

C6225588

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

REG. U.S. PAT. & TM. OFF

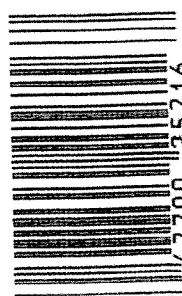
SERIAL NO.
C6225588

ORDER NO.
5716

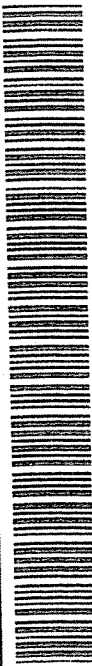
MODEL 700TH H24

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

UPC



0 47700 25716 7



5716 C6225588

SCAP 0406

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225588

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock	12 9	88	RW
600	Proof	12 9	88	RW
607	Check Headspace	12 9	88	RW
610	Dis-assemble Gun	12 9	88	RW
612	Magnaflux Barrel Action		12.22 88	RJC.
	Magnaflux Bolt		1-3.89	RJC.
615	Rollmark Caliber		3/22/88	WAC.
617	Drill and Tap Sight Holes	1 3	89	FB
618	Polish Barrel	12 2	88	WJT
620	Apply Coatings (Barrel Action)		1/28/89	TSA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		1/24/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/24/89	RW
	C) Inspect Ejector Hole for Chamfer		1/24/89	RW
	D) Oil Firing Pin Ass'y		1/24/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		23 Jan 89	JD

op. #	OP. NAME	READINGS					DATE	INITIAL
625 cont.	F) Safety On Force	5	5	5			25 Jun 89	JS
	G) Safety Off Force	4	4	4			25 Jun 89	JS
	H) Trigger Pull Test & Retainability						23 Jun 89	JS
	I) Firing Pin Indent	.021	.022	.0215			25 Jun 89	JS
	J) Assemble Stock						2/2/89	RW
	K) Assemble Swivel Studs						7/2/89	JS
	L) Attach Front and Rear Sight Assemblies						2/2/89	RW
	M) Iron Sight Alignment						2/2/89	RW
	N) Detach Front & Rear Sights & place in numbered container						2/2/89	RW
	O) Attach Scope to Rifle							
	P) Detach & Attach Scope 20 Times						3/2/89	JS
640	Gallery Target & Test	462	1102				2/6/89	DH
	A) Time						2/6/89	DH
	B) Malfunctions						2/6/89	DH
	C) Pierced Primers						2/6/89	DH
	D) Optical Clarity of Scope						2/6/89	DH
645	Inspect for Live Ammo						2/6/89	DH
655	Final Inspection							
	A) Headspace						7/2/89	JS
	B) Trigger Pull	2.65	2.62	2.64	2.59	2.54	7/2/89	JS
	C) Function						7/2/89	JS
660	Pack						23 Nov 89	JS

SWS TRIGGER PULL TEST

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

SERIAL NO. 622558

DATE 3-28-90

TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.32	2.41		2.41	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.34	2.34		2.43	
PULL #3	2.25	2.30		2.40	
PULL #4	2.27	2.35		2.39	
PULL #5	2.31	2.33		2.31	
TOTAL	11.49	11.73		11.94	
AVG.	2.298	2.346		2.388	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.60	3.39		
PULL #2	3.36	3.40		
PULL #3	3.38	3.46		
PULL #4	3.39	3.35		
PULL #5	3.40	3.41		
TOTAL	17.13	17.01		
AVG.	3.426	3.402		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.47	4.42		
PULL #2	4.40	4.26		
PULL #3	4.39	4.31		
PULL #4	4.27	4.51		
PULL #5	4.30	4.40		
TOTAL	21.83	21.90		
AVG.	4.366	4.38		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225588
10 Feb 1989

CENTROIDAL DISTANCES

0 TO	1	.789763
1 TO	2	.288877
1 TO	3	.678417
1 TO	4	1.00116
1 TO	5	.60643

$\frac{r_1^2}{4}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .4332
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0436
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .435389

THE AMR FOR THIS RIFLE IS: 1.142

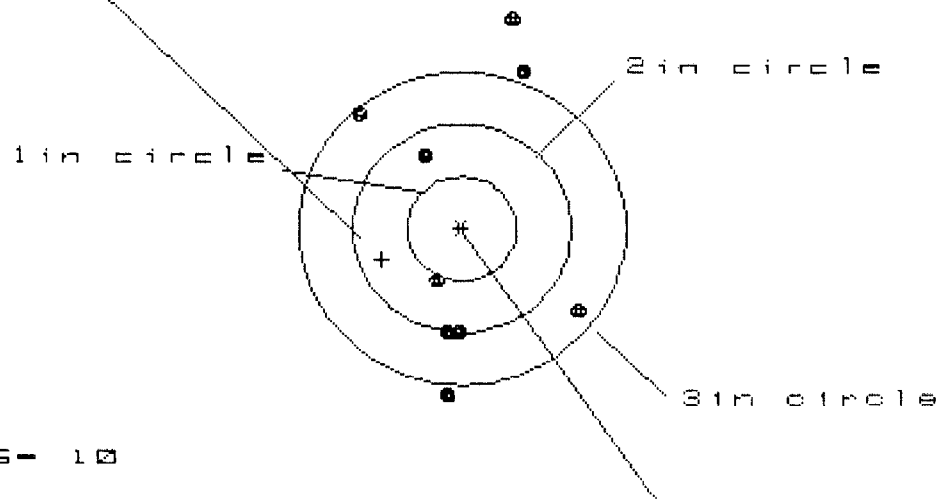
6 Feb 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6225588

CENTERFIRE PATTERNS

1

POA



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 5

3 in = 7

HS= 2.039

VS= 3.588

GS= 3.639

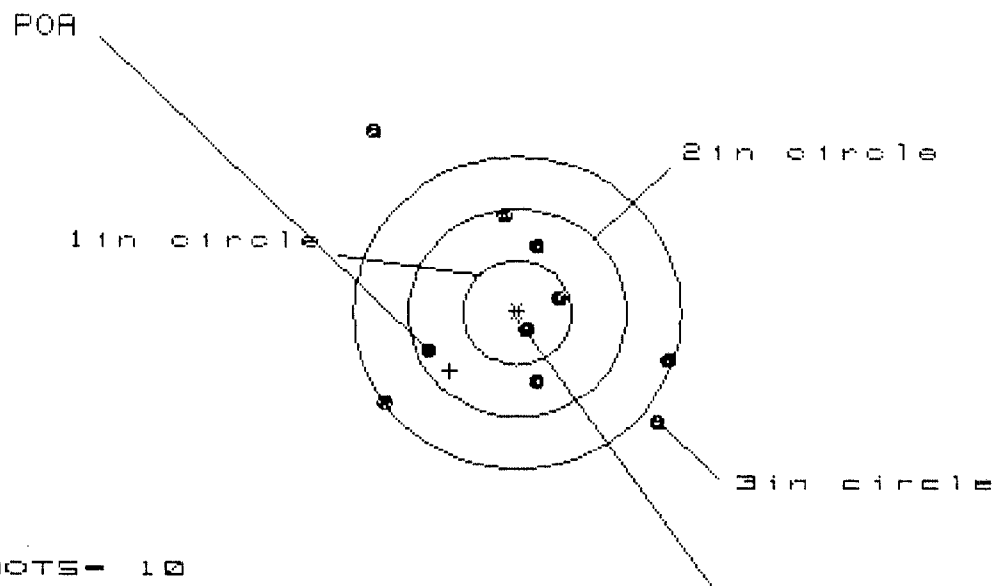
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.079	1.132	1.122
MINIMUM X	-.960	-.907	-.917
MAXIMUM Y	1.978	1.681	1.508
MINIMUM Y	-1.610	-1.391	-.915
CENTROID X	.733	.680	.690
CENTROID Y	.294	.075	.248
POA TO CENTROID in.	.790	.684	.734
MIN RADIUS	.514	.297	.454
MEAN RADIUS	1.177	1.014	1.000
MAX RADIUS	2.034	1.806	1.641
HORIZONTAL SPREAD	2.039	2.039	2.039
VERTICAL SPREAD	3.588	3.072	2.423
EXTREME SPREAD	3.639	3.160	2.758
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

6 Feb 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6225588

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 2.641

VS= 2.806

GS= 3.786

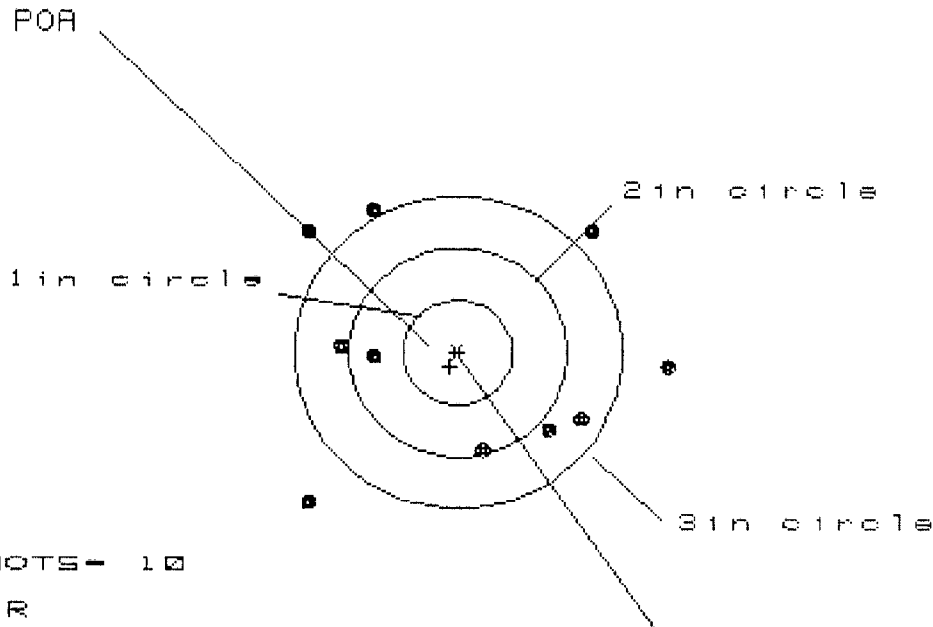
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.343	1.199	1.336
MINIMUM X	:	-1.298	-1.376	-1.239
MAXIMUM Y	:	1.772	1.129	1.025
MINIMUM Y	:	-1.034	-.837	-.756
CENTROID X	:	.618	.762	.625
CENTROID Y	:	.559	.362	.466
POA TO CENTROID in.	:	.833	.844	.780
MIN RADIUS	:	.124	.128	.045
MEAN RADIUS	:	1.042	.898	.818
MAX RADIUS	:	2.197	1.523	1.452
HORIZONTAL SPREAD	:	2.641	2.575	2.575
VERTICAL SPREAD	:	2.806	1.966	1.781
EXTREME SPREAD	:	3.786	2.608	2.608
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

8 Feb 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6225588

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 0

2in = 2

3in = 5

HS= 3.320

VS= 2.835

GS= 3.749

CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.909	1.755	1.322
MINIMUM X	:	-1.411	-1.565	-1.346
MAXIMUM Y	:	1.380	1.218	1.187
MINIMUM Y	:	-1.455	-1.066	-1.097
CENTROID X	:	.073	.227	.008
CENTROID Y	:	.137	.299	.330
POA TO CENTROID in.	:	.155	.375	.330
MIN RADIUS	:	.728	.903	.700
MEAN RADIUS	:	1.429	1.369	1.296
MAX RADIUS	:	2.009	1.854	1.665
HORIZONTAL SPREAD	:	3.320	3.320	2.668
VERTICAL SPREAD	:	2.835	2.284	2.284
EXTREME SPREAD	:	3.749	3.547	3.135
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		5	

6 Feb 1985

FILE:/PATTERNING/CENTERFIRE_PATT/C6225588

CENTERFIRE PATTERNS

4

POR

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 0

2 in = 5

3 in = 8

HS= 3.051

VS= 2.331

GS= 3.244

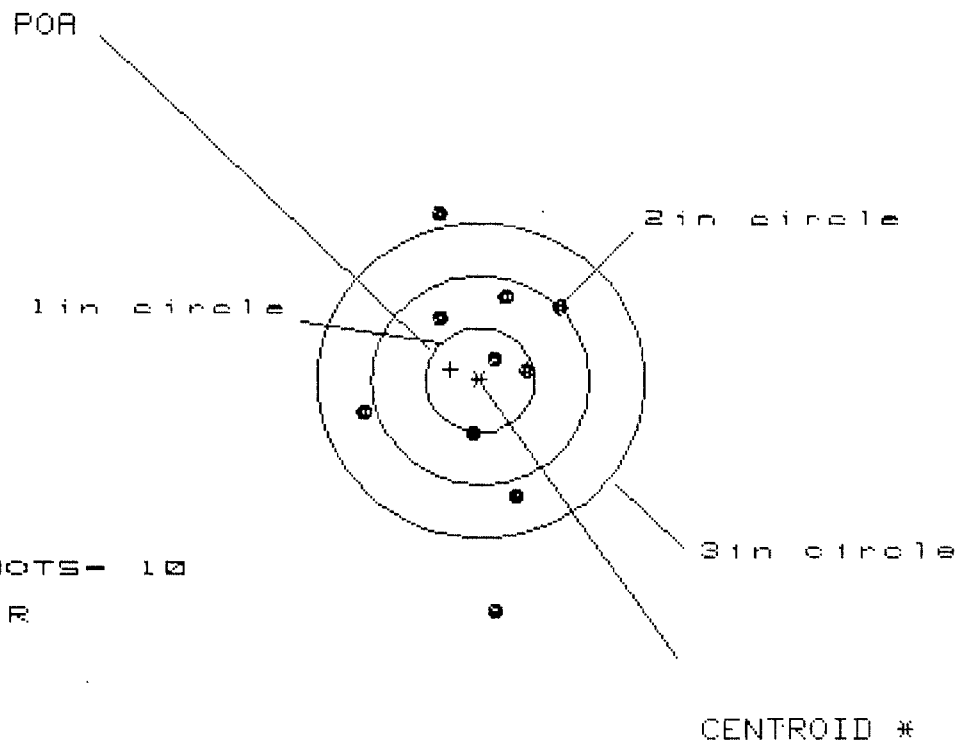
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.759	1.511	1.374
MINIMUM X	:	-1.292	-1.096	-.878
MAXIMUM Y	:	.911	.890	.784
MINIMUM Y	:	-1.420	-1.441	-1.329
CENTROID X	:	.470	.274	.411
CENTROID Y	:	-.672	-.651	-.763
POR TO CENTROID in.	:	.820	.707	.866
MIN RADIUS	:	.523	.330	.501
MEAN RADIUS	:	1.071	.956	.915
MAX RADIUS	:	1.770	1.534	1.382
HORIZONTAL SPREAD	:	3.051	2.607	2.252
VERTICAL SPREAD	:	2.331	2.331	2.113
EXTREME SPREAD	:	3.244	2.851	2.421
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

6 Feb 1989

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 5

3 in = 8

HS = 1.804

VS = 3.887

GS = 3.916

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.763	.774	.727
MINIMUM X	-1.041	-1.030	-1.077
MAXIMUM Y	1.643	1.394	.736
MINIMUM Y	-2.244	-1.346	-1.172
CENTROID X	.272	.261	.308
CENTROID Y	-.100	.149	-.025
POA TO CENTROID in.	.290	.301	.309
MIN RADIUS	.271	.133	.187
MEAN RADIUS	.991	.811	.731
MAX RADIUS	2.246	1.444	1.200
HORIZONTAL SPREAD	1.804	1.804	1.804
VERTICAL SPREAD	3.887	2.740	1.908
EXTREME SPREAD	3.916	2.824	2.036
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		