

C6611455

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 700™ M24

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

SERIAL NO.
C6611455

ORDER NO.
5716

20



CEM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611455

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		2 25 91	RW
600	Proof		1 25 91	RW
607	Check Headspace		1 25 91	RW
610	Dis-assemble Gun			RW
612	Magnaflux Barrel Action		1 2 91	K.R
	Magnaflux Bolt		1 25 91	KR
615	Rollmark Caliber		1 25 91	GL
617	Drill and Tap Sight Holes		1 30 91	LB
618	Polish Barrel <i>RBB</i>		1 30 91	LB
620	Apply Coatings (Barrel Action)		2-10-91	TJA
	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		2/16/91	JP

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			2/16/91	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			2/16/91	WB
	H) Trigger Pull Test & Retainability						2/16/91	RF
	I) Firing Pin Indent	.0225	.0225	.0225			2/16/91	WB
	J) Assemble Stock						2/18/91	RW
	K) Assemble Swivel Studs						2-22-91	A
	L) Attach Front and Rear Sight Assemblies						2/18/91	RW
	M) Iron Sight Alignment						2/18/91	RW
	N) Detach Front & Rear Sights & place in numbered container						2/18/91	RW
	O) Attach Scope to Rifle						2/18/91	RW
	P) Detach & Attach Scope 20 Times						2/18/91	RW
640	Gallery Target & Test						2-19-91	RF
	A) Time						"	RF
	B) Malfunctions						"	RF
	C) Pierced Primers						"	RF
	D) Optical Clarity of Scope						"	RF
645	Inspect for Live Ammo						2-19-91	RF
655	Final Inspection						2-22-91	A
	A) Headspace						2-22-91	A
	B) Trigger Pull	2.35	2.20	2.38	2.29	2.32	2/21/91	RF
	C) Function						2-22-91	A
660	Pack						3-19-91	RF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± 50#
3.00# ± 75#
4.00# ± 100#

SERIAL NO. 06611455

DATE 2/16/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.33	2.30	2.35	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.43	2.43	2.20	2.20	
PULL #3	2.52	2.47	2.25	2.38	
PULL #4	2.48	2.28	2.30	2.29	
PULL #5	2.38	2.36	2.31	2.32	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.45	3.17		
PULL #2	3.20	3.42		
PULL #3	3.42	3.32		
PULL #4	3.44	3.41		
PULL #5	3.48	3.25		
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	4.43		4.38
PULL #2	4.39	4.44		4.45
PULL #3	4.49	4.44		4.46
PULL #4	4.52	4.21		4.25
PULL #5	4.36	4.48		4.39
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611455
20 Feb 1991

CENTROIDAL DISTANCES

0 TO	1	.116417
1 TO	2	.0938616
1 TO	3	.129248
1 TO	4	.0576975
1 TO	5	.247164

5. <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0716
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0842
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .110527
THE AMP FOR THIS RIFLE IS: 1.026

28 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06811455

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 1

2 in = 2

3 in = 7

IS = 3.389

VS = 3.224

GS = 4.223

CENTROID *

PATTERN #

1

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.655

1.317

1.206

MINIMUM X

-1.734

-1.550

-1.661

MAXIMUM Y

1.708

1.453

1.287

MINIMUM Y

-1.516

-1.327

-.933

CENTROID X

.113

-.071

.040

CENTROID Y

-.028

-.217

-.051

POA TO CENTROID in.

.116

.229

.065

MIN RADIUS

.364

.334

.399

MEAN RADIUS

1.264

1.124

1.051

MAX RADIUS

2.378

1.597

1.661

HORIZONTAL SPREAD

3.389

2.867

2.867

VERTICAL SPREAD

3.224

2.780

2.220

EXTREME SPREAD

4.223

2.957

2.957

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

2

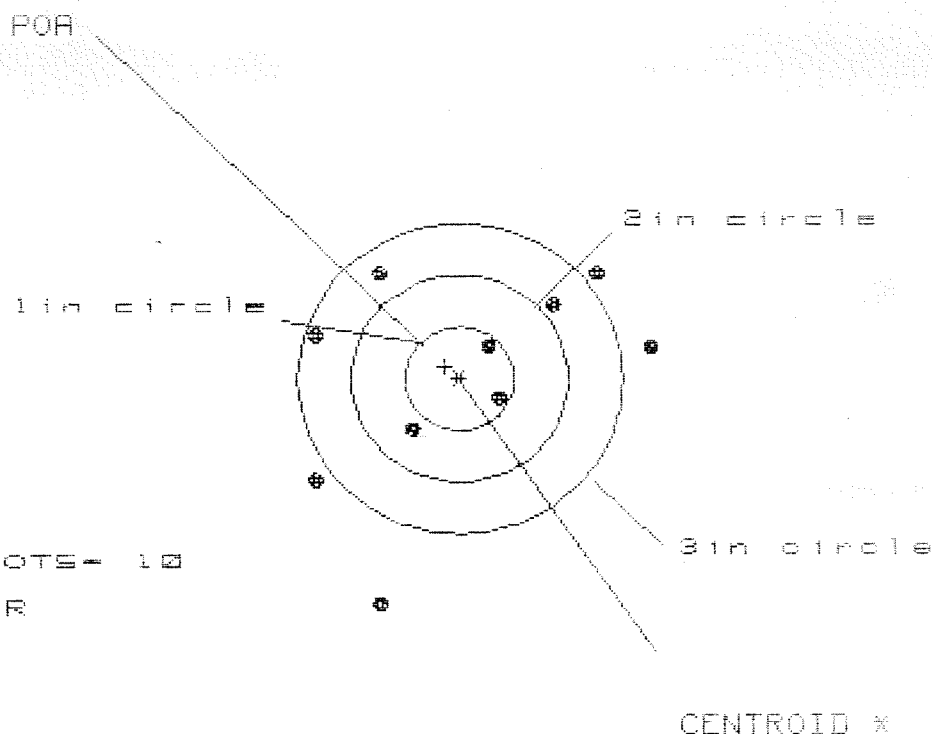
NUMBER IN THREE INCH CIRCLE =

7

20 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6811455

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 3

3 in = 6

HS = 3.118

VS = 3.197

GS = 3.795

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.792	1.705	1.389
MINIMUM X	:	-1.326	-1.413	-1.200
MAXIMUM Y	:	1.036	.796	.810
MINIMUM Y	:	-2.161	-1.224	-1.210
CENTROID X	:	.136	.223	.010
CENTROID Y	:	-.119	.121	.107
POA TO CENTROID in.	:	.181	.254	.187
MIN RADIUS	:	.369	.163	.376
MEAN RADIUS	:	1.256	1.107	1.046
MAX RADIUS	:	2.298	1.870	1.704
HORIZONTAL SPREAD	:	3.118	3.118	2.589
VERTICAL SPREAD	:	3.197	2.020	2.020
EXTREME SPREAD	:	3.795	3.393	3.284
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			3	
NUMBER IN THREE INCH CIRCLE =			6	

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FILE:/PATTERNING/CENTERFIRE_PATT/06611455

CENTERFIRE PATTERNS # 3

POB

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 2

2in = 8

3in = 10

HS= 1.415

VS= 2.514

GS= 2.606

PATTERN #

3

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.663

.696

.651

MINIMUM X

-.752

-.719

-.764

MAXIMUM Y

1.303

.611

.478

MINIMUM Y

-1.211

-1.066

-.720

CENTROID X

.105

.072

.117

CENTROID Y

-.157

-.302

-.169

POB TO CENTROID in.

.189

.311

.205

MIN RADIUS

.076

.086

.063

MEAN RADIUS

.710

.647

.562

MAX RADIUS

1.337

1.124

.951

HORIZONTAL SPREAD

1.415

1.415

1.415

VERTICAL SPREAD

2.514

1.677

1.198

EXTREME SPREAD

2.606

1.882

1.604

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

8

28 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611455

CENTERFIRE PATTERNS

4

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= 2.374

VS= 2.243

GS= 2.653

CENTROID #

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.219

1.090

.821

MINIMUM X

-1.155

-.757

-.620

MAXIMUM Y

1.198

1.288

1.253

MINIMUM Y

-1.045

-.955

-.990

CENTROID X

.138

.267

.130

CENTROID Y

-.080

-.170

-.135

POA TO CENTROID in.

.160

.316

.188

MIN RADIUS

.262

.381

.287

MEAN RADIUS

.890

.839

.780

MAX RADIUS

1.413

1.288

1.260

HORIZONTAL SPREAD

2.374

1.847

1.441

VERTICAL SPREAD

2.243

2.243

2.243

NUMBER IN ONE	INCH CIRCLE	=	2
NUMBER IN TWO	INCH CIRCLE	=	5
NUMBER IN THREE	INCH CIRCLE	=	10

20 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B11455

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 3

2in = 6

3in = 8

HS= 3.201

VS= 3.050

GS= 3.453

CENTROID #

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.083

.848

.866

MINIMUM X

-2.117

-.407

-.389

MAXIMUM Y

.959

.992

.735

MINIMUM Y

-2.091

-2.058

-1.344

CENTROID X

-.134

.101

.083

CENTROID Y

-.037

-.070

.187

POA TO CENTROID in.

.139

.123

.285

MIN RADIUS

.366

.253

.152

MEAN RADIUS

1.010

.867

.647

HORIZONTAL SPREAD :	3.201	1.255	1.255
VERTICAL SPREAD :	3.050	3.050	2.079
EXTREME SPREAD :	3.453	3.059	2.079
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	