

C6649294

MODEL 700™ M24

Model **SWS**™

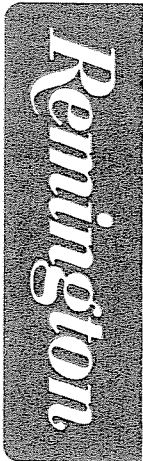
Action _____

Barrel Length _____

Capacity _____

Order No. **5716**

*Includes 1 in chamber.





Remington
REG. U.S. PAT. & TM. OFF.

MODEL 700™
W24

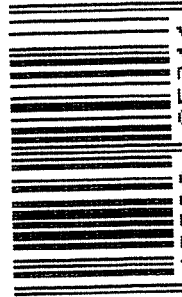
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

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

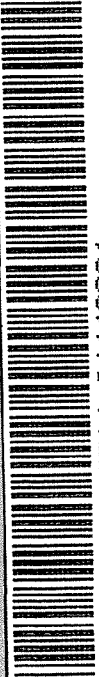
SERIAL NO.
C6649294

ORDER NO.
5716

UPC



0 47700 25716 7



5716 C6649294

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649294

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	DA
	Apply Coating (Bolt)			DA
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		8-7-91	JH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 $\frac{3}{4}$	5	5 $\frac{1}{2}$			8-7-91	D/H
	G) Safety Off Force	3	3	3			8-7-91	D/H
	H) Trigger Pull Test & Retainability						8-7-91	SH
	I) Firing Pin Indent	.020	.021	.021			8-7-91	D/H
	J) Assemble Stock						8/10/91	RW
	K) Assemble Swivel Studs						8-13-91	D/H
	L) Attach Front and Rear Sight Assemblies						8/10/91	RW
	M) Iron Sight Alignment						8/10/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/10/91	RW
	O) Attach Scope to Rifle						8/10/91	RW
	P) Detach & Attach Scope 20 Times						8/10/91	RW
640	Gallery Target & Test						8-12-91	AC
	A) Time						8-12-91	AC
	B) Malfunctions						8-12-91	AC
	C) Pierced Primers						8-12-91	AC
	D) Optical Clarity of Scope						8-12-91	AC
645	Inspect for Live Ammo						8-12-91	AC
655	Final Inspection							
	A) Headspace						8-13-91	D/H
	B) Trigger Pull	2.25	2.19	2.28	2.20	2.25	8-13-91	gdk
	C) Function						8-13-91	D/H
660	Pack						9-19-91	NE

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C-6649284

DATE 8-7-91

TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.21	2.30	2.28	2.25	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.28	2.29	2.30	2.19	
PULL #3	2.25	2.34	2.35	2.28	
PULL #4	2.32	2.33	2.25	2.20	
PULL #5	2.31	2.21	2.20	2.25	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.23	3.36		
PULL #2	3.35	3.37		
PULL #3	3.37	3.39		
PULL #4	3.28	3.36		
PULL #5	3.34	3.26		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.16	4.56		4.13
PULL #2	4.42	4.44		4.38
PULL #3	4.45	4.49		4.50
PULL #4	4.46	4.53		4.60
PULL #5	4.48	4.48		4.56
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649294
12 Aug 1991

CENTROIDAL DISTANCES

0 TO 1	.40446
1 TO 2	.940454
1 TO 3	.877023
1 TO 4	.869876
1 TO 5	.5478

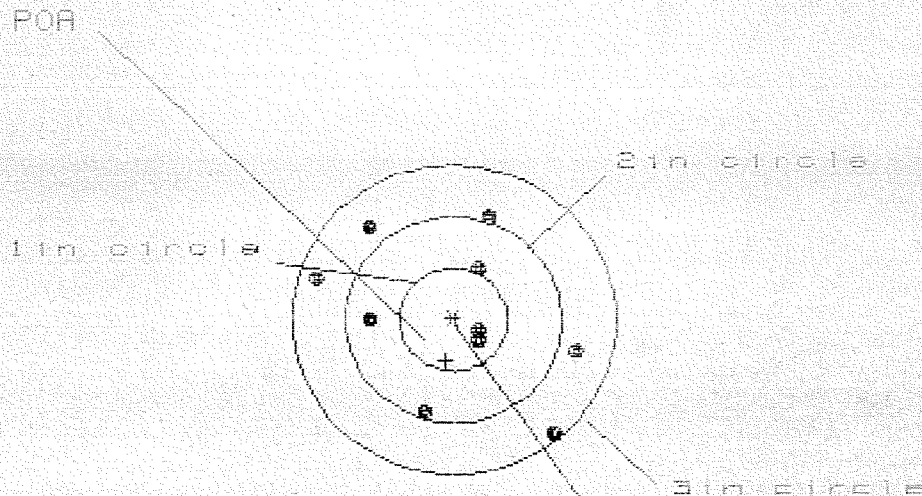
1
5+ ---- POA
2

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.3736
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0216
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .374224
THE AMR FOR THIS RIFLE IS: .9608

(12 Aug 1991)

FILE:/PATTERNING/CENTERFIRE_PATT/C6648294

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in - 2

2in - 5

3in - 10

HS= 2.436

VS= 2.102

GS= 2.734

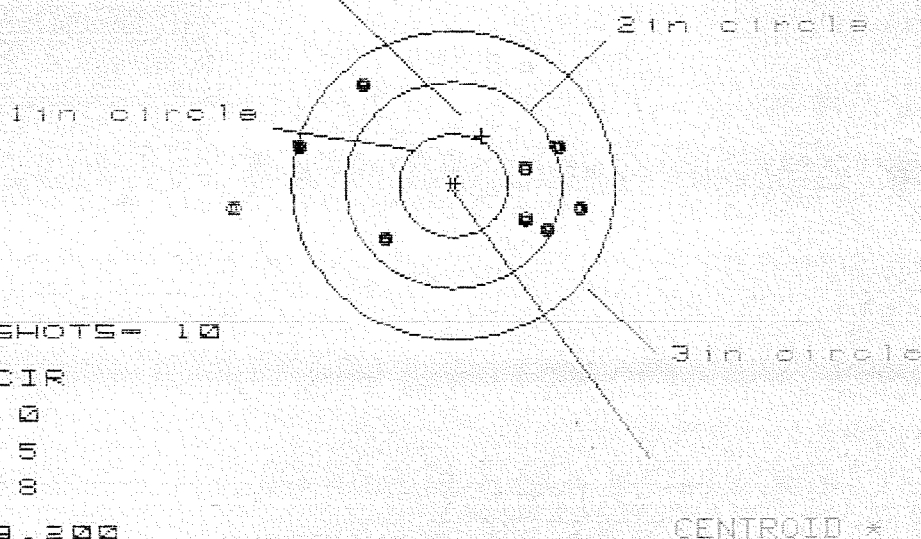
PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.156	1.263	1.117
MINIMUM X	:	-1.280	-1.173	-.853
MAXIMUM Y	:	.971	.845	.874
MINIMUM Y	:	-1.131	-1.058	-1.029
CENTROID X	:	.072	-.035	.111
CENTROID Y	:	.398	.524	.495
POA TO CENTROID in.	:	.405	.525	.568
MIN RADIUS	:	.275	.435	.311
MEAN RADIUS	:	.911	.852	.784
MAX RADIUS	:	1.486	1.327	1.203
HORIZONTAL SPREAD	:	2.436	2.436	1.970
VERTICAL SPREAD	:	2.102	1.903	1.903
EXTREME SPREAD	:	2.734	2.517	2.320
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	10		

12 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649294

CENTERFIRE PATTERNS # 2

FOR



OF SHOTS = 10

IN CIR

1in = 0

2in = 5

3in = 8

HS = 3.200

VS = 1.489

GS = 3.200

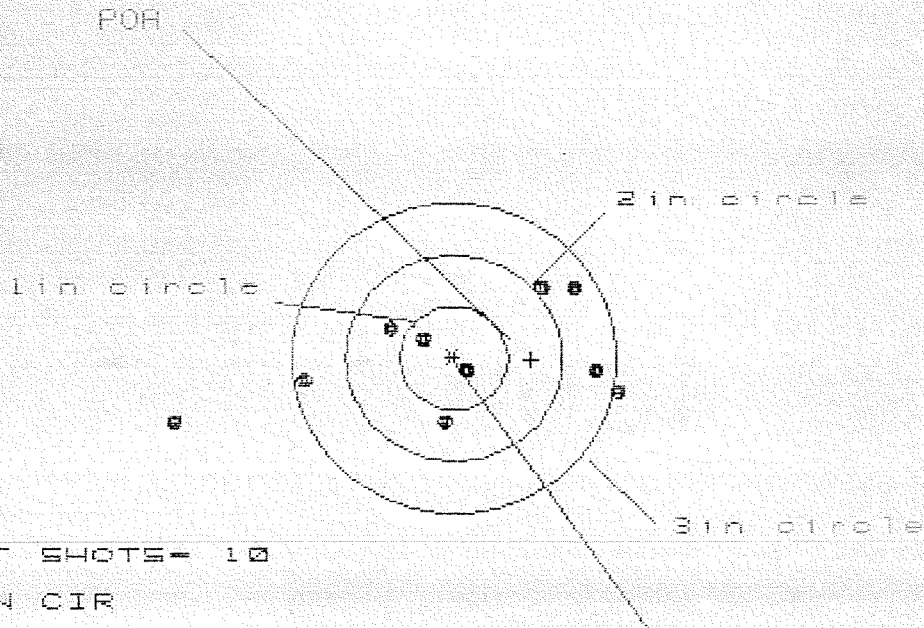
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.190	.967	.754
MINIMUM X	:	-2.010	-1.707	-1.244
MAXIMUM Y	:	1.002	.973	1.012
MINIMUM Y	:	-.487	-.516	-.477
CENTROID X	:	-.265	-.042	.171
CENTROID Y	:	-.480	-.451	-.490
FOR TO CENTROID in.	:	.548	.453	.519
MIN RADIUS	:	.684	.487	.322
MEAN RADIUS	:	1.090	.915	.722
MAX RADIUS	:	2.026	1.736	1.604
HORIZONTAL SPREAD	:	3.200	2.674	1.998
VERTICAL SPREAD	:	1.489	1.489	1.489
EXTREME SPREAD	:	3.200	2.737	2.353
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

12 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8648294

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 2

2in = 4

3in = 8

HS = 4.108

VS = 1.344

GS = 4.119

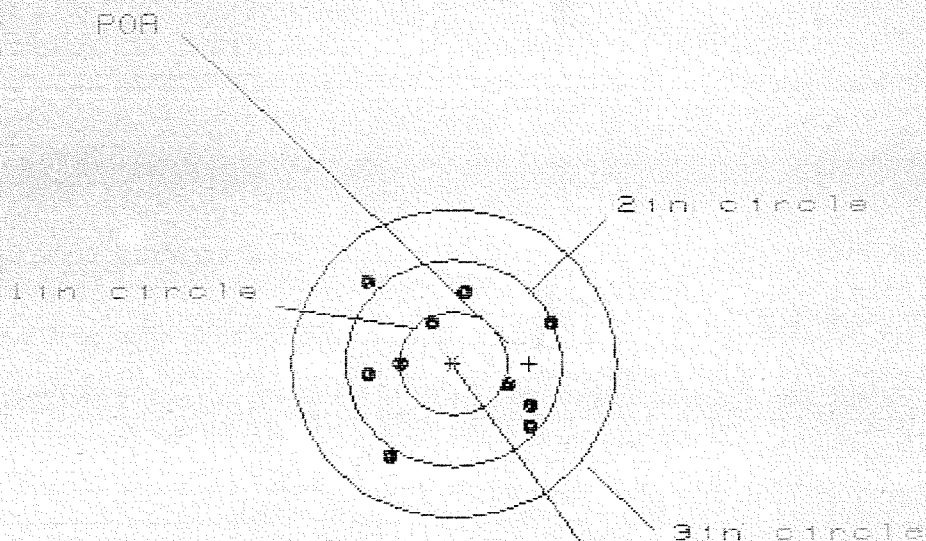
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.546	1.261	1.214
MINIMUM X	:	-2.562	-1.665	-1.507
MAXIMUM Y	:	.722	.658	.614
MINIMUM Y	:	-.622	-.686	-.730
CENTROID X	:	-.716	-.431	-.589
CENTROID Y	:	.013	.077	.121
POA TO CENTROID in.	:	.716	.438	.601
MIN RADIUS	:	.130	.232	.190
MEAN RADIUS	:	1.104	.931	.861
MAX RADIUS	:	2.627	1.685	1.538
HORIZONTAL SPREAD	:	4.108	2.926	2.721
VERTICAL SPREAD	:	1.344	1.344	1.344
EXTREME SPREAD	:	4.119	2.927	2.723
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

12 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6645294

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 8

3 in = 10

HS = 1.730

VS = 1.700

GS = 2.062

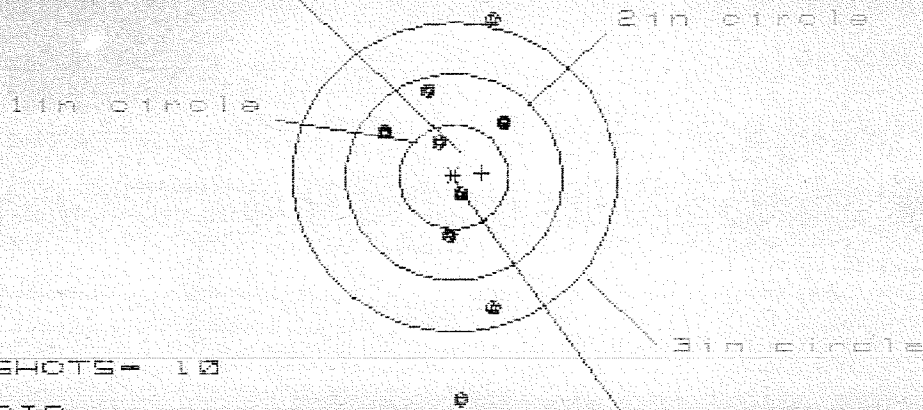
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.906	.820	.735
MINIMUM X	:	-.824	-.910	-.995
MAXIMUM Y	:	.820	.764	.665
MINIMUM Y	:	-.880	-.789	-.638
CENTROID X	:	-.702	-.616	-.531
CENTROID Y	:	.001	-.099	.009
POA TO CENTROID in.	:	.702	.623	.531
MIN RADIUS	:	.464	.474	.443
MEAN RADIUS	:	.799	.758	.708
MAX RADIUS	:	1.129	1.044	1.004
HORIZONTAL SPREAD	:	1.730	1.730	1.730
VERTICAL SPREAD	:	1.700	1.553	1.303
EXTREME SPREAD	:	2.062	1.960	1.800
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			10	

12 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B49294

CENTERFIRE PATTERNS # 5

POA



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 8

HS= 1.140

VS= 3.672

GS= 3.681

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.457	.467	.510
MINIMUM X	:	-.683	-.673	-.630
MAXIMUM Y	:	1.542	1.305	.810
MINIMUM Y	:	-2.130	-1.469	-1.306
CENTROID X	:	-.257	-.267	-.310
CENTROID Y	:	-.040	.197	.034
POA TO CENTROID in.	:	.260	.332	.311
MIN RADIUS	:	.175	.159	.259
MEAN RADIUS	:	.900	.715	.646
MAX RADIUS	:	2.132	1.513	1.367
HORIZONTAL SPREAD	:	1.140	1.140	1.140
VERTICAL SPREAD	:	3.672	2.774	2.116
EXTREME SPREAD	:	3.681	2.774	2.203
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			8	