

C6649273

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.

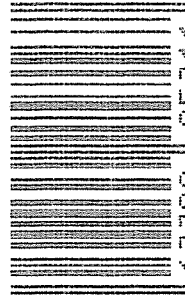
MODEL 700TM H24

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

SERIAL NO.
C6649273

ORDER NO.
5716

LPC



0 47700 25716 7



5716 C6649273

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649273

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 27 9 1		RW
600	Proof	6 27 9 1		RW
607	Check Headspace	6 27 9 1		RW
610	Dis-assemble Gun	6 27 9 1		RW
612	Magnaflux Barrel Action		JUL 2 1991	KR
	Magnaflux Bolt		JUL 2 1991	KR
615	Rollmark Caliber		JUL 2 1991	GL
617	Drill and Tap Sight Holes		JUL 2 1991	LB
618	Polish Barrel		JUL 7 1991	WB
620	Apply Coatings (Barrel Action)		7-22-91	LB
	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	JJ

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7	7	7			8-1-91	OU
	G) Safety Off Force	4	4	4			8-1-91	OU
	H) Trigger Pull Test & Retainability						8-1-91	OU
	I) Firing Pin Indent	.0215	.0215	.0215			8-1-91	OU
	J) Assemble Stock						8/1/91	RW
	K) Assemble Swivel Studs						8-6-91	R
	L) Attach Front and Rear Sight Assemblies						8/1/91	RW
	M) Iron Sight Alignment						8/1/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/1/91	RW
	O) Attach Scope to Rifle						8/1/91	RW
	P) Detach & Attach Scope 20 Times						8/1/91	RW
640	Gallery Target & Test						8-2-91	AC
	A) Time						8-2-91	AC
	B) Malfunctions						8-2-91	AC
	C) Pierced Primers						8-2-91	AC
	D) Optical Clarity of Scope						8-2-91	AC
645	Inspect for Live Ammo						8-2-91	AC
655	Final Inspection							
	A) Headspace						8-6-91	AC
	B) Trigger Pull	2.25	2.20	2.20	2.18	2.25	8-5-91	OU
	C) Function						8-6-91	AC
660	Pack						9-19-91	AC

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6649273

DATE 8-1-91

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.54	2.51	2.50	2.25	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.49	2.50	2.48	2.20	
PULL #3	2.56	2.45	2.51	2.20	
PULL #4	2.54	2.53	2.55	2.18	
PULL #5	2.41	2.52	2.53	2.25	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.33		
PULL #2	3.32	3.45		
PULL #3	3.29	3.43		
PULL #4	3.26	3.23		
PULL #5	3.41	3.43		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.38	4.41		4.33
PULL #2	4.43	4.32		4.35
PULL #3	4.23	4.35		4.40
PULL #4	4.34	4.37		4.38
PULL #5	4.27	4.44		4.47
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649273
2 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.1119403
1 TO	2	.175263
1 TO	3	.180006
1 TO	4	.206712
1 TO	5	.238606

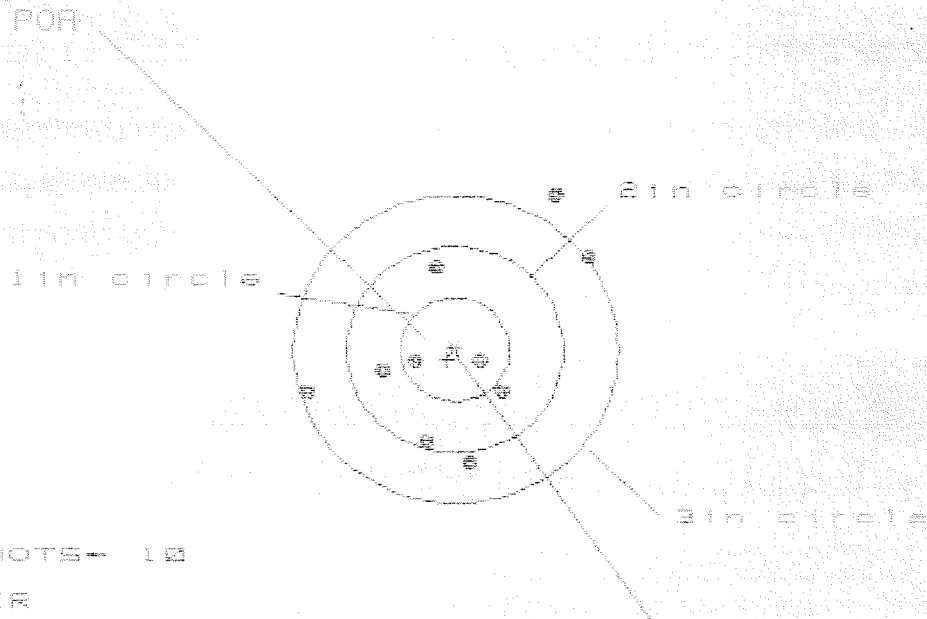
45 (----)POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0564
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0338
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0657526
THE AMR FOR THIS RIFLE IS: .8706

2 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649873

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 8

HS= 2.505

VS= 2.526

GS= 2.929

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.256	1.357	.698
MINIMUM X	-1.349	-1.248	-1.079
MAXIMUM Y	1.458	1.046	1.083
MINIMUM Y	-1.069	-1.906	-1.776
CENTROID X	.071	-.030	-.200
CENTROID Y	.096	-.066	-.196
POA TO CENTROID in.	.119	.072	.280
MIN RADIUS	.241	.245	.186
MEAN RADIUS	.937	.815	.682
MAX RADIUS	1.715	1.713	1.085
HORIZONTAL SPREAD	2.605	2.605	1.776
VERTICAL SPREAD	2.526	1.952	1.059
EXTREME SPREAD	2.929	2.911	1.884
NUMBER IN ONE INCH CIRCLE =	3	2	2
NUMBER IN TWO INCH CIRCLE =	5	6	5
NUMBER IN THREE INCH CIRCLE =	8	8	8

2 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6849273

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 2.033

VS= 1.215

GS= 2.185

PATTERN #

2

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.818

.683

.542

MINIMUM X

-1.214

-1.128

-.721

MAXIMUM Y

.576

.505

.522

MINIMUM Y

-.639

-.699

-.682

CENTROID X

.050

.185

.326

CENTROID Y

-.078

-.007

-.024

POA TO CENTROID in.

.093

.185

.327

MIN RADIUS

.279

.227

.181

MEAN RADIUS

.731

.628

.527

MAX RADIUS

1.372

1.136

.877

HORIZONTAL SPREAD

2.032

1.811

1.263

VERTICAL SPREAD

1.215

1.204

1.204

EXTREME SPREAD

2.185

1.848

1.451

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

8

NUMBER IN THREE INCH CIRCLE =

10

2 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C0849273

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID +

OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 1.201

VS= 2.688

CS= 2.812

PATTERN #

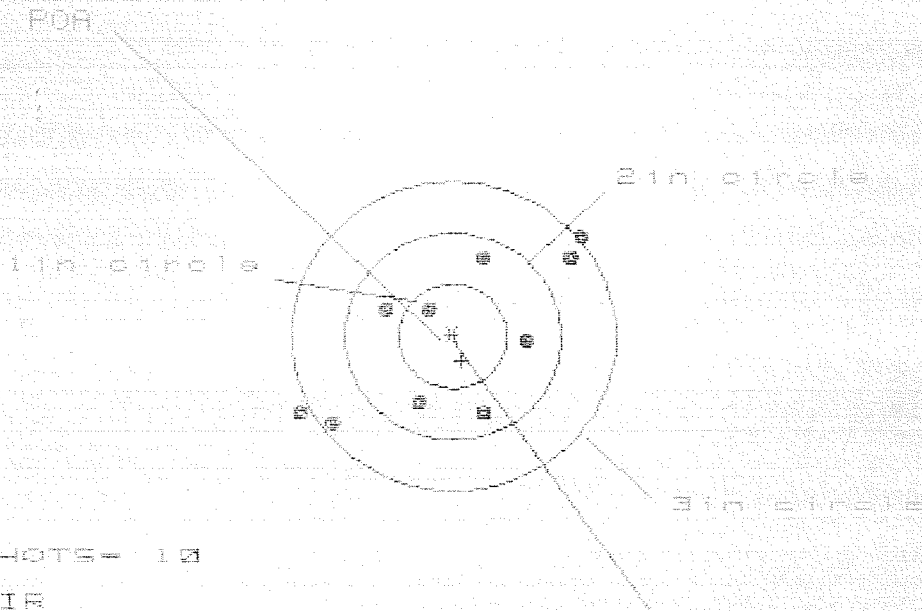
3

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.630	.670	.604
MINIMUM X	-.563	-.531	-.478
MAXIMUM Y	1.156	.987	1.038
MINIMUM Y	-1.524	1.187	-1.864
CENTROID X	-.030	-.062	.004
CENTROID Y	-.053	.118	-.007
POA TO CENTROID in.	.081	.132	.008
MIN RADIUS	.072	.118	.022
MEAN RADIUS	.772	.682	.608
MAX RADIUS	1.591	1.193	1.123
HORIZONTAL SPREAD	1.201	1.201	1.082
VERTICAL SPREAD	2.688	2.174	2.102
EXTREME SPREAD	2.812	2.213	2.189
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	9	

2 Aug 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 6

3 in = 8

HS = 2.599

VS = 1.717

GS = 3.097

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.216	1.062	1.037
MINIMUM X	:	-1.983	-1.255	-1.122
MAXIMUM Y	:	.919	.834	.756
MINIMUM Y	:	-.798	-.883	-.778
CENTROID X	:	-.082	.072	-.061
CENTROID Y	:	.235	.321	.216
FOR TO CENTROID in.	:	.249	.329	.225
MIN RADIUS	:	.361	.417	.358
MEAN RADIUS	:	.967	.891	.822
MAX RADIUS	:	1.581	1.534	1.366
HORIZONTAL SPREAD	:	2.599	2.317	2.219
VERTICAL SPREAD	:	1.717	1.717	1.534
EXTREME SPREAD	:	3.097	2.384	2.698
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			8	

2 AUG 1981

FILE: PATTERNING/CENTERFIRE_PATT/08649273

CENTERFIRE PATTERNS

5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 10

HS = 2.514

VS = 1.982

GS = 2.711

CENTROID #

PATTERN # : 5

SHOTS (BEST OF)	10	7	8
MAXIMUM X	1.346	.852	.956
MINIMUM X	-1.158	-1.019	-1.912
MAXIMUM Y	1.118	1.060	.987
MINIMUM Y	-1.864	-1.922	-1.789
CENTROID X	.273	.124	.1017
CENTROID Y	-.031	.027	-.106
POA TO CENTROID in.	.275	.126	.102
MIN RADIUS	.338	.325	.160
MEAN RADIUS	.946	.886	.795
MAX RADIUS	1.442	1.361	1.318
HORIZONTAL SPREAD	2.514	1.871	1.969
VERTICAL SPREAD	1.982	1.982	1.696
EXTREME SPREAD	2.711	2.410	3.225
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		10	