

C6649109

MODEL 700™ M24

Model SWS™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF	100 RDS TEST	
TEST		
TGT		
PROOF	OK 7-1391	
TEST		
TGT		
PROOF	ENGINEER DH	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

MOD.		GA. CAL.	GUN #	ASSEM. #
#	DATE	C6649109		
TEST		MALFUNCTION/DEFECT		
	1st			
8-28-91		slane brass + ejector stuck		KS
	2nd			
8/28/91	X	Repaired		KK
	3rd			
	4th			
		FUNCTION		RD 6654 Rev 1




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

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

MODEL 700™ M24

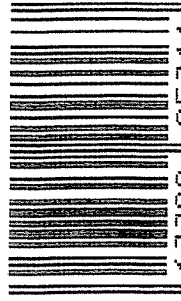
SERIAL NO.
C6649109

ORDER NO.
5716

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

0.6

UPC



0 47700 25716 7



5716 C6649109

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6649109

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/24/91	KA
600	Proof		6/26/91	KA
607	Check Headspace		6/26/91	KA
610	Dis-assemble Gun		6/26/91	KA
612	Magnaflux Barrel Action		JUL 1 8 1991	CS
	Magnaflux Bolt		JUL 1 8 1991	CS
615	Rollmark Caliber		JUL 1 8 1991	CS
617	Drill and Tap Sight Holes		JUL 1 8 1991	FB
618	Polish Barrel		JUL 2 0 1991	WB
620	Apply Coatings (Barrel Action)		7-91	TS
	Apply Coating (Bolt)		8-91	TS
625	Final Assembly A) Clean inside of Bolt Assembly		8/22/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/22/91	KA
	C) Inspect Ejector Hole for Chamfer		8/22/91	KA
	D) Oil Firing Pin Ass'y		8/22/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		8/23/91	KA

op. #	OP. NAME	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	5 1/2	5 1/2	5 1/2	8-23-91	DH		
	G) Safety Off Force	2 1/2	2	2	8-23-91	DH		
	H) Trigger Pull Test & Retainability				8-23-91	JH		
	I) Firing Pin Indent	.020	.020	.021	8-23-91	DH		
	J) Assemble Stock				8/27/91	TK		
	K) Assemble Swivel Studs				9/13/91	JH		
	L) Attach Front and Rear Sight Assemblies				8/27/91	TK		
	M) Iron Sight Alignment				8/27/91	TK		
	N) Detach Front & Rear Sights & place in numbered container				8/27/91	TK		
	O) Attach Scope to Rifle				8/27/91	TK		
	P) Detach & Attach Scope 20 Times				8/27/91	TK		
640	Gallery Target & Test				8-28-91	DH		
	A) Time				8-28-91	DH		
	B) Malfunctions				8-28-91	DH		
	C) Pierced Primers				8-28-91	DH		
	D) Optical Clarity of Scope				8-28-91	DH		
645	Inspect for Live Ammo				8-28-91	DH		
655	Final Inspection							
	A) Headspace				9/13/91	JH		
	B) Trigger Pull	2.55	2.61	2.53	2.60	2.64	8-28-91	DH
	C) Function						9/13/91	JH
660	Pack						9-19-91	TK

SWS TRIGGER PULL TEST

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

SERIAL NO. C6649109

DATE 8/23/91

TESTER JY.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.37	2.29	2.35	2.55	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.35	2.29	2.38	2.61	
PULL #3	2.20	2.32	2.36	2.53	
PULL #4	2.26	2.30	2.35	2.60	
PULL #5	2.25	2.33	2.30	2.64	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.38	3.18		
PULL #2	3.43	3.21		
PULL #3	3.37	3.35		
PULL #4	3.46	3.31		
PULL #5	3.31	3.35		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.46	4.38		4.31
PULL #2	4.45	4.26		4.48
PULL #3	4.40	4.33		4.29
PULL #4	4.29	4.52		4.44
PULL #5	4.43	4.49		4.58
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649109
28 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.472038
1 TO	2	.454368
1 TO	3	.087046
1 TO	4	.167012
1 TO	5	.286344

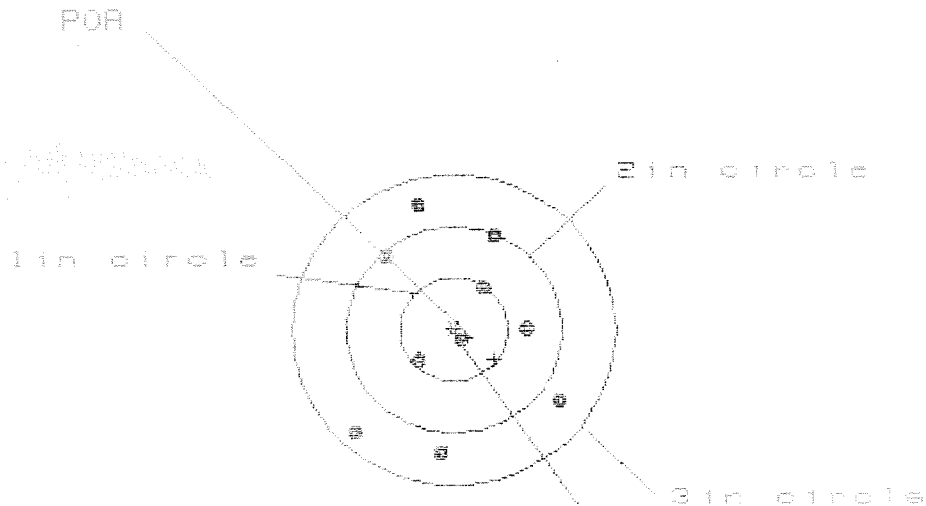
$\bar{x}$ $\bar{y}$ <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.3844
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1366
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .40795
THE AMS FOR THIS RIFLE IS: .7844

26 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649103

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 1.838

VS= 2.414

GS= 2.426

CENTROID #

PATTERN #

1

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.932	.831	.772
MINIMUM X	-.906	-.695	-.754
MAXIMUM Y	1.222	1.117	.971
MINIMUM Y	-1.192	-1.297	-1.157
CENTROID X	-.374	-.273	-.214
CENTROID Y	.288	.393	.253
POA TO CENTROID in.	.472	.479	.332
MIN RADIUS	.138	.211	.101
MEAN RADIUS	.865	.805	.748
MAX RADIUS	1.307	1.317	1.193
HORIZONTAL SPREAD	1.838	1.526	1.526
VERTICAL SPREAD	2.414	2.414	2.128
EXTREME SPREAD	2.426	2.426	2.193
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		10	

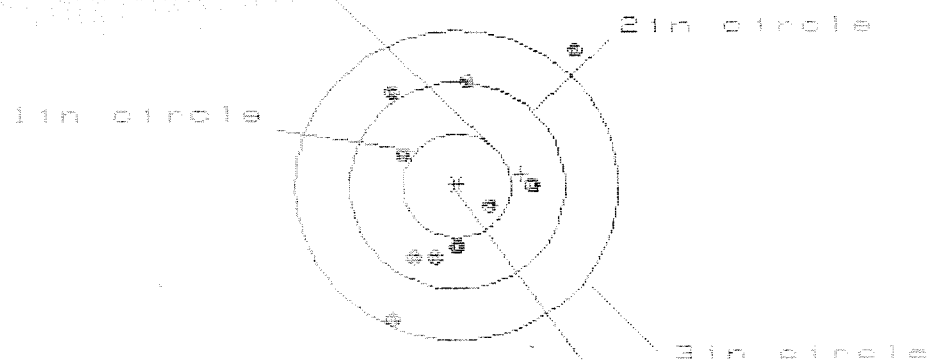
26 Aug 1991

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CENTERFIRE PATTERNS

2

FOR



OF SHOTS= 10

IN CIR

1in = 1

2in = 7

3in = 9

HS= 1.731

VS= 2.578

GS= 3.105

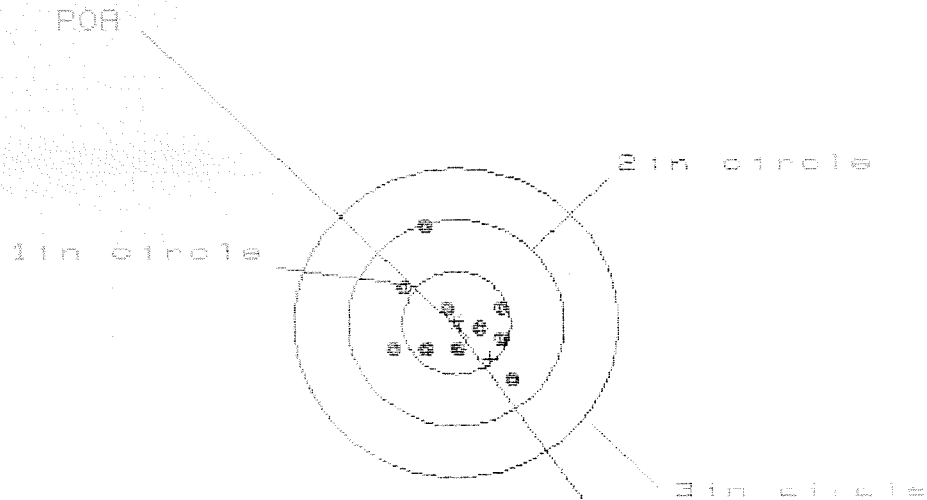
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.120	.863	.862
MINIMUM X	-.611	-.486	-.520
MAXIMUM Y	1.281	1.120	.976
MINIMUM Y	-1.297	-1.155	-.740
CENTROID X	-.595	-.720	-.659
CENTROID Y	-.109	-.251	-.107
POA TO CENTROID in.	.685	.762	.668
MIN RADIUS	.364	.428	.424
MEAN RADIUS	.896	.784	.728
MAX RADIUS	1.702	1.253	1.016
HORIZONTAL SPREAD	1.731	1.349	1.322
VERTICAL SPREAD	2.578	2.275	1.716
EXTREME SPREAD	3.105	2.392	1.807
NUMBER IN ONE INCH CIRCLE =	1	7	9
NUMBER IN TWO INCH CIRCLE =			
NUMBER IN THREE INCH CIRCLE =			

28 Aug 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 6

2in = 10

3in = 10

HS = 1.105

VS = 1.477

GS = 1.675

CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.835	.507	.497
MINIMUM X	:	-.570	-.598	-.535
MAXIMUM Y	:	.935	.407	.352
MINIMUM Y	:	-.542	-.438	-.239
CENTROID X	:	-.315	-.287	-.350
CENTROID Y	:	.352	.248	.303
POB TO CENTROID in.	:	.472	.379	.453
MIN RADIUS	:	.150	.171	.195
MEAN RADIUS	:	.496	.433	.404
MAX RADIUS	:	.969	.675	.592
HORIZONTAL SPREAD	:	1.105	1.105	1.032
VERTICAL SPREAD	:	1.477	.845	.591
EXTREME SPREAD	:	1.675	1.345	1.186
NUMBER IN ONE INCH CIRCLE	=		6	
NUMBER IN TWO INCH CIRCLE	=		10	
NUMBER IN THREE INCH CIRCLE	=		10	

28 Aug 1991

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CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 8

HS= 3.549

VS= 1.156

ES= 3.578

CENTROID #

PATTERN #

4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.913	.938	.760
MINIMUM X	-1.636	-1.424	-1.054
MAXIMUM Y	.476	.506	.485
MINIMUM Y	-.679	-.850	-.671
CENTROID X	-.376	-.588	-.411
CENTROID Y	.121	.092	.112
POA TO CENTROID in.	.395	.596	.426
MIN RADIUS	.156	.122	.131
MEAN RADIUS	.880	.752	.650
MAX RADIUS	1.931	1.433	1.131
HORIZONTAL SPREAD	3.549	2.362	1.815
VERTICAL SPREAD	1.156	1.156	1.156
EXTREME SPREAD	3.578	2.455	1.944
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	

28 Aug 1991

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CENTERFIRE PATTERNS # 5

POR

2in circle

1in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 1.227

VS= 2.488

GS= 2.587

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.537	.589	.528
MINIMUM X	-.780	-.728	-.718
MAXIMUM Y	1.215	1.075	1.104
MINIMUM Y	-1.265	-.773	-.639
CENTROID X	-.262	-.234	-.244
CENTROID Y	.031	.171	.037
POR TO CENTROID in.	.264	.290	.247
MIN RADIUS	.347	.212	.334
MEAN RADIUS	.785	.716	.667
MAX RADIUS	1.290	1.078	1.182
HORIZONTAL SPREAD	1.237	1.237	1.237
VERTICAL SPREAD	2.488	1.848	1.743
EXTREME SPREAD	2.587	2.082	2.082
NUMBER IN ONE INCH CIRCLE	= 3		
NUMBER IN TWO INCH CIRCLE	= 7		
NUMBER IN THREE INCH CIRCLE	= 10		