

C6636049

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Sword




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

MODEL 700™ H24

SERIAL NO. C6636049

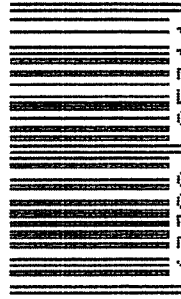
ORDER NO. 5716

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



5716 C6636049

LPC



0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6636049

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		5/1/91	KS
600	Proof		5/1/91	KS
607	Check Headspace		5/1/91	KS
610	Dis-assemble Gun		5/1/91	KS
612	Magnaflux Barrel Action	5 8 9 1		Ked
	Magnaflux Bolt	5 8 9 1		Ked
615	Rollmark Caliber	5 8 9 1		GB
617	Drill and Tap Sight Holes	5 15 9 1		KB
618	Polish Barrel	5 15 9 1		WB
620	Apply Coatings (Barrel Action)		5-31-91	AA
	Apply Coating (Bolt)			D
625	Final Assembly			
	A) Clean inside of Bolt Assembly		7/15/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/15/91	KS
	C) Inspect Ejector Hole for Chamfer		7/15/91	KS
	D) Oil Firing Pin Ass'y		7/15/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		7-16-91	JK

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6 1/4	6 1/4	6 1/4			7/16/91	WB
	G) Safety Off Force	2 3/4	2 3/4	2 3/4			7/16/91	WB
	H) Trigger Pull Test & Retainability						7.16.91	JU
	I) Firing Pin Indent	.023	.023	.023			7/16/91	WB
	J) Assemble Stock						7/16/91	KS
	K) Assemble Swivel Studs						7-23-91	NH
	L) Attach Front and Rear Sight Assemblies						7/16/91	KS
	M) Iron Sight Alignment						7/16/91	KS
	N) Detach Front & Rear Sights & place in numbered container						7/16/91	KS
	O) Attach Scope to Rifle						7/16/91	KS
	P) Detach & Attach Scope 20 Times						7/16/91	KS
640	Gallery Target & Test						7-17-91	NH
	A) Time						7-17-91	NH
	B) Malfunctions						7-17-91	NH
	C) Pierced Primers						7-17-91	NH
	D) Optical Clarity of Scope						7-17-91	NH
645	Inspect for Live Ammo						7-17-91	NH
655	Final Inspection							
	A) Headspace						7-23-91	NH
	B) Trigger Pull	2.56	2.63	2.50	2.57	2.54	7-22-91	NH
	C) Function						7-23-91	NH
660	Pack						7-18-91	NH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO C-6636049

DATE 7-16-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.28	2.66	2.54	2.56	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.21	2.58	2.56	2.63	
PULL #3	2.54	2.56	2.50	2.50	
PULL #4	2.59	2.56	2.52	2.59	
PULL #5	2.58	2.55	2.58	2.59	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.59	3.37		
PULL #2	3.44	3.39		
PULL #3	3.10	3.28		
PULL #4	3.46	3.39		
PULL #5	3.46	3.41		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.45	4.29		4.35
PULL #2	4.40	4.37		4.30
PULL #3	4.30	4.34		4.13
PULL #4	4.38	4.28		4.30
PULL #5	4.31	4.26		4.27
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636049
17 Jul 1991

CENTROIDAL DISTANCES

0 TO	1	.978684
1 TO	2	.780064
1 TO	3	1.13724
1 TO	4	.262688
1 TO	5	.764431

4¹
+ 2 (----POA
3

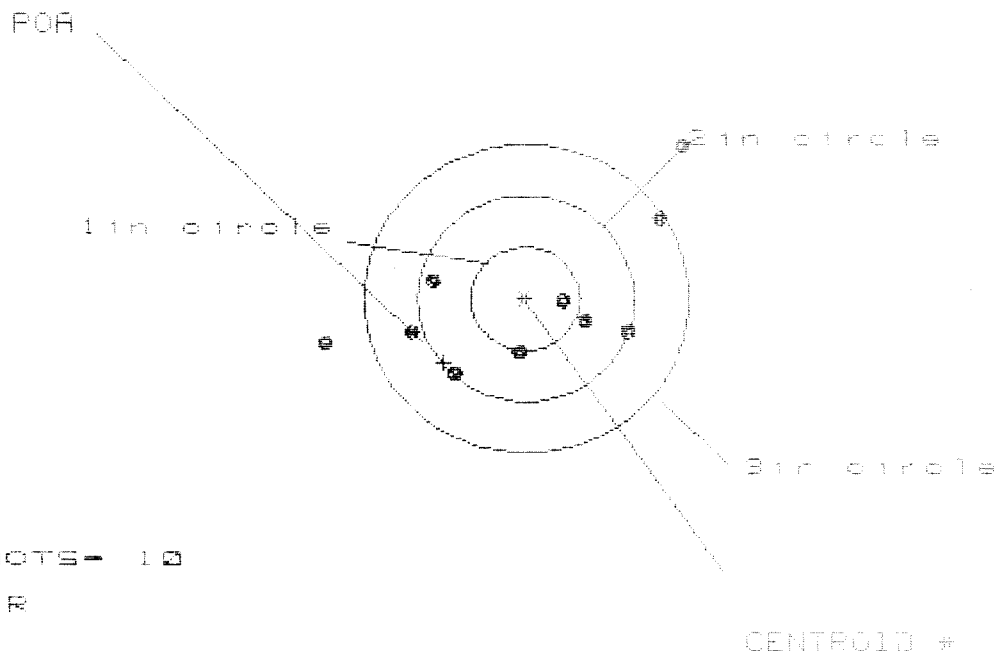
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .508
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0886
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .54248

THE AMR FOR THIS RIFLE IS: 1.098

17 JUL 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06836043

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HE= 3.254

VE= 2.184

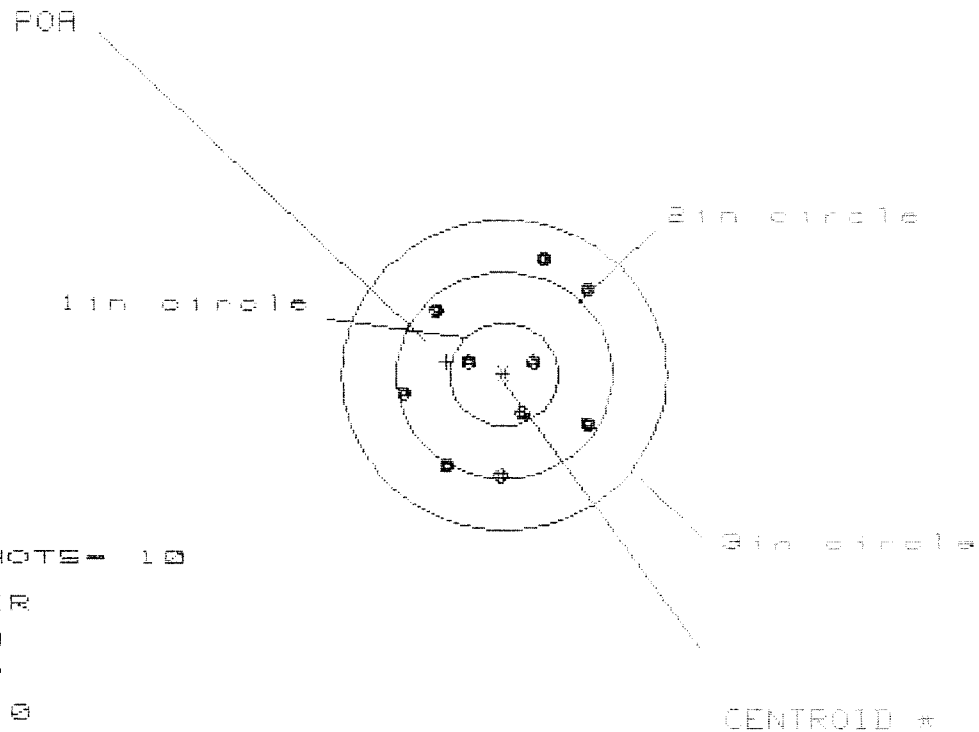
GE= 3.752

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.432	1.392	1.184
MINIMUM X	-1.822	-1.663	-1.124
MAXIMUM Y	1.486	.976	.949
MINIMUM Y	-.698	-.533	-.560
CENTROID X	.758	.599	.807
CENTROID Y	.619	.454	.481
POA TO CENTROID in.	.979	.752	.840
MIN RADIUS	.342	.372	.383
MEAN RADIUS	1.081	.945	.930
MAX RADIUS	2.063	1.700	1.517
HORIZONTAL SPREAD	3.254	3.055	2.388
VERTICAL SPREAD	2.184	1.509	1.509
EXTREME SPREAD	3.752	3.280	2.555
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

17 JUL 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08636049

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 3

2in = 7

3in = 10

HS = 1.778

VS = 2.025

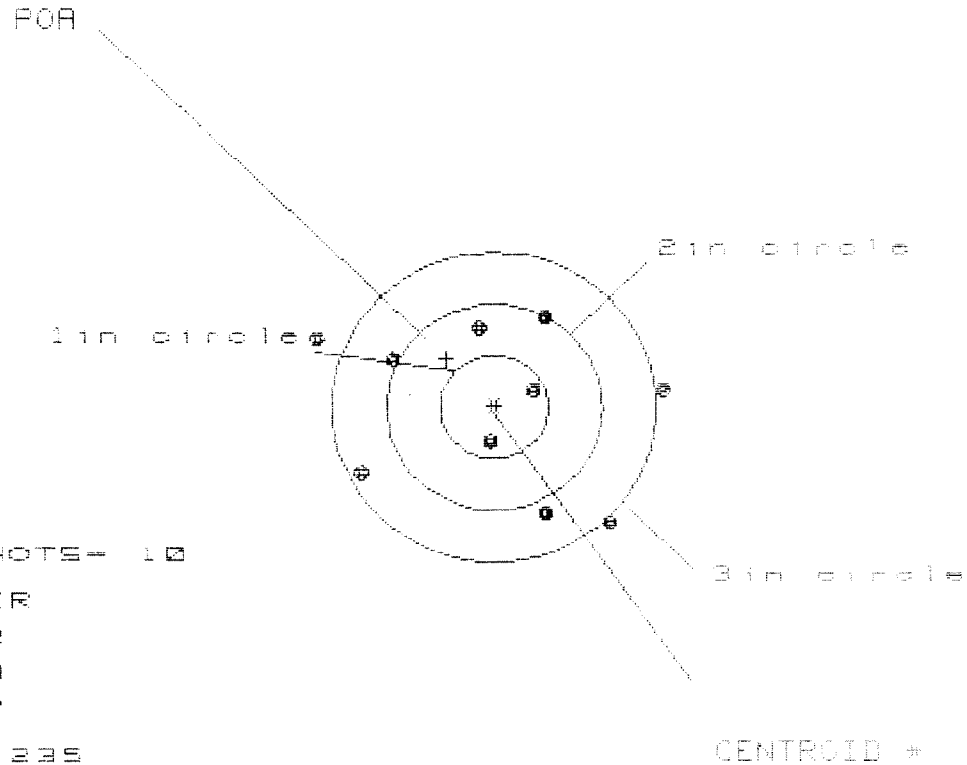
GS = 2.123

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.811	.847	.946
MINIMUM X	:	-.967	-.931	-.832
MAXIMUM Y	:	1.082	.927	.824
MINIMUM Y	:	-.943	-.823	-.707
CENTROID X	:	.530	.494	.395
CENTROID Y	:	-.127	-.247	-.363
POA TO CENTROID in.	:	.545	.552	.536
MIN RADIUS	:	.268	.324	.355
MEAN RADIUS	:	.790	.746	.685
MAX RADIUS	:	1.131	1.219	.968
HORIZONTAL SPREAD	:	1.778	1.778	1.778
VERTICAL SPREAD	:	2.025	1.750	1.531
EXTREME SPREAD	:	2.123	2.094	1.803
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			10	

17 JUL 1981

FILE:/PATTERNING/CENTERFIRE_PATT/08636049

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 2

2in = 3

3in = 7

HS= 2.235

VS= 2.014

GS= 3.280

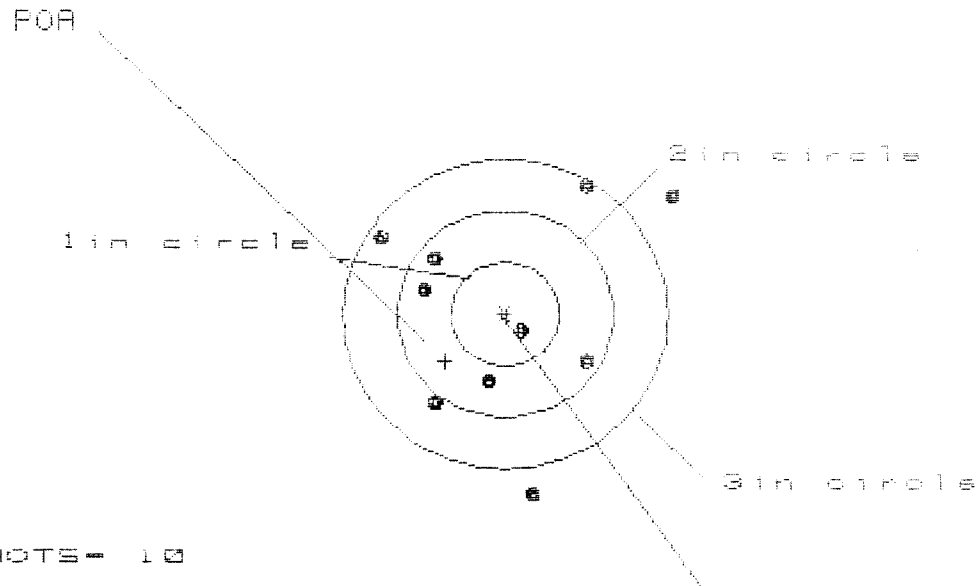
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.611	1.430	1.095
MINIMUM X	:	-1.624	-1.385	-1.206
MAXIMUM Y	:	.886	.965	.996
MINIMUM Y	:	-1.128	-1.049	-1.019
CENTROID X	:	.437	.618	.439
CENTROID Y	:	-.472	-.551	-.582
POA TO CENTROID in.	:	.643	.828	.729
MIN RADIUS	:	.323	.306	.213
MEAN RADIUS	:	1.106	1.018	.956
MAX RADIUS	:	1.773	1.583	1.490
HORIZONTAL SPREAD	:	3.235	2.815	2.295
VERTICAL SPREAD	:	2.014	2.014	2.014
EXTREME SPREAD	:	3.280	2.937	2.640
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		7	

17 JUL 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C863B049

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS= 2.693

VS= 2.911

GS= 3.168

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.508	.899	.645
MINIMUM X	:	-1.185	-1.018	-.972
MAXIMUM Y	:	1.197	1.327	1.129
MINIMUM Y	:	-1.714	-1.584	-1.944
CENTROID X	:	.552	.385	.339
CENTROID Y	:	.456	.326	.524
POA TO CENTROID in.	:	.718	.505	.624
MIN RADIUS	:	.226	.291	.421
MEAN RADIUS	:	1.086	.967	.886
MAX RADIUS	:	1.989	1.626	1.470
HORIZONTAL SPREAD	:	2.693	1.917	1.917
VERTICAL SPREAD	:	2.911	2.911	2.073
EXTREME SPREAD	:	3.168	2.959	2.471
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

17 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08836048

CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 0

2in = 3

3in = 8

HS= 2.149

VS= 2.995

GS= 3.129

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.312

1.372

.941

MINIMUM X

-1.837

-1.777

-1.606

MAXIMUM Y

1.427

1.253

1.180

MINIMUM Y

-1.568

-1.234

-1.357

CENTROID X

.463

.343

.172

CENTROID Y

-.058

.116

.239

POA TO CENTROID in.

.487

.362

.294

MIN RADIUS

.549

.448

.281

MEAN RADIUS

1.128

1.028

.876

MAX RADIUS

1.657

1.689

1.450

HORIZONTAL SPREAD

2.149

2.149

1.547

VERTICAL SPREAD

2.995

2.487

2.487

EXTREME SPREAD

3.129

2.799

2.512

NUMBER IN ONE

INCH CIRCLE

=

0

NUMBER IN TWO

INCH CIRCLE

=

3

NUMBER IN THREE

INCH CIRCLE

=

8