

C6649127

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.

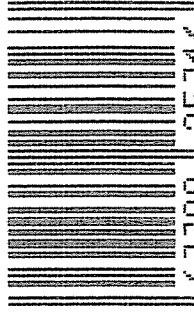
MODEL 700TM H24

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

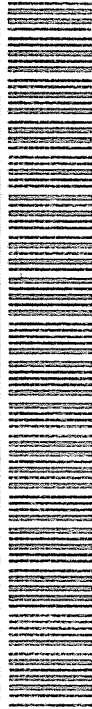
SERIAL NO.
C6649127

ORDER NO.
5716

UPC



0 47700 25716 7



5716 C6649127

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6649127

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/27/91	KA
600	Proof		6/27/91	KA
607	Check Headspace		6/27/91	KA
610	Dis-assemble Gun		6/27/91	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 22 00 1991	WB
620	Apply Coatings (Barrel Action)		8/27-91	KA
	Apply Coating (Bolt)			
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		8/24/91	KA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			8-26-91	D/H
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			8-26-91	D/H
	H) Trigger Pull Test & Retainability						8/24/91	RA
	I) Firing Pin Indent	.022	.022	.023			8-26-91	D/H
	J) Assemble Stock						8/27/91	RA
	K) Assemble Swivel Studs						8-31-91	D/H
	L) Attach Front and Rear Sight Assemblies						8/27/91	RA
	M) Iron Sight Alignment						8/27/91	RA
	N) Detach Front & Rear Sights & place in numbered container						8/27/91	RA
	O) Attach Scope to Rifle						8/27/91	RA
	P) Detach & Attach Scope 20 Times						8/27/91	RA
640	Gallery Target & Test						8/27/91	RA
	A) Time							ICT
	B) Malfunctions							ICT
	C) Pierced Primers							ICT
	D) Optical Clarity of Scope							ICT
645	Inspect for Live Ammo						8/27/91	RA
655	Final Inspection							
	A) Headspace						8-31-91	D/H
	B) Trigger Pull	2.17	2.28	2.43	2.18	2.28	8/29/91	RA
	C) Function						8-31-91	D/H
660	Pack						7-17-91	D/H

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6649127

DATE 8/24/91

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.23	2.53	2.35	2.17	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.19	2.42	2.20	2.28	
PULL #3	2.24	2.63	2.38	2.43	
PULL #4	2.48	2.36	2.44	2.18	
PULL #5	2.48	2.16	2.40	2.28	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.48	3.21		
PULL #2	3.26	3.59		
PULL #3	3.52	3.47		
PULL #4	3.21	3.60		
PULL #5	3.45	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	4.32	4.54		4.56
PULL #2	4.27	4.53		4.51
PULL #3	4.48	4.53		4.55
PULL #4	4.35	4.25		4.34
PULL #5	4.48	4.45		4.39
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06649127
27 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.364803
1 TO	2	.329577
1 TO	3	.376356
1 TO	4	.490156
1 TO	5	.30885

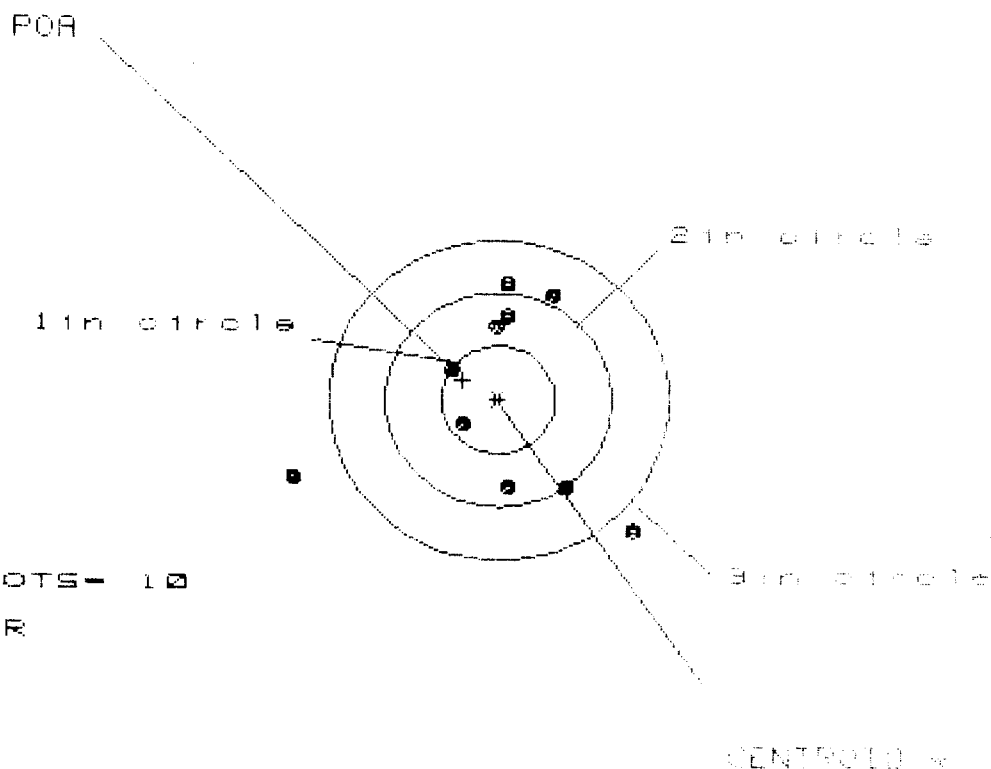
$\bar{x}_1$ (----) FOR

THE AVERAGE X COORDINATE FOR THIS RIFLE IS: .0701
THE AVERAGE Y COORDINATE FOR THIS RIFLE IS: -.0012
THE AVERAGE Z COORDINATE FOR THIS RIFLE IS: .0000
THE AVERAGE RADIUS FOR THIS RIFLE IS: .0000

27 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649127

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.979

VS= 2.346

GS= 3.021

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.153	.950	.985
MINIMUM X	:	-1.826	-.578	-.459
MAXIMUM Y	:	1.122	1.041	.876
MINIMUM Y	:	-1.224	-1.305	1.639
CENTROID X	:	.315	.518	.099
CENTROID Y	:	-.184	-.103	.060
POA TO CENTROID in.	:	.365	.528	.404
MIN RADIUS	:	.443	.616	.462
MEAN RADIUS	:	1.011	.902	.762
MAC RADIUS	:	1.964	1.614	1.192
HORIZONTAL SPREAD	:	2.979	1.528	.744
VERTICAL SPREAD	:	2.346	2.346	1.967
EXTREME SPREAD	:	3.021	2.566	2.019
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

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FILE:/PATTERNING/CENTERFIRE_PATT/06849127

CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 2.628

VS= 2.578

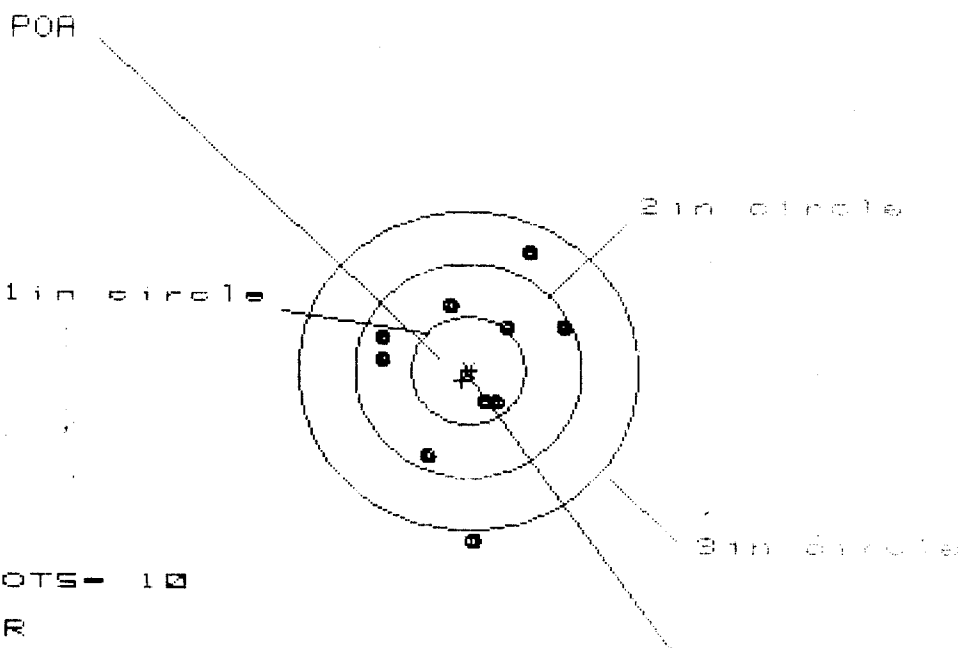
GS= 3.128

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.010	.830	.787
MINIMUM X	:	-1.618	-1.161	-1.204
MAXIMUM Y	:	1.502	1.402	1.112
MINIMUM Y	:	-1.076	-1.176	-1.001
CENTROID X	:	.045	.225	.268
CENTROID Y	:	.005	.105	-.070
POA TO CENTROID in.	:	.045	.248	.277
MIN RADIUS	:	.107	.102	.166
MEAN RADIUS	:	1.031	.921	.857
MAJ RADIUS	:	1.852	1.444	1.320
HORIZONTAL SPREAD	:	2.628	1.991	1.991
VERTICAL SPREAD	:	2.578	2.578	2.113
EXTREME SPREAD	:	3.128	2.583	2.457
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 8

3in = 9

HS= 1.605

VS= 2.625

GS= 2.685

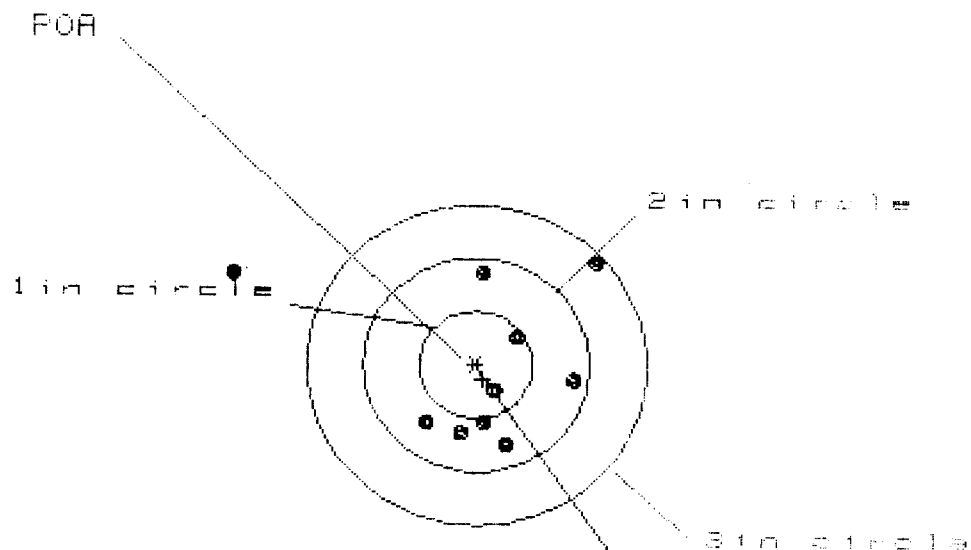
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.813	.813	.883
MINIMUM X	:	-.792	-.792	-.722
MAXIMUM Y	:	1.080	.908	.518
MINIMUM Y	:	-1.545	-1.006	-.892
CENTROID X	:	.058	.058	-.012
CENTROID Y	:	.091	.263	.149
POB TO CENTROID in.	:	.108	.269	.150
MIN RADIUS	:	.318	.440	.403
MEAN RADIUS	:	.806	.713	.663
MAX RADIUS	:	1.545	1.075	.945
HORIZONTAL SPREAD	:	1.605	1.605	1.685
VERTICAL SPREAD	:	2.625	1.914	1.410
EXTREME SPREAD	:	2.685	2.134	1.703
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 8

3 in = 9

HS= 3.168

VS= 1.661

GS= 3.170

CENTROID #

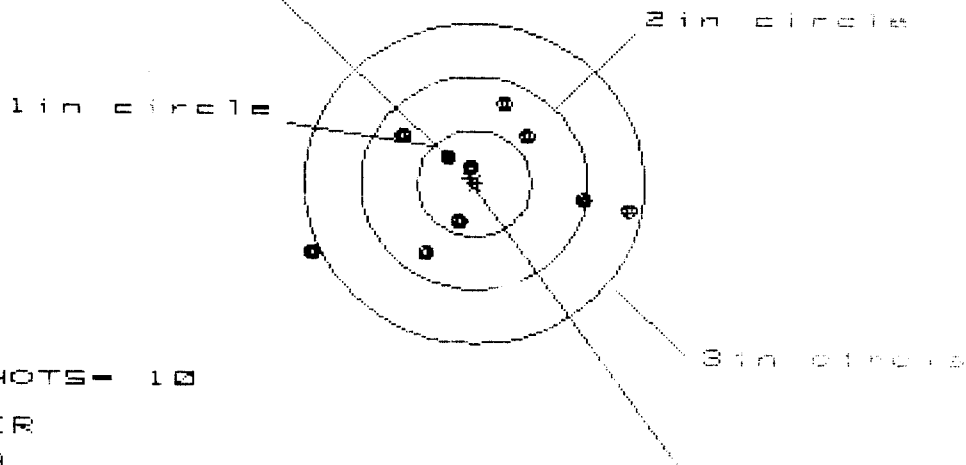
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.073	.840	.725
MINIMUM X	:	-2.095	-.626	-.521
MAXIMUM Y	:	.963	1.058	1.043
MINIMUM Y	:	-.698	-.603	-.471
CENTROID X	:	-.058	.174	.069
CENTROID Y	:	.134	.039	-.093
FOR TO CENTROID in.	:	.146	.179	.116
MIN RADIUS	:	.303	.216	.053
MEAN RADIUS	:	.873	.671	.538
MAX RADIUS	:	2.262	1.351	1.044
HORIZONTAL SPREAD	:	3.168	1.466	1.246
VERTICAL SPREAD	:	1.661	1.661	1.514
EXTREME SPREAD	:	3.170	2.120	1.526
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5

POB



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 9

HS= 2.800

VS= 1.430

GS= 2.830

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.365	1.205	.916
MINIMUM X	:	-1.443	-.818	-.567
MAXIMUM Y	:	.749	.681	.640
MINIMUM Y	:	-.681	-.749	-.790
CENTROID X	:	.036	.196	.045
CENTROID Y	:	-.052	.016	.057
POB TO CENTROID in.	:	.063	.197	.073
MO. RADIUS	:	.110	.202	.049
MEAN RADIUS	:	.777	.694	.505
MO. RADIUS	:	1.507	1.249	.946
SPREAD (X) SPREAD	:	2.800	2.023	1.584
SPREAD (Y) SPREAD	:	1.430	1.430	1.430
SPREAD (R) SPREAD	:	2.830	2.155	1.696
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	