

C6611520

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington



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

MODEL 700™ H24

SERIAL NO.
C6611520

ORDER NO.
5716

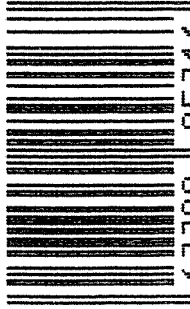
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



5716 C6611520

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611520

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	cr
615	Rollmark Caliber	3 28	91	LS
617	Drill and Tap Sight Holes	APR	3 1991	FB
618	Polish Barrel	APR	3 1991	WB
620	Apply Coatings (Barrel Action)		4-11-91	TJH
	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	SH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5-9-91	A
	G) Safety Off Force	3	2	3			5-9-91	A
	H) Trigger Pull Test & Retainability						5/8/91	JK
	I) Firing Pin Indent	.022	.021	.022			5-9-91	AC
	J) Assemble Stock						5/9/91	RW
	K) Assemble Swivel Studs						5-18-91	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	261	261	257	2155	261	5/13/91	JK
	C) Function						5-18-91	A
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. 26611520

DATE 5/8/91

TESTER JA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.20	2.46	2.50	2.61	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.25	2.49	2.46	2.61	
PULL #3	2.23	2.54	2.40	2.57	
PULL #4	2.42	2.48	2.40	2.55	
PULL #5	2.49	2.48	2.47	2.61	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.46	3.41		
PULL #2	3.39	3.32		
PULL #3	3.19	3.41		
PULL #4	3.40	3.38		
PULL #5	3.38	3.43		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.39	4.38		4.41
PULL #2	4.24	4.15		4.38
PULL #3	4.36	4.40		4.43
PULL #4	4.40	4.43		4.44
PULL #5	4.40	4.42		4.40
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611520
11 May 1991

CENTROIDAL DISTANCES

0 TO	1	.213216
1 TO	2	.244086
1 TO	3	.136488
1 TO	4	.242786
1 TO	5	.132382

4' <----POA

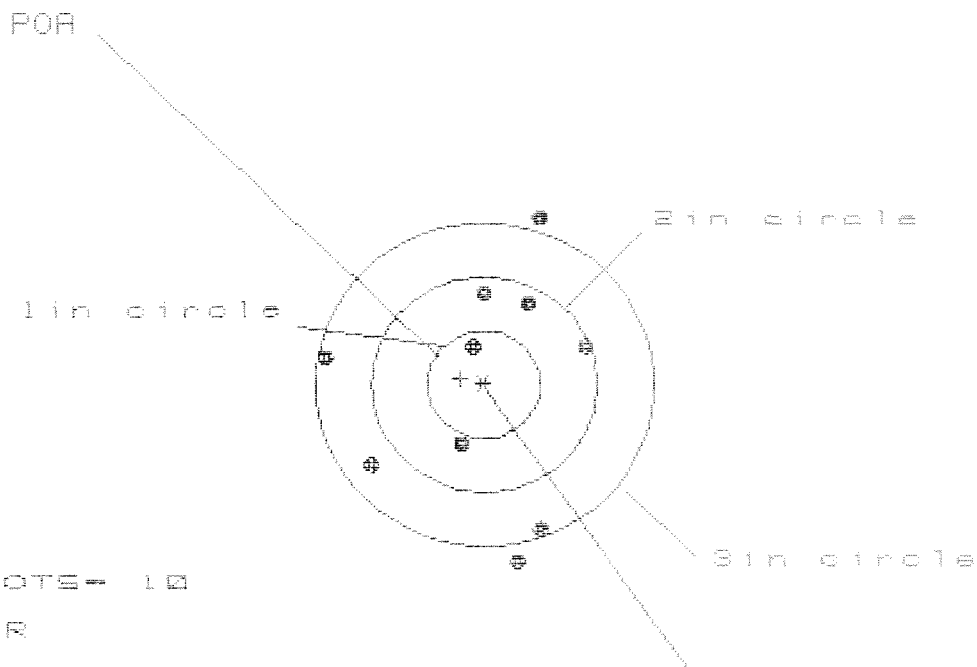
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1406
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0454
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .147748

THE AMR FOR THIS RIFLE IS: .9972

11 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611520

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS= 2.336

VS= 3.192

GS= 3.198

CENTROID *

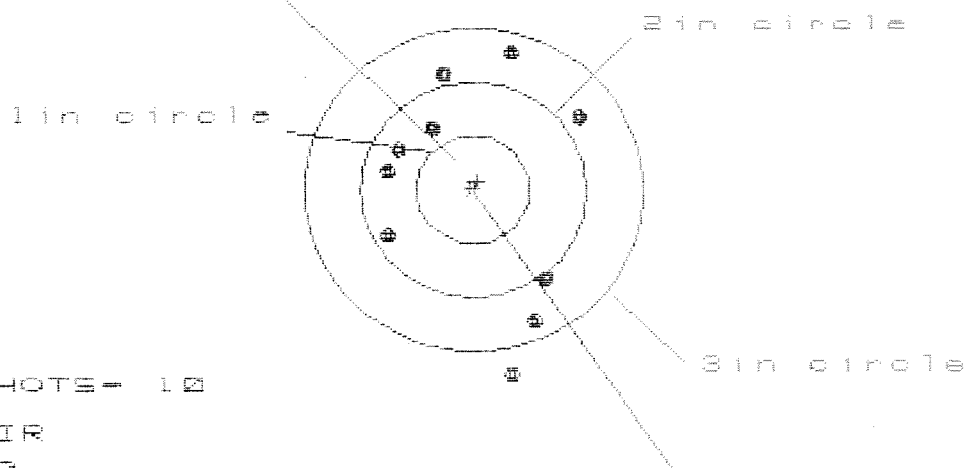
PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.928	.984	1.031
MINIMUM X	:	-1.408	-1.352	-1.305
MAXIMUM Y	:	1.593	1.059	.881
MINIMUM Y	:	-1.599	-1.422	-1.316
CENTROID X	:	.206	.150	.103
CENTROID Y	:	-.055	-.232	-.054
POA TO CENTROID in.	:	.213	.276	.116
MIN RADIUS	:	.401	.406	.396
MEAN RADIUS	:	1.113	1.052	.976
MAX RADIUS	:	1.672	1.470	1.459
HORIZONTAL SPREAD	:	2.336	2.336	2.336
VERTICAL SPREAD	:	3.192	2.481	2.197
EXTREME SPREAD	:	3.198	2.548	2.504
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 2

POA



OF SHOTS- 10

IN CIR

1in = 0

2in = 5

3in = 9

HS= 1.742

VS= 2.924

GS= 2.924

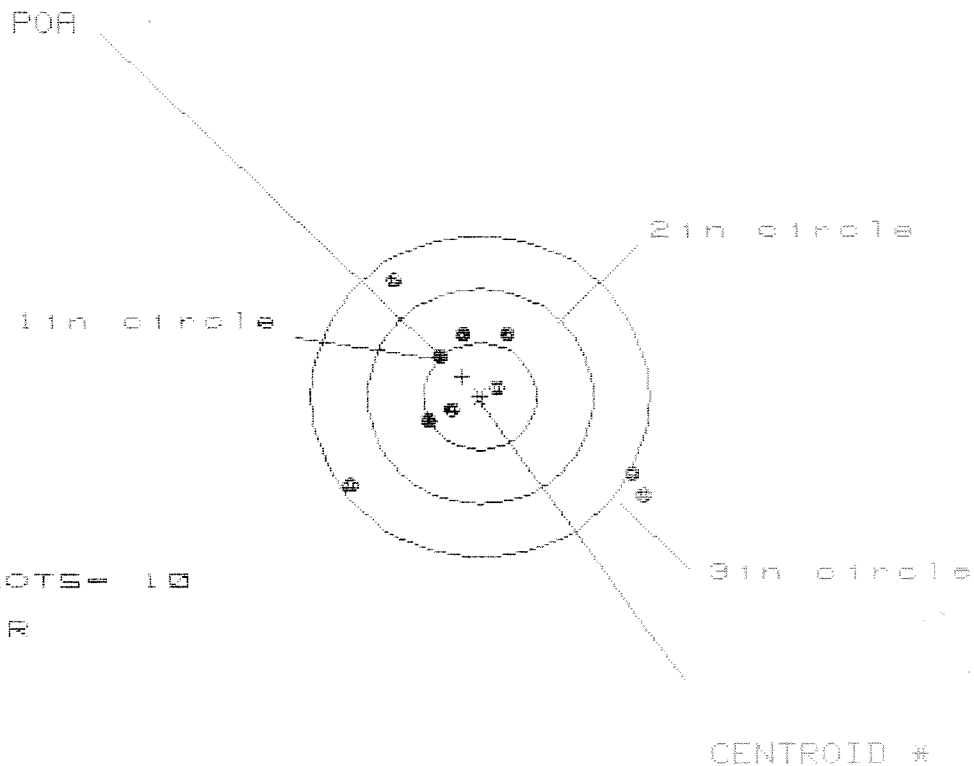
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.969	1.004	1.075
MINIMUM X	:	-.773	-.738	-.667
MAXIMUM Y	:	1.242	1.056	.884
MINIMUM Y	:	-1.681	-1.374	-1.147
CENTROID X	:	-.037	-.072	-.143
CENTROID Y	:	-.078	.108	.280
POA TO CENTROID in.	:	.087	.130	.314
MIN RADIUS	:	.661	.489	.317
MEAN RADIUS	:	1.065	.958	.846
MAX RADIUS	:	1.711	1.488	1.348
HORIZONTAL SPREAD	:	1.742	1.742	1.742
VERTICAL SPREAD	:	2.924	2.430	2.031
EXTREME SPREAD	:	2.924	2.438	2.090
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 2.546

VS= 2.024

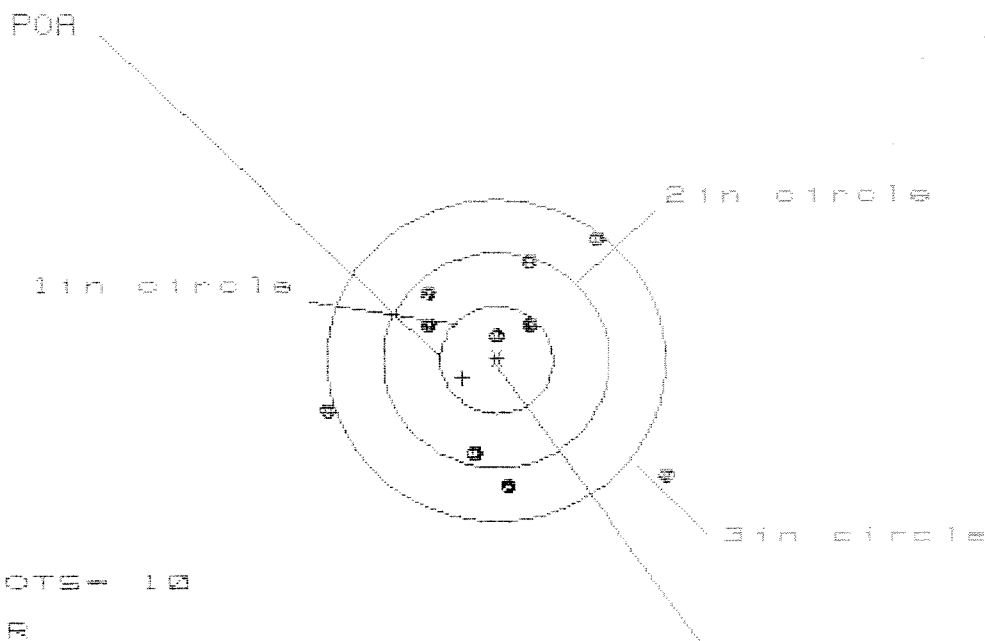
GS= 3.029

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.477	1.515	.577
MINIMUM X	:	-1.169	-1.005	-.816
MAXIMUM Y	:	1.114	1.013	.912
MINIMUM Y	:	-.910	-.878	-.979
CENTROID X	:	.156	-.008	-.197
CENTROID Y	:	-.182	-.081	.020
POA TO CENTROID in.	:	.240	.081	.198
MIN RADIUS	:	.157	.258	.179
MEAN RADIUS	:	.871	.736	.602
MAX RADIUS	:	1.734	1.718	1.274
HORIZONTAL SPREAD	:	2.646	2.520	1.393
VERTICAL SPREAD	:	2.024	1.891	1.891
EXTREME SPREAD	:	3.029	2.802	1.954
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.992

VS= 2.322

GS= 3.058

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.463	1.018	.847
MINIMUM X	:	-1.529	-1.366	-.629
MAXIMUM Y	:	1.178	1.060	.991
MINIMUM Y	:	-1.144	-1.262	-1.331
CENTROID X	:	.302	.139	.310
CENTROID Y	:	.168	.286	.355
POA TO CENTROID in.	:	.345	.318	.472
MIN RADIUS	:	.214	.167	.041
MEAN RADIUS	:	1.007	.885	.781
MAX RADIUS	:	1.812	1.473	1.332
HORIZONTAL SPREAD	:	2.992	2.384	1.476
VERTICAL SPREAD	:	2.322	2.322	2.322
EXTREME SPREAD	:	3.058	2.878	2.456
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.276

VS= 2.625

GS= 3.058

CENTROID *

PATTERN #

5

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.149	1.054	1.028
MINIMUM X	:	-1.127	-1.222	-1.090
MAXIMUM Y	:	1.419	.662	.571
MINIMUM Y	:	-1.206	-1.049	-1.140
CENTROID X	:	.076	.172	.040
CENTROID Y	:	-.080	-.237	-.146
POA TO CENTROID in.	:	.111	.293	.152
MIN RADIUS	:	.321	.339	.250
MEAN RADIUS	:	.930	.845	.774
MAX RADIUS	:	1.659	1.375	1.310
HORIZONTAL SPREAD	:	2.276	2.276	2.118
VERTICAL SPREAD	:	2.625	1.711	1.711
EXTREME SPREAD	:	3.058	2.651	2.151
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			9	