

C6611410

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.

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

DUPONT

MODEL 700TM M24

SERIAL NO.
C6611410

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 2

5716 C6611410

CFM

GUN SERIAL # C6611410

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 25	9 1	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 25	9 1	KR
	Magnaflux Bolt	1 25	9 1	KR
615	Rollmark Caliber	1 25	9 1	GB
617	Drill and Tap Sight Holes	1 30	9 1	FB
618	Polish Barrel RBB	1 30	9 1	WB
620	Apply Coatings (Barrel Action)		2-10-91	PA
	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		4/19/91	ML

Op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			2/20/91	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			2/20/91	WB
	H) Trigger Pull Test & Retainability						2/14/91	XL
	I) Firing Pin Indent	.021	.0215	.0215			2/20/91	WB
	J) Assemble Stock						2/20/91	RW
	K) Assemble Swivel Studs						2-22-91	A
	L) Attach Front and Rear Sight Assemblies						2/20/91	RW
	M) Iron Sight Alignment						2/20/91	RW
	N) Detach Front & Rear Sights & place in numbered container						2/20/91	RW
	O) Attach Scope to Rifle						2/20/91	RW
	P) Detach & Attach Scope 20 Times						2/20/91	RW
640	Gallery Target & Test						2/20/91	NF
	A) Time							NF
	B) Malfunctions							NF
	C) Pierced Primers							NF
	D) Optical Clarity of Scope							NF
645	Inspect for Live Ammo						2/21/91	NF
655	Final Inspection							
	A) Headspace						2-22-91	A
	B) Trigger Pull	257	248	242	239	241	2/21/91	XL
	C) Function						2-22-91	A
660	Pack						3-15-91	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6611410

DATE 2/19/91

TESTER JJF

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.37	2.44	2.41	2.57	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.40	2.40	2.41	2.48	
PULL #3	2.50	2.40	2.38	2.42	
PULL #4	2.26	2.33	2.36	2.39	
PULL #5	2.46	2.42	2.41	2.41	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.50	3.25		
PULL #2	3.39	3.35		
PULL #3	3.33	3.21		
PULL #4	3.50	3.38		
PULL #5	3.36	2.27		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.17	4.31		4.51
PULL #2	4.26	4.30		4.46
PULL #3	4.38	4.50		4.39
PULL #4	4.42	4.33		4.35
PULL #5	4.24	4.51		4.32
TOTAL				
AVG.				

CENTROIDAL DISTANCES

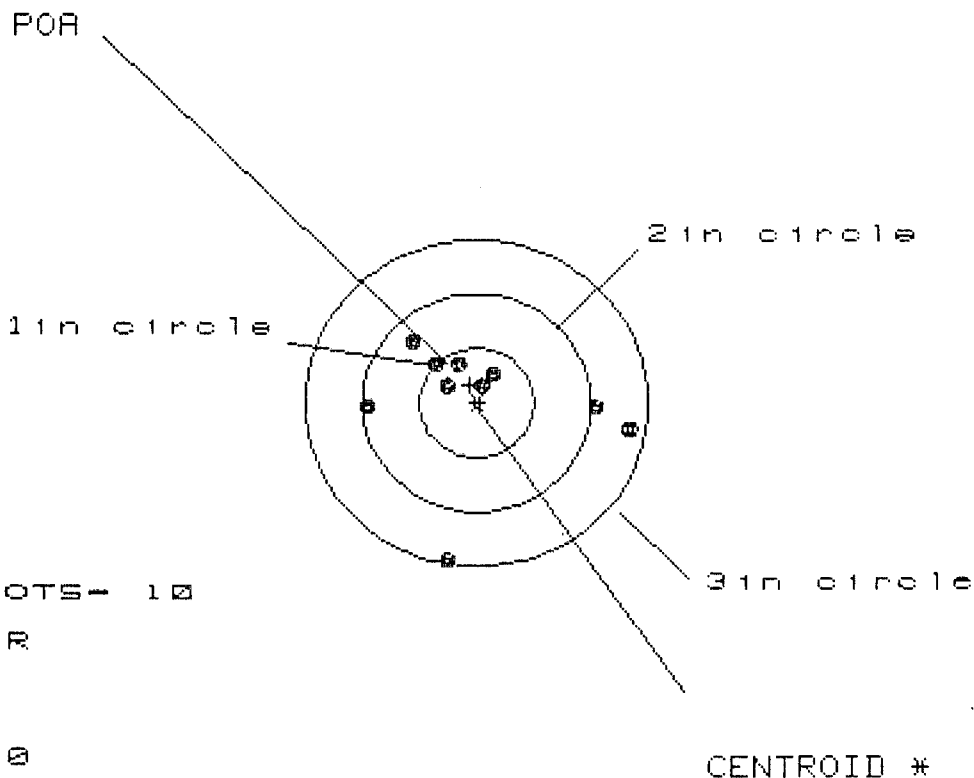
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28 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611410

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 5

2in = 7

3in = 10

HS= 2.285

VS= 1.912

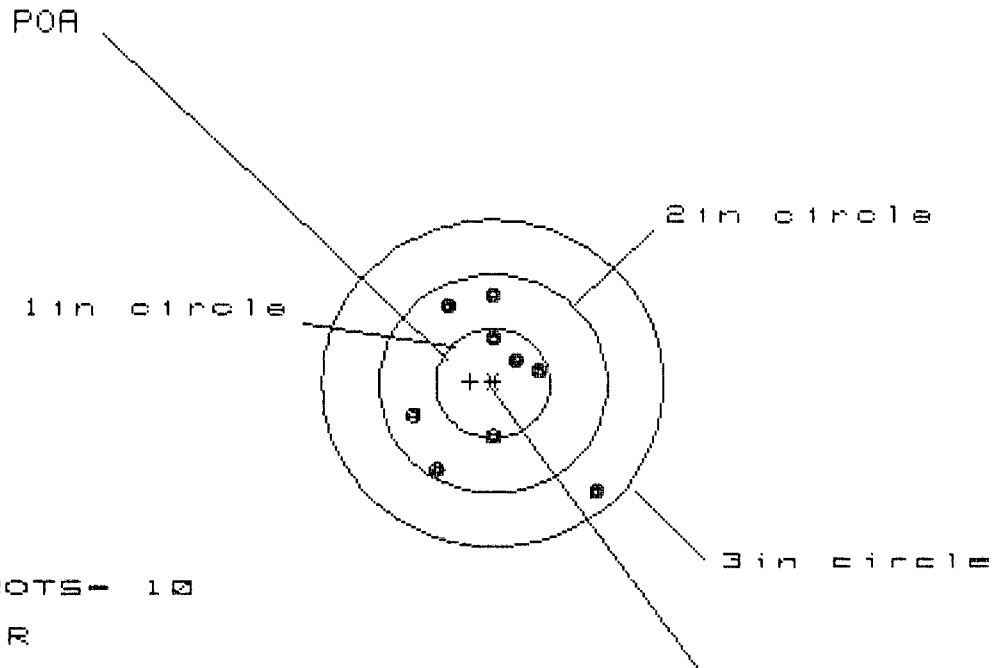
GS= 2.300

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.302	1.269	1.147
MINIMUM X	:	-.983	-1.016	-.858
MAXIMUM Y	:	.514	.358	.303
MINIMUM Y	:	-1.398	-.439	-.230
CENTROID X	:	.059	.092	-.066
CENTROID Y	:	-.161	-.005	.050
POA TO CENTROID in.	:	.171	.092	.083
MIN RADIUS	:	.139	.031	.101
MEAN RADIUS	:	.707	.576	.445
MA: RADIUS	:	1.429	1.342	1.169
HORIZONTAL SPREAD	:	2.285	2.285	2.005
VERTICAL SPREAD	:	1.912	.797	.534
EXTREME SPREAD	:	2.300	2.300	2.005
NUMBER IN ONE INCH CIRCLE =			5	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			10	

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 5

2 in = 9

3 in = 10

HS= 1.540

VS= 1.792

GS= 2.068

CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.854	.456	.410
MINIMUM X	:	-.686	-.591	-.637
MAXIMUM Y	:	.843	.737	.622
MINIMUM Y	:	-.949	-.923	-.668
CENTROID X	:	.198	.103	.149
CENTROID Y	:	-.017	.089	.204
POA TO CENTROID in.	:	.199	.136	.253
MIN RADIUS	:	.270	.285	.204
MEAN RADIUS	:	.642	.562	.475
MAX RADIUS	:	1.277	.993	.817
HORIZONTAL SPREAD	:	1.540	1.047	1.047
VERTICAL SPREAD	:	1.792	1.660	1.290
EXTREME SPREAD	:	2.068	1.721	1.322
NUMBER IN ONE INCH CIRCLE =			5	
NUMBER IN TWO INCH CIRCLE =			9	
NUMBER IN THREE INCH CIRCLE =			10	

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CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS= 2.454

VS= 2.347

GS= 3.320

CENTROID #

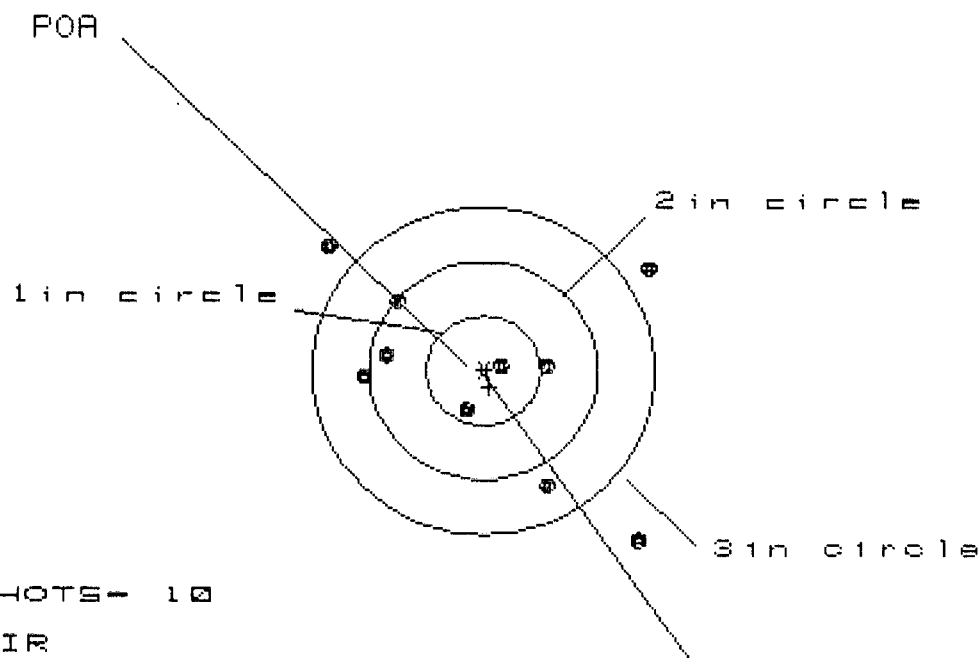
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.767	.579	.636
MINIMUM X	:	-1.697	-.881	-.824
MAXIMUM Y	:	1.055	1.095	.948
MINIMUM Y	:	-1.292	-1.175	-.859
CENTROID X	:	-.024	.164	.107
CENTROID Y	:	-.214	-.331	-.184
POA TO CENTROID in.	:	.215	.369	.213
MIN RADIUS	:	.150	.098	.154
MEAN RADIUS	:	.965	.807	.763
MAX RADIUS	:	1.998	1.406	1.256
HORIZONTAL SPREAD	:	2.464	1.460	1.460
VERTICAL SPREAD	:	2.347	2.270	1.807
EXTREME SPREAD	:	3.320	2.638	2.012
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 7

HS= 2.751

VS= 2.678

GS= 3.759

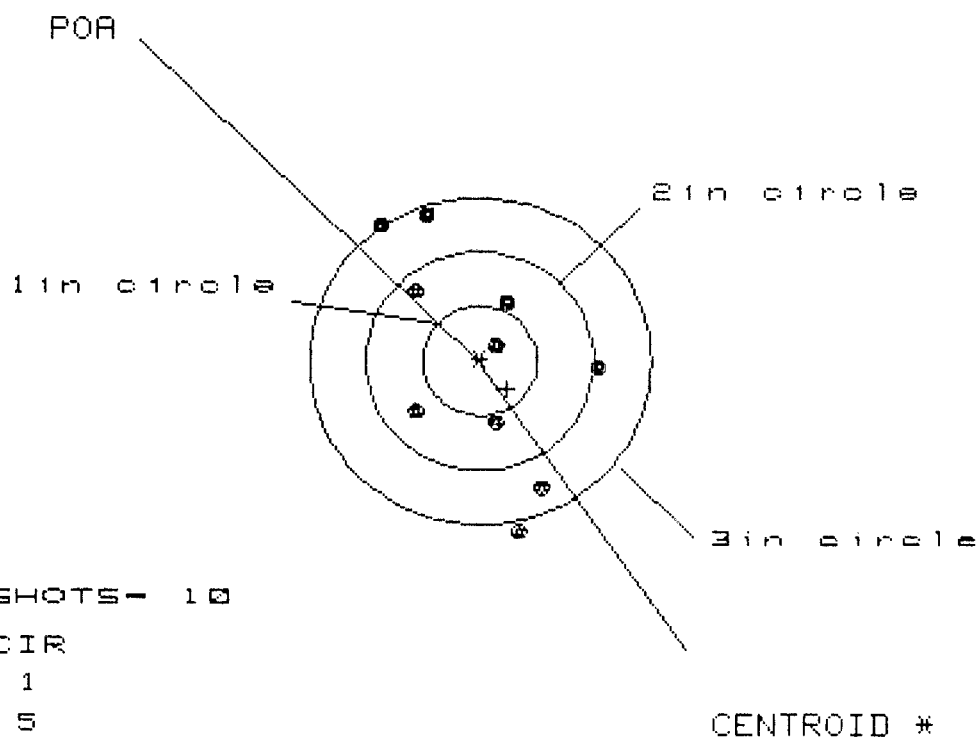
CENTROID *

PATTERN #	:	34		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.450	1.599	.948
MINIMUM X	:	-1.301	-1.152	-.952
MAXIMUM Y	:	1.103	.928	1.020
MINIMUM Y	:	-1.575	-1.203	-1.111
CENTROID X	:	-.052	-.201	-.401
CENTROID Y	:	.156	.331	.238
POA TO CENTROID in.	:	.165	.387	.466
MIN RADIUS	:	.132	.305	.476
MEAN RADIUS	:	1.065	.953	.828
MAX RADIUS	:	2.066	1.763	1.460
HORIZONTAL SPREAD	:	2.751	2.751	1.900
VERTICAL SPREAD	:	2.678	2.131	2.131
EXTREME SPREAD	:	3.759	2.855	2.855
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HSI = 1.892

VS= 2.916

GS= 3.030

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.011	1.047	.942
MINIMUM X	-.881	-.845	-.673
MAXIMUM Y	1.363	1.190	1.322
MINIMUM Y	-1.553	-1.375	-1.243
CENTROID X	-.237	-.273	-.168
CENTROID Y	.257	.430	.298
POA TO CENTROID in.	.350	.509	.342
MIN RADIUS	.258	.222	.181
MEAN RADIUS	.992	.911	.842
MAX RADIUS	1.587	1.481	1.408
HORIZONTAL SPREAD	1.892	1.892	1.615
VERTICAL SPREAD	2.916	2.565	2.565
EXTREME SPREAD	3.030	2.801	2.728
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

SWS TRIGGER PULL TEST

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

SERIAL NO. C6611410

DATE 11-7-95

TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.74	2.71	2.68	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.52	2.64	2.68	
PULL #3	2.73	2.71	2.60	
PULL #4	2.80	2.80	2.71	
PULL #5	2.66	2.56	2.73	
TOTAL	13.45	13.42	13.40	
AVG.	2.69	2.68	2.68	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.01	2.90	
PULL #2	3.00	2.88	
PULL #3	3.02	2.87	
PULL #4	3.00	2.90	
PULL #5	3.00	2.93	
TOTAL	15.03	14.48	
AVG.	3.00	2.89	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.21		4.04
PULL #2	4.25	4.22		4.05
PULL #3	4.26	4.31		4.00
PULL #4	4.20	4.22		4.00
PULL #5	4.25	4.19		4.02
TOTAL	21.18	21.15		20.11
AVG.	4.23	4.23		4.02

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6611410

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock			
600	Proof			
607.	Check Headspace			
610	Dis-assemble Gun			
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			1/25/96	WB
	G) Safety Off Force	3	3	3			1/25/96	WB
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent							
	J) Assemble Stock							
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies							
	M) Iron Sight Alignment							
	N) Detach Front & Rear Sights & place in numbered container							
	O) Attach Scope to Rifle							
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test						1/22/96	WB
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection A) Headspace							
	B) Trigger Pull	260	2.56	2.58	2.48	2.54	1/25/96	WB
	C) Function							
660	Pack							