

C6611596

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington[®]

MODEL 700TM M24

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

REG. U.S. PAT. & TM. OFF.

SERIAL NO.
C6611596

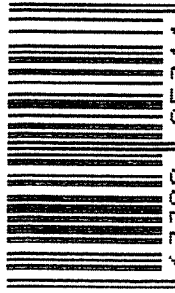
ORDER NO.
5716

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

20



LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6611596

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/17/91	K.S.
600	Proof		3/17/91	K.S.
607	Check Headspace		3/17/91	K.S.
610	Dis-assemble Gun		3/17/91	K.S.
612	Magnaflux Barrel Action		3/28/91	KR
	Magnaflux Bolt		11	KR
615	Rollmark Caliber		11	GS
617	Drill and Tap Sight Holes	APR	3 1991	K.B
618	Polish Barrel	APR	3 1991	W.B
620	Apply Coatings (Barrel Action)		4-16-91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/24/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/24/91	KS
	C) Inspect Ejector Hole for Chamfer		4/24/91	KS
	D) Oil Firing Pin Ass'y		4/24/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		4/25/91	JK

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			4/25/91	JP
	G) Safety Off Force	3	3	3			4/25/91	JP
	H) Trigger Pull Test & Retainability						4/25/91	JP
	I) Firing Pin Indent	0235	0235	0235			4/25/91	JP
	J) Assemble Stock						4/29/91	KS
	K) Assemble Swivel Studs						5-18-91	D/H
	L) Attach Front and Rear Sight Assemblies						4/29/91	KS
	M) Iron Sight Alignment						4/29/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/29/91	KS
	O) Attach Scope to Rifle						4/29/91	KS
	P) Detach & Attach Scope 20 Times						4/29/91	KS
640	Gallery Target & Test						4-30-91	AC
	A) Time						4-30-91	AC
	B) Malfunctions						4-30-91	AC
	C) Pierced Primers						4-30-91	AC
	D) Optical Clarity of Scope						4-30-91	AC
645	Inspect for Live Ammo						4-30-91	AC
655	Final Inspection							
	A) Headspace						5-18-91	D/H
	B) Trigger Pull	2.59	2.55	2.60	2.61	2.55	5/10/91	JP
	C) Function						5-18-91	D/H
660	Pack						6-18-91	NF

SWS TRIGGER PULL TEST

MAY 1990

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6611596

DATE 4/25/91

TESTER J. J. J. (P)

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.28	2.48	2.59	MINIMUM SETTING,
PULL #2	2.43	2.34	2.39	2.55	NO AVG. OF 5
PULL #3	2.45	2.38	2.36	2.60	READINGS ACCEPT-
PULL #4	2.39	2.37	2.30	2.61	ABLE LESS THAN 2#
PULL #5	2.48	2.46	2.33	2.55	NOT (M)
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS	
PULL #1	3.27	3.39		
PULL #2	3.31	3.25		
PULL #3	3.25	3.33		
PULL #4	3.32	3.37		
PULL #5	3.36	3.49		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.34	4.36		4.44
PULL #2	4.29	4.35		4.39
PULL #3	4.56	4.55		4.35
PULL #4	4.45	4.48		4.39
PULL #5	4.27	4.22		4.40
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611596
30 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.232691
1 TO	2	.528346
1 TO	3	.364078
1 TO	4	.163527
1 TO	5	.171686

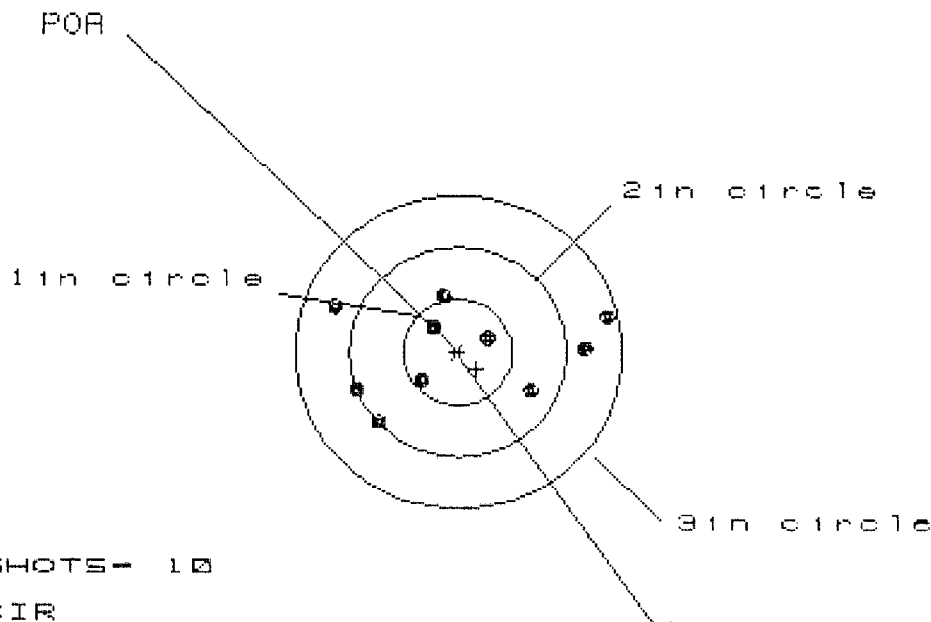
Sp2 <----POR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0058
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .039
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0394289
THE AMR FOR THIS RIFLE IS: .9526

30 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611596

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 10

HS= 2.499

VS= 1.234

GS= 2.500

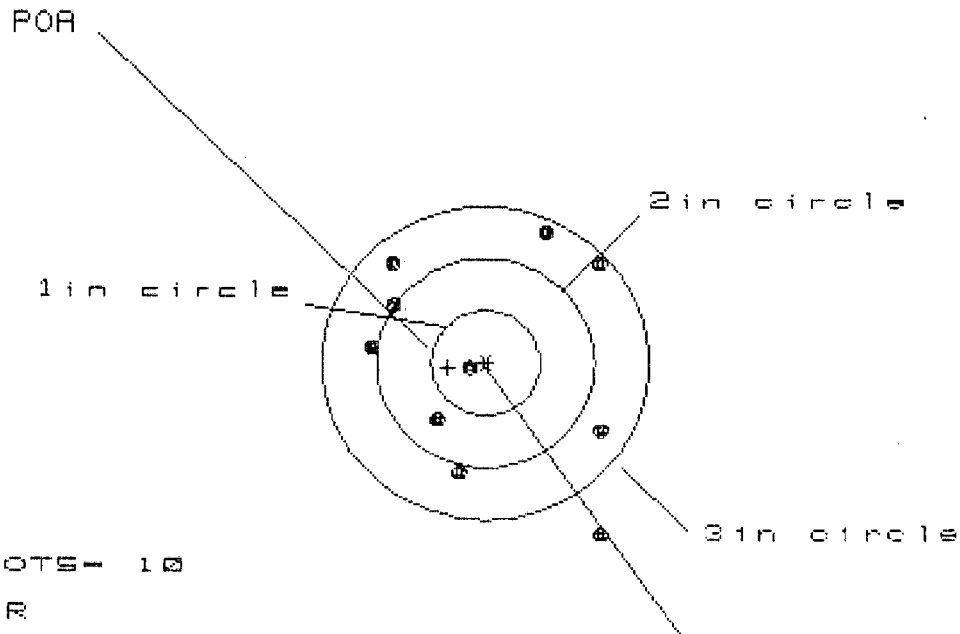
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.337	1.318	1.192
MINIMUM X	:	-1.161	-1.013	-.909
MAXIMUM Y	:	.551	.591	.648
MINIMUM Y	:	-.683	-.643	-.586
CENTROID X	:	-.168	-.316	-.190
CENTROID Y	:	.161	.121	.064
POA TO CENTROID in.	:	.232	.339	.200
MIN RADIUS	:	.306	.290	.333
MEAN RADIUS	:	.827	.752	.708
MAX RADIUS	:	1.384	1.320	1.199
HORIZONTAL SPREAD	:	2.499	2.331	2.100
VERTICAL SPREAD	:	1.234	1.234	1.234
EXTREME SPREAD	:	2.500	2.363	2.140
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			10	

30 Apr 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 8

HS= 2.130

VS= 2.850

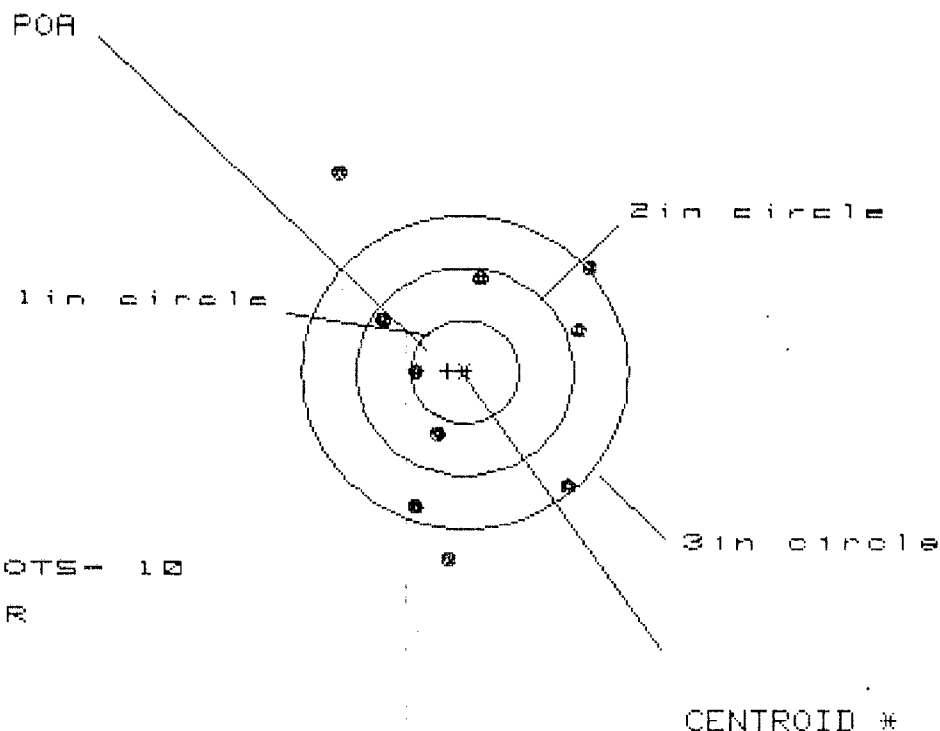
GS= 3.147

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.055	1.126	1.264
MINIMUM X	:	-1.075	-.958	-.817
MAXIMUM Y	:	1.246	1.068	1.168
MINIMUM Y	:	-1.604	-1.232	-1.131
CENTROID X	:	.347	.230	.089
CENTROID Y	:	.043	.221	.120
POA TO CENTROID in.	:	.349	.319	.150
MIN RADIUS	:	.205	.247	.147
MEAN RADIUS	:	1.116	1.007	.917
MAX RADIUS	:	1.920	1.401	1.463
HORIZONTAL SPREAD	:	2.130	2.084	2.081
VERTICAL SPREAD	:	2.850	2.300	2.300
EXTREME SPREAD	:	3.147	2.453	2.453
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	3		
NUMBER IN THREE INCH CIRCLE	=	9		

30 Apr 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 7

HS = 2.355

VS = 3.735

GS = 3.866

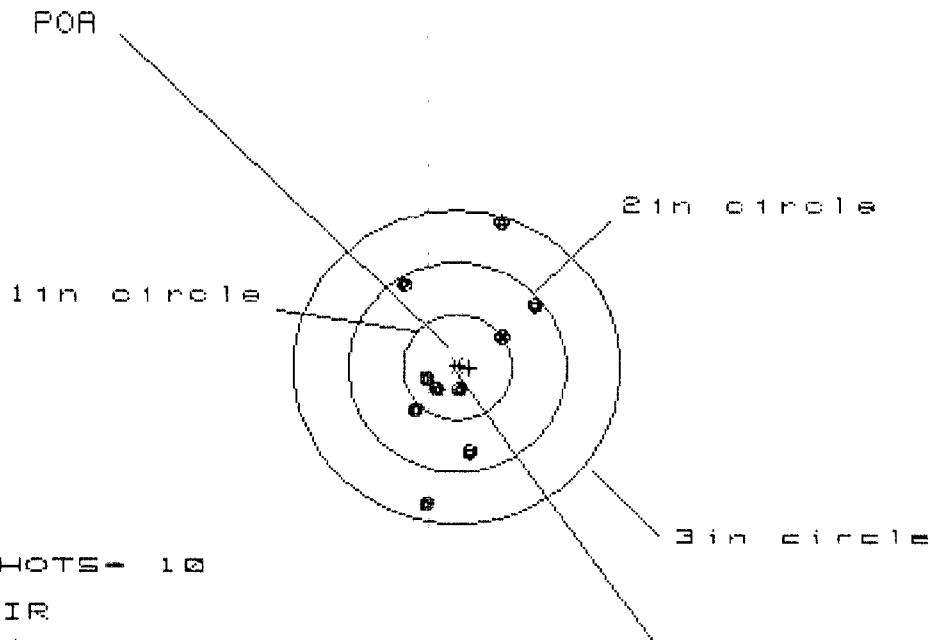
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.163	1.030	.990
MINIMUM X	:	-1.192	-.848	-.889
MAXIMUM Y	:	1.901	1.247	1.044
MINIMUM Y	:	-1.834	-1.623	-1.236
CENTROID X	:	.155	.288	.329
CENTROID Y	:	-.007	-.218	-.015
POA TO CENTROID in.	:	.155	.361	.329
MIN RADIUS	:	.452	.567	.624
MEAN RADIUS	:	1.244	1.130	1.053
MAX RADIUS	:	2.244	1.655	1.439
HORIZONTAL SPREAD	:	2.355	1.878	1.878
VERTICAL SPREAD	:	3.735	2.870	2.280
EXTREME SPREAD	:	3.866	3.175	2.819
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1in = 4

2in = 8

3in = 10

HS= 1.135

VS= 2.756

GS= 2.830

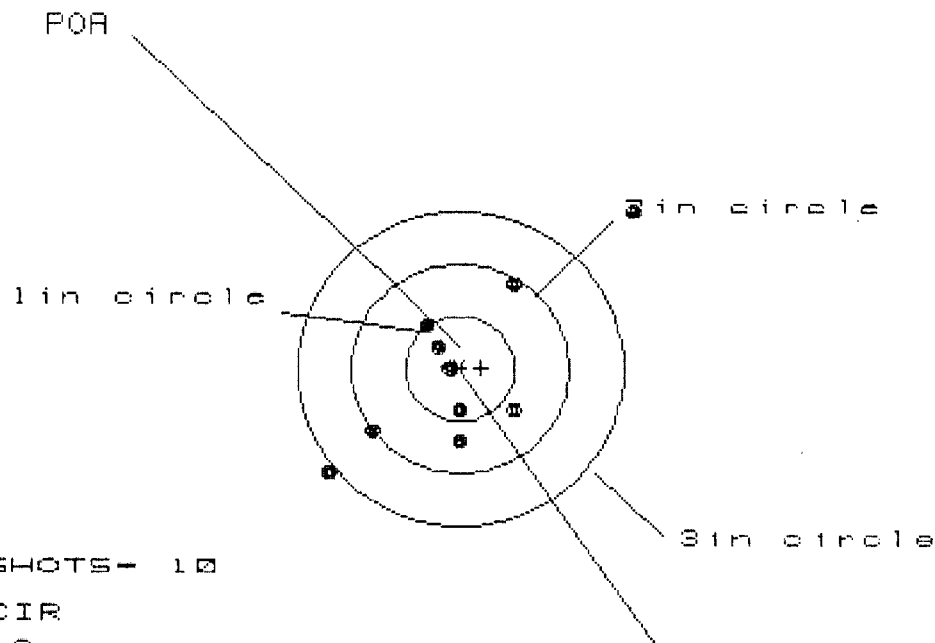
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.673	.715	.688
MINIMUM X	:	-.462	-.420	-.447
MAXIMUM Y	:	1.425	.937	.790
MINIMUM Y	:	-1.331	-1.172	-.799
CENTROID X	:	-.113	-.155	-.128
CENTROID Y	:	.007	-.152	-.005
POA TO CENTROID in.	:	.113	.217	.128
MIN RADIUS	:	.236	.108	.227
MEAN RADIUS	:	.738	.618	.564
MAX RADIUS	:	1.476	1.192	.922
HORIZONTAL SPREAD	:	1.135	1.135	1.135
VERTICAL SPREAD	:	2.756	2.109	1.589
EXTREME SPREAD	:	2.830	2.146	1.696
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 8

HS= 2.819

VS= 2.557

GS= 3.806

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.600	.678	.548
MINIMUM X	:	-1.219	-1.041	-.799
MAXIMUM Y	:	1.538	1.021	.915
MINIMUM Y	:	-1.019	-.848	-.589
CENTROID X	:	-.192	-.370	-.240
CENTROID Y	:	-.009	-.180	-.074
POA TO CENTROID in.	:	.193	.412	.251
MIN RADIUS	:	.115	.173	.087
MEAN RADIUS	:	.838	.669	.561
MAX RADIUS	:	2.220	1.343	1.066
HORIZONTAL SPREAD	:	2.819	1.719	1.347
VERTICAL SPREAD	:	2.557	1.869	1.504
EXTREME SPREAD	:	3.806	2.539	1.970
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	