

C6636102

MODEL 700™ M24

Model **SWS**™

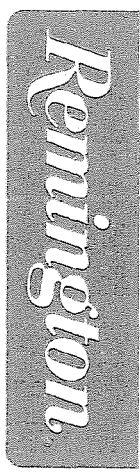
Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



Remington[®]

MODEL 700TM M24

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

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

DU PONT
REG. U.S. PAT. & T.M. OFF.

SERIAL NO. C6636102	20
ORDER NO. 5716	



5716 C6636102

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636102

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 8	91	RW
600	Proof	4 8	91	RW
607	Check Headspace	4 8	91	RW
610	Dis-assemble Gun	4 8	91	RW
612	Magnaflux Barrel Action	APR	9 1991	KR
	Magnaflux Bolt	APR	9 1991	11
615	Rollmark Caliber	APR	9 1991	JS
617	Drill and Tap Sight Holes	APR 1	9 1991	LB
618	Polish Barrel	APR	19 1991	WB
620	Apply Coatings (Barrel Action)		5-10-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/14/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/14/91	RW
	C) Inspect Ejector Hole for Chamfer		5/14/91	RW
	D) Oil Firing Pin Ass'y		5/14/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/29/91	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5/30/91	JH
	G) Safety Off Force	3	3	3			5/30/91	JH
	H) Trigger Pull Test & Retainability						5/29/91	JH
	I) Firing Pin Indent	.023	.022	.022			5/30/91	JH
	J) Assemble Stock						5/30/91	RW
	K) Assemble Swivel Studs						6-8-91	DH
	L) Attach Front and Rear Sight Assemblies						5/30/91	RW
	M) Iron Sight Alignment						5/30/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/30/91	RW
	O) Attach Scope to Rifle						5/30/91	RW
	P) Detach & Attach Scope 20 Times						5/30/91	RW
640	Gallery Target & Test						6-3-91	DH
	A) Time						6-3-91	DH
	B) Malfunctions						6-3-91	DH
	C) Pierced Primers						6-3-91	DH
	D) Optical Clarity of Scope						6-3-91	DH
645	Inspect for Live Ammo						6-3-91	DH
655	Final Inspection							
	A) Headspace						6-8-91	DH
	B) Trigger Pull	2.25	2.44	2.22	2.46	2.47	2-8-91	JH
	C) Function						6-8-91	DH
660	Pack						6-20-91	NF

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6636102

DATE 5/29/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.54	2.58	2.54	2.25	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.51	2.52	2.50	2.44	
PULL #3	2.49	2.53	2.63	2.22	
PULL #4	2.49	2.50	2.49	2.46	
PULL #5	2.53	2.51	2.57	2.47	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.22	3.41		
PULL #2	3.34	3.36		
PULL #3	3.30	3.34		
PULL #4	3.30	3.45		
PULL #5	3.38	3.44		
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	4.33		4.34
PULL #2	4.20	4.26		4.42
PULL #3	4.55	4.32		4.40
PULL #4	4.50	4.34		4.43
PULL #5	4.49	4.40		4.46
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636102
3 Jun 1991

CENTROIDAL DISTANCES

0 TO 1	.250721
1 TO 2	.33754
1 TO 3	.587725
1 TO 4	.395182
1 TO 5	.446937

47

<----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0318
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0648
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0999914
THE AMR FOR THIS RIFLE IS: .9716

3 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8B36J02

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 0

2in = 6

3in = 9

HS= 2.335

VS= 2.334

GS= 3.001

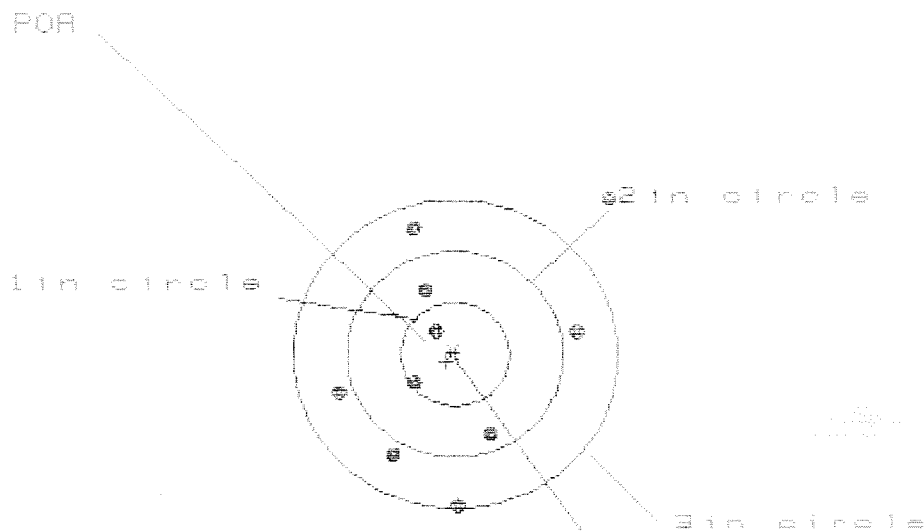
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.332	1.220	1.130
MINIMUM X	-1.003	-1.000	-.947
MAXIMUM Y	.931	.775	.769
MINIMUM Y	-1.403	-.976	-.982
CENTROID X	-.019	.093	-.060
CENTROID Y	-.250	-.094	-.098
POA TO CENTROID in.	.250	.132	.107
MIN RADIUS	.608	.588	.509
MEAN RADIUS	1.022	.926	.971
MAX RADIUS	1.725	1.397	1.297
HORIZONTAL SPREAD	2.335	2.220	1.967
VERTICAL SPREAD	2.334	1.751	1.751
EXTREME SPREAD	3.001	2.522	2.522
NUMBER IN ONE INCH CIRCLE	= 0		
NUMBER IN TWO INCH CIRCLE	= 6		
NUMBER IN THREE INCH CIRCLE	= 9		

8 JUN 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636102

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

HS = 2.434

VS = 3.002

GS = 3.292

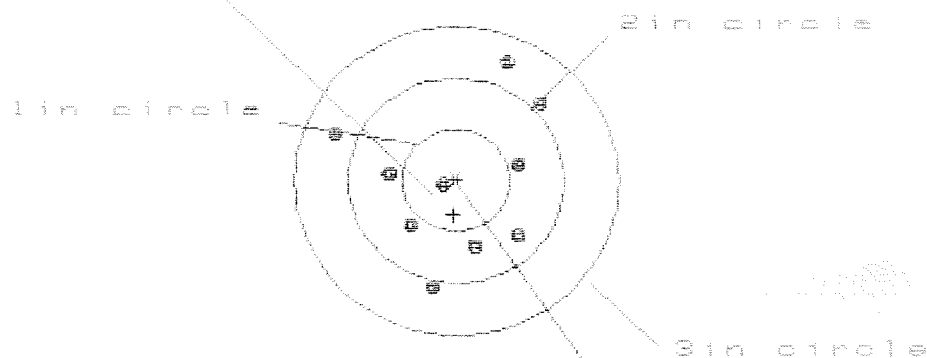
PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.398	1.236	1.261
MINIMUM X	-1.036	-.880	-.855
MAXIMUM Y	1.491	1.367	1.199
MINIMUM Y	-1.511	-1.346	-.933
CENTROID X	.079	-.077	-.102
CENTROID Y	.073	-.092	.076
POA TO CENTROID in.	.108	.120	.127
MIN RADIUS	.271	.288	.214
MEAN RADIUS	1.041	.896	.821
MAX RADIUS	2.044	1.392	1.285
HORIZONTAL SPREAD	2.434	2.116	2.116
VERTICAL SPREAD	3.002	2.713	2.132
EXTREME SPREAD	3.292	2.753	2.202
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		8	

3 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636102

CENTERFIRE PATTERNS # 3

FOR



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 10

HS= 1.952

VS= 2.200

GS= 2.323

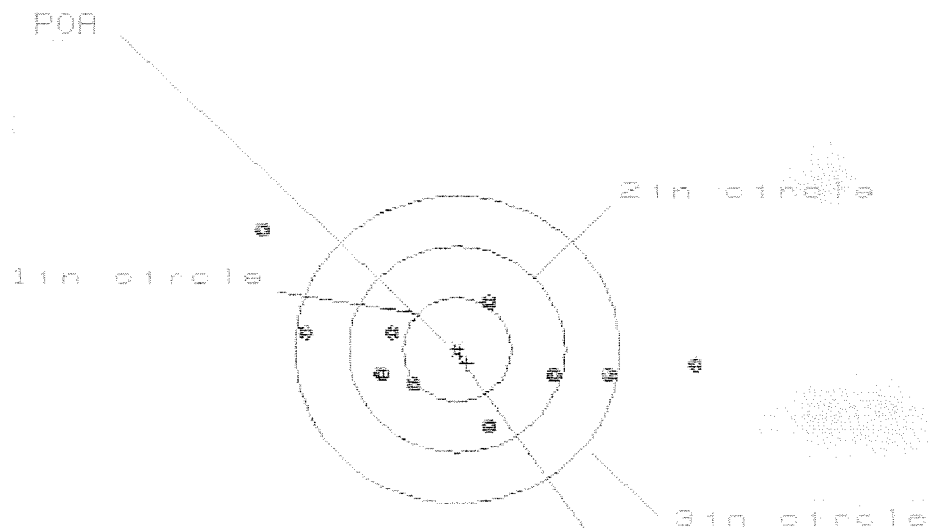
CENTROID #

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.790	.843	.705
MINIMUM X	-1.161	-1.109	-.742
MAXIMUM Y	1.194	.941	1.013
MINIMUM Y	-1.006	-.873	-.901
CENTROID X	.026	-.027	.111
CENTROID Y	.336	.203	.131
FOR TO CENTROID in.	.337	.205	.172
MIN RADIUS	.160	.164	.314
MEAN RADIUS	.831	.759	.694
MAX RADIUS	1.285	1.264	1.234
HORIZONTAL SPREAD	1.952	1.952	1.447
VERTICAL SPREAD	2.200	1.814	1.814
EXTREME SPREAD	2.323	2.102	2.102
NUMBER IN ONE INCH CIRCLE	= 1		
NUMBER IN TWO INCH CIRCLE	= 6		
NUMBER IN THREE INCH CIRCLE	= 10		

3 Jun 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1in = 1

2in = 6

3in = 8

HS = 4.037

VS = 1.874

GS = 4.221

CENTROID #

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.193	1.689	1.409
MINIMUM X	-1.844	-1.601	-1.345
MAXIMUM Y	1.138	1.127	.555
MINIMUM Y	-1.736	-1.747	-1.606
CENTROID X	-.094	-.337	-.137
CENTROID Y	.138	.149	.008
POA TO CENTROID in.	.167	.369	.138
MIN RADIUS	.492	.361	.470
MEAN RADIUS	1.125	.974	.847
MAX RADIUS	2.195	1.958	1.411
HORIZONTAL SPREAD	4.037	3.210	2.754
VERTICAL SPREAD	1.874	1.874	1.161
EXTREME SPREAD	4.221	3.477	2.774
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

3 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636182

CENTERFIRE PATTERNS # 5

POA

2in circle

1in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 10

HS= 1.551

VS= 2.531

GS= 2.617

CENTROID *

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.189

1.217

1.176

MINIMUM X

-.762

-.734

-.582

MAXIMUM Y

1.429

.735

.788

MINIMUM Y

-1.102

-.943

-.990

CENTROID X

-.151

-.179

-.331

CENTROID Y

.177

.018

-.836

POA TO CENTROID in.

.232

.180

.333

MIN RADIUS

.134

.153

.179

MEAN RADIUS

.839

.759

.668

MAX RADIUS

1.452

1.289

1.228

HORIZONTAL SPREAD

1.951

1.951

1.758

VERTICAL SPREAD

2.531

1.678

1.678

EXTREME SPREAD

2.617

2.107

1.766

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

6

NUMBER IN THREE INCH CIRCLE =

10