

C6611429

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington®



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

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

MODEL 700™ M24

20

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



5716 C6611429

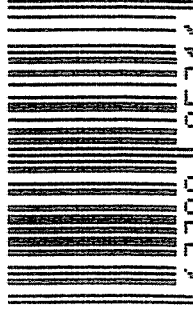
SERIAL NO.

C6611429

ORDER NO.

5716

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611429

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/19/91	K.S.
600	Proof		3/19/91	K.S.
607	Check Headspace		3/19/91	K.S.
610	Dis-assemble Gun		3/19/91	K.S.
612	Magnaflux Barrel Action		3/28/91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	JS
617	Drill and Tap Sight Holes	APR	3 1991	LB
618	Polish Barrel	APR	3 1991	LB
620	Apply Coatings (Barrel Action)		4-14-91	JS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/24/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/24/91	KS
	C) Inspect Ejector Hole for Chamfer		4/24/91	KS
	D) Oil Firing Pin Ass'y		4/24/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		4/29/91	JS

Op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			4/29/91	JK
	G) Safety Off Force	3	3	3			4/29/91	JK
	H) Trigger Pull Test & Retainability						4/29/91	JK
	I) Firing Pin Indent	.023	.0225	.0225			4/29/91	JK
	J) Assemble Stock						4/29/91	1-5
	K) Assemble Swivel Studs						5-13-91	AC
	L) Attach Front and Rear Sight Assemblies						4/29/91	1-5
	M) Iron Sight Alignment						4/29/91	1-5
	N) Detach Front & Rear Sights & place in numbered container						4/29/91	1-5
	O) Attach Scope to Rifle						4/29/91	1-5
	P) Detach & Attach Scope 20 Times						4/29/91	1-5
640	Gallery Target & Test						5-1-91	AC
	A) Time						5-1-91	AC
	B) Malfunctions						5-1-91	AC
	C) Pierced Primers						5-1-91	AC
	D) Optical Clarity of Scope						5-1-91	AC
645	Inspect for Live Ammo						5-1-91	AC
655	Final Inspection							
	A) Headspace						5-13-91	A
	B) Trigger Pull	253	247	254	258	260	5/14/91	JK
	C) Function						5-13-91	AC
660	Pack						6-17-91	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-6611929

DATE 4/29/91

TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.57	2.31	2.30	2.53	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.53	2.28	2.30	2.47	
PULL #3	2.46	2.27	2.28	2.54	
PULL #4	2.44	2.35	2.36	2.58	
PULL #5	2.41	2.29	2.28	2.60	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.56	3.42		
PULL #2	3.40	3.37		
PULL #3	3.34	3.36		
PULL #4	3.39	3.40		
PULL #5	3.39	3.39		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.46	4.46		4.47
PULL #2	4.46	4.37		4.47
PULL #3	4.44	4.47		4.47
PULL #4	4.46	4.44		4.26
PULL #5	4.42	4.46		4.39
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611429
1 May 1991

CENTROIDAL DISTANCES

0 TO	1	.570565
1 TO	2	.524295
1 TO	3	.46727
1 TO	4	.521536
1 TO	5	.230228

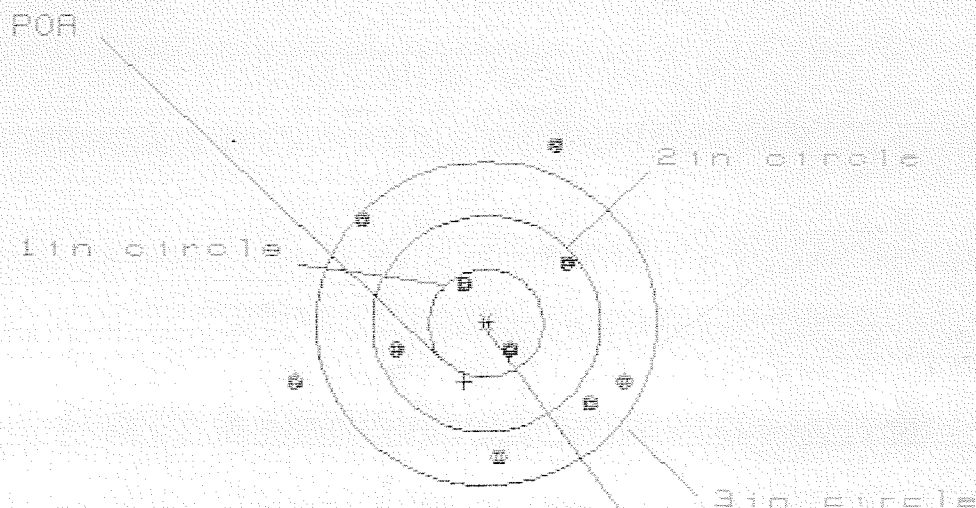
 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1464
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1986
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .246728
THE AMR FOR THIS RIFLE IS: 1.014

1 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611429

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 2.925

VS= 2.932

GS= 3.288

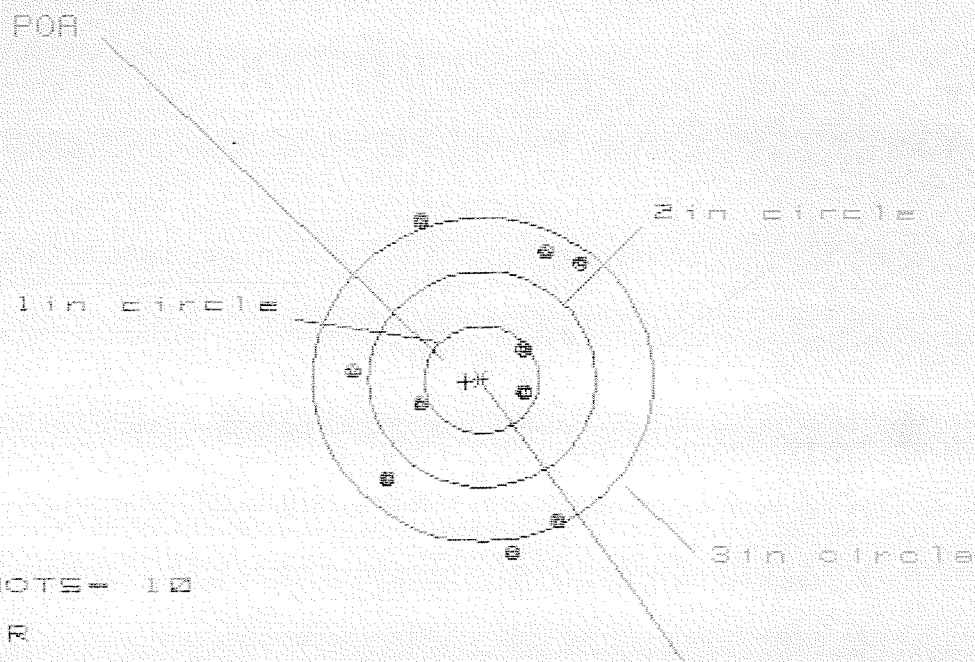
CENTROID #

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.198	1.007	1.061
MINIMUM X	:	-1.727	-1.309	-1.255
MAXIMUM Y	:	1.708	1.643	1.065
MINIMUM Y	:	-1.224	-1.289	-1.083
CENTROID X	:	.190	.381	.327
CENTROID Y	:	.538	.603	.397
POA TO CENTROID in.	:	.570	.713	.515
MIN RADIUS	:	.304	.272	.109
MEAN RADIUS	:	1.118	1.026	.915
MAX RADIUS	:	1.824	1.700	1.646
HORIZONTAL SPREAD	:	2.925	2.316	2.316
VERTICAL SPREAD	:	2.932	2.932	2.148
EXTREME SPREAD	:	3.288	2.973	2.730
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

1 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611429

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 3

3 in = 5

HS= 2.023

VS= 3.041

GS= 3.139

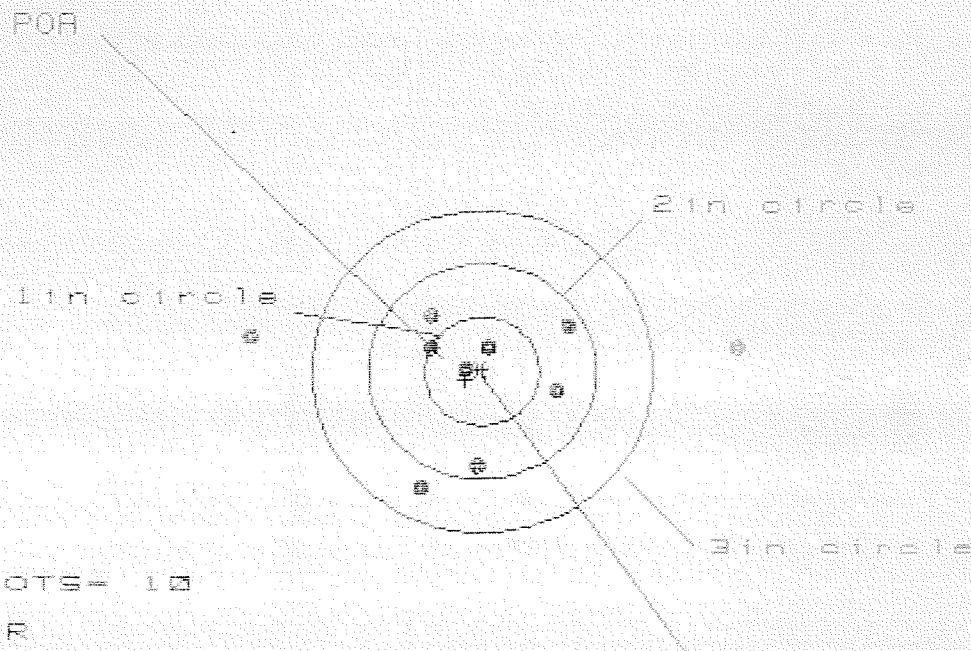
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.889	.919	.859
MINIMUM X	:	-1.133	-1.104	-1.164
MAXIMUM Y	:	1.444	1.266	1.167
MINIMUM Y	:	-1.597	-1.491	-1.338
CENTROID X	:	.141	.111	.171
CENTROID Y	:	.016	.194	.036
POA TO CENTROID in.	:	.141	.223	.174
MIN RADIUS	:	.345	.387	.325
MEAN RADIUS	:	1.112	1.049	.994
MAX RADIUS	:	1.620	1.657	1.489
HORIZONTAL SPREAD	:	2.023	2.023	2.023
VERTICAL SPREAD	:	3.041	2.757	2.500
EXTREME SPREAD	:	3.139	3.008	2.657
NUMBER IN ONE INCH CIRCLE =		2		
NUMBER IN TWO INCH CIRCLE =		3		
NUMBER IN THREE INCH CIRCLE =		5		

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 8

HS= 4.278

VS= 1.619

GS= 4.278

CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.282	.977	.759
MINIMUM X	:	-1.996	-1.742	-.486
MAXIMUM Y	:	.543	.574	.615
MINIMUM Y	:	-1.076	-1.045	-1.004
CENTROID X	:	.144	-.110	.108
CENTROID Y	:	.073	.042	.001
POA TO CENTROID in.	:	.161	.118	.108
MIN RADIUS	:	.156	.151	.174
MEAN RADIUS	:	.954	.801	.662
MAX RADIUS	:	2.299	1.773	1.116
HORIZONTAL SPREAD	:	4.278	2.719	1.245
VERTICAL SPREAD	:	1.619	1.619	1.619
EXTREME SPREAD	:	4.278	2.724	1.976
NUMBER IN ONE INCH CIRCLE	=	2	2	2
NUMBER IN TWO INCH CIRCLE	=	7	7	7
NUMBER IN THREE INCH CIRCLE	=	8	8	8

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FILE:/PATTERNING/CENTERFIRE_PATT/C6611429

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 10

HS= 2.036

VS= 2.452

GS= 2.476

PATTERN #

SHOTS (BEST OF)

MAXIMUM X

MINIMUM X

MAXIMUM Y

MINIMUM Y

CENTROID X

CENTROID Y

POA TO CENTROID in.

MIN RADIUS

MEAN RADIUS

MAX RADIUS

HORIZONTAL SPREAD

VERTICAL SPREAD

EXTREME SPREAD

NUMBER IN ONE INCH CIRCLE =

NUMBER IN TWO INCH CIRCLE =

NUMBER IN THREE INCH CIRCLE =



10

1.070

-.966

1.265

-1.187

.006

.050

.050

.189

.813

1.284

2.036

2.452

2.476

9

1.125

-.911

1.133

-.827

-.049

.182

.188

.216

.759

1.151

2.036

1.960

2.149

3

5

10

8

1.149

-.886

.972

-.685

-.073

.040

.084

.110

.690

1.150

2.036

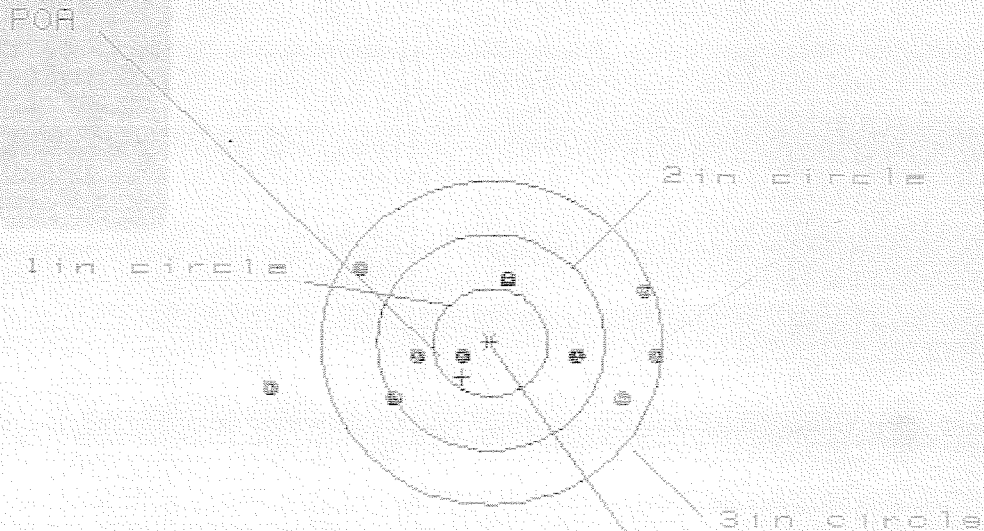
1.657

2.094

1 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611429

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 5

3 in = 4

HS= 3.411

VS= 1.161

GS= 3.424

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.488	1.274	1.293
MINIMUM X	-1.923	-1.363	-1.204
MAXIMUM Y	.658	.617	.603
MINIMUM Y	-.503	-.544	-.558
CENTROID X	.251	.464	.305
CENTROID Y	.316	.357	.371
POA TO CENTROID in.	.403	.586	.488
MIN RADIUS	.285	.501	.355
MEAN RADIUS	1.073	.970	.914
MAX RADIUS	1.958	1.496	1.351
HORIZONTAL SPREAD	3.411	2.637	2.497
VERTICAL SPREAD	1.161	1.161	1.161
EXTREME SPREAD	3.424	2.735	2.565
NUMBER IN ONE INCH CIRCLE =	1	5	9
NUMBER IN TWO INCH CIRCLE =	5	5	9
NUMBER IN THREE INCH CIRCLE =	9	9	9