

C6611464

MODEL 700TM M24

Model **SWS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington®



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

MODEL 700™ H24

20

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



5716 C6611464

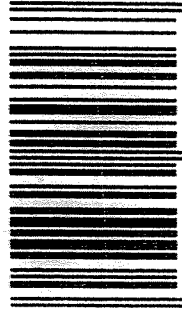
SERIAL NO.

C6611464

ORDER NO.

5716

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611464

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/12/91	K.S.
600	Proof		3/12/91	K.S.
607	Check Headspace		3/12/91	K.S.
610	Dis-assemble Gun		3/12/91	K.S.
612	Magnaflux Barrel Action		3/27/91	K.R.
	Magnaflux Bolt		11	K.R.
615	Rollmark Caliber		3/27/91	Y.S.
617	Drill and Tap Sight Holes		APR 3 1991	K.B.
618	Polish Barrel		APR 3 1991	W.B.
620	Apply Coatings (Barrel Action)		4-12-91	K.S.
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/29/91	K.S.
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/29/91	K.S.
	C) Inspect Ejector Hole for Chamfer		4/29/91	K.S.
	D) Oil Firing Pin Ass'y		4/29/91	K.S.
	E) Adjust Trigger Pull to Min Setting and Stake		5/7/91	J.F.

Op. #	Op. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5/7/91	SL
	G) Safety Off Force	4	4	4			5/7/91	SL
	H) Trigger Pull Test & Retainability						5/7/91	SL
	I) Firing Pin Indent	.0225	.022	.0225			5/7/91	SL
	J) Assemble Stock						5/7/91	KS
	K) Assemble Swivel Studs						5-12-91	D/H
	L) Attach Front and Rear Sight Assemblies						5/7/91	KS
	M) Iron Sight Alignment						5/7/91	KS
	N) Detach Front & Rear Sights & place in numbered container						5/7/91	KS
	O) Attach Scope to Rifle						5/7/91	KS
	P) Detach & Attach Scope 20 Times						5/7/91	KS
640	Gallery Target & Test						5-9-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						5-9-91	AF
655	Final Inspection							
	A) Headspace						5-12-91	D/H
	B) Trigger Pull	2.60	2.58	2.42	2.44	2.53	5/10/91	SL
	C) Function						5-12-91	D/H
660	Pack						6-18-91	AF

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

SERIAL NO. 26611464DATE 5/7/97TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.39	2.32	2.60	MIN. SETTING,
PULL #2	2.33	2.42	2.39	2.38	NO AVG. OF 5
PULL #3	2.30	2.38	2.44	2.42	READINGS ACCEPT-
PULL #4	2.37	2.43	2.40	2.44	ABLE LESS THAN 2#
PULL #5	2.36	2.34	2.40	2.53	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS	
PULL #1	3.36	3.21		
PULL #2	3.17	3.18		
PULL #3	3.28	3.20		
PULL #4	3.34	3.25		
PULL #5	3.22	3.20		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.40	4.28		4.27
PULL #2	4.31	4.25		4.26
PULL #3	4.29	4.28		4.23
PULL #4	4.28	4.26		4.23
PULL #5	4.27	4.22		4.26
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611464
9 May 1991

CENTROIDAL DISTANCES

0 TO	1	.0631506
1 TO	2	.192094
1 TO	3	.409575
1 TO	4	.149683
1 TO	5	.244377

5
3-12 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -1.94
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: 1.94
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: 1.94

THE AMR FOR THIS RIFLE IS: .9534

9 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8B11464

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 7

HS= 2.171

VS= 4.415

GS= 4.636

CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	9
MAXIMUM X	:	1.006	.884	1.006
MINIMUM X	:	-1.165	-1.287	-1.165
MAXIMUM Y	:	1.771	1.477	1.771
MINIMUM Y	:	-2.644	-1.225	-2.644
CENTROID X	:	.062	.134	.062
CENTROID Y	:	.012	.308	.012
POA TO CENTROID in.	:	.063	.357	.063
MIN RADIUS	:	.495	.177	.495
MEAN RADIUS	:	1.251	1.011	1.251
MAX RADIUS	:	2.864	1.500	2.864
HORIZONTAL SPREAD	:	2.171	2.171	2.171
VERTICAL SPREAD	:	4.415	2.702	4.415
EXTREME SPREAD	:	4.636	2.843	4.636
NUMBER IN ONE INCH CIRCLE	=	1	1	1
NUMBER IN TWO INCH CIRCLE	=	4	4	4
NUMBER IN THREE INCH CIRCLE	=	7	7	7

9 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611464

CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 2.466

VS= 2.788

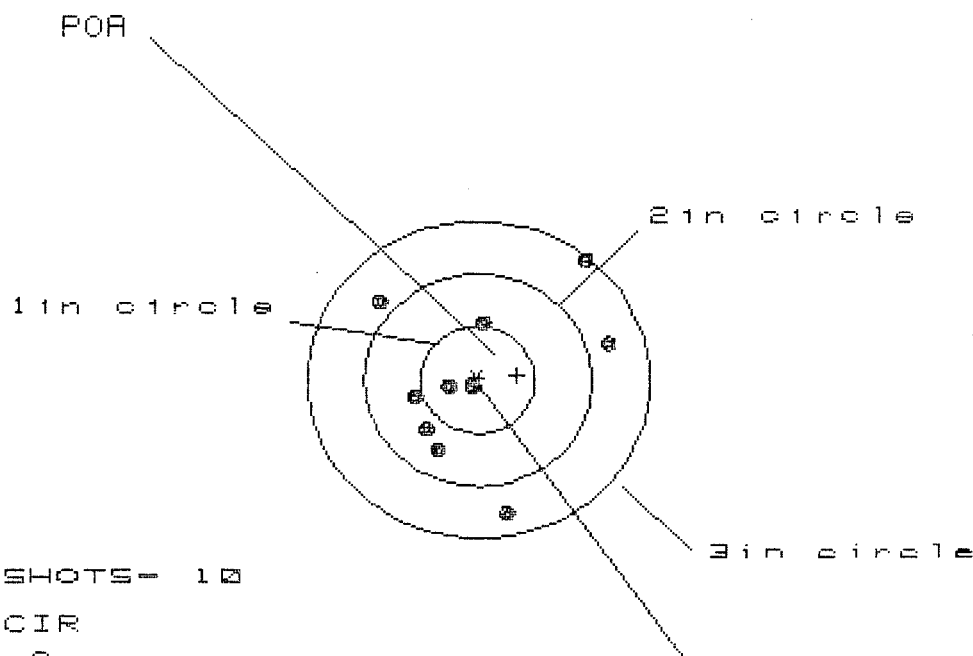
GS= 2.824

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.961	.794	.723
MINIMUM X	:	-1.505	-.996	-1.067
MAXIMUM Y	:	1.425	1.375	.977
MINIMUM Y	:	-1.363	-1.413	-1.241
CENTROID X	:	.254	.421	.444
CENTROID Y	:	.006	.057	.115
POA TO CENTROID in.	:	.254	.425	.505
MIN RADIUS	:	.311	.427	.246
MEAN RADIUS	:	.947	.858	.744
MAX RADIUS	:	1.572	1.488	1.255
HORIZONTAL SPREAD	:	2.466	1.790	1.790
VERTICAL SPREAD	:	2.788	2.788	2.110
EXTREME SPREAD	:	2.824	2.824	2.140
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

9 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611464

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.038

VS= 2.432

GS= 2.538

CENTROID #

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.149	1.259	1.306
MINIMUM X	:	-.889	-.779	-.732
MAXIMUM Y	:	1.128	.892	.745
MINIMUM Y	:	-1.304	-1.179	-.689
CENTROID X	:	-.344	-.454	-.501
CENTROID Y	:	-.042	-.167	-.020
POA TO CENTROID in.	:	.347	.484	.502
MIN RADIUS	:	.103	.091	.093
MEAN RADIUS	:	.798	.680	.611
MAX RADIUS	:	1.500	1.333	1.338
HORIZONTAL SPREAD	:	2.038	2.038	2.038
VERTICAL SPREAD	:	2.432	2.071	1.434
EXTREME SPREAD	:	2.538	2.370	2.088
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	9		

9 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611464

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 5

2 in = 6

3 in = 9

HS= 2.769

VS= 2.621

GS= 2.879

CENTROID #

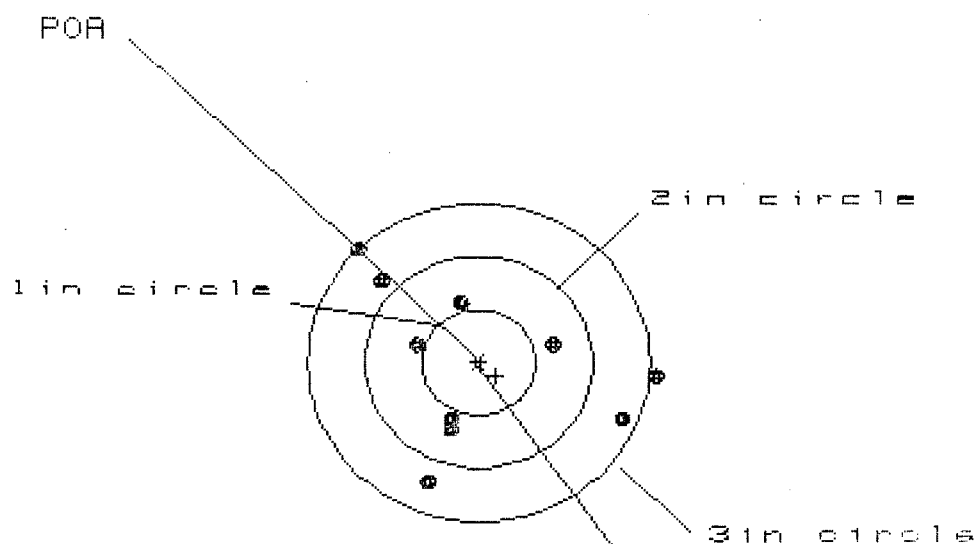
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.058	.868	.370
MINIMUM X	:	-1.711	-.506	-.504
MAXIMUM Y	:	1.327	1.241	.515
MINIMUM Y	:	-1.294	-1.380	-1.225
CENTROID X	:	.176	.366	.364
CENTROID Y	:	.109	.195	.040
POA TO CENTROID in.	:	.207	.415	.367
MIN RADIUS	:	.178	.115	.199
MEAN RADIUS	:	.788	.648	.594
MAX RADIUS	:	1.877	1.402	1.249
HORIZONTAL SPREAD	:	2.769	1.374	1.374
VERTICAL SPREAD	:	2.621	2.621	1.740
EXTREME SPREAD	:	2.879	2.634	1.743
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

9 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611464

CENTERFIRE PATTERNS

5



OF SHOTS- 10

IN CIR

1 in - 0

2 in - 5

3 in - 9

HS- 2.552

VS- 2.214

GS- 2.823

CENTROID #

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.551	1.467	1.363
MINIMUM X	-1.001	-0.828	-0.781
MAXIMUM Y	1.105	1.093	0.957
MINIMUM Y	-1.109	-1.121	-0.984
CENTROID X	-0.152	-0.325	-0.201
CENTROID Y	0.130	0.142	0.005
POA TO CENTROID in.	0.200	0.354	0.221
MIN RADIUS	0.540	0.415	0.367
MEAN RADIUS	0.983	0.894	0.790
MAX RADIUS	1.555	1.547	1.479
HORIZONTAL SPREAD	2.552	2.295	2.144
VERTICAL SPREAD	2.214	2.214	1.041
EXTREME SPREAD	2.823	2.790	2.464
NUMBER IN ONE INCH CIRCLE =	0	0	0
NUMBER IN TWO INCH CIRCLE =	5	5	5
NUMBER IN THREE INCH CIRCLE =	9	9	9