

C6611514

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



Remington		 REG. U.S. PAT. & TM. OFF.	VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700 TM M24		SERIAL NO. C6611514	ORDER NO. 5716
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off. Marca Registrada Marque Deposee.			
 5716 C6611514			

UPC



0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611514

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 25	91	RW
600	Proof	3 25	91	RW
607	Check Headspace	3 25	91	RW
610	Dis-assemble Gun	3 25	91	RW
612	Magnaflux Barrel Action	3 28	91	KR
	Magnaflux Bolt	3 28	91	Y
615	Rollmark Caliber	3 28	91	GS
617	Drill and Tap Sight Holes	APR	3 1991	LB
618	Polish Barrel	APR	3 1991	LB
620	Apply Coatings (Barrel Action)		4-11-91	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/16/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/16/91	RW
	C) Inspect Ejector Hole for Chamfer		4/16/91	RW
	D) Oil Firing Pin Ass'y		4/16/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/8/91	JP

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	5	5			5-9-91	DH
	G) Safety Off Force	4	4	4			5-9-91	DH
	H) Trigger Pull Test & Retainability						5/8/91	JM
	I) Firing Pin Indent	.021	.021	.021			5-9-91	DH
	J) Assemble Stock						5/9/91	RW
	K) Assemble Swivel Studs						5-8-91	A
	L) Attach Front and Rear Sight Assemblies						5/9/91	RW
	M) Iron Sight Alignment						5/9/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/9/91	RW
	O) Attach Scope to Rifle						5/9/91	RW
	P) Detach & Attach Scope 20 Times						5/9/91	RW
640	Gallery Target & Test						5-11-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						5-11-91	AF
655	Final Inspection							
	A) Headspace						5-18-91	A
	B) Trigger Pull	2.47	2.44	2.34	2.45	2.44	5/13/91	JM
	C) Function						5-18-91	AC
660	Pack						6-18-91	AF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6611514

DATE 5/8/90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & 13 TO RESET 2.50#		COMMENTS
PULL #1	2.36	2.27	2.20	2.47	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.27	2.31	2.25	2.44	
PULL #3	2.24	2.28	2.29	2.34	
PULL #4	2.34	2.30	2.31	2.45	
PULL #5	2.30	2.25	2.31	2.44	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.39	3.56		
PULL #2	3.59	3.57		
PULL #3	3.44	3.60		
PULL #4	3.41	3.55		
PULL #5	3.52	3.60		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.36		4.38
PULL #2	4.35	4.17		4.29
PULL #3	4.23	4.27		4.30
PULL #4	4.24	4.21		4.28
PULL #5	4.20	4.36		4.30
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611514
11 May 1991

CENTROIDAL DISTANCES

0 TO	1	.169446
1 TO	2	.35805
1 TO	3	.131217
1 TO	4	.0955249
1 TO	5	.236163

 <----POA

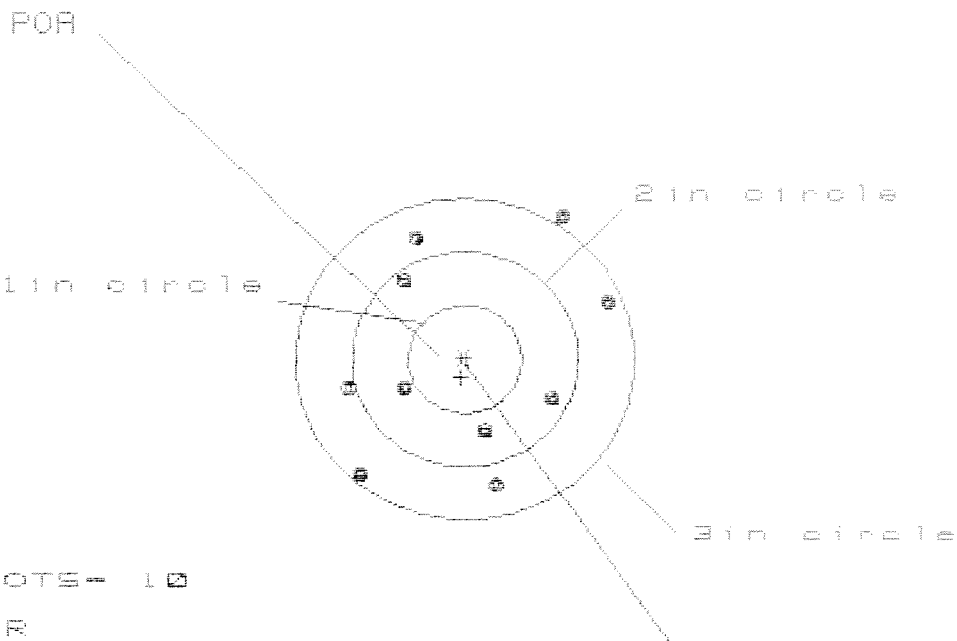
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .03
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0244
THE RESULTING AVERAGE POI RANGE FOR THIS RIFLE IS: .0386699

THE LAMP FOR THIS RIFLE IS: 1.006

11 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06611514

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 0

2in = 4

3in = 9

HS = 2.289

VS = 2.456

GS = 2.974

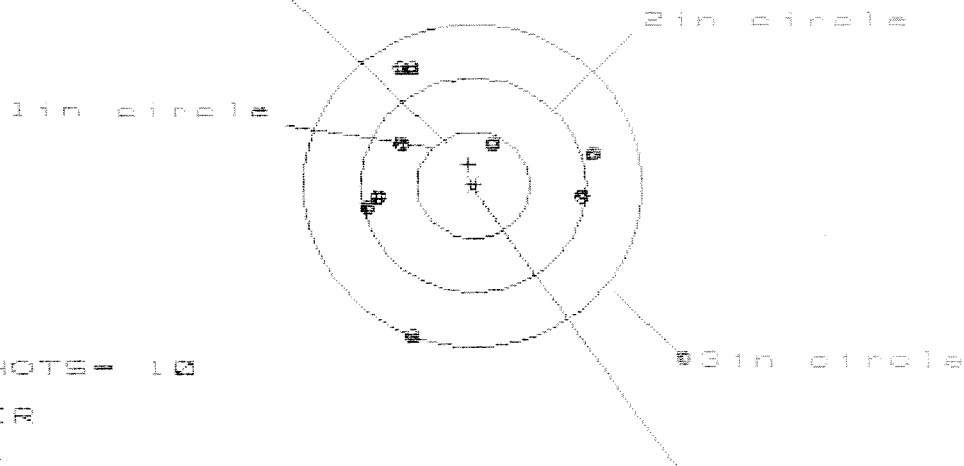
PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.258	1.357	1.254
MINIMUM X	:	-1.031	-.932	-1.036
MAXIMUM Y	:	1.288	1.271	1.156
MINIMUM Y	:	-1.168	-1.025	-1.140
CENTROID X	:	.034	-.065	.038
CENTROID Y	:	.166	.022	.137
POA TO CENTROID in.	:	.169	.069	.142
MIN RADIUS	:	.545	.406	.529
MEAN RADIUS	:	1.081	.998	.976
MAX RADIUS	:	1.568	1.534	1.389
HORIZONTAL SPREAD	:	2.289	2.289	2.289
VERTICAL SPREAD	:	2.456	2.296	2.296
EXTREME SPREAD	:	2.974	2.730	2.442
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

11 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611514

CENTERFIRE PATTERNS # 2

POA



OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 9

HS= 2.784

VS= 2.898

GS= 3.895

CENTROID *

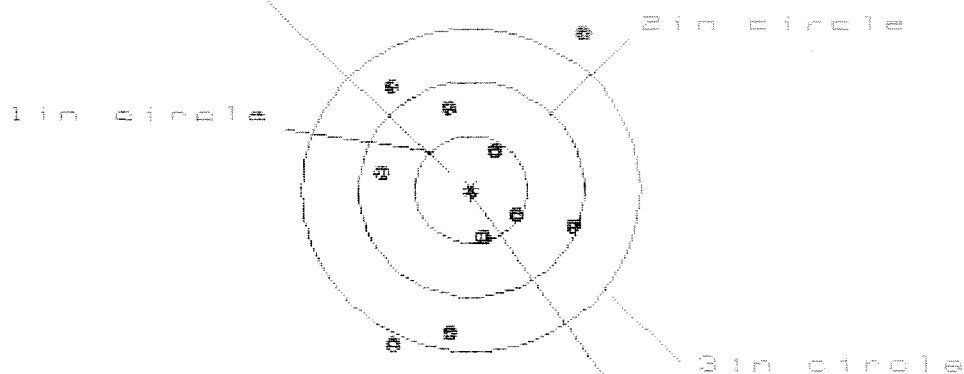
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.890	1.225	1.187
MINIMUM X	:	-.894	-.684	-.722
MAXIMUM Y	:	1.137	.963	.765
MINIMUM Y	:	-1.561	-1.581	-.543
CENTROID X	:	.040	-.170	-.132
CENTROID Y	:	-.192	-.018	.179
POA TO CENTROID in.	:	.196	.171	.223
MIN RADIUS	:	.441	.410	.290
MEAN RADIUS	:	1.145	.937	.825
MAX RADIUS	:	2.451	1.610	1.277
HORIZONTAL SPREAD	:	2.784	1.909	1.909
VERTICAL SPREAD	:	2.698	2.544	1.309
EXTREME SPREAD	:	3.695	2.544	2.079
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

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FILE:/PATTERNING/CENTERFIRE_PATT/06611514

CENTERFIRE PATTERNS # 3

POA



OF SHOTS= 10

IN CIR

1in = 3

2in = 6

3in = 8

HE= 1.843

VS= 2.898

GS= 3.386

CENTROID #

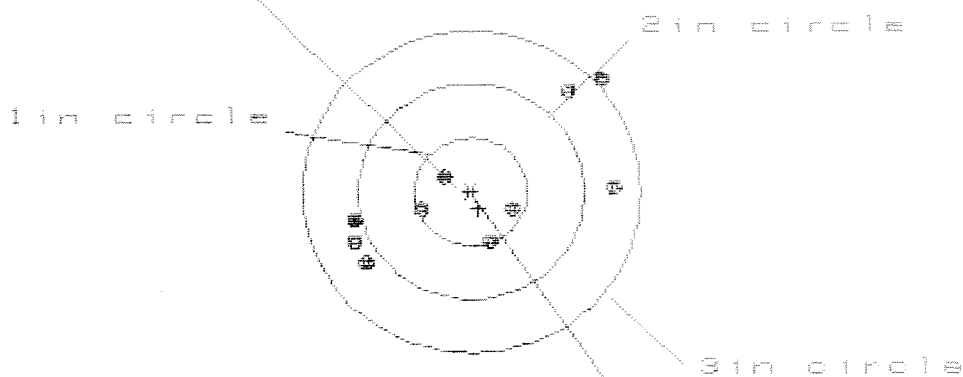
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.846	1.843	.969
MINIMUM X	:	-.797	-.680	-.754
MAXIMUM Y	:	1.488	1.145	.989
MINIMUM Y	:	-1.410	-1.244	-1.318
CENTROID X	:	.001	-.116	-.042
CENTROID Y	:	.039	-.127	.029
POA TO CENTROID in.	:	.039	.171	.051
MIN RADIUS	:	.420	.308	.419
MEAN RADIUS	:	.981	.887	.805
MAX RADIUS	:	1.819	1.377	1.327
HORIZONTAL SPREAD	:	1.843	1.723	1.723
VERTICAL SPREAD	:	2.898	2.389	2.307
EXTREME SPREAD	:	3.386	2.389	2.372
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 4

POA



OF SHOTS= 10

IN CIR

1in = 3

2in = 4

3in = 9

HS= 2.257

VS= 1.688

GS= 2.741

CENTROID #

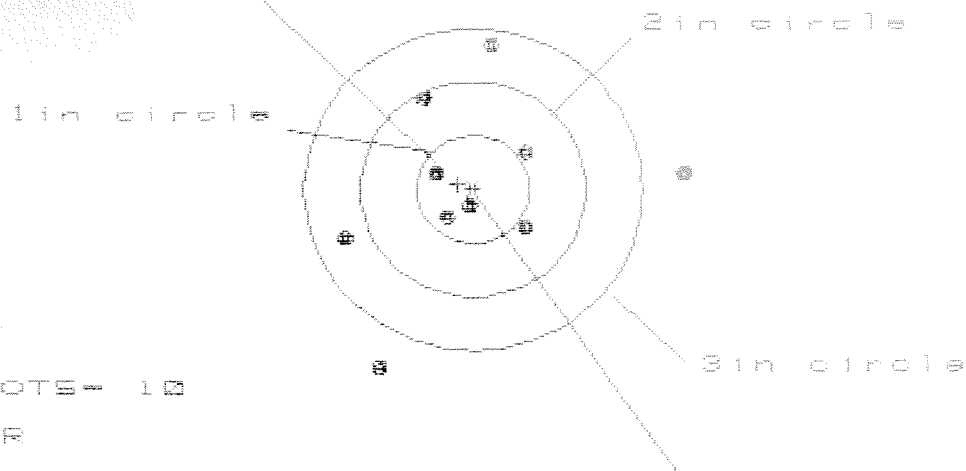
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.213	1.345	1.465
MINIMUM X	:	-1.044	-.912	-.792
MAXIMUM Y	:	1.047	1.065	.365
MINIMUM Y	:	-.641	-.525	-.392
CENTROID X	:	-.061	-.193	-.313
CENTROID Y	:	.156	.040	-.093
POA TO CENTROID in.	:	.167	.197	.327
MIN RADIUS	:	.309	.278	.208
MEAN RADIUS	:	.907	.797	.694
MAX RADIUS	:	1.588	1.433	1.498
HORIZONTAL SPREAD	:	2.257	2.257	2.257
VERTICAL SPREAD	:	1.688	1.590	.757
EXTREME SPREAD	:	2.741	2.395	2.290
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

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FILE:/PATTERNING/CENTERFIRE_PATT/CBB11514

CENTERFIRE PATTERNS # 5

POA



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 6

3 in = 8

HS = 2.927

VS = 2.985

GS = 3.175

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.817	.692	.615
MINIMUM X	:	-1.110	-.908	-.985
MAXIMUM Y	:	1.366	1.384	1.183
MINIMUM Y	:	-1.619	-1.601	-.593
CENTROID X	:	.136	-.066	.011
CENTROID Y	:	-.047	-.065	.135
POA TO CENTROID in.	:	.144	.092	.136
MIN RADIUS	:	.154	.232	.223
MEAN RADIUS	:	.918	.807	.694
MAX RADIUS	:	1.823	1.715	1.224
HORIZONTAL SPREAD	:	2.927	1.600	1.600
VERTICAL SPREAD	:	2.985	2.985	1.776
EXTREME SPREAD	:	3.175	3.149	2.199
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	