

C6349080

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington




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

MODEL 700™ H24

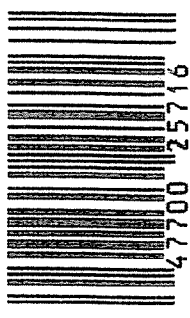
SERIAL NO.
C6349080

ORDER NO.
5716

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

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UPC



0 47700 25716 7



5716 C6349080

RC 51

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349080

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OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	12-20	89	RW
600	Proof	12-20	89	R
607	Check Headspace	12-20	89	R
610	Dis-assemble Gun	12-20	89	RW
612	Magnaflux Barrel Action	1-5-90		KCR
	Magnaflux Bolt	1-5-90		
615	Rollmark Caliber		1/5/90	JS
617	Drill and Tap Sight Holes		1/8/90	FB
618	Polish Barrel RB		1/9/90	WB
620	Apply Coatings (Barrel Action)		1-15-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		1/24/90 1/24/90	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/24/90	RW
	C) Inspect Ejector Hole for Chamfer		1/24/90	RW
	D) Oil Firing Pin Ass'y		1/24/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2/2/90	JS

op. #	OP. NAME	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	6	6	6	1-26-90	SM		
	G) Safety Off Force	3	3	3	1-26-90	SM		
	H) Trigger Pull Test & Retainability				2/27/90	JS		
	I) Firing Pin Indent	.023	.0235	.0235	1-26-90	SM		
	J) Assemble Stock				2/27/90	RW		
	K) Assemble Swivel Studs				3/15/90	WB		
	L) Attach Front and Rear Sight Assemblies				2/27/90	RW		
	M) Iron Sight Alignment				2/27/90	RW		
	N) Detach Front & Rear Sights & place in numbered container				2/27/90	RW		
	O) Attach Scope to Rifle				2/27/90	WB		
	P) Detach & Attach Scope 20 Times				2/27/90	WB		
640	Gallery Target & Test				2-28-90	JS		
	A) Time				↓	(TEMPORARY) HELP "		
	B) Malfunctions					"		
	C) Pierced Primers					"		
	D) Optical Clarity of Scope					"		
645	Inspect for Live Ammo					"		
655	Final Inspection				15/Mar/90	JS		
	A) Headspace				15/Mar/90	JS		
	B) Trigger Pull	2.58	2.39	2.37	2.44	2.51	15/Mar/90	JS
	C) Function						15/Mar/90	JS
660	Pack				19/Mar/90	JS		

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6349080
DATE 26 Jan 90
TESTER WJS

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.48	2.43	2.39	2.58	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.48	2.37	2.35	2.39	
PULL #3	2.53	2.44	2.36	2.37	
PULL #4	2.49	2.37	2.32	2.44	
PULL #5	2.54	2.37	2.34	2.51	
TOTAL	1252	1198	1176	1229	
AVG.	2.504	2.396	2.352	2.458	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	2.93	3.04		
PULL #2	2.99	3.07		
PULL #3	3.06	3.07		
PULL #4	2.95	3.03		
PULL #5	3.01	3.06		
TOTAL	1494	1527		
AVG.	2.988	3.054		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.00	3.77		3.80
PULL #2	3.96	3.90		4.14
PULL #3	4.09	3.84		3.98
PULL #4	3.98	3.88		4.03
PULL #5	4.02	3.93		3.95
TOTAL	2005	1939		1990
AVG.	4.01	3.878		3.98

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349080
28 Feb 1990

CENTROIDAL DISTANCES

0 TO 1	.414146
1 TO 2	.510549
1 TO 3	.634206
1 TO 4	.512533
1 TO 5	.440822

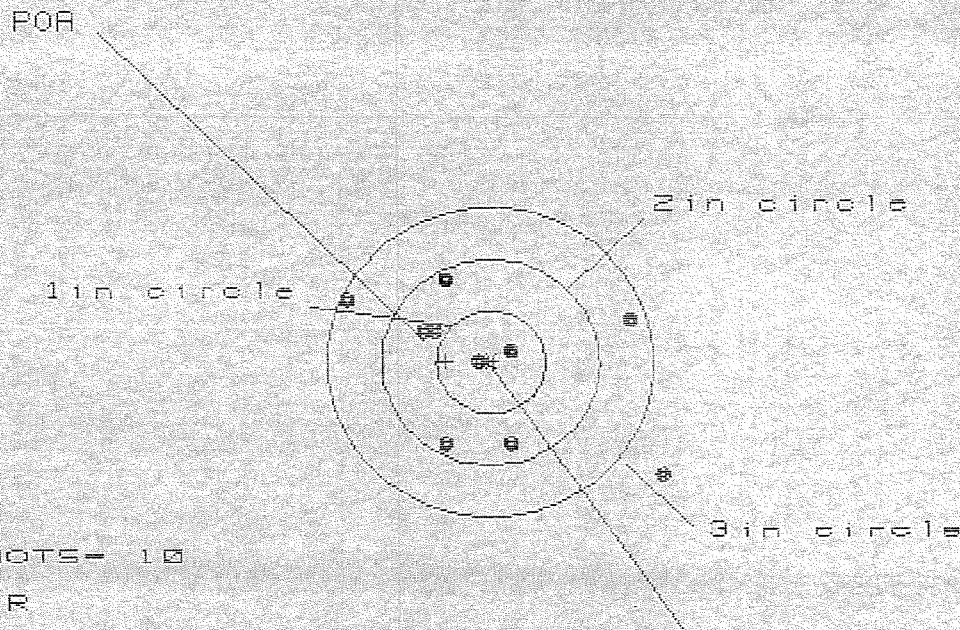
1 (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1084
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2036
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .230659
THE AMR FOR THIS RIFLE IS: .9526

28 Feb 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06349060

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 3.880

VS= 1.865

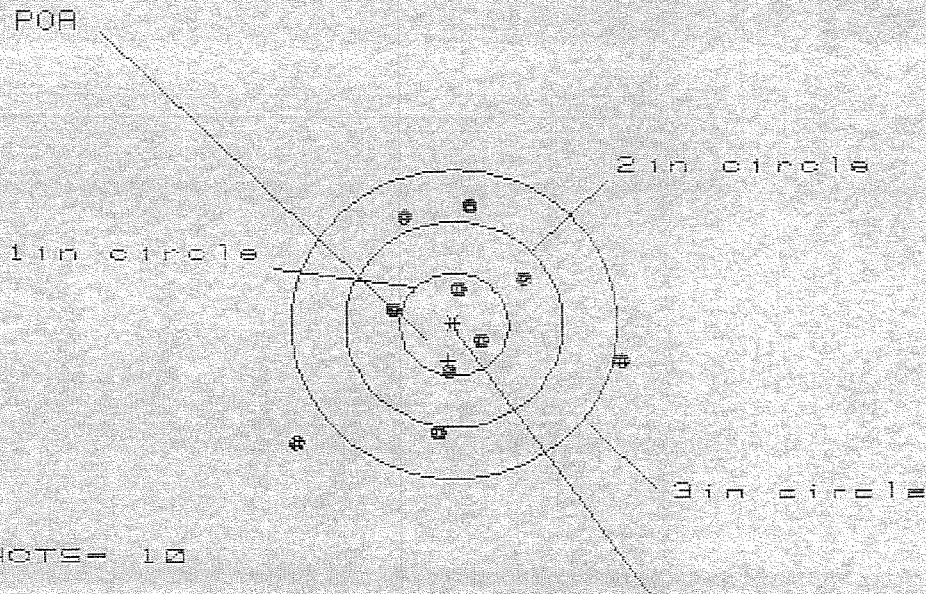
CS= 3.353

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.578	1.509	1.368
MINIMUM X	:	-1.302	-1.126	-1.534
MAXIMUM Y	:	.791	.672	.738
MINIMUM Y	:	-1.074	-.868	-.802
CENTROID X	:	.414	.238	.379
CENTROID Y	:	-.011	.108	.042
POA TO CENTROID in.	:	.414	.262	.381
MIN RADIUS	:	.155	.120	.131
MEAN RADIUS	:	.894	.747	.690
MAX RADIUS	:	1.909	1.545	1.425
HORIZONTAL SPREAD	:	2.880	2.635	1.952
VERTICAL SPREAD	:	1.865	1.540	1.540
EXTREME SPREAD	:	3.353	2.642	2.103
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

28 Feb 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C63490B0

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 8

HS= 3.044

VS= 2.306

GS= 3.142

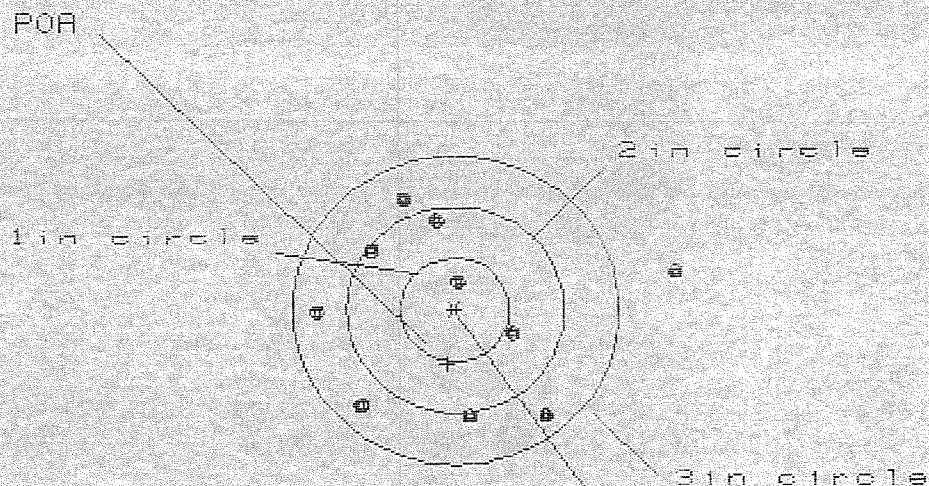
PATTERN # : 2

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.577	1.414	.630
MINIMUM X	-1.467	-.712	-.535
MAXIMUM Y	1.153	1.025	.963
MINIMUM Y	-1.153	-1.154	-1.216
CENTROID X	.056	.219	.042
CENTROID Y	.353	.481	.543
POA TO CENTROID in.	.357	.528	.545
MIN RADIUS	.319	.230	.169
MEAN RADIUS	.928	.809	.709
MAX RADIUS	1.866	1.500	1.224
HORIZONTAL SPREAD	3.044	2.126	1.165
VERTICAL SPREAD	2.306	2.179	2.179
EXTREME SPREAD	3.142	2.487	2.194
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		8	

28 Feb 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6345000

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS= 3.259

VS= 2.056

GS= 3.287

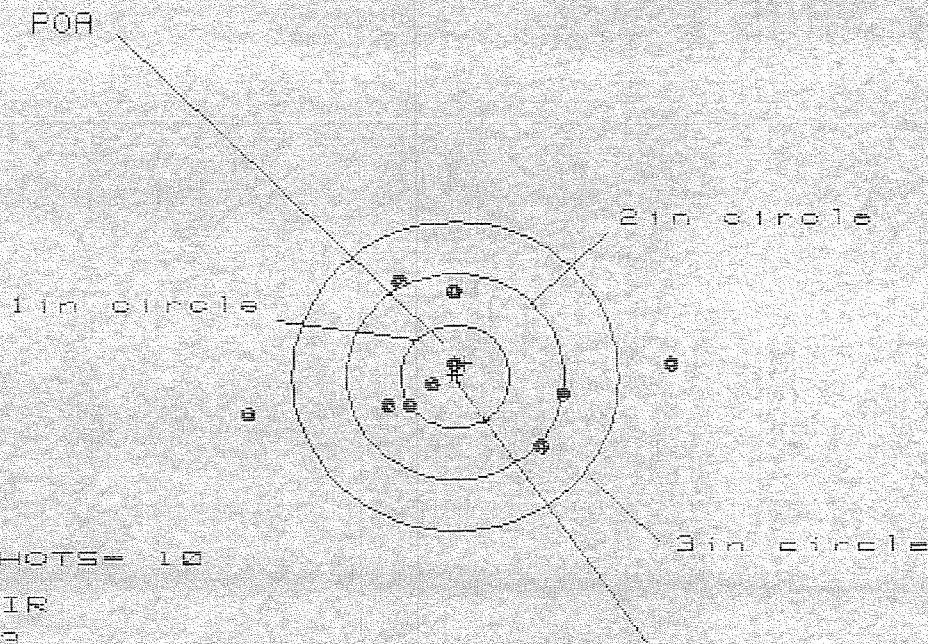
CENTROID *

PATTERN #	3		
SHOTS (BEST OF)	10	9	9
MAXIMUM X	2.001	1.022	.914
MINIMUM X	-1.258	-1.035	-.908
MAXIMUM Y	1.047	1.090	.972
MINIMUM Y	-1.009	-.966	-1.084
CENTROID X	.075	-.148	-.275
CENTROID Y	.525	.482	.600
POA TO CENTROID IN.	.531	.504	.661
MIN RADIUS	.308	.421	.429
MEAN RADIUS	1.075	.958	.882
MAX RADIUS	2.039	1.394	1.195
HORIZONTAL SPREAD	3.259	2.057	1.822
VERTICAL SPREAD	2.056	2.056	2.056
EXTREME SPREAD	3.287	2.410	2.153
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		9	

28 Feb 1990

FILE:/PATTERNING/CENTERFIRE_PATT/06345000

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 6

3 in = 8

HS= 3.927

VS= 1.575

GS= 3.954

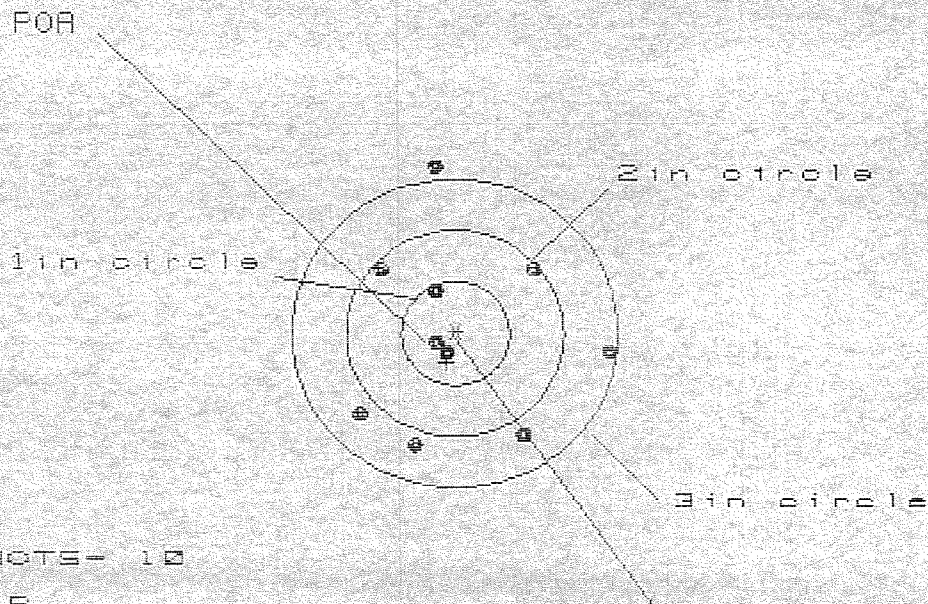
CENTROID #

PATTERN #	4	9	8
SHOTS (BEST QF)	10	9	8
MAXIMUM X	1.989	1.156	.942
MINIMUM X	-1.938	-1.717	-.630
MAXIMUM Y	.878	.888	.842
MINIMUM Y	-.697	-.687	-.733
CENTROID X	-.085	-.306	-.091
CENTROID Y	-.128	-.138	-.092
POA TO CENTROID in.	.154	.336	.130
MIN RADIUS	.099	.064	.067
MEAN RADIUS	.931	.788	.665
MAX RADIUS	1.991	1.755	1.079
HORIZONTAL SPREAD	3.927	2.873	1.572
VERTICAL SPREAD	1.575	1.575	1.575
EXTREME SPREAD	3.954	2.883	2.038
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

28 Feb 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06349080

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 5

3 in = 9

HS= 2.289

VS= 2.744

GS= 2.747

CENTROID #

PATTERN #

:

5

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

1.372

1.348

.919

MINIMUM X

:

-.917

-.941

-.773

MAXIMUM Y

:

1.640

.842

.842

MINIMUM Y

:

-1.104

-.922

-.922

CENTROID X

:

.082

.106

-.062

CENTROID Y

:

.279

.097

.097

POA TO CENTROID in.:

:

.291

.144

.115

MIN RADIUS

:

.196

.070

.093

MEAN RADIUS

:

.935

.840

.747

MAX RADIUS

:

1.654

1.348

1.145

HORIZONTAL SPREAD

:

2.289

2.289

1.592

VERTICAL SPREAD

:

2.744

1.764

1.764

EXTREME SPREAD

:

2.747

2.368

2.122

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

5

NUMBER IN THREE INCH CIRCLE =

9