

C6649234

MODEL 700TM M24

Model **SWS** TM

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.

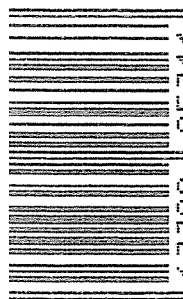
MODEL 700™ M24

SERIAL NO.
C6649234

ORDER NO.
5716

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

UPC



0 47700 25716 7



5716 C6649234

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649234

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 25	9 1	RW
600	Proof	6 25	9 1	RW
607	Check Headspace	6 25	9 1	RW
610	Dis-assemble Gun	6 25	9 1	RW
612	Magnaflux Barrel Action	JUL	1 1991	KR
	Magnaflux Bolt	JUL	1 1991	KR
615	Rollmark Caliber	JUL	1 1991	LS
617	Drill and Tap Sight Holes	JUL	1 1991	LB
618	Polish Barrel	JUL	2 1991	WB
620	Apply Coatings (Barrel Action)		8-7-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/28/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/28/91	RW
	C) Inspect Ejector Hole for Chamfer		8/28/91	RW
	D) Oil Firing Pin Ass'y		8/28/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9-3-91	JM

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			9-3-91	Ju
	G) Safety Off Force	2	2	2			9-3-91	Ju
	H) Trigger Pull Test & Retainability						9-3-91	Ju
	I) Firing Pin Indent	.0225	.022	.022			9-3-91	Ju
	J) Assemble Stock						9/4/91	Rw
	K) Assemble Swivel Studs						9-9-91	K
	L) Attach Front and Rear Sight Assemblies						9/4/91	Rw
	M) Iron Sight Alignment						9/4/91	Rw
	N) Detach Front & Rear Sights & place in numbered container						9/4/91	Rw
	O) Attach Scope to Rifle						9/4/91	Rw
	P) Detach & Attach Scope 20 Times						9/4/91	Rw
640	Gallery Target & Test						9-4-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						9-4-91	NF
655	Final Inspection							
	A) Headspace						9-9-91	K
	B) Trigger Pull	2.60	2.48	2.42	2.47	2.39	9-6-91	Ju
	C) Function						9-9-91	K
660	Pack						9-10-91	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6649234

DATE 9-3-91

TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.39	2.27	2.60	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.43	2.38	2.48	
PULL #3	2.38	2.34	2.41	2.42	
PULL #4	2.40	2.38	2.40	2.47	
PULL #5	2.41	2.28	2.33	2.39	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.57	3.43		
PULL #2	3.34	3.38		
PULL #3	3.36	3.12		
PULL #4	3.24	3.19		
PULL #5	3.32	3.28		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.37	4.21		4.33
PULL #2	4.32	4.44		4.55
PULL #3	4.31	4.48		4.54
PULL #4	4.24	4.54		4.56
PULL #5	4.19	4.52		4.53
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649234
4 Sep 1991

CENTROIDAL DISTANCES

0 TO 1	.576281
1 TO 2	.521463
1 TO 3	.653312
1 TO 4	.397112
1 TO 5	.621837

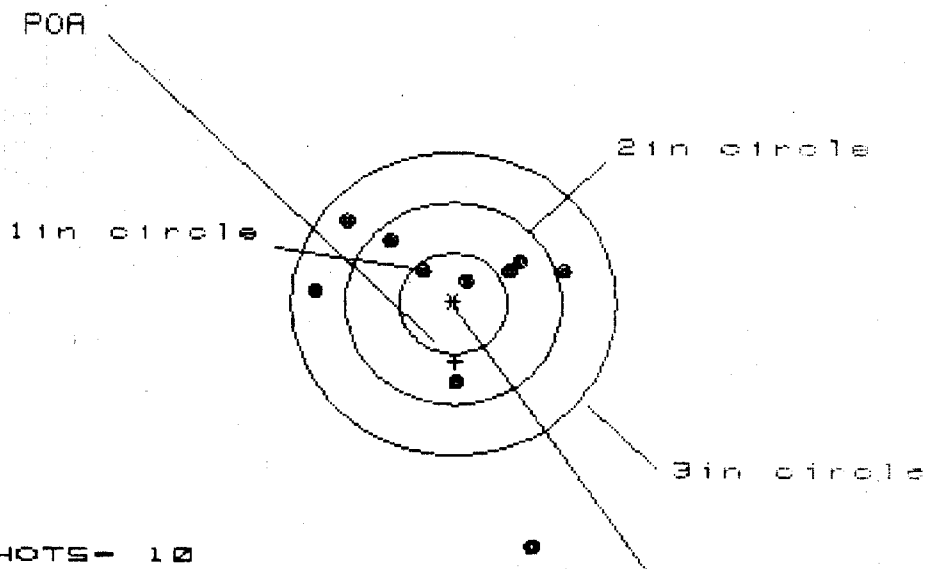
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4 <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0856
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1428
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .166491
THE POI FOR THIS RIFLE IS: 1.077

4 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649234

CENTERFIRE PATTERNS # 1



* OF SHOTS - 10

* IN CIR

1in = 2

2in = 6

3in = 9

HS = 2.253

VS = 3.145

GS = 3.568

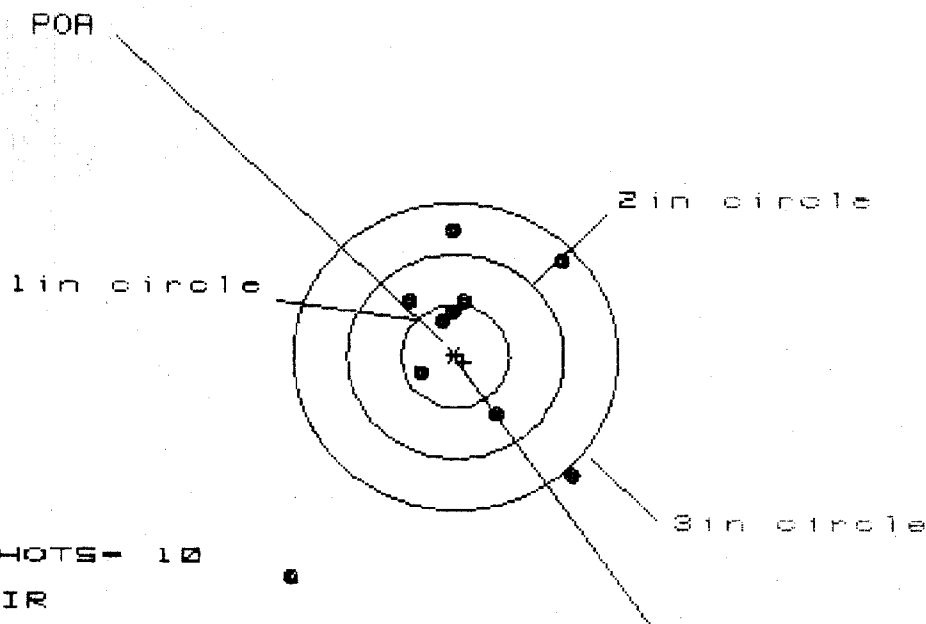
CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.974	1.058	.909
MINIMUM X	:	-1.279	-1.195	-.997
MAXIMUM Y	:	.780	.517	.499
MINIMUM Y	:	-2.365	-1.011	-1.029
CENTROID X	:	-.018	-.102	.047
CENTROID Y	:	.576	.839	.857
POA TO CENTROID in.	:	.576	.845	.858
MIN RADIUS	:	.270	.216	.099
MEAN RADIUS	:	.971	.745	.664
MAX RADIUS	:	2.482	1.204	1.115
HORIZONTAL SPREAD	:	2.253	2.253	1.906
VERTICAL SPREAD	:	3.145	1.528	1.528
EXTREME SPREAD	:	3.568	2.262	1.962
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

4 Sep 1991

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CENTERFIRE PATTERNS # 2



* OF SHOTS- 10

* IN CIR

1in = 3

2in = 6

3in = 8

HS= 2.648

VS= 3.349

GS= 3.949

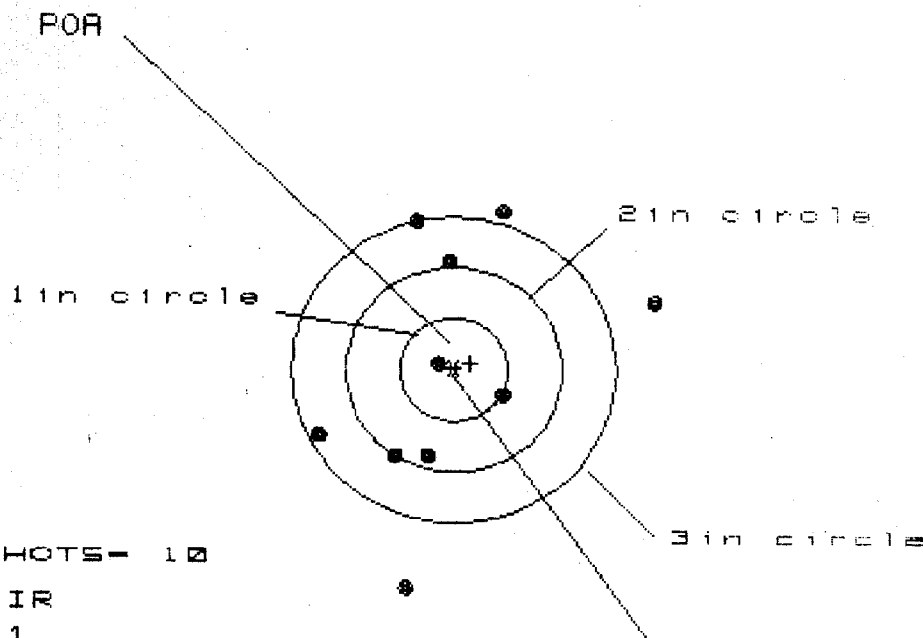
CENTROID *

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.094	.921	.894
MINIMUM X	:	-1.554	-.610	-.495
MAXIMUM Y	:	1.234	.999	.819
MINIMUM Y	:	-2.115	-1.435	-.944
CENTROID X	:	-.078	.095	-.020
CENTROID Y	:	.058	.293	.473
POA TO CENTROID in.	:	.097	.308	.473
MIN RADIUS	:	.401	.271	.089
MEAN RADIUS	:	.992	.759	.563
MAX RADIUS	:	2.625	1.705	1.035
HORIZONTAL SPREAD	:	2.648	1.531	1.389
VERTICAL SPREAD	:	3.349	2.434	1.763
EXTREME SPREAD	:	3.949	2.670	1.807
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

4 Sep 1991

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CENTERFIRE PATTERNS # 3



* OF SHOTS- 10

* IN CIR

1 in = 1

2 in = 3

3 in = 7

HS= 3.100

VS= 3.660

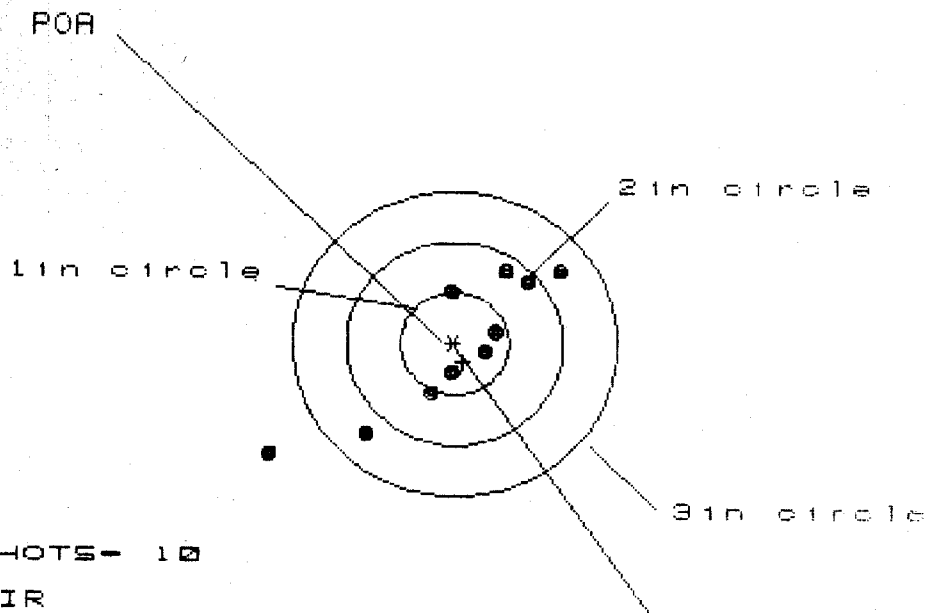
GS= 3.763

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.897	1.851	.676
MINIMUM X	:	-1.203	-1.249	-1.017
MAXIMUM Y	:	1.525	1.287	1.335
MINIMUM Y	:	-2.135	-1.110	-1.062
CENTROID X	:	-.154	-.107	-.339
CENTROID Y	:	-.063	.175	.127
POA TO CENTROID in.	:	.166	.205	.362
MIN RADIUS	:	.142	.256	.147
MEAN RADIUS	:	1.219	1.119	.997
MAX RADIUS	:	2.176	1.891	1.482
HORIZONTAL SPREAD	:	3.100	3.100	1.693
VERTICAL SPREAD	:	3.660	2.397	2.397
EXTREME SPREAD	:	3.763	3.349	2.734
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		7	

4 Sep 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 2.676

VS= 1.797

GS= 3.223

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.960	.770	.563
MINIMUM X	-1.716	-1.047	-.951
MAXIMUM Y	.743	.626	.665
MINIMUM Y	-1.054	-.960	-.882
CENTROID X	-.075	.115	.019
CENTROID Y	.183	.300	.222
POA TO CENTROID in.	.198	.322	.223
MIN RADIUS	.301	.193	.219
MEAN RADIUS	.826	.643	.608
MAX RADIUS	2.014	1.421	1.297
HORIZONTAL SPREAD	2.676	1.817	1.514
VERTICAL SPREAD	1.797	1.586	1.547
EXTREME SPREAD	3.223	2.412	2.085
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

4 Sep 1993

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CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

CENTROID *

* OF SHOTS- 10

* IN CIR

1in = 0

2in = 4

3in = 7

HS= 4.133

VS= 4.217

GS= 4.357

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.472	1.411	1.071
MINIMUM X	:	-2.661	-2.722	-1.393
MAXIMUM Y	:	1.531	1.233	1.128
MINIMUM Y	:	-2.686	-0.840	-0.458
CENTROID X	:	-0.103	-0.042	.298
CENTROID Y	:	-0.040	.258	.363
POA TO CENTROID in.	:	.111	.262	.470
MIN RADIUS	:	.528	.464	.224
MEAN RADIUS	:	1.378	1.158	.864
MAX RADIUS	:	2.740	2.848	1.411
HORIZONTAL SPREAD	:	4.133	4.133	2.464
VERTICAL SPREAD	:	4.217	2.073	1.586
EXTREME SPREAD	:	4.357	4.162	2.475
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	