

C6649113

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

* Includes 1 in chamber.

Remington

Remington®



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

MODEL 700™ H24

SERIAL NO.
C6649113

ORDER NO.
5716

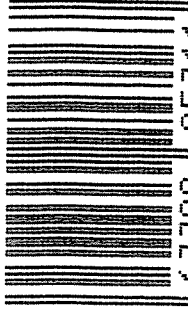
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

06



5716 C6649113

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6649113**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/27/91	YH
600	Proof		6/27/91	YH
607	Check Headspace		6/27/91	YH
610	Dis-assemble Gun		6/27/91	YH
612	Magnaflux Barrel Action		JUL 18 1991	CS
	Magnaflux Bolt		JUL 18 1991	CS
615	Rollmark Caliber		JUL 18 1991	CS
617	Drill and Tap Sight Holes		JUL 18 1991	FB
618	Polish Barrel		JUL 20 1991	WB
620	Apply Coatings (Barrel Action)		8-7-91	YH
	Apply Coating (Bolt)		8-7-91	YH
625	Final Assembly A) Clean inside of Bolt Assembly		8/29/91	YH
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/29/91	YH
	C) Inspect Ejector Hole for Chamfer		8/29/91	YH
	D) Oil Firing Pin Ass'y		8/29/91	YH
	E) Adjust Trigger Pull to Min Setting and Stake		9/4/91	JH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			9/4/91	JU
	G) Safety Off Force	5	5	5			9/4/91	JU
	H) Trigger Pull Test & Retainability						9/4/91	JU
	I) Firing Pin Indent	.023	.0215	.0215			9/4/91	JU
	J) Assemble Stock						9/4/91	JU
	K) Assemble Swivel Studs						9/12/91	JU
	L) Attach Front and Rear Sight Assemblies						9/4/91	JU
	M) Iron Sight Alignment						9/4/91	JU
	N) Detach Front & Rear Sights & place in numbered container						9/4/91	JU
	O) Attach Scope to Rifle						9/4/91	JU
	P) Detach & Attach Scope 20 Times						9/4/91	JU
640	Gallery Target & Test						9-5-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						9-5-91	NF
655	Final Inspection							
	A) Headspace						9-12-91	JU
	B) Trigger Pull	2.42	2.50	2.57	2.64	2.58	9-6-91	JU
	C) Function						9/12/91	JU
660	Pack						7-8-91	JU

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO C-6649113

DATE 9-4-91

TESTER JY

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.33	2.39	2.42	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.33	2.35	2.32	2.50	
PULL #3	2.37	2.36	2.40	2.57	
PULL #4	2.33	2.38	2.35	2.64	
PULL #5	2.28	2.37	2.30	2.58	
TOTAL			2		
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.67	3.63		
PULL #2	3.59	3.52		
PULL #3	3.62	3.56		
PULL #4	3.58	3.59		
PULL #5	3.57	3.59		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.26	4.54		4.46
PULL #2	4.25	4.56		4.48
PULL #3	4.22	4.46		4.49
PULL #4	4.55	4.50		4.50
PULL #5	4.52	4.46		4.53
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649113
5 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.221741
1 TO	2	.174889
1 TO	3	.23821
1 TO	4	.631854
1 TO	5	.0547083

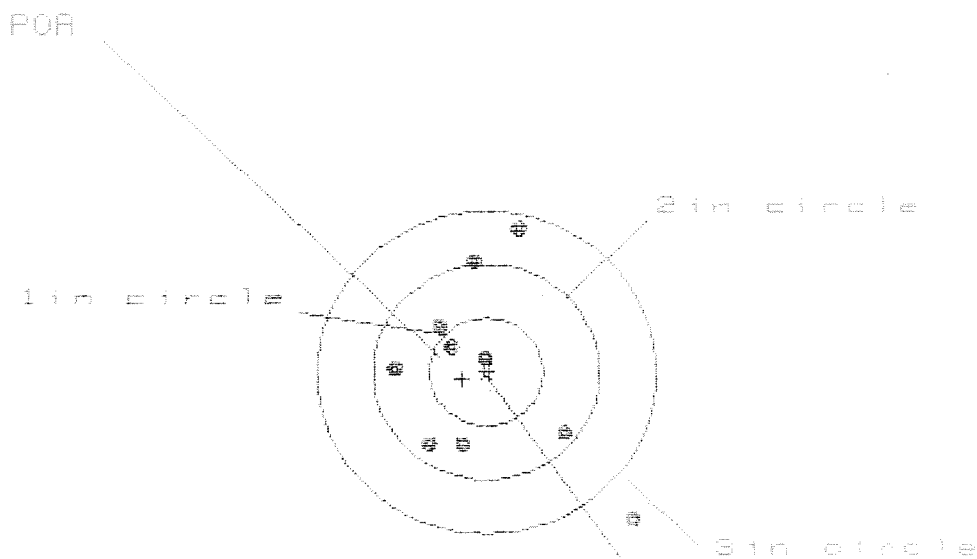
4 3/4 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0446
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.041
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0605818
THE AMR FOR THIS RIFLE IS: .8154

5 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08649113

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 2

2in = 8

3in = 8

HS = 2.158

VS = 2.649

GS = 2.825

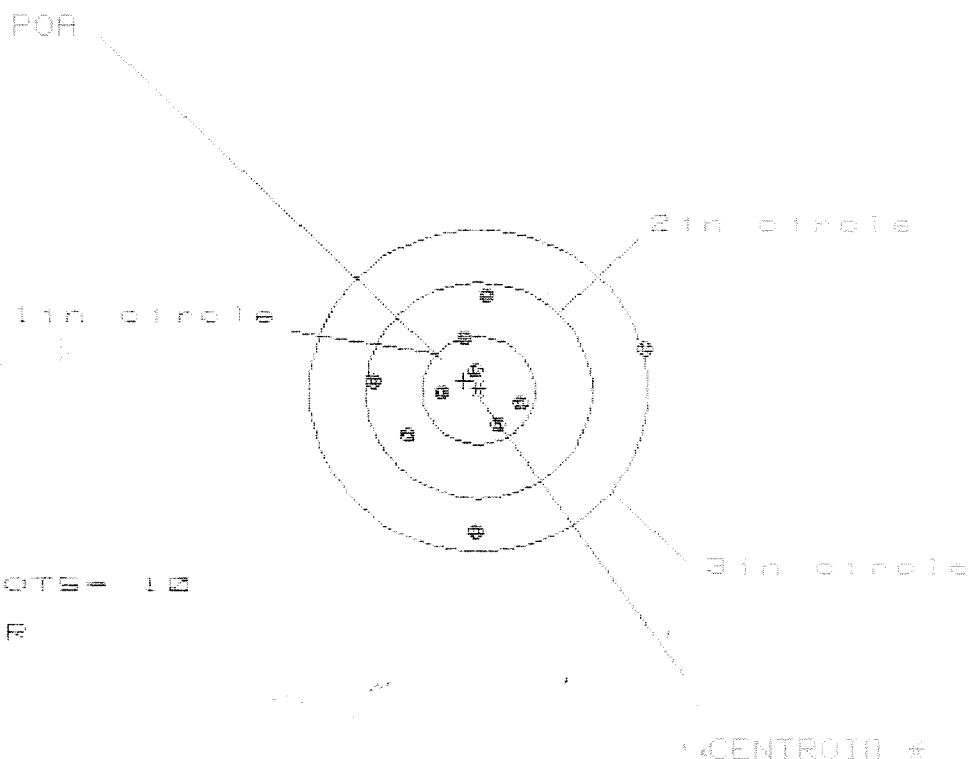
CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.317	.854	.914
MINIMUM X	:	-.841	-.695	-.635
MAXIMUM Y	:	1.310	1.161	.988
MINIMUM Y	:	-1.339	-.812	-.666
CENTROID X	:	.212	.066	.006
CENTROID Y	:	.065	.214	.069
FOR TO CENTROID in.	:	.222	.224	.069
MIN RADIUS	:	.095	.179	.247
MEAN RADIUS	:	.862	.711	.642
MAX RADIUS	:	1.878	1.257	1.068
HORIZONTAL SPREAD	:	2.158	1.549	1.549
VERTICAL SPREAD	:	2.649	1.973	1.655
EXTREME SPREAD	:	2.825	2.131	1.727
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

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FILE:/PATTERNING/CENTERFIRE_PATT/08649113

CENTERFIRE PATTERNS # 2



OF SHOTS = 12

IN CIR

1in = 4

2in = 8

3in = 9

HS = 2.395

VS = 2.200

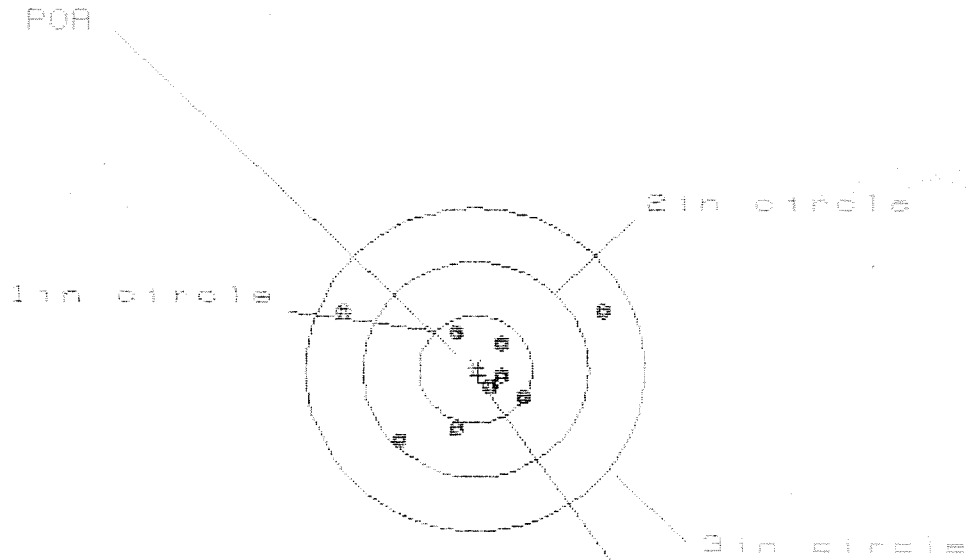
GS = 2.421

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.492	.544	.556
MINIMUM X	:	-.903	-.737	-.723
MAXIMUM Y	:	.896	.943	.786
MINIMUM Y	:	-1.304	-1.257	-.552
CENTROID X	:	.131	-.035	-.049
CENTROID Y	:	-.090	-.137	.020
POA TO CENTROID in.	:	.158	.142	.053
MIN RADIUS	:	.209	.117	.151
MEAN RADIUS	:	.715	.607	.510
MAX RADIUS	:	1.552	1.262	.815
HORIZONTAL SPREAD	:	2.395	1.281	1.281
VERTICAL SPREAD	:	2.200	2.200	1.338
EXTREME SPREAD	:	2.421	2.202	1.480
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 5

2in = 8

3in = 10

HS= 2.297

VS= 1.195

GS= 2.297

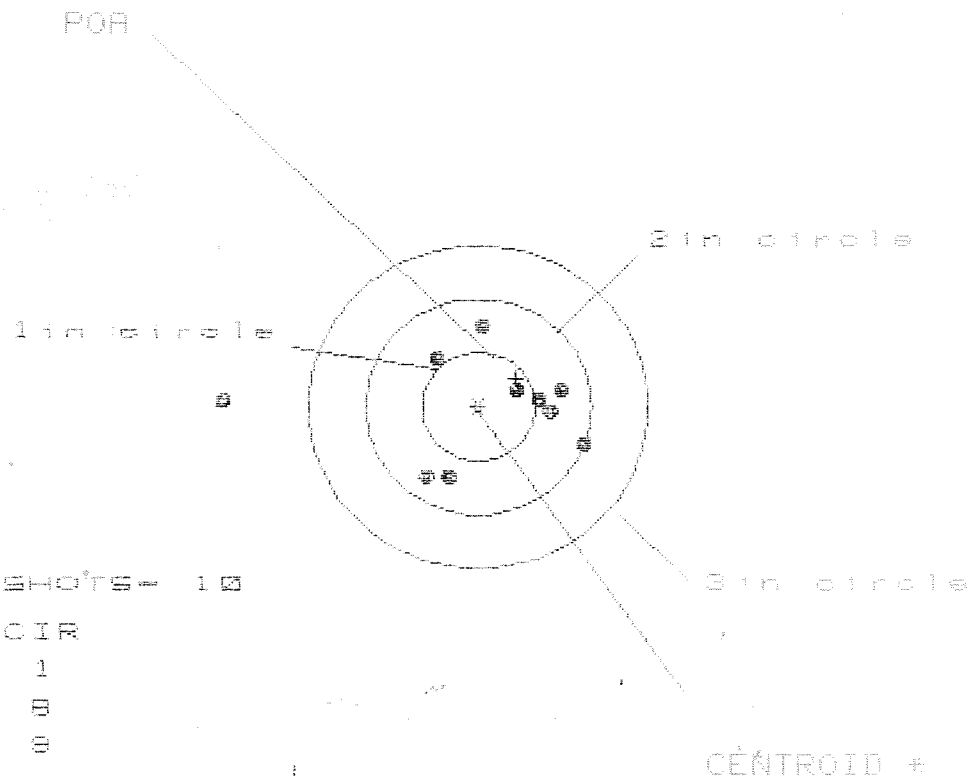
CENTROID #

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.187	.975	.455
MINIMUM X	-1.198	-.823	-.782
MAXIMUM Y	.559	.616	.478
MINIMUM Y	-.636	-.579	-.582
CENTROID X	-.026	.106	-.016
CENTROID Y	.055	-.002	-.079
POA TO CENTROID in.	.061	.106	.081
MIN RADIUS	.134	.064	.070
MEAN RADIUS	.576	.456	.385
MAX RADIUS	1.297	1.153	.862
HORIZONTAL SPREAD	2.297	1.798	1.156
VERTICAL SPREAD	1.195	1.195	.988
EXTREME SPREAD	2.297	2.159	1.268
NUMBER IN ONE INCH CIRCLE =		5	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 1

2in = 8

3in = 8

HS= 0.004

VS= 1.422

GS= 0.254

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.968	.717	.578
MINIMUM X	:	-2.256	-.737	-.647
MAXIMUM Y	:	.778	.784	.736
MINIMUM Y	:	-.644	-.638	-.686
CENTROID X	:	-.334	-.083	-.173
CENTROID Y	:	-.253	-.259	-.211
POA TO CENTROID in.	:	.419	.272	.272
MIN RADIUS	:	.364	.211	.212
MEAN RADIUS	:	.854	.627	.610
MAX RADIUS	:	2.257	.975	.943
HORIZONTAL SPREAD	:	3.224	1.454	1.225
VERTICAL SPREAD	:	1.422	1.422	1.422
EXTREME SPREAD	:	3.254	1.585	1.528
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

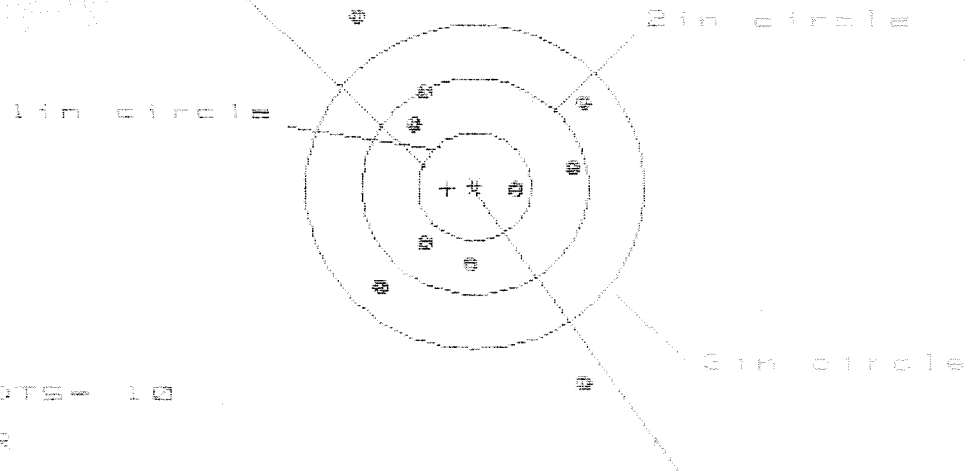
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CENTERFIRE PATTERNS

5

POA



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 8

HS= 1.998

VS= 3.375

GS= 3.921

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.002	1.113	1.002
MINIMUM X	:	-1.996	-1.885	-1.823
MAXIMUM Y	:	1.538	1.334	.864
MINIMUM Y	:	-1.837	-1.081	-.914
CENTROID X	:	.240	.129	.239
CENTROID Y	:	.018	.222	.055
POA TO CENTROID in.	:	.241	.257	.246
MIN RADIUS	:	.359	.502	.359
MEAN RADIUS	:	1.070	.950	.848
MAX RADIUS	:	2.091	1.601	1.265
HORIZONTAL SPREAD	:	1.998	1.998	1.825
VERTICAL SPREAD	:	3.375	2.415	1.718
EXTREME SPREAD	:	3.921	2.484	2.484
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	