

06349070

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington[®]  REG. U.S. PAT. & TM. OFF.

MODEL 700TM 1124

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

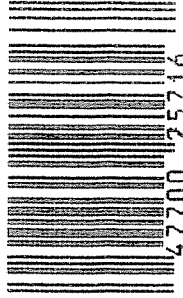
VERY IMPORTANT!
Instruction Book
enclosed to assure
safe use of this
firearm.

SERIAL NO. C6349070	ORDER NO. 5716
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5716 C6349070

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349070

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 12	90	RW
600	Proof	1 12	90	A
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	1-22-90		WB
620	Apply Coatings (Barrel Action)		1-30-90	TH
	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		2/2/90	RW
	C) Inspect Ejector Hole for Chamfer		2/2/90	RW
	D) Oil Firing Pin Ass'y		2/2/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2/4/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4	4			9/4/90	WS
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			9/4/90	WS
	H) Trigger Pull Test & Retainability						9-4-90	WS
	I) Firing Pin Indent	.0225	.0225	.0225			7/7/90	WS
	J) Assemble Stock						9/6/90	RW
	K) Assemble Swivel Studs						9/9/90	WS
	L) Attach Front and Rear Sight Assemblies						9/6/90	RW
	M) Iron Sight Alignment						9/6/90	RW
	N) Detach Front & Rear Sights & place in numbered container						9/6/90	RW
	O) Attach Scope to Rifle						9/6/90	RW
	P) Detach & Attach Scope 20 Times						9/6/90	RW
640	Gallery Target & Test						9-8-90	DH
	A) Time						9-8-90	DH
	B) Malfunctions						9-8-90	DH
	C) Pierced Primers						9-8-90	DH
	D) Optical Clarity of Scope						9-8-90	DH
645	Inspect for Live Ammo						9-8-90	DH
655	Final Inspection						9/9/90	WS
	A) Headspace						9/9/90	WS
	B) Trigger Pull	248	247	253	259	253	9/9/90	WS
	C) Function						9/9/90	WS
660	Pack						7-18-90	WS

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C634 9070

DATE 9/4/90

TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.34	2.33	2.16	2.48	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.55	2.31	2.25	2.47	
PULL #3	2.49	2.34	2.24	2.53	
PULL #4	2.53	2.43	2.16	2.59	
PULL #5	2.43	2.46	2.27	2.53	
TOTAL	12.54	11.87	11.08		
AVG.	2.51	2.39	2.21		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.47	3.31		
PULL #2	3.19	3.30		
PULL #3	3.20	3.29		
PULL #4	3.29	3.28		
PULL #5	3.29	3.30		
TOTAL	16.14	16.48		
AVG.	3.21	3.29		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.06	4.14		4.03
PULL #2	4.09	4.02		4.08
PULL #3	4.06	4.01		4.11
PULL #4	4.14	3.91		4.12
PULL #5	4.09	4.06		4.14
TOTAL	20.44	20.14		20.48
AVG.	4.09	4.03		4.09

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349070
8 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.508685
1 TO	2	.451868
1 TO	3	.684901
1 TO	4	.851733
1 TO	5	.887811

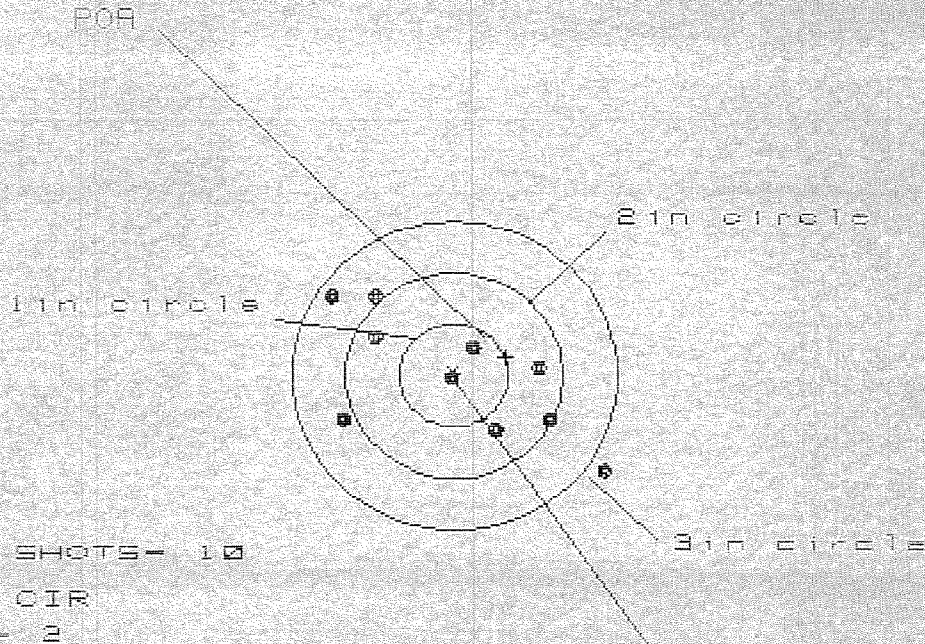
1 2 3 4 5 (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0594
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0264
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0650025
THE AMP FOR THIS RIFLE IS: .7796

8 Sep 1998

FILE: /PATTERNING/CENTERFIRE_PATT/06349070

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.521

VS= 1.748

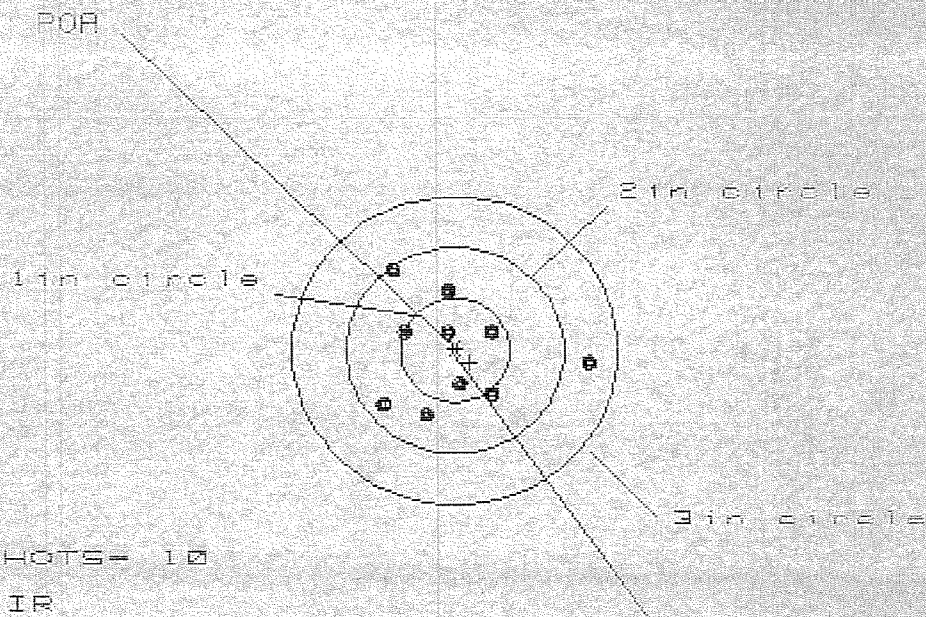
GS= 3.052

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.371	1.014	.889
MINIMUM X	:	-1.150	-.998	-.995
MAXIMUM Y	:	.778	.670	.751
MINIMUM Y	:	-.970	-.588	-.507
CENTROID X	:	-.478	-.630	-.505
CENTROID Y	:	-.174	-.066	-.147
POA TO CENTROID in.	:	.508	.633	.526
MIN RADIUS	:	.011	.178	.032
MEAN RADIUS	:	.874	.793	.714
MAX RADIUS	:	1.679	1.187	1.093
HORIZONTAL SPREAD	:	2.521	2.012	1.884
VERTICAL SPREAD	:	1.748	1.258	1.258
EXTREME SPREAD	:	3.052	2.330	1.970
NUMBER IN ONE INCH CIRCLE =	:	2		
NUMBER IN TWO INCH CIRCLE =	:	6		
NUMBER IN THREE INCH CIRCLE =	:	9		

8 Sep 1990

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 3

2in = 9

3in = 10

HS= 1.969

VS= 1.414

GS= 2.029

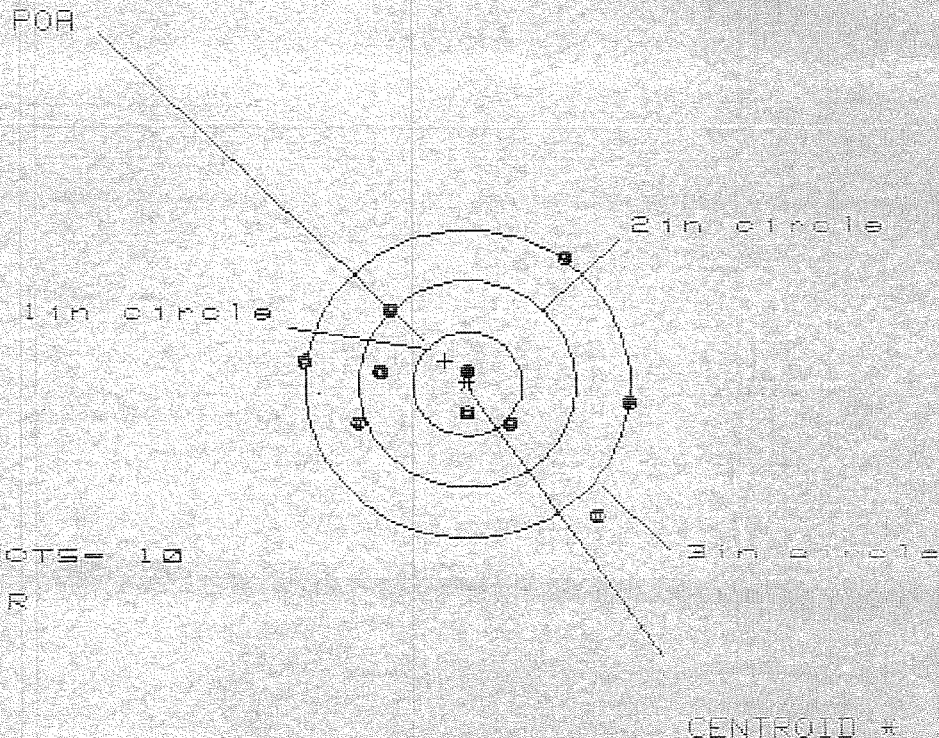
CENTROID #

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.280	.523	.475
MINIMUM X	-.689	-.546	-.594
MAXIMUM Y	.792	.784	.710
MINIMUM Y	-.622	-.630	-.532
CENTROID X	-.134	-.277	-.229
CENTROID Y	.119	.127	.029
POA TO CENTROID in.	.179	.305	.230
MIN RADIUS	.150	.157	.232
MEAN RADIUS	.637	.561	.514
MAX RADIUS	1.283	.873	.763
HORIZONTAL SPREAD	1.969	1.069	1.069
VERTICAL SPREAD	1.414	1.414	1.242
EXTREME SPREAD	2.029	1.458	1.350
NUMBER IN ONE INCH CIRCLE	= 3		
NUMBER IN TWO INCH CIRCLE	= 9		
NUMBER IN THREE INCH CIRCLE	= 10		

8 Sep 1990

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 9

HS= 2.935

VS= 2.438

GS= 3.060

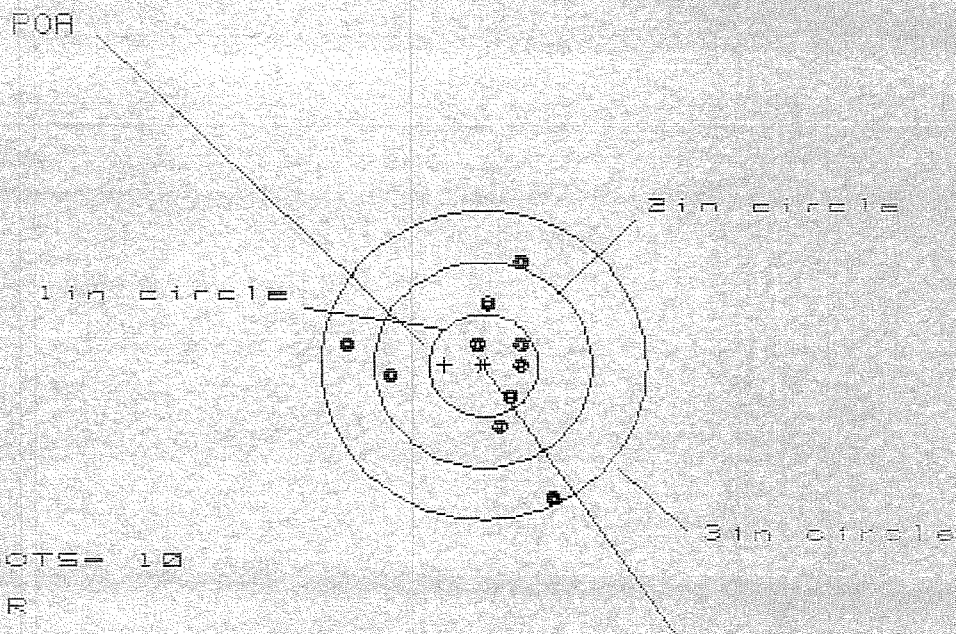
PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.459	1.595	1.427
MINIMUM X	:	-1.476	-1.340	-1.008
MAXIMUM Y	:	1.192	1.054	1.062
MINIMUM Y	:	-1.246	-.487	-.479
CENTROID X	:	.205	.069	.237
CENTROID Y	:	-.225	-.087	-.095
POA TO CENTROID in.	:	.304	.111	.255
MIN RADIUS	:	.104	.105	.079
MEAN RADIUS	:	.994	.905	.848
MAX RADIUS	:	1.743	1.624	1.458
HORIZONTAL SPREAD	:	2.935	2.935	2.435
VERTICAL SPREAD	:	2.438	1.541	1.541
EXTREME SPREAD	:	3.060	2.958	2.441
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS

4



OF SHOTS= 10

IN CIR

1 in = 4

2 in = 7

3 in = 10

HS= 1.853

VS= 2.223

GS= 2.370

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.638

.435

.292

MINIMUM X

-1.215

-1.144

-.888

MAXIMUM Y

.976

.837

.849

MINIMUM Y

-1.247

-.706

-.694

CENTROID X

.357

.286

.429

CENTROID Y

-.006

.133

.121

POA TO CENTROID in.

.357

.315

.446

MIN RADIUS

.218

.062

.187

MEAN RADIUS

.703

.615

.526

MAX RADIUS

1.401

1.148

.905

HORIZONTAL SPREAD

1.853

1.579

1.180

VERTICAL SPREAD

2.223

1.543

1.543

EXTREME SPREAD

2.370

1.720

1.554

NUMBER IN ONE INCH CIRCLE

=

4

NUMBER IN TWO INCH CIRCLE

=

7

NUMBER IN THREE INCH CIRCLE

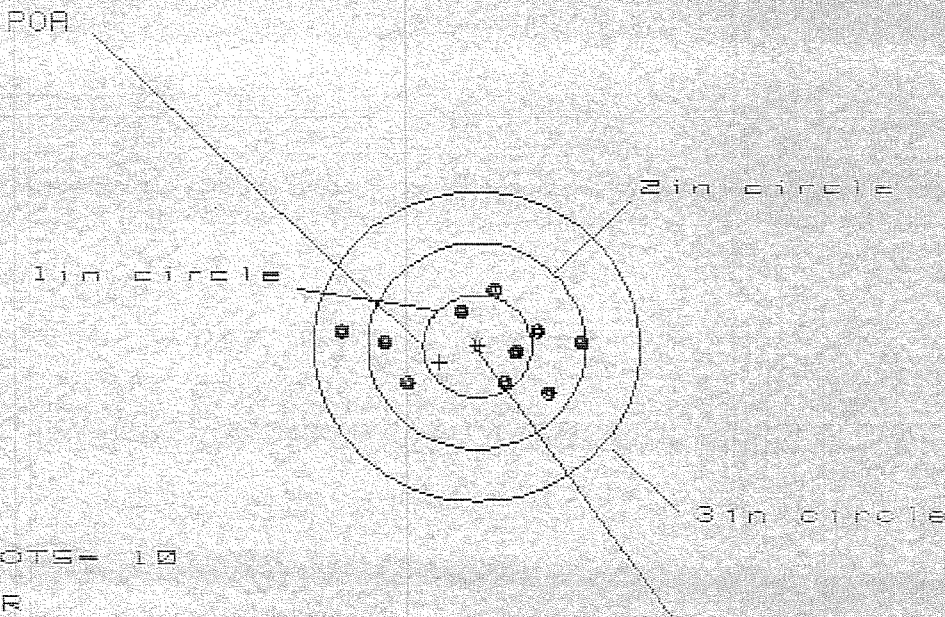
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10

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FILE:/PATTERNING/CENTERFIRE_PATT/06345070

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 9

3 in = 10

HS= 2.234

VS= 1.034

GS= 2.236

CENTROID #

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.958	.816	.580
MINIMUM X	-1.276	-.959	-.857
MAXIMUM Y	.582	.593	.596
MINIMUM Y	-.452	-.441	-.438
CENTROID X	.347	.489	.387
CENTROID Y	.154	.143	.140
POA TO CENTROID in.	.380	.509	.411
MIN RADIUS	.330	.255	.357
MEAN RADIUS	.690	.596	.578
MAX RADIUS	1.280	.959	.857
HORIZONTAL SPREAD	2.234	1.775	1.437
VERTICAL SPREAD	1.034	1.034	1.034
EXTREME SPREAD	2.236	1.775	1.508
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	