

C6611523

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

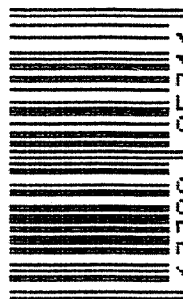


Remington®  REG. U.S. PAT. & TM. OFF.		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700™ H24		SERIAL NO. C6611523
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.		ORDER NO. 5716



5716 C6611523

UPC



0 47700 25716 7

MOD. _____ GA. CAL. _____ GUN # 1523

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
KT	1st	Case Scratched/ bad	KS
	4/19		
	2nd	Repaired at Custom Shop	4/7/91
	3rd		
		20 Rd 5.56	5.56
	4th	48-31	
5/8/91		NEW MAG BOX	KS
		FUNCTION	RD 6634 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

DON'T SAY IT - WRITE IT

To: _____

Date: _____

From: _____

Needs new stock
**NEW STOCK HAS BEEN
REPLACED
K.S. 5-9-91**

ARM YOURSELF WITH SAFETY - IT WILL TRIGGER LIFETIME REWARDS

Forms From Farnsworth 1-800-451-1555

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611523

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	3/26/91	K.S.
600	Proof		3/26/91	K.S.
607	Check Headspace		3/26/91	K.S.
610	Dis-assemble Gun		3/26/91	K.S.
612	Magnaflux Barrel Action	APR	2 1991	KR
	Magnaflux Bolt	APR	2 1991	KR
615	Rollmark Caliber	APR	2 1991	GL
617	Drill and Tap Sight Holes	APR	5 1991	LB
618	Polish Barrel	APR	5 1991	WB
620	Apply Coatings (Barrel Action)		4-10-91	AS
	Apply Coating (Bolt)			
625	Final Assembly		4/10/91	KS
	A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/10/91	KS
	C) Inspect Ejector Hole for Chamfer		4/10/91	KS
	D) Oil Firing Pin Ass'y		4/10/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		4/15/91	SL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			4/15/91	SM
	G) Safety Off Force	3	3	3			4/15/91	SM
	H) Trigger Pull Test & Retainability						4/15/91	SM
	I) Firing Pin Indent	022	022	022			4/15/91	SM
	J) Assemble Stock						4/18/91	KS
	K) Assemble Swivel Studs						5-14-91	17/8
	L) Attach Front and Rear Sight Assemblies						4/18/91	KS
	M) Iron Sight Alignment						4/18/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/18/91	KS
	O) Attach Scope to Rifle						4/18/91	KS
	P) Detach & Attach Scope 20 Times						4/18/91	KS
640	Gallery Target & Test						4/19/91	KS
	A) Time							KS
	B) Malfunctions							KS
	C) Pierced Primers							KS
	D) Optical Clarity of Scope							KS
645	Inspect for Live Ammo						4/19/91	KS
655	Final Inspection							
	A) Headspace						5-14-91	DH
	B) Trigger Pull	2.24	2.15	2.17	2.19	2.20	4/22/91	SM
	C) Function						5-14-91	DH
660	Pack						6-14-91	NF

SWS TRIGGER PULL TEST

TIK

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. C-6611523 252

DATE 4/15/91

TESTER [Signature]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.37	2.32	2.24	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.42	2.34	2.30	2.15	
PULL #3	2.35	2.33	2.33	2.17	
PULL #4	2.38	2.28	2.22	2.19	
PULL #5	2.38	2.32	2.35	2.20	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.47	3.48		
PULL #2	3.43	3.45		
PULL #3	3.45	3.43		
PULL #4	3.48	3.46		
PULL #5	3.54	3.38		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.35	4.32		4.29
PULL #2	4.29	4.34		4.43
PULL #3	4.31	4.29		4.26
PULL #4	4.29	4.34		4.40
PULL #5	4.30	4.20		4.23
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611523
19 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.0527731
1 TO	2	.409826
1 TO	3	.207196
1 TO	4	.274323
1 TO	5	.216566

2.5' ← POA

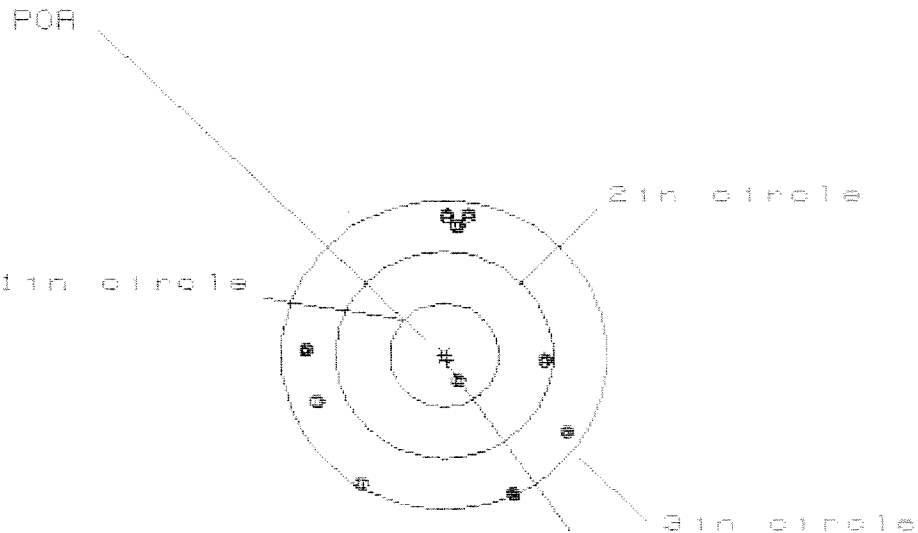
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0042
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0426
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0428065

THE AMR FOR THIS RIFLE IS: 1.103

19 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611523

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 2

3in = 10

HS= 2.397

VS= 2.679

GS= 2.779

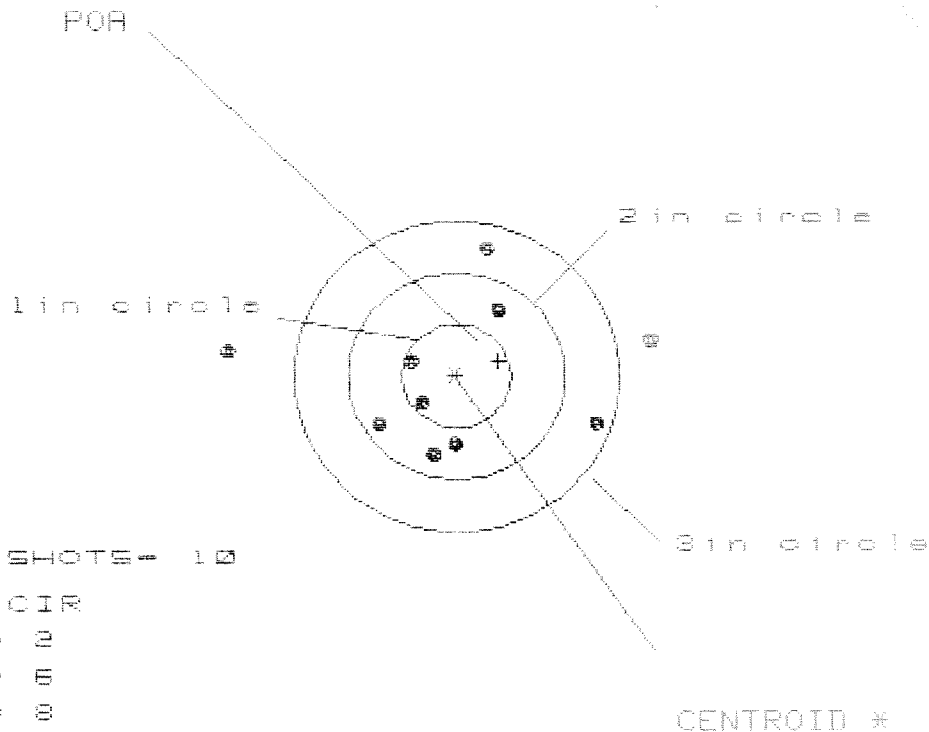
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.148	1.212	1.127
MINIMUM X	:	-1.257	-1.185	-1.270
MAXIMUM Y	:	1.371	1.226	1.055
MINIMUM Y	:	-1.308	-1.361	-1.052
CENTROID X	:	-.024	-.096	-.011
CENTROID Y	:	.047	.192	.363
POR TO CENTROID in.	:	.053	.215	.363
MIN RADIUS	:	.271	.433	.573
MEAN RADIUS	:	1.196	1.167	1.108
MAX RADIUS	:	1.460	1.524	1.541
HORIZONTAL SPREAD	:	2.397	2.397	2.397
VERTICAL SPREAD	:	2.679	2.587	2.107
EXTREME SPREAD	:	2.779	2.779	2.512
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		10	

19 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611523

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 2

2in = 6

3in = 8

HS = 3.865

VS = 2.032

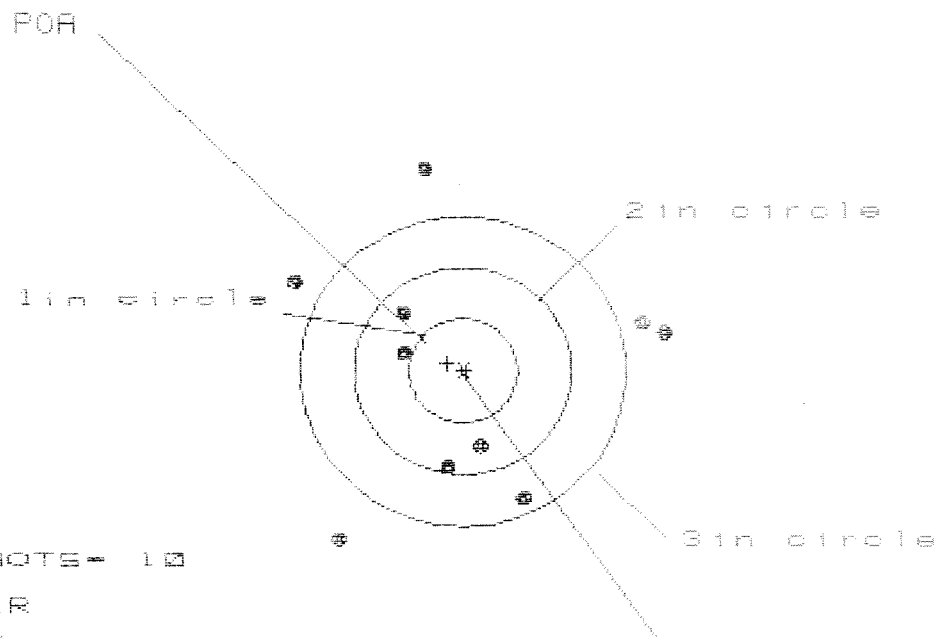
GS = 3.869

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.764	1.531	1.254
MINIMUM X	:	-2.101	-.921	-.730
MAXIMUM Y	:	1.270	1.292	1.342
MINIMUM Y	:	-.762	-.740	-.690
CENTROID X	:	-.385	-.152	-.343
CENTROID Y	:	-.147	-.169	-.219
POA TO CENTROID in.	:	.412	.227	.407
MIN RADIUS	:	.382	.614	.430
MEAN RADIUS	:	1.044	.947	.813
MAX RADIUS	:	2.110	1.583	1.366
HORIZONTAL SPREAD	:	3.865	2.452	1.984
VERTICAL SPREAD	:	2.032	2.032	2.032
EXTREME SPREAD	:	3.869	2.577	2.100
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

19 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06611523

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 0

2in = 4

3in = 5

HS = 3.393

VS = 3.537

GS = 3.645

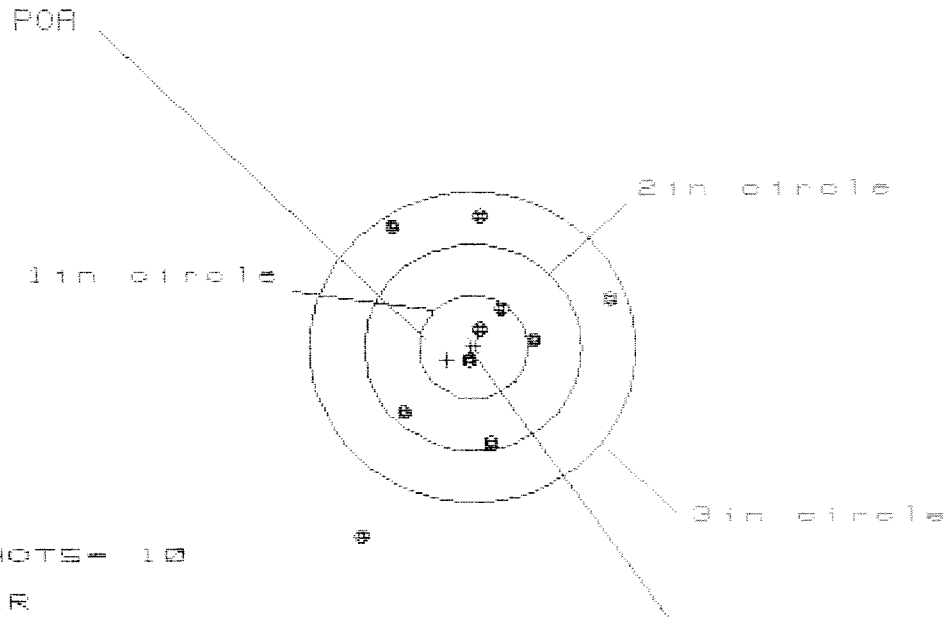
CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.854	1.723	1.661
MINIMUM X	-1.539	-1.670	-1.732
MAXIMUM Y	1.920	1.740	.945
MINIMUM Y	-1.617	-1.455	-1.237
CENTROID X	.147	.278	.340
CENTROID Y	-.070	.110	-.108
POA TO CENTROID in.	.163	.299	.357
MIN RADIUS	.548	.661	.660
MEAN RADIUS	1.383	1.330	1.240
MAX RADIUS	2.000	1.821	1.973
HORIZONTAL SPREAD	3.393	3.393	3.393
VERTICAL SPREAD	3.537	3.195	2.182
EXTREME SPREAD	3.645	3.429	3.429
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		5	

19 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611523

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 5

2 in = 5

3 in = 0

IM = N.W.40

VM = 0.0000

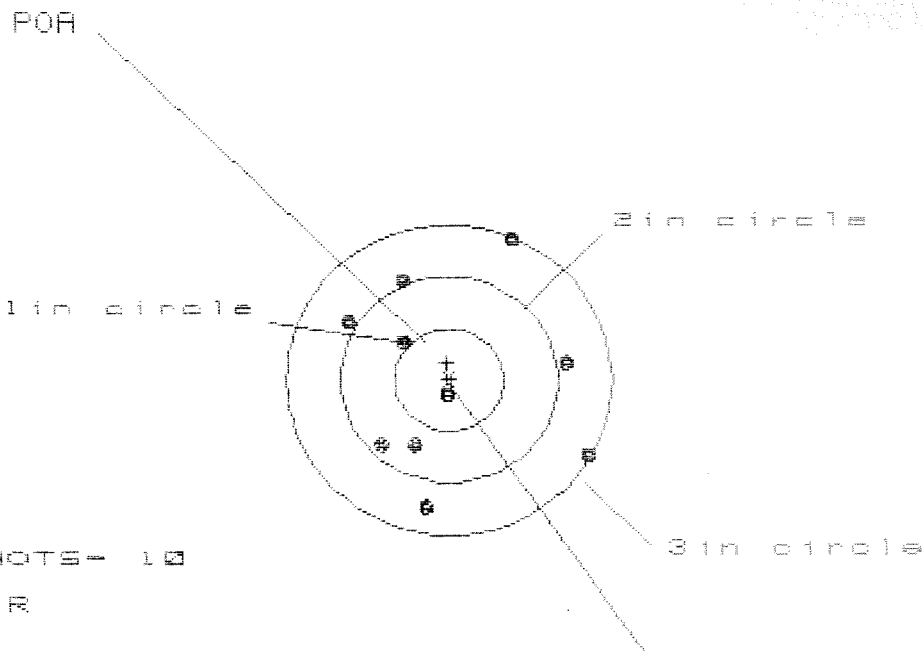
GM = 0.2442

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.303	1.188	1.085
MINIMUM X	:	-1.037	-.820	-.871
MAXIMUM Y	:	1.232	1.031	1.154
MINIMUM Y	:	-1.006	-1.172	-1.049
CENTROID X	:	.239	.354	.457
CENTROID Y	:	.125	.326	.203
POA TO CENTROID in.	:	.270	.482	.500
MIN RADIUS	:	.136	.100	.238
MEAN RADIUS	:	.931	.771	.706
MAX RADIUS	:	2.083	1.279	1.160
HORIZONTAL SPREAD	:	2.340	2.008	1.956
VERTICAL SPREAD	:	3.038	2.203	2.203
EXTREME SPREAD	:	3.242	2.333	2.221
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

19 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08611523

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 10

HS= 2.258

VS= 2.540

GS= 2.639

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.296	1.182	1.267
MINIMUM X	-.962	-.818	-.733
MAXIMUM Y	1.320	1.243	1.044
MINIMUM Y	-1.220	-1.297	-1.141
CENTROID X	.022	-.122	-.207
CENTROID Y	-.168	-.091	-.247
POA TO CENTROID in.	.169	.152	.322
MIN RADIUS	.155	.271	.237
MEAN RADIUS	.962	.892	.804
MAX RADIUS	1.466	1.416	1.282
HORIZONTAL SPREAD	2.258	2.000	2.000
VERTICAL SPREAD	2.540	2.540	2.185
EXTREME SPREAD	2.639	2.639	2.203
NUMBER IN ONE INCH CIRCLE	= 1		
NUMBER IN TWO INCH CIRCLE	= 4		
NUMBER IN THREE INCH CIRCLE	= 10		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06611523
11 May 1991

CENTROIDAL DISTANCES

0 TO 1	.120603
1 TO 2	.71507
1 TO 3	.221274
1 TO 4	.102318
1 TO 5	.215084

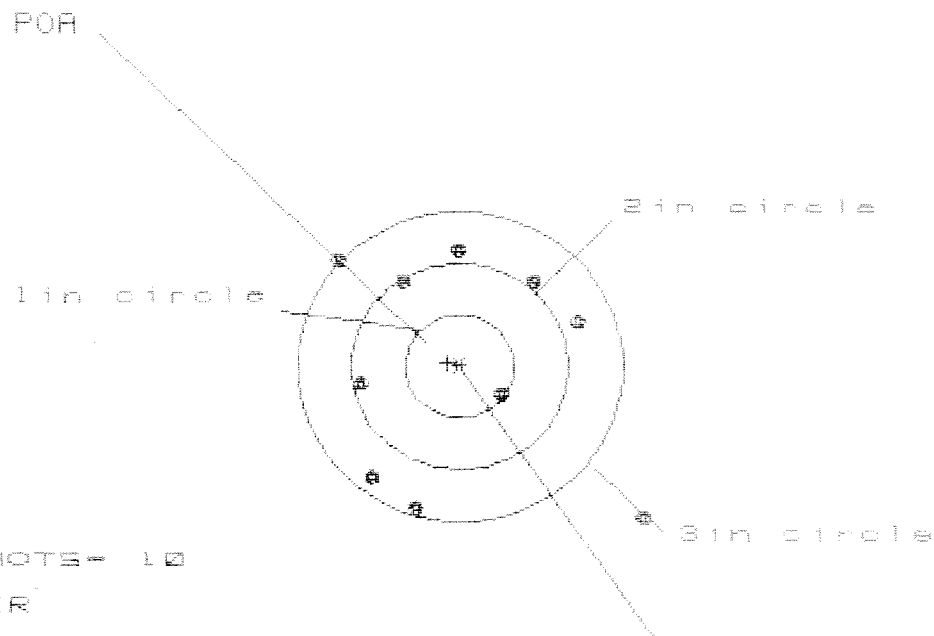
2 4 <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0638
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0818
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .103739
THE AMR FOR THIS RIFLE IS: 1.083

11 May 1931

FILE:/PATTERNING/CENTERFIRE_PATT/C8611523.1

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 3

3 in = 8

HS= 2.823

VS= 2.595

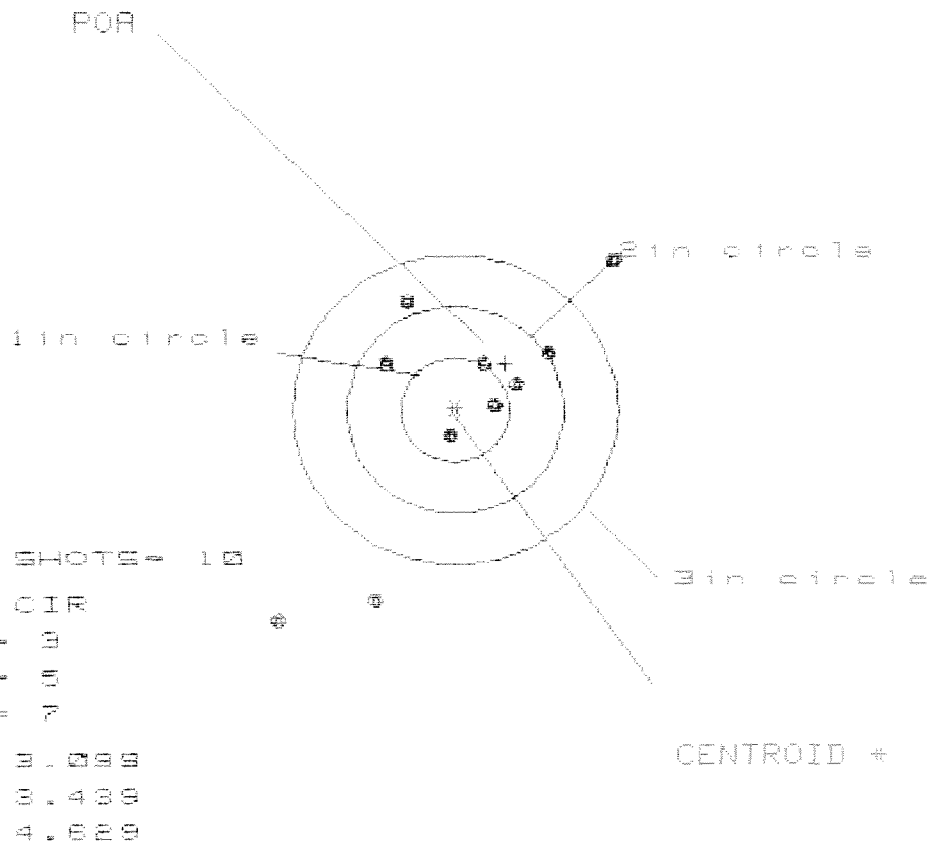
GS= 3.816

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.677	1.284	1.164
MINIMUM X	-1.146	-.960	-.826
MAXIMUM Y	1.091	.923	1.036
MINIMUM Y	-1.504	-1.539	-1.426
CENTROID X	.116	-.070	.058
CENTROID Y	-.033	.135	.023
POA TO CENTROID in.	.121	.152	.055
MIN RADIUS	.433	.683	.519
MEAN RADIUS	1.229	1.090	1.056
MAX RADIUS	2.253	1.558	1.472
HORIZONTAL SPREAD	2.823	2.244	1.990
VERTICAL SPREAD	2.595	2.462	2.462
EXTREME SPREAD	3.816	2.538	2.518
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	8		

11 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611523.1

CENTERFIRE PATTERNS # 2

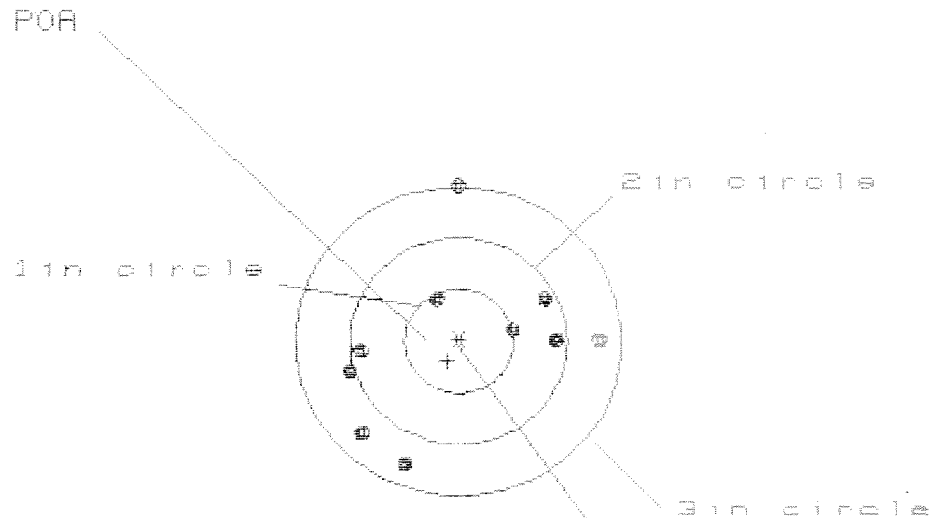


PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.439	1.254	.844
MINIMUM X	:	-1.660	-.873	-.716
MAXIMUM Y	:	1.437	1.215	.977
MINIMUM Y	:	-2.002	-2.093	-1.941
CENTROID X	:	-.462	-.277	-.434
CENTROID Y	:	-.454	-.232	-.384
POA TO CENTROID in.	:	.648	.362	.580
MIN RADIUS	:	.287	.214	.322
MEAN RADIUS	:	1.126	.891	.812
MAX RADIUS	:	2.601	2.268	2.069
HORIZONTAL SPREAD	:	3.099	2.127	1.560
VERTICAL SPREAD	:	3.439	3.308	2.918
EXTREME SPREAD	:	4.629	3.933	2.927
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

11 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611523.1

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 2.300

VS= 2.675

GS= 2.730

CENTROID X

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.319	1.319	1.108
MINIMUM X	-.981	-.981	-.816
MAXIMUM Y	1.501	.595	.612
MINIMUM Y	-1.174	-1.007	-.990
CENTROID X	.105	.105	-.060
CENTROID Y	.188	.021	.004
POA TO CENTROID in.	.215	.107	.060
MIN RADIUS	.493	.559	.617
MEAN RADIUS	1.013	.962	.904
MAX RADIUS	1.501	1.326	1.132
HORIZONTAL SPREAD	2.300	2.300	1.924
VERTICAL SPREAD	2.675	1.002	1.602
EXTREME SPREAD	2.730	2.421	2.162
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

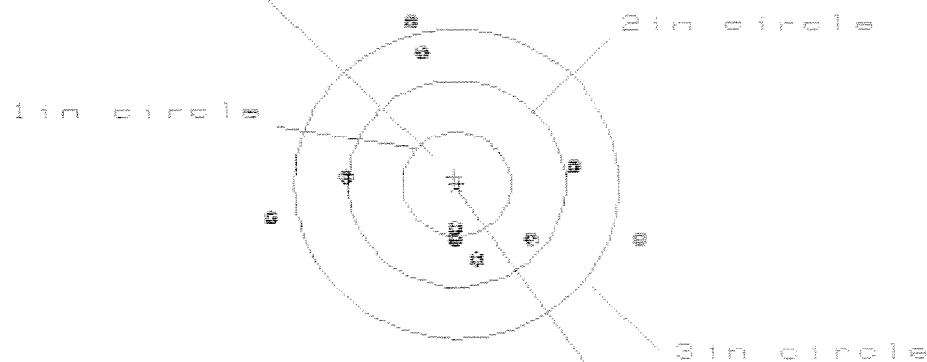
11 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611523.1

CENTERFIRE PATTERNS

4

POA



OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 7

HS= 3.426

VS= 2.262

GS= 3.436

CENTROID *

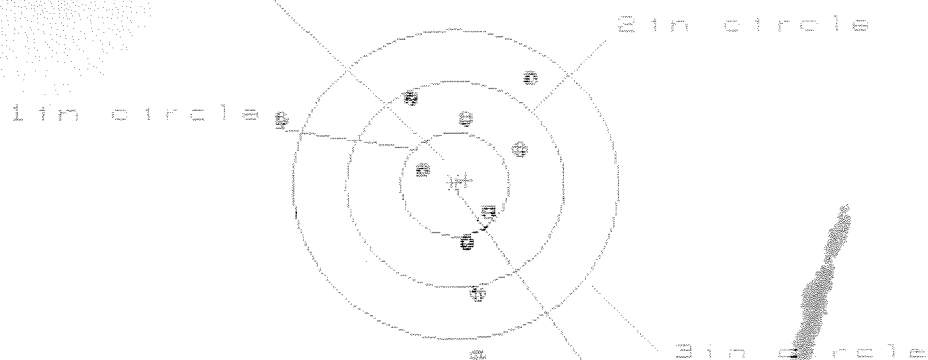
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.670	1.475	1.044
MINIMUM X	-1.756	-1.261	-1.077
MAXIMUM Y	1.581	1.547	1.470
MINIMUM Y	-.681	-.715	-.791
CENTROID X	.021	.216	.032
CENTROID Y	-.071	-.037	.040
POA TO CENTROID in.	.074	.219	.051
MIN RADIUS	.404	.479	.515
MEAN RADIUS	1.109	1.025	.963
MAX RADIUS	1.783	1.677	1.542
HORIZONTAL SPREAD	3.426	2.736	2.121
VERTICAL SPREAD	2.262	2.262	2.262
EXTREME SPREAD	3.436	3.025	2.380
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

11 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611523.1

CENTERFIRE PATTERNS # 5

POA



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.278

VS= 2.689

GS= 2.944

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.697	.522	.530
MINIMUM X	-1.581	-.565	-.557
MAXIMUM Y	1.022	1.094	.895
MINIMUM Y	-1.667	-1.595	-1.223
CENTROID X	-.099	.076	.068
CENTROID Y	-.039	-.111	.088
POA TO CENTROID in.	.107	.135	.111
MIN RADIUS	.367	.242	.435
MEAN RADIUS	.939	.837	.728
MAX RADIUS	1.708	1.596	1.223
HORIZONTAL SPREAD	2.278	1.087	1.087
VERTICAL SPREAD	2.689	2.689	2.118
EXTREME SPREAD	2.944	2.727	2.179
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		