

C6349053

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington® **DUPONT** REG. U.S. PAT. & TM. OFF.

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

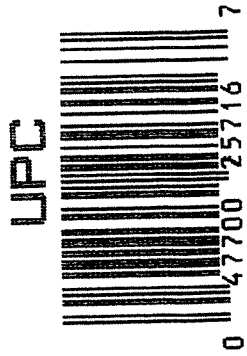
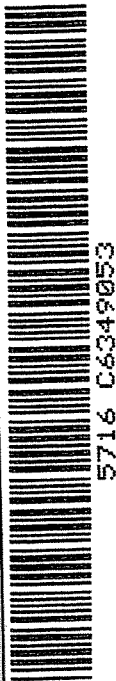
MODEL 700™ H24

SERIAL NO. C6349053

ORDER NO. 5716

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

Ø1



RC52

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349053

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 12	90	RW
600	Proof	1 12	90	L
607	Check Headspace	1 12	90	A
610	Dis-assemble Gun	1 12	90	RW
612	Magnaflux Barrel Action	1-16-90		KCR
	Magnaflux Bolt	1-17-90		KCR
615	Rollmark Caliber		1-17-90	GS
617	Drill and Tap Sight Holes		1-19-90	FB
618	Polish Barrel RB		1-22-90	WB
620	Apply Coatings (Barrel Action)		1-28-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/2/90	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/6/90	RW
	C) Inspect Ejector Hole for Chamfer		2/6/90	RW
	D) Oil Firing Pin Ass'y		2/6/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2-6-90	RL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	3 1/2	3 1/2	3 1/2			4/8/90	WB
	G) Safety Off Force	2	2	2			4/8/90	WB
	H) Trigger Pull Test & Retainability						2-90	HL
	I) Firing Pin Indent	.0202	.0205	.0202			4/8/90	WB
	J) Assemble Stock						4/16/90	RW
	K) Assemble Swivel Studs						4/27/90	JA
	L) Attach Front and Rear Sight Assemblies						4/16/90	RW
	M) Iron Sight Alignment						4/16/90	RW
	N) Detach Front & Rear Sights & place in numbered container						4/16/90	RW
	O) Attach Scope to Rifle						4/16/90	WB
	P) Detach & Attach Scope 20 Times						4/16/90	WB
640	Gallery Target & Test						4-17-90	DH
	A) Time						4-17-90	DH
	B) Malfunctions						4-17-90	DH
	C) Pierced Primers						4-17-90	DH
	D) Optical Clarity of Scope						4-17-90	DH
645	Inspect for Live Ammo						4-17-90	DH
655	Final Inspection						4/26/90	WB
	A) Headspace							
	B) Trigger Pull	2.67	2.70	2.70	2.71	2.71	4/26/90	WB
	C) Function						4/27/90	JA
660	Pack						4/19/90	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6349053

DATE 4-16-90

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.57	2.44	2.38	2.67	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.56	2.43	2.38	2.70	
PULL #3	2.56	2.45	2.36	2.70	
PULL #4	2.44	2.44	2.38	2.71	
PULL #5	2.49	2.45	2.33	2.71	
TOTAL	12.62	12.21	11.83		
AVG.	2.52	2.44	2.36		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.18	3.09		
PULL #2	3.12	3.12		
PULL #3	3.11	3.08		
PULL #4	3.09	3.09		
PULL #5	3.11	3.05		
TOTAL	15.61	15.43		
AVG.	3.12	3.08		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.05		4.27
PULL #2	4.15	4.04		4.30
PULL #3	4.12	4.11		4.21
PULL #4	4.13	4.06		4.27
PULL #5	4.09	4.06		4.10
TOTAL	20.71	20.32		21.15
AVG.	4.14	4.06		4.23

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349053
17 Apr 1990

CENTROIDAL DISTANCES

0 TO	1	.215128
1 TO	2	.235614
1 TO	3	.178045
1 TO	4	.248244
1 TO	5	.0920054

✂ <----POA

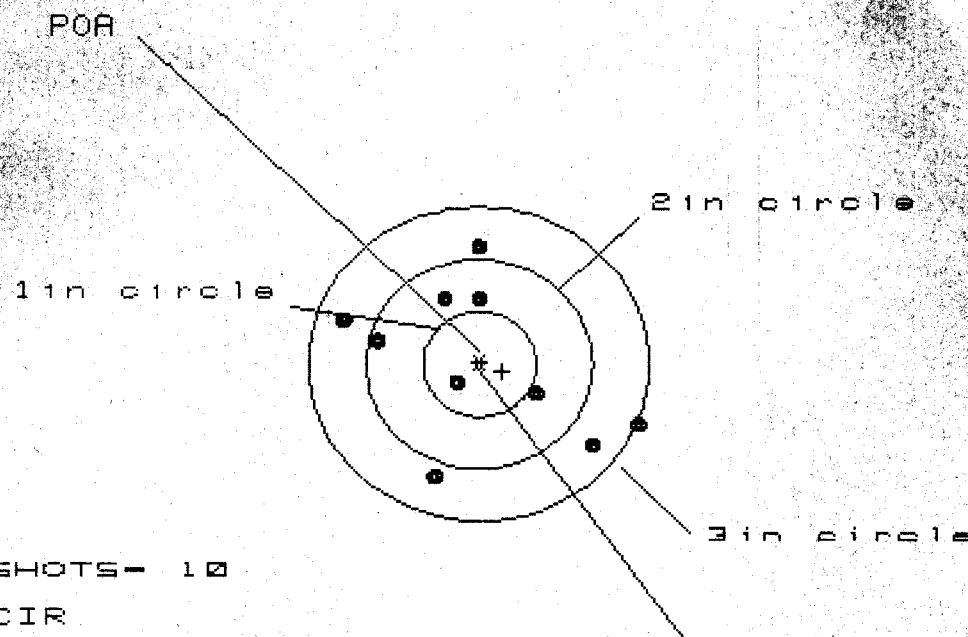
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1174
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1094
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .160472
THE AMR FOR THIS RIFLE IS: .974

17 Apr 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6349053

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1in - 1

2in - 5

3in - 9

HS- 2.565

VS- 2.174

GS- 2.742

CENTROID #

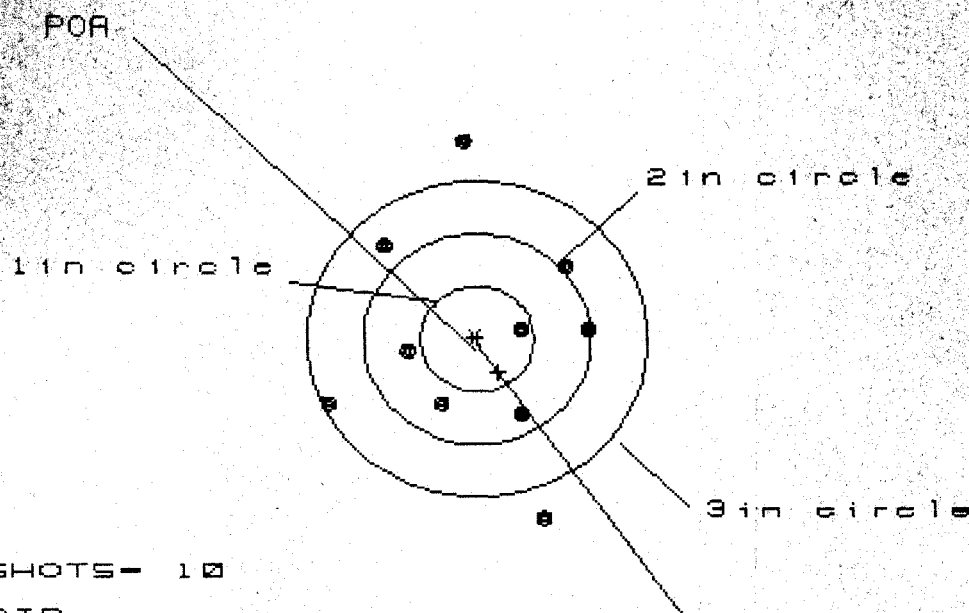
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.413	1.183	.757
MINIMUM X	-1.152	-.995	-.847
MAXIMUM Y	1.139	1.076	.966
MINIMUM Y	-1.035	-1.098	-1.208
CENTROID X	-.202	-.359	-.507
CENTROID Y	.074	.137	.247
POA TO CENTROID in.	.216	.385	.564
MIN RADIUS	.261	.246	.373
MEAN RADIUS	.924	.834	.733
MAX RADIUS	1.523	1.473	1.212
HORIZONTAL SPREAD	2.565	2.178	1.604
VERTICAL SPREAD	2.174	2.174	2.174
EXTREME SPREAD	2.742	2.494	2.218
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

17 Apr 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6349053

CENTERFIRE PATTERNS

2



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 2.226

VS= 3.598

GS= 3.671

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.949	.935	1.007
MINIMUM X	-1.277	-1.291	-1.219
MAXIMUM Y	1.939	1.100	.920
MINIMUM Y	-1.659	-1.444	-.647
CENTROID X	-.185	-.171	-.243
CENTROID Y	.309	.094	.274
POA TO CENTROID in.	.361	.195	.367
MIN RADIUS	.380	.448	.443
MEAN RADIUS	1.074	.955	.879
MAX RADIUS	1.943	1.557	1.344
HORIZONTAL SPREAD	2.226	2.226	2.226
VERTICAL SPREAD	3.598	2.544	1.567
EXTREME SPREAD	3.671	2.891	2.430
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

17 Apr 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8349053

CENTERFIRE PATTERNS

3

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 8

HS= 2.076

VS= 2.737

GS= 3.237

CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.230	.610	.565
MINIMUM X	:	-.846	-.710	-.755
MAXIMUM Y	:	1.597	1.470	1.395
MINIMUM Y	:	-1.140	-1.266	-1.082
CENTROID X	:	-.030	-.166	-.121
CENTROID Y	:	.028	.155	-.029
POA TO CENTROID in.	:	.041	.227	.125
MIN RADIUS	:	.136	.322	.186
MEAN RADIUS	:	.902	.836	.699
MAX RADIUS	:	1.677	1.514	1.452
HORIZONTAL SPREAD	:	2.076	1.320	1.320
VERTICAL SPREAD	:	2.737	2.736	2.477
EXTREME SPREAD	:	3.237	2.747	2.541
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

12 APR 1968

FILE:/PATTERNING/CENTERFIRE_PATT/C6349053

CENTERFIRE PATTERNS

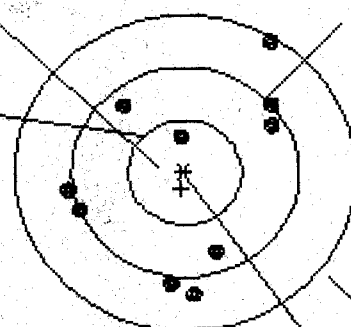
4

POA

1 in circle

2 in circle

3 in circle



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 6

3 in = 9

HS= 1.813

VS= 2.403

GS= 2.536

CENTROID *

PATTERN #

:

4

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

.805

.878

.901

MINIMUM X

:

-1.008

-.919

-.896

MAXIMUM Y

:

1.291

.832

.711

MINIMUM Y

:

-1.112

-.969

-1.048

CENTROID X

:

.033

-.056

-.079

CENTROID Y

:

.154

.011

.132

POA TO CENTROID in.:

.158

.057

.154

MIN RADIUS

:

.377

.516

.397

MEAN RADIUS

:

.963

.892

.868

MAX RADIUS

:

1.521

1.158

1.095

HORIZONTAL SPREAD

:

1.813

1.797

1.797

VERTICAL SPREAD

:

2.403

1.801

1.759

EXTREME SPREAD

:

2.536

1.946

1.946

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

6

NUMBER IN THREE INCH CIRCLE =

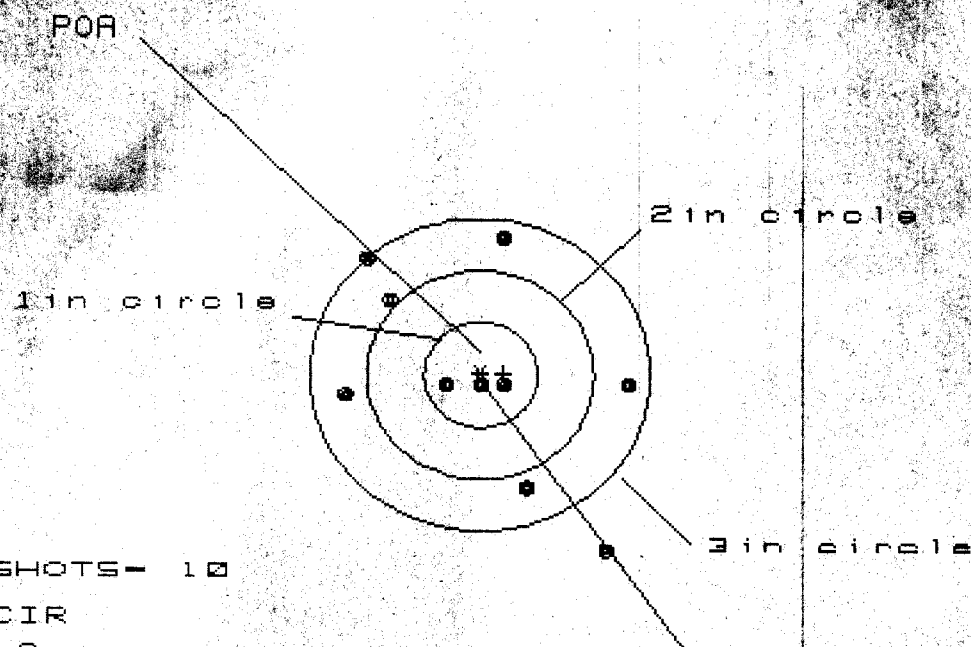
9

12 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6349053

CENTERFIRE PATTERNS

5



OF SHOTS- 10

IN CIR

1in = 3

2in = 3

3in = 9

HS= 2.461

VS= 2.972

GS= 3.463

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.271	1.393	1.287
MINIMUM X	-1.190	-1.068	-1.174
MAXIMUM Y	1.321	1.138	1.255
MINIMUM Y	-1.651	-1.287	-1.170
CENTROID X	-.203	-.325	-.219
CENTROID Y	-.018	.165	.048
POA TO CENTROID in.	.204	.365	.224
MIN RADIUS	.076	.279	.141
MEAN RADIUS	1.007	.914	.836
MAX RADIUS	1.985	1.412	1.292
HORIZONTAL SPREAD	2.461	2.461	2.461
VERTICAL SPREAD	2.972	2.425	2.425
EXTREME SPREAD	3.463	2.607	2.465
NUMBER IN ONE INCH CIRCLE =	3	3	3
NUMBER IN TWO INCH CIRCLE =	3	3	3
NUMBER IN THREE INCH CIRCLE =	9	9	9