

C6649133

MODEL 700™ M24

Model SWS™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

Remington®  REG. U.S. PAT. & TM. OFF.

MODEL 700™ **M24**

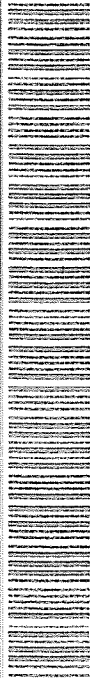
MADE IN ILION, N.Y., U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

SERIAL NO. C6649133

ORDER NO. 5716

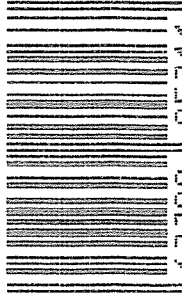
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VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.



5716 C6649133

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649133

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 27 91		dw
600	Proof	6 27 91		dw
607	Check Headspace	6 27 91		dw
610	Dis-assemble Gun	6 27 91		dw
612	Magnaflux Barrel Action		JUL 2 1991	KR
	Magnaflux Bolt		JUL 2 1991	KR
615	Rollmark Caliber		JUL 2 1991	LS
617	Drill and Tap Sight Holes		JUL 2 1991	LB
618	Polish Barrel		JUL 1 7 1991	WB
620	Apply Coatings (Barrel Action)		7-22-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/23/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/23/91	RW
	C) Inspect Ejector Hole for Chamfer		7/23/91	RW
	D) Oil Firing Pin Ass'y		7/23/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8-1-91	JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7	7	7			8-1-91	JH
	G) Safety Off Force	5	5	5			8-1-91	JH
	H) Trigger Pull Test & Retainability						8-1-91	JH
	I) Firing Pin Indent	10205	1205	1205			8-1-91	JH
	J) Assemble Stock						8/5/91	RW
	K) Assemble Swivel Studs						8-6-91	AC
	L) Attach Front and Rear Sight Assemblies						8/5/91	RW
	M) Iron Sight Alignment						8/5/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/5/91	RW
	O) Attach Scope to Rifle						8/5/91	RW
	P) Detach & Attach Scope 20 Times						8/5/91	RW
640	Gallery Target & Test						8-5-91	AC
	A) Time						8-5-91	AC
	B) Malfunctions						8-5-91	AC
	C) Pierced Primers						8-5-91	AC
	D) Optical Clarity of Scope						8-5-91	AC
645	Inspect for Live Ammo						8-5-91	AC
655	Final Inspection							
	A) Headspace						8-6-91	AC
	B) Trigger Pull	2.35	2.31	2.34	2.33	2.34	8-5-91	JH
	C) Function						8-6-91	AC
660	Pack						9/17/91	JH

SWS TRIGGER PULL TEST

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

SERIAL NO. C6649133
DATE 8-1-91
TESTER JM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.54	2.30	2.38	2.35	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.57	2.33	2.34	2.31	
PULL #3	2.50	2.34	2.34	2.34	
PULL #4	2.55	2.34	2.30	2.33	
PULL #5	2.60	2.31	2.36	2.34	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.54	3.37		
PULL #2	3.27	3.31		
PULL #3	3.46	3.31		
PULL #4	3.57	3.32		
PULL #5	3.48	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	4.44	4.50		4.40
PULL #2	4.42	4.41		4.40
PULL #3	4.42	4.55		4.44
PULL #4	4.42	4.40		4.49
PULL #5	4.39	4.29		4.48
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06649133
5 Aug 1991

CENTROIDAL DISTANCES

0 TO 1	.466135
1 TO 2	.393289
1 TO 3	.453848
1 TO 4	.689456
1 TO 5	.501328

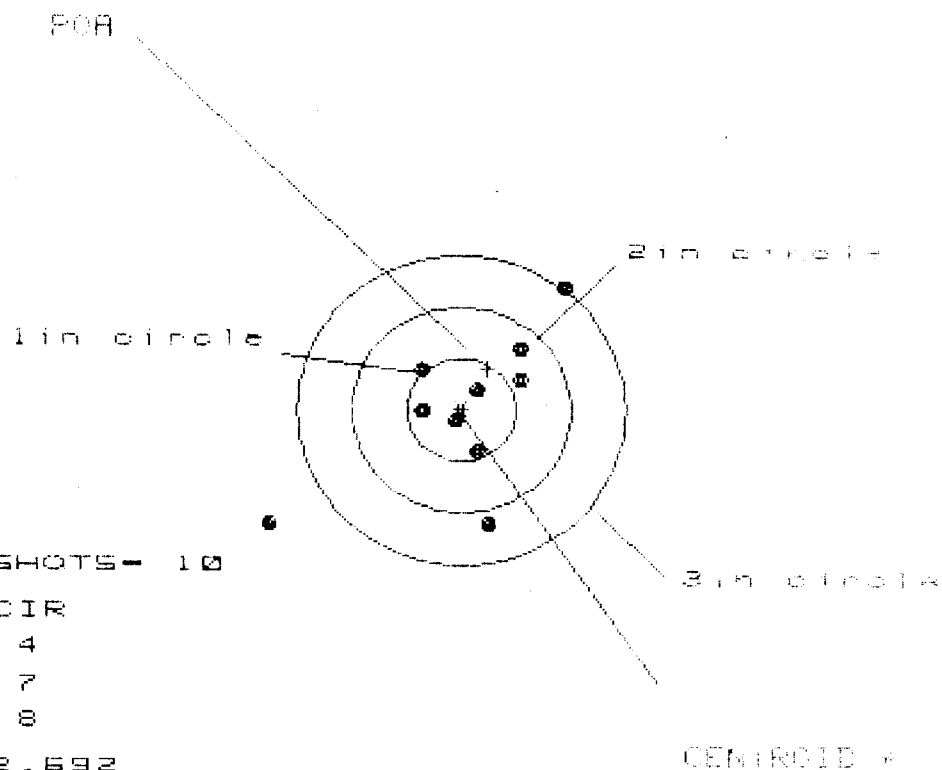
45+ <-----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -1.3546
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -1.0000
THE AVERAGE Z-COORDINATE FOR THIS RIFLE IS: 1.0000
THE AVERAGE R FOR THIS RIFLE IS: .9825

5 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649135

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 8

HS= 2.692

VS= 2.356

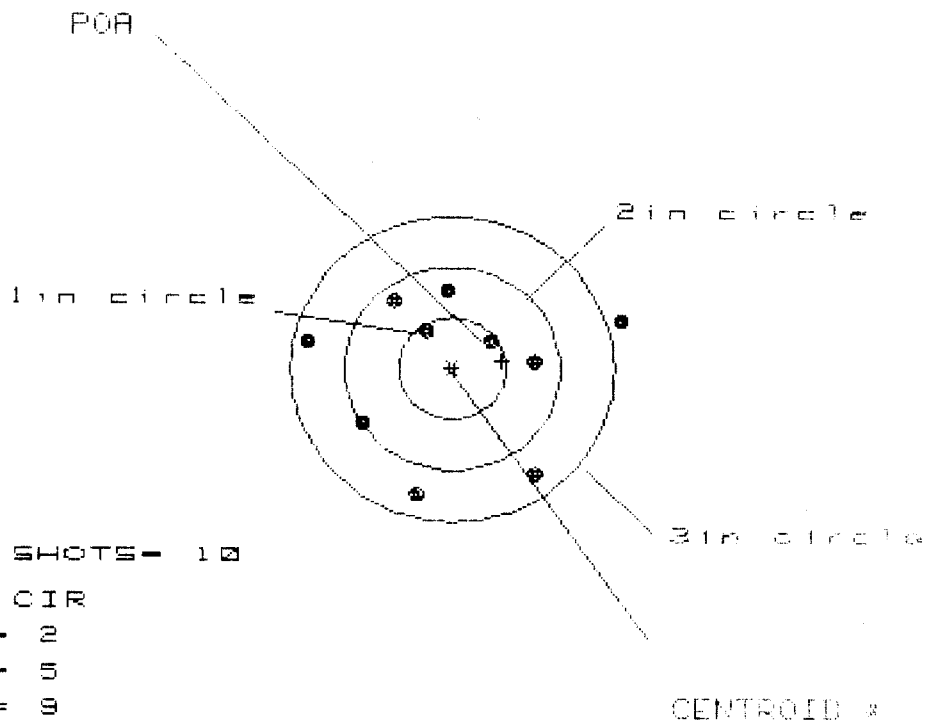
GS= 3.572

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.913	.716	.484
MINIMUM X	:	-1.778	-.564	-.475
MAXIMUM Y	:	1.213	1.087	.031
MINIMUM Y	:	-1.143	-1.269	-1.183
CENTROID X	:	-.241	-.044	-.133
CENTROID Y	:	-.399	-.273	-.409
POB TO CENTROID in.	:	.467	.277	.430
1in RADIUS	:	.067	.132	.139
2in RADIUS	:	.786	.630	.533
3in RADIUS	:	2.110	1.302	1.141
HORIZONTAL SPREAD	:	2.692	1.280	.939
VERTICAL SPREAD	:	2.356	2.356	1.764
CIRCULAR SPREAD	:	3.572	2.449	1.781
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS= 2.872

VS= 1.967

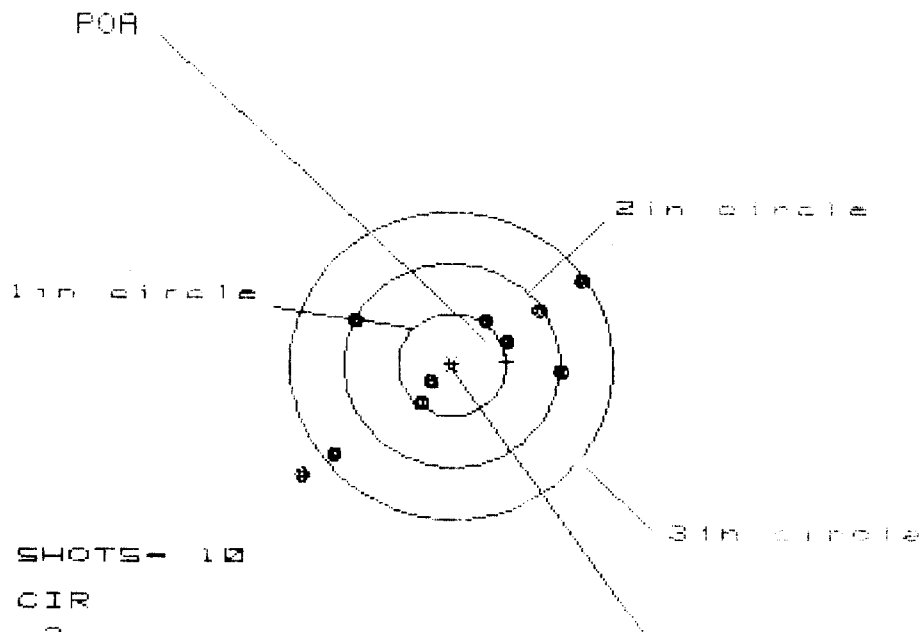
GS= 2.880

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	0
MAXIMUM X	:	1.518	.896	.747
MINIMUM X	:	-1.354	-1.185	-.829
MAXIMUM Y	:	.774	.824	.861
MINIMUM Y	:	-1.193	-1.143	-1.105
CENTROID X	:	-.461	-.630	-.491
CENTROID Y	:	-.073	-.123	-.161
POA TO CENTROID in.	:	.467	.642	.507
MIN RADIUS	:	.406	.384	.470
MEAN RADIUS	:	.967	.898	.851
MAX RADIUS	:	1.584	1.299	1.173
HORIZONTAL SPREAD	:	2.872	2.081	1.506
VERTICAL SPREAD	:	1.967	1.967	1.967
EXTREME SPREAD	:	2.880	2.421	2.063
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 9

HS= 2.550

VS= 1.816

GS= 3.131

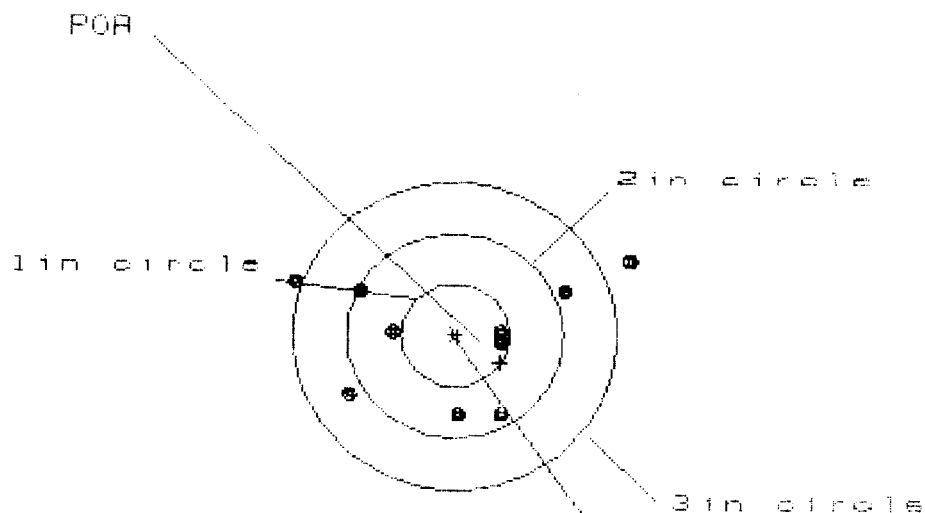
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.171	1.018	.998
MINIMUM X	:	-1.379	-1.282	-1.155
MAXIMUM Y	:	.769	.675	.510
MINIMUM Y	:	-1.027	-.960	-.876
CENTROID X	:	-.508	-.355	-.482
CENTROID Y	:	-.032	.082	-.002
POA TO CENTROID in.	:	.509	.365	.483
MIN RADIUS	:	.261	.369	.299
MEAN RADIUS	:	.945	.835	.769
MAX RADIUS	:	1.719	1.602	1.449
HORIZONTAL SPREAD	:	2.550	2.300	2.152
VERTICAL SPREAD	:	1.816	1.635	1.386
EXTREME SPREAD	:	3.131	2.822	2.419
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 3.055

VS= 1.510

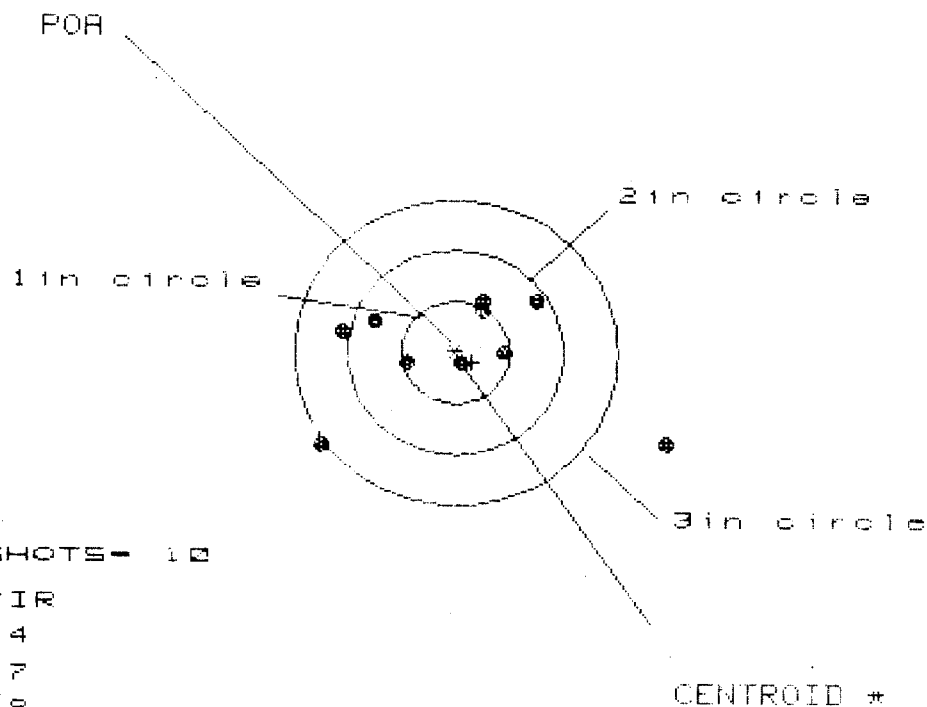
GS= 3.060

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.595	1.214	1.054
MINIMUM X	:	-1.460	-1.283	-1.939
MAXIMUM Y	:	.725	.628	.638
MINIMUM Y	:	-.785	-.705	-.626
CENTROID X	:	-.423	-.600	-.440
CENTROID Y	:	.266	.186	.107
POA TO CENTROID in.	:	.500	.628	.453
MIN RADIUS	:	.382	.448	.427
MEAN RADIUS	:	.962	.868	.772
MAX RADIUS	:	1.752	1.428	1.219
HORIZONTAL SPREAD	:	3.055	2.497	1.992
VERTICAL SPREAD	:	1.510	1.333	1.264
EXTREME SPREAD	:	3.060	2.499	2.052
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 8

HS= 3.196

VS= 1.441

GS= 3.197

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.907	.996	.861
MINIMUM X	:	-1.289	-1.077	-1.021
MAXIMUM Y	:	.519	.424	.296
MINIMUM Y	:	-.902	-1.017	-.337
CENTROID X	:	-.150	-.362	-.227
CENTROID Y	:	.094	.189	.317
POR TO CENTROID in.	:	.177	.408	.390
MIN RADIUS	:	.057	.276	.293
MEAN RADIUS	:	.854	.713	.591
MAX RADIUS	:	2.092	1.482	1.022
HORIZONTAL SPREAD	:	3.196	2.073	1.832
VERTICAL SPREAD	:	1.441	1.441	.533
EXTREME SPREAD	:	3.197	2.525	1.912
NUMBER IN ONE INCH CIRCLE =			4	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			8	