

C6611407

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Remington

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

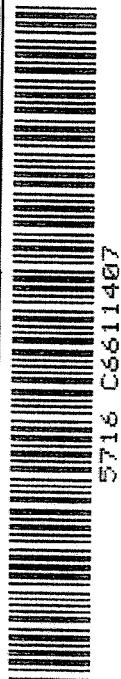
MODEL 700TM M24

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

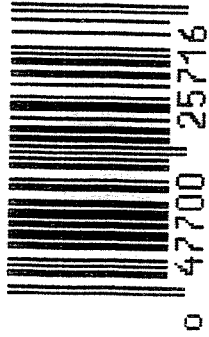
SERIAL NO. C6611407	ORDER NO. 5716
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MADE IN LION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

20



UPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611407

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 25	9 7	RW
600	Proof	1 25	9 1	RW
607	Check Headspace	1 25	9 1	RW
610	Dis-assemble Gun	1 25	9 1	RW
612	Magnaflux Barrel Action	1	9 1	KR
	Magnaflux Bolt	1 25	9 1	BR
615	Rollmark Caliber	1 25	9 1	LS
617	Drill and Tap Sight Holes	1 30	9 1	LB
618	Polish Barrel <i>LB</i>	1 30	9 1	LB
620	Apply Coatings (Barrel Action)		2-10-91	JA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		2/11/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/11/91	RW
	C) Inspect Ejector Hole for Chamfer		2/11/91	RW
	D) Oil Firing Pin Ass'y		2/11/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2/15/91	RL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			2/15/91	WB
	G) Safety Off Force	2	2	2			2/15/91	WB
	H) Trigger Pull Test & Retainability						2/15/91	HL
	I) Firing Pin Indent	.0205	.0202	.0202			2/15/91	WB
	J) Assemble Stock						2/15/91	RW
	K) Assemble Swivel Studs						2-25-91	A
	L) Attach Front and Rear Sight Assemblies						2/15/91	RW
	M) Iron Sight Alignment						2/15/91	RW
	N) Detach Front & Rear Sights & place in numbered container						2/15/91	RW
	O) Attach Scope to Rifle						2/15/91	RW
	P) Detach & Attach Scope 20 Times						2/15/91	RW
640	Gallery Target & Test						2-15-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						2-15-91	NF
655	Final Inspection							
	A) Headspace						2-25-91	K
	B) Trigger Pull	2.34	2.31	2.22	2.18	2.49	2/21/91	HL
	C) Function						2-25-91	AC
660	Pack						3-19-91	NF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6611407
DATE 2/15/91
TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.26	2.19	2.35	2.34	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.30	2.45	2.39	2.31	
PULL #3	2.27	2.39	2.39	2.22	
PULL #4	2.27	2.38	2.40	2.18	
PULL #5	2.27	2.44	2.40	2.48	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.51	3.26		
PULL #2	3.43	3.31		
PULL #3	3.55	3.32		
PULL #4	3.39	3.32		
PULL #5	3.30	3.48		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.45	4.32		4.46
PULL #2	4.37	4.45		4.30
PULL #3	4.38	4.40		4.33
PULL #4	4.46	4.44		4.43
PULL #5	4.44	4.00		4.49
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611407
15 Feb 1991

CENTROIDAL DISTANCES

0 TO	1	.268069
1 TO	2	.196515
1 TO	3	.364905
1 TO	4	.268509
1 TO	5	.329219

138 <----POA

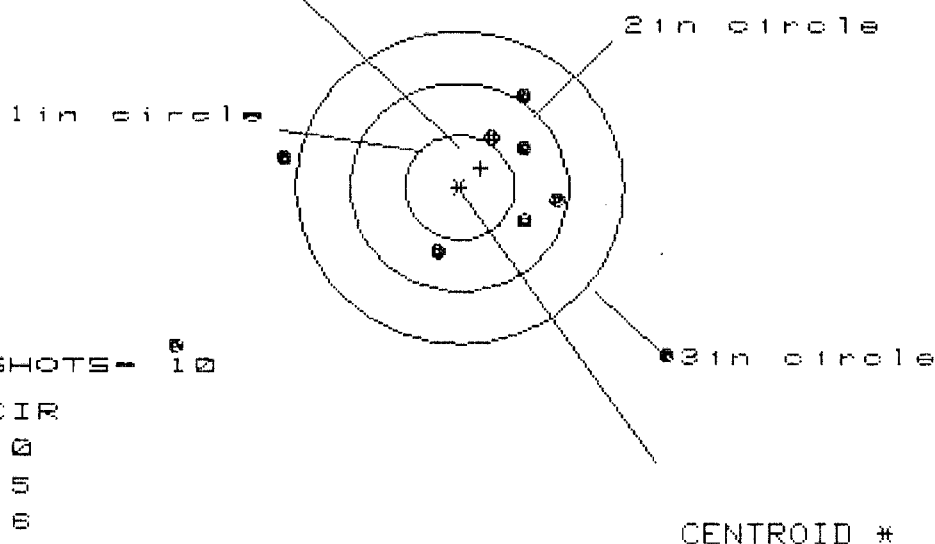
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .008
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1774
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .17758
THE AMR FOR THIS RIFLE IS: 1.009

15 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611487

CENTERFIRE PATTERNS # 1

POA



OF SHOTS - 10

IN CIR

1in = 10

2in = 5

3in = 8

IS = 4.533

VS = 3.850

GS = 4.550

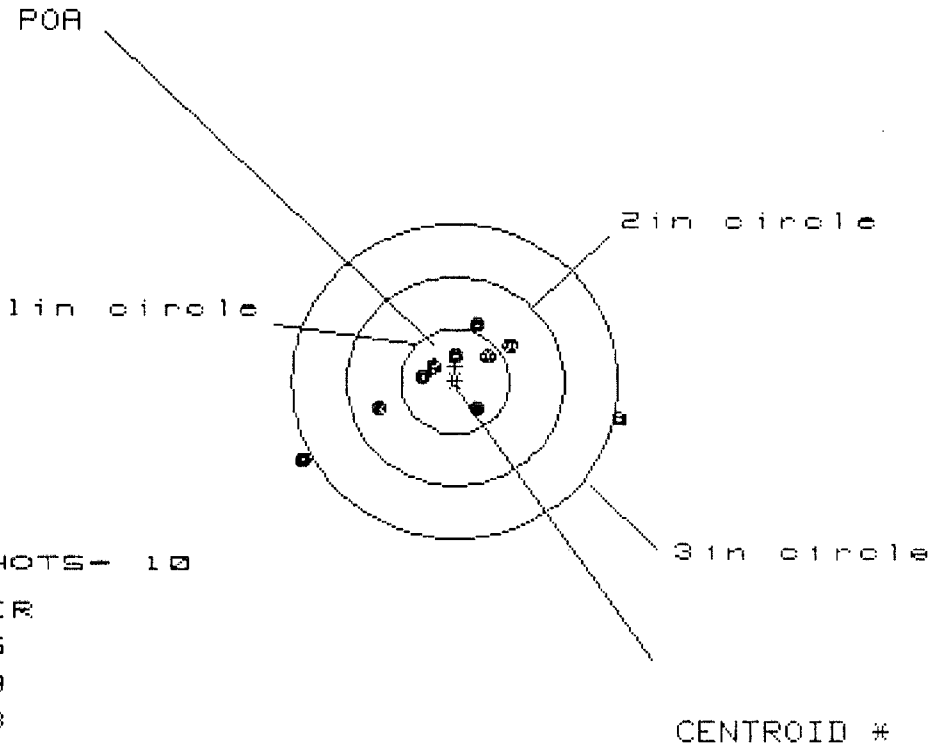
PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.897	1.604	.781
MINIMUM X	:	-2.636	-1.858	-1.657
MAXIMUM Y	:	2.186	2.017	1.788
MINIMUM Y	:	-1.664	-1.833	-1.017
CENTROID X	:	-.194	.099	-.102
CENTROID Y	:	-.185	-.016	.213
POA TO CENTROID in.	:	.268	.100	.236
MIN RADIUS	:	.607	.343	.262
MEAN RADIUS	:	1.405	1.130	.994
MAX RADIUS	:	3.044	2.436	1.897
HORIZONTAL SPREAD	:	4.533	3.462	2.438
VERTICAL SPREAD	:	3.850	3.850	2.805

PREME	SPREAD :	4.558	4.558	2.827
NUMBER IN ONE	INCH CIRCLE	=	0	
NUMBER IN TWO	INCH CIRCLE	=	5	
NUMBER IN THREE	INCH CIRCLE	=	6	

15 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611487

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 5

2 in = 8

3 in = 8

HS= 2.934

VS= 1.250

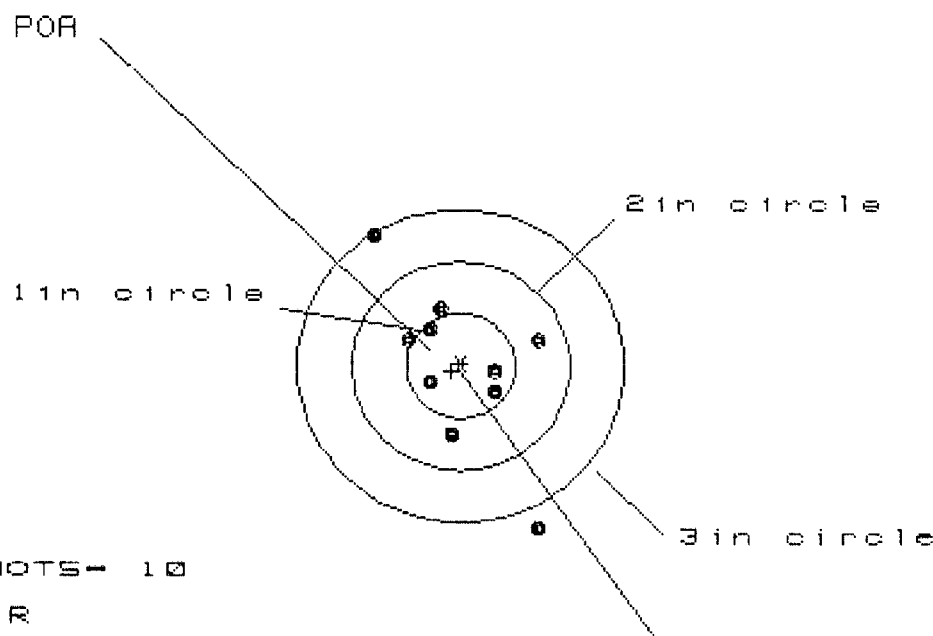
GS= 2.950

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.518	1.360	.472
MINIMUM X	:	-1.416	-.906	-.736
MAXIMUM Y	:	.546	.468	.408
MINIMUM Y	:	-.704	-.477	-.403
CENTROID X	:	-.001	.157	-.013
CENTROID Y	:	-.148	-.070	-.010
POA TO CENTROID in.	:	.148	.171	.017
MIN RADIUS	:	.246	.216	.126
MEAN RADIUS	:	.666	.547	.401
MAX RADIUS	:	1.582	1.442	.827
HORIZONTAL SPREAD	:	2.934	2.266	1.208
VERTICAL SPREAD	:	1.250	.945	.811
EXTREME SPREAD	:	2.950	2.272	1.327
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		8	

15 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611407

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 4

2in = 8

3in = 9

HS= 1.553

VS= 2.728

GS= 3.108

CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.757	.834	.744
MINIMUM X	:	-.796	-.719	-.511
MAXIMUM Y	:	1.202	1.032	.475
MINIMUM Y	:	-1.526	-.776	-.647
CENTROID X	:	.086	.009	.099
CENTROID Y	:	.049	.219	.090
POA TO CENTROID in.	:	.099	.219	.134
MIN RADIUS	:	.292	.229	.321
MEAN RADIUS	:	.705	.583	.491
MAX RADIUS	:	1.676	1.258	.764
HORIZONTAL SPREAD	:	1.553	1.553	1.255
VERTICAL SPREAD	:	2.728	1.808	1.122
EXTREME SPREAD	:	3.108	1.933	1.258
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

15 Feb 1991

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CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 0

2 in = 4

3 in = 8

HS= 2.104

VS= 2.918

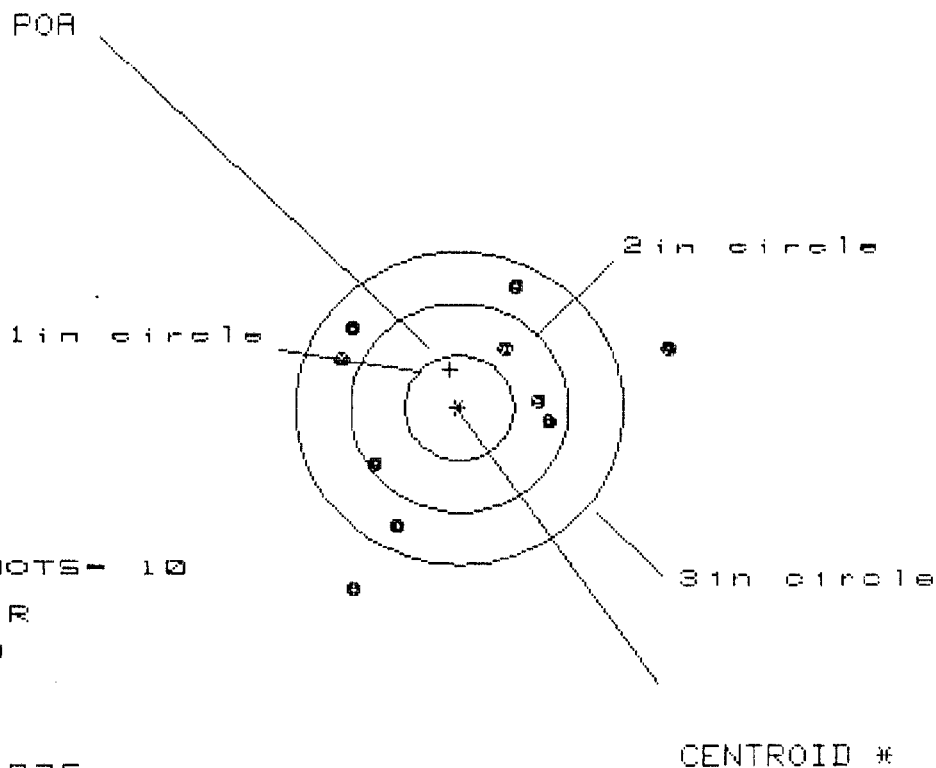
GS= 3.416

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.093	1.186	1.073
MINIMUM X	:	-1.011	-.918	-1.031
MAXIMUM Y	:	1.255	1.070	1.198
MINIMUM Y	:	-1.663	-.931	-.802
CENTROID X	:	.070	-.023	.090
CENTROID Y	:	-.234	-.049	-.177
POA TO CENTROID in.	:	.244	.054	.199
MIN RADIUS	:	.511	.652	.513
MEAN RADIUS	:	1.060	.967	.897
MAX RADIUS	:	1.863	1.508	1.340
HORIZONTAL SPREAD	:	2.104	2.104	2.104
VERTICAL SPREAD	:	2.918	2.001	2.001
EXTREME SPREAD	:	3.416	2.870	2.271
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

15 Feb 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 8

HS= 2.935

VS= 2.957

GS= 3.688

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.886	1.777	.927
MINIMUM X	:	-1.049	-1.158	-.935
MAXIMUM Y	:	1.210	1.016	1.064
MINIMUM Y	:	-1.747	-1.339	-1.291
CENTROID X	:	.079	.188	-.035
CENTROID Y	:	-.369	-.175	-.223
POA TO CENTROID in.	:	.377	.256	.226
MIN RADIUS	:	.664	.446	.645
MEAN RADIUS	:	1.211	1.093	1.008
MAX RADIUS	:	2.001	1.819	1.374
HORIZONTAL SPREAD	:	2.935	2.935	1.062
VERTICAL SPREAD	:	2.957	2.355	2.355
EXTREME SPREAD	:	3.688	3.014	2.613
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	