

C6636149

MODEL 700™ M24

Model **SWS**™

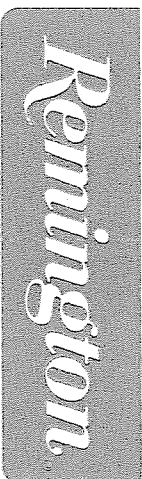
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Remington [®]		 REG. U.S. PAT. & TM. OFF.	VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700 TM H24		SERIAL NO. C6636149	ORDER NO. 5716
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		06	
 5716 C6636149			

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636149

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	4/23/91	K.S.
600	Proof		4/23/91	K.S.
607	Check Headspace		4/23/91	K.S.
610	Dis-assemble Gun		4/23/91	K.S.
612	Magnaflux Barrel Action	5 8 9 1		Kcd
	Magnaflux Bolt	5 8 9 1		Kcd
615	Rollmark Caliber	5 8 9 1		68
617	Drill and Tap Sight Holes	5 15 9 1		LB
618	Polish Barrel	5 15 9 1		WB
620	Apply Coatings (Barrel Action)		5-31-91	JH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/12/91	K.S.
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/12/91	K.S.
	C) Inspect Ejector Hole for Chamfer		4/12/91	K.S.
	D) Oil Firing Pin Ass'y		4/12/91	K.S.
	E) Adjust Trigger Pull to Min Setting and Stake		6-13-91	D/H

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			6-13-91	DH
	G) Safety Off Force	2	2	2			6-13-91	DH
	H) Trigger Pull Test & Retainability						6-13-91	DH
	I) Firing Pin Indent	.021	.021	.021			6-13-91	DH
	J) Assemble Stock						6-13-91	KS
	K) Assemble Swivel Studs						6-15-91	DH
	L) Attach Front and Rear Sight Assemblies						6-13-91	KS
	M) Iron Sight Alignment						6-13-91	KS
	N) Detach Front & Rear Sights & place in numbered container						6-13-91	KS
	O) Attach Scope to Rifle						6-13-91	KS
	P) Detach & Attach Scope 20 Times						6-13-91	KS
640	Gallery Target & Test						6-14-91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KS
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						6-14-91	KT
655	Final Inspection							
	A) Headspace						6-15-91	DH
	B) Trigger Pull	2.59	2.57	2.58	2.59	2.56	6-15-91	JD
	C) Function						6-15-91	DH
660	Pack						6-19-91	N

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6636149

DATE 6-13-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.23	2.59	2.61	2.59	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.12	2.52	2.63	2.57	
PULL #3	2.24	2.52	2.64	2.58	
PULL #4	2.17	2.51	2.61	2.59	
PULL #5	2.20	2.52	2.70	2.56	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.23	3.30		
PULL #2	3.00	3.34		
PULL #3	3.11	3.29		
PULL #4	2.99	3.19		
PULL #5	3.18	3.26		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.37	4.16		4.28
PULL #2	4.42	4.13		4.24
PULL #3	4.01	4.16		4.27
PULL #4	3.96	4.16		4.02
PULL #5	4.02	4.17		4.29
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636149
14 Jun 1991

CENTROIDAL DISTANCES

Ø TO	1	.541901
1 TO	2	.661069
1 TO	3	.853029
1 TO	4	.666888
1 TO	5	.847917

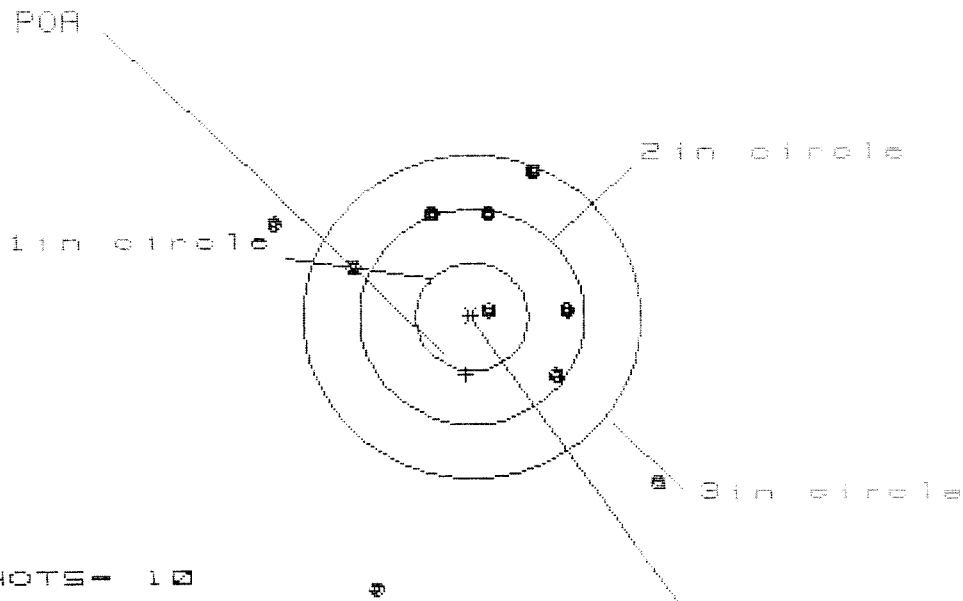
1
54
53 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0766
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0416
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0871672
THE AMR FOR THIS RIFLE IS: 1.234

14 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08636149

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 1

2in = 3

3in = 7

HS= 3.366

VS= 3.864

GS= 4.154

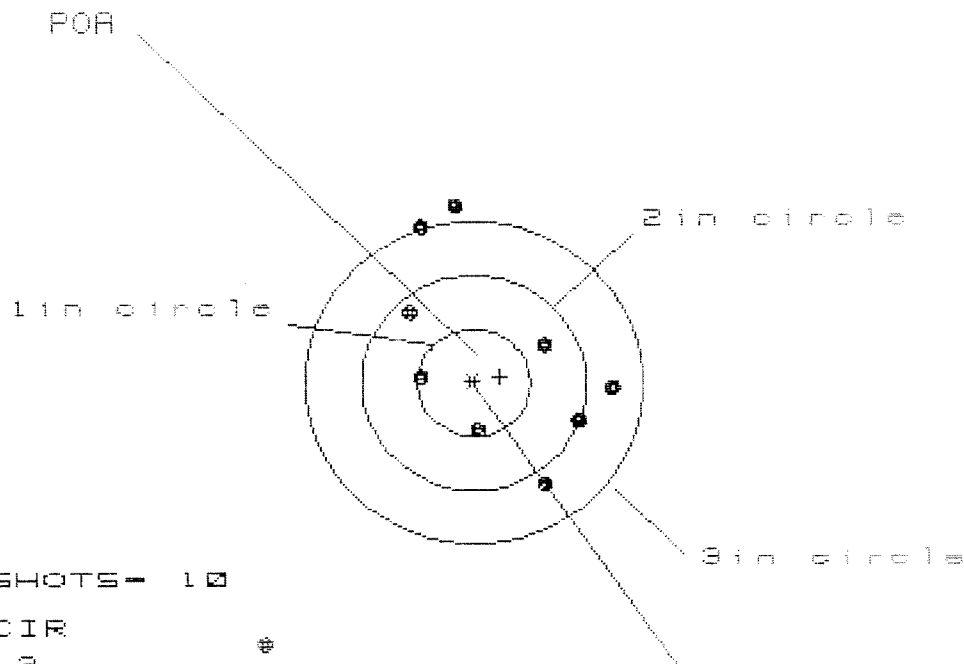
CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.621	1.530	.962
MINIMUM X	:	-1.745	-1.836	-1.644
MAXIMUM Y	:	1.320	1.037	.807
MINIMUM Y	:	-2.544	-1.841	-1.068
CENTROID X	:	.056	.147	-.045
CENTROID Y	:	.539	.822	1.052
POA TO CENTROID in.	:	.542	.835	1.053
MIN RADIUS	:	.104	.253	.523
MEAN RADIUS	:	1.334	1.130	.960
MAX RADIUS	:	2.672	2.394	1.684
HORIZONTAL SPREAD	:	3.366	3.366	2.606
VERTICAL SPREAD	:	3.864	2.878	1.875
EXTREME SPREAD	:	4.154	4.154	2.828
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	3		
NUMBER IN THREE INCH CIRCLE	=	7		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 7

HS= 3.138

VS= 4.099

GS= 4.441

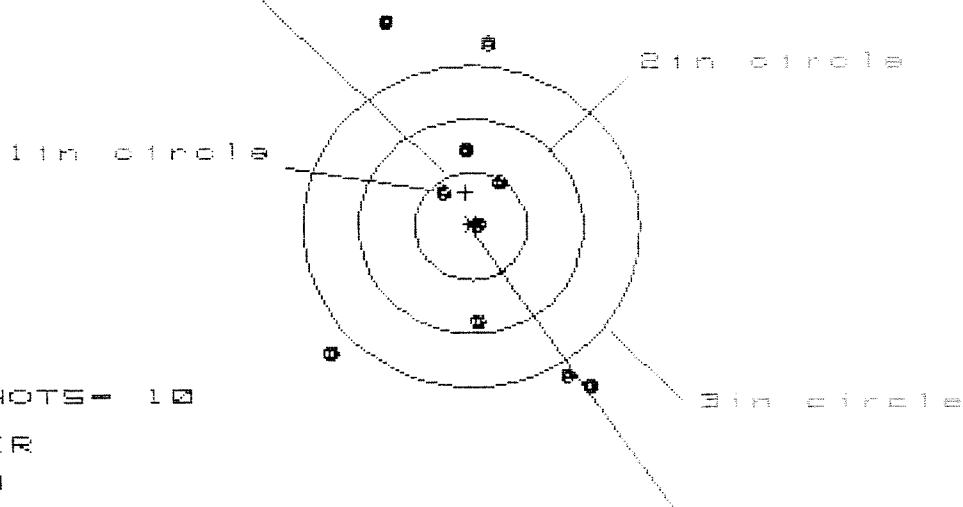
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.260	1.052	1.005
MINIMUM X	:	-1.878	-0.769	-0.816
MAXIMUM Y	:	1.659	1.388	1.391
MINIMUM Y	:	-2.440	-1.177	-1.003
CENTROID X	:	-0.230	-0.022	.025
CENTROID Y	:	-0.057	.214	.040
POA TO CENTROID in.	:	.237	.215	.048
MIN RADIUS	:	.435	.406	.454
MEAN RADIUS	:	1.211	.979	.896
MAX RADIUS	:	3.079	1.438	1.547
HORIZONTAL SPREAD	:	3.138	1.821	1.821
VERTICAL SPREAD	:	4.099	2.565	2.394
EXTREME SPREAD	:	4.441	2.677	2.602
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 3

POA



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 5

3 in = 5

HS = 2.324

VS = 3.394

GS = 3.813

CENTROID #

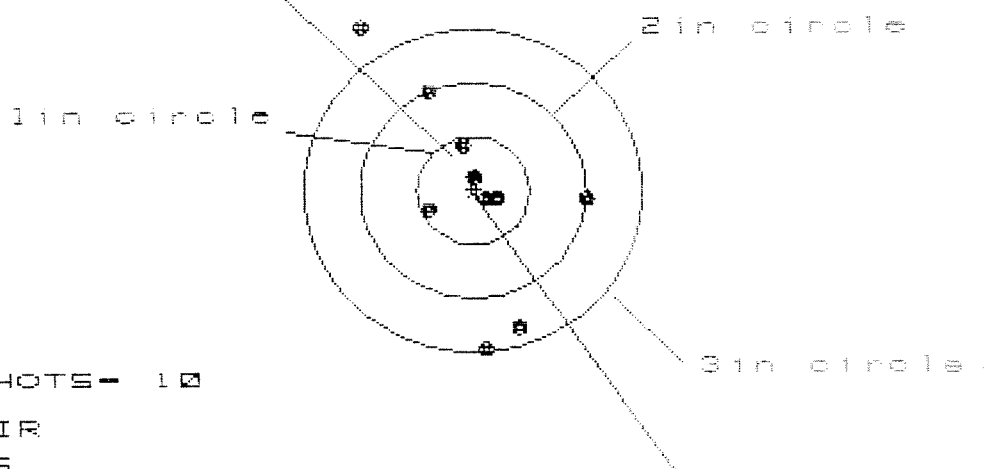
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.039	.961	.873
MINIMUM X	:	-1.285	-1.363	-1.243
MAXIMUM Y	:	1.906	1.893	1.734
MINIMUM Y	:	-1.488	-1.276	-1.329
CENTROID X	:	.049	.127	.007
CENTROID Y	:	-.314	-.526	-.367
POA TO CENTROID in.:	:	.318	.541	.367
MIN RADIUS	:	.037	.221	.098
MEAN RADIUS	:	1.149	1.081	.970
MAX RADIUS	:	2.030	1.894	1.743
HORIZONTAL SPREAD	:	2.324	2.324	2.116
VERTICAL SPREAD	:	3.394	3.169	3.062
EXTREME SPREAD	:	3.813	3.294	3.234
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		5	

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CENTERFIRE PATTERNS # 4

POA



OF SHOTS- 10

IN CIR

1in = 5

2in = 6

3in = 9

HS= 2.050

VS= 3.016

GS= 3.210

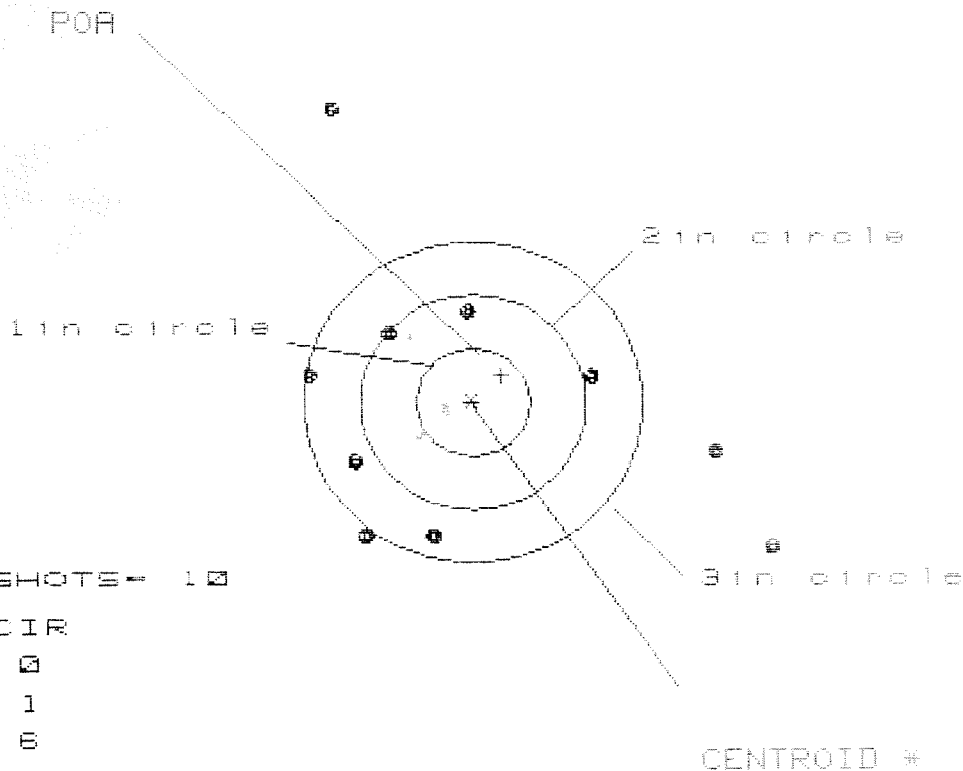
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.049	.938	.936
MINIMUM X	:	-1.001	-.536	-.537
MAXIMUM Y	:	1.520	1.079	.913
MINIMUM Y	:	-1.496	-1.327	-1.228
CENTROID X	:	-.006	.105	.106
CENTROID Y	:	-.125	-.294	-.128
POA TO CENTROID in.	:	.125	.312	.167
MIN RADIUS	:	.121	.140	.026
MEAN RADIUS	:	.808	.708	.583
MAX RADIUS	:	1.820	1.327	1.259
HORIZONTAL SPREAD	:	2.050	1.474	1.474
VERTICAL SPREAD	:	3.016	2.406	2.141
EXTREME SPREAD	:	3.210	2.459	2.286
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 1

3 in = 6

HS = 4.129

VS = 4.102

GS = 5.678

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.690	2.553	2.315
MINIMUM X	:	-1.439	-1.576	-1.257
MAXIMUM Y	:	2.799	1.170	1.046
MINIMUM Y	:	-1.304	-0.993	-1.059
CENTROID X	:	-0.252	-0.115	-0.434
CENTROID Y	:	-0.251	-0.561	-0.437
POA TO CENTROID in.	:	0.356	0.573	0.616
MIN RADIUS	:	0.862	1.020	0.934
MEAN RADIUS	:	1.660	1.512	1.286
MAX RADIUS	:	3.059	2.739	2.329
HORIZONTAL SPREAD	:	4.129	4.129	3.572
VERTICAL SPREAD	:	4.102	2.163	2.115
EXTREME SPREAD	:	5.678	4.408	3.535
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		1	
NUMBER IN THREE INCH CIRCLE	=		6	