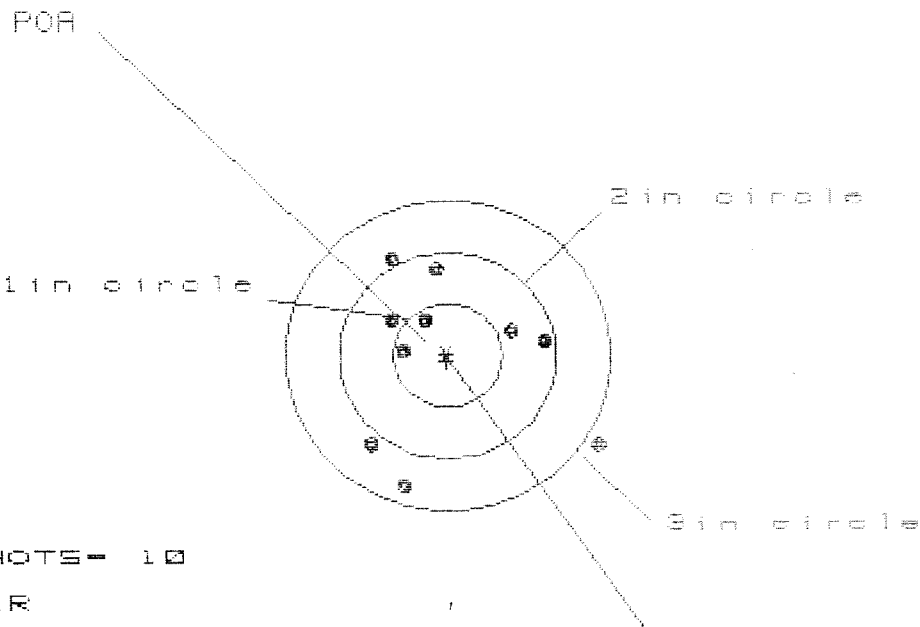
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.385	1.223	.755
MINIMUM X	:	-1.457	-1.196	-1.043
MAXIMUM Y	:	.345	.290	.319
MINIMUM Y	:	-.495	-.460	-.424
CENTROID X	:	-.077	.085	-.068
CENTROID Y	:	.141	.196	.160
POA TO CENTROID in.	:	.161	.214	.174
MIN RADIUS	:	.106	.134	.100
MEAN RADIUS	:	.765	.655	.583
MAX RADIUS	:	1.539	1.257	1.048
HORIZONTAL SPREAD	:	2.842	2.419	1.798
VERTICAL SPREAD	:	.840	.750	.743
EXTREME SPREAD	:	2.964	2.457	1.803
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

1 May 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.195

VS= 2.148

GS= 2.612

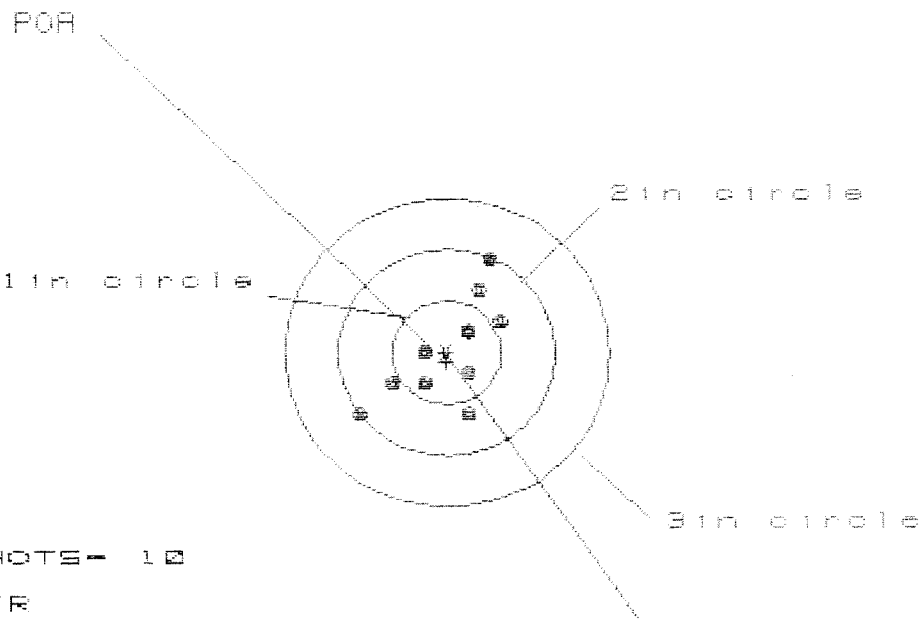
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.436	1.031	1.001
MINIMUM X	:	-.759	-.599	-.629
MAXIMUM Y	:	.940	.846	.683
MINIMUM Y	:	-1.208	-1.302	-1.124
CENTROID X	:	.012	-.148	-.119
CENTROID Y	:	.056	.152	.315
POA TO CENTROID in.	:	.059	.212	.336
MIN RADIUS	:	.378	.209	.166
MEAN RADIUS	:	.897	.762	.657
MAX RADIUS	:	1.668	1.324	1.288
HORIZONTAL SPREAD	:	2.195	1.630	1.630
VERTICAL SPREAD	:	2.148	2.148	1.807
EXTREME SPREAD	:	2.612	2.149	1.894
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

1 May 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 4

2in = 10

3in = 10

HS= 1.241

VS= 1.493

GS= 1.859

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.467
MINIMUM X	-.774
MAXIMUM Y	.868
MINIMUM Y	-.625
CENTROID X	.086
CENTROID Y	.093
POR TO CENTROID in.	.093
MIN RADIUS	.175
MEAN RADIUS	.542
MAX RADIUS	.964
HORIZONTAL SPREAD	1.241
VERTICAL SPREAD	1.493
EXTREME SPREAD	1.859
NUMBER IN ONE INCH CIRCLE =	4
NUMBER IN TWO INCH CIRCLE =	10
NUMBER IN THREE INCH CIRCLE =	10