

C6349136

MODEL 700™ M24

Model SWS™

Action _____

Barrel Length _____

Capacity _____

Order No. 5716

* Includes 1 in chamber.

Remington

Remington®



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

MODEL 700™ H24

SERIAL NO.
C6349136

ORDER NO.
5716

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

01



5716 C6349136

UPC



0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349136

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	8 31	90	Rw
600	Proof	8 31	90	Rw
607	Check Headspace	8 31	90	Rw
610	Dis-assemble Gun	8 31	90	Rw
612	Magnaflux Barrel Action	4-2-90		KCR
	Magnaflux Bolt	4-2-90		KCR
615	Rollmark Caliber	4-2-90		g.f.
617	Drill and Tap Sight Holes		4/4/90	FB
618	Polish Barrel RB		4/5/90	WB
620	Apply Coatings (Barrel Action)		4-9-90	TA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/18/90	Rw
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/18/90	Rw
	C) Inspect Ejector Hole for Chamfer		4/18/90	Rw
	D) Oil Firing Pin Ass'y		4/18/90	Rw
	E) Adjust Trigger Pull to Min Setting and Stake		4/30/90	g.f.

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			4/30/90	9C
	G) Safety Off Force	3	3	3			4/30/90	9C
	H) Trigger Pull Test & Retainability						4/30/90	9C
	I) Firing Pin Indent	.0215	.0215	.0215			4/30/90	9C
	J) Assemble Stock						5/4/90	RW
	K) Assemble Swivel Studs						5/8/90	WB
	L) Attach Front and Rear Sight Assemblies						5/4/90	RW
	M) Iron Sight Alignment						5/4/90	RW
	N) Detach Front & Rear Sights & place in numbered container						5/4/90	RW
	O) Attach Scope to Rifle						5/4/90	9C
	P) Detach & Attach Scope 20 Times						5/4/90	9C
640	Gallery Target & Test						5-7-90	DH
	A) Time						5-7-90	DH
	B) Malfunctions						5-7-90	DH
	C) Pierced Primers						5-7-90	DH
	D) Optical Clarity of Scope						5-7-90	DH
645	Inspect for Live Ammo						5-7-90	DH
655	Final Inspection						5/8/90	WB
	A) Headspace						5/8/90	WB
	B) Trigger Pull	2.33	2.33	2.38	2.34	2.28	5/7/90	WB
	C) Function						5/8/90	WB
660	Pack						6-20-90	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. 06349136

DATE 4/30/90

TESTER JRL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.47	2.55	2.58	2.33	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.52	2.47	2.33	
PULL #3	2.44	2.46	2.44	2.38	
PULL #4	2.45	2.50	2.52	2.34	
PULL #5	2.49	2.41	2.56	2.28	
TOTAL	12.26	12.44	12.57		
AVG.	2.452	2.488	2.504		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.57	3.27		
PULL #2	3.57	3.33		
PULL #3	3.54	3.47		
PULL #4	3.52	3.15		
PULL #5	3.55	3.41		
TOTAL	17.75	16.63		
AVG.	3.55	3.326		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.53	4.43		4.49
PULL #2	4.22	4.38		4.51
PULL #3	4.25	4.55		4.48
PULL #4	4.26	4.43		4.44
PULL #5	4.36	4.20		4.54
TOTAL	21.62	21.99		22.46
AVG.	4.324	4.398		4.492

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349136
7 May 1990

CENTROIDAL DISTANCES

0 TO	1	.204384
1 TO	2	.466357
1 TO	3	.18544
1 TO	4	.868079
1 TO	5	.167672

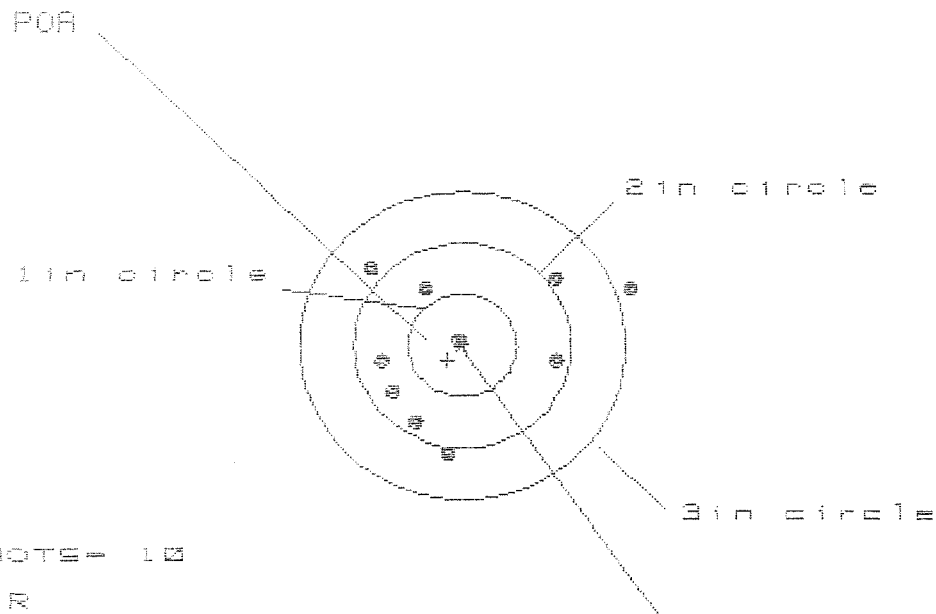
27¹⁸ 9 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2958
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1522
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .33266
THE AMR FOR THIS RIFLE IS: .8314

7 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8349136

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 2.425

VS= 1.809

GS= 2.430

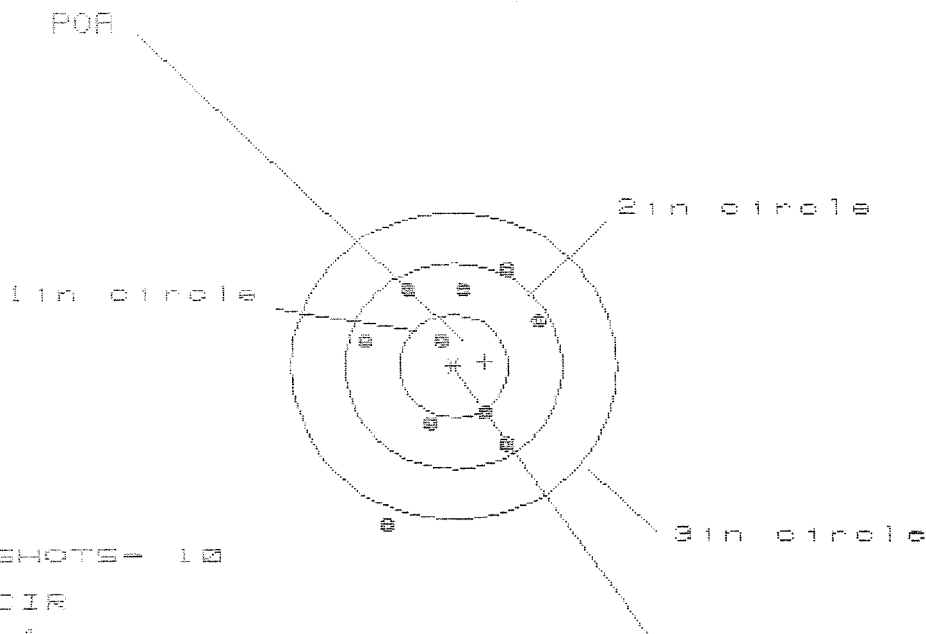
CENTROID *

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.541	1.059	.970
MINIMUM X	:	-.884	-.713	-.648
MAXIMUM Y	:	.718	.780	.856
MINIMUM Y	:	-1.091	-1.029	-.931
CENTROID X	:	.142	-.029	.060
CENTROID Y	:	.147	.085	-.013
POA TO CENTROID in.	:	.205	.089	.062
MIN RADIUS	:	.034	.175	.197
MEAN RADIUS	:	.896	.793	.762
MAX RADIUS	:	1.640	1.261	1.256
HORIZONTAL SPREAD	:	2.425	1.772	1.618
VERTICAL SPREAD	:	1.809	1.809	1.787
EXTREME SPREAD	:	2.430	2.049	2.049
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 8

3in = 9

H51 = 1.610

V51 = 2.498

G51 = 2.736

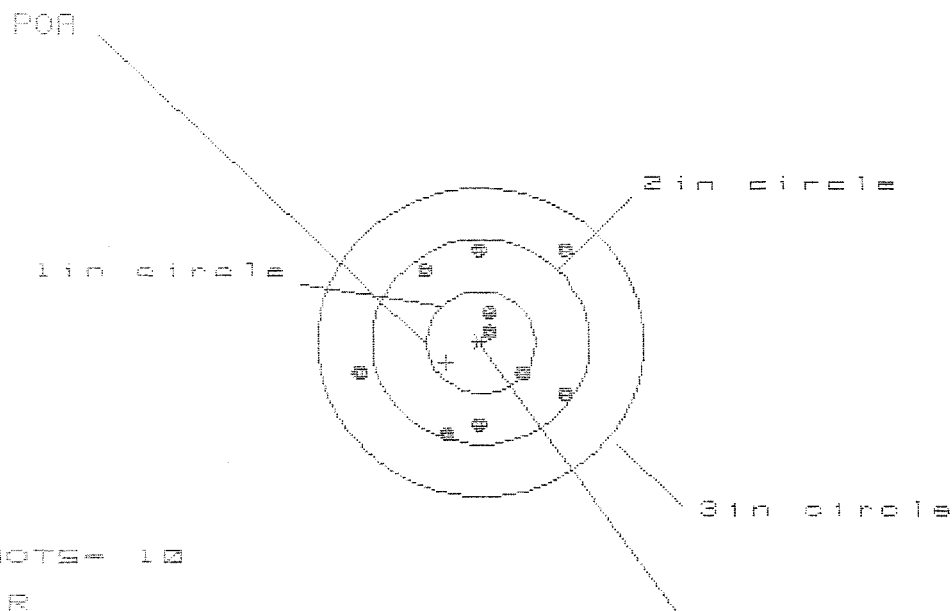
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.829	.763	.820
MINIMUM X	:	-.781	-.847	-.790
MAXIMUM Y	:	.903	.725	.704
MINIMUM Y	:	-1.595	-.922	-.831
CENTROID X	:	-.283	-.217	-.274
CENTROID Y	:	-.045	.133	.042
POR TO CENTROID in.	:	.287	.254	.277
MIN RADIUS	:	.243	.183	.178
MEAN RADIUS	:	.845	.729	.706
MAX RADIUS	:	1.703	1.006	.949
HORIZONTAL SPREAD	:	1.610	1.610	1.610
VERTICAL SPREAD	:	2.498	1.647	1.535
EXTREME SPREAD	:	2.736	1.742	1.742
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 3

2in = 7

3in = 10

HSI = 1.879

VS = 1.881

GS = 2.270

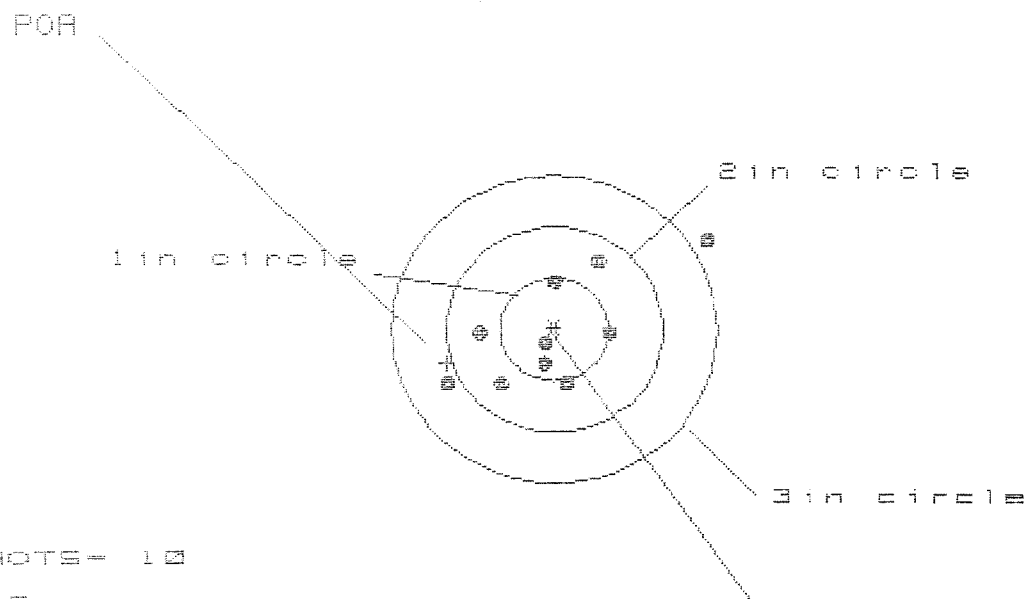
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.780	.866	.739
MINIMUM X	:	-1.099	-1.013	-.563
MAXIMUM Y	:	.945	.983	.953
MINIMUM Y	:	-.936	-.831	-.861
CENTROID X	:	.320	.234	.361
CENTROID Y	:	.199	.094	.124
POA TO CENTROID in.	:	.377	.253	.382
MIN RADIUS	:	.080	.215	.143
MEAN RADIUS	:	.781	.744	.682
MAX RADIUS	:	1.219	1.041	.973
HORIZONTAL SPREAD	:	1.879	1.879	1.302
VERTICAL SPREAD	:	1.881	1.814	1.814
EXTREME SPREAD	:	2.270	1.887	1.852
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 9

HSI = 2.408

VS = 1.388

GS = 2.775

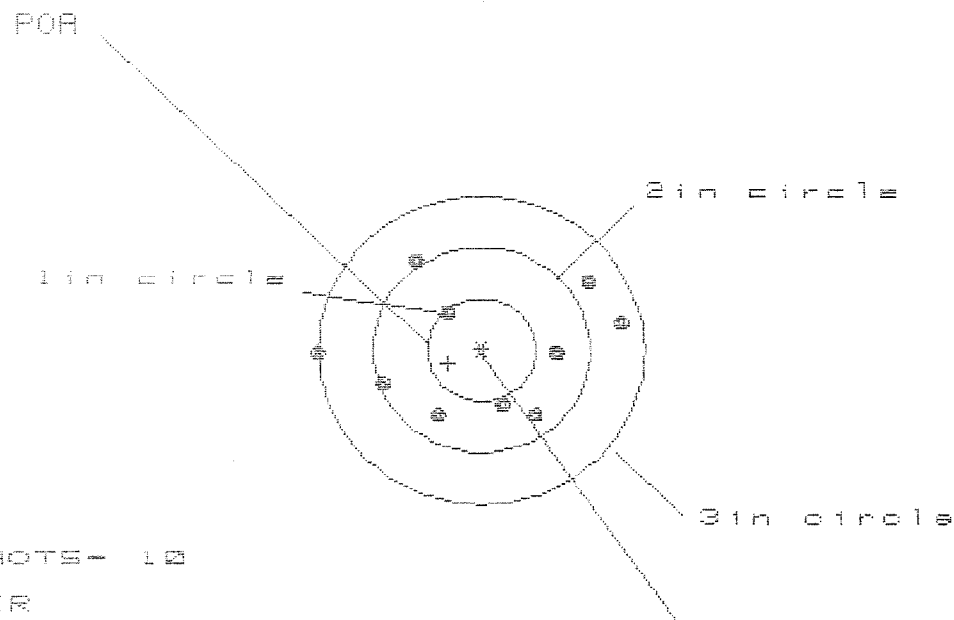
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.416	.632	.528
MINIMUM X	:	-.993	-.836	-.683
MAXIMUM Y	:	.851	.781	.727
MINIMUM Y	:	-.537	-.443	-.497
CENTROID X	:	.991	.834	.938
CENTROID Y	:	.328	.234	.288
POA TO CENTROID in.	:	1.044	.866	.982
MIN RADIUS	:	.160	.101	.105
MEAN RADIUS	:	.704	.571	.522
MAX RADIUS	:	1.652	.947	.845
HORIZONTAL SPREAD	:	2.409	1.468	1.211
VERTICAL SPREAD	:	1.388	1.224	1.224
EXTREME SPREAD	:	2.775	1.831	1.509
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			9	

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1in = 1

2in = 6

3in = 10

HEI = 2.812

VS = 1.507

GS = 2.828

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.321	1.155	.942
MINIMUM X	:	-1.491	-1.039	-.895
MAXIMUM Y	:	.831	.832	.872
MINIMUM Y	:	-.676	-.675	-.635
CENTROID X	:	.309	.475	.331
CENTROID Y	:	.132	.131	.091
POA TO CENTROID in.	:	.336	.493	.343
MIN RADIUS	:	.480	.487	.525
MEAN RADIUS	:	.931	.858	.804
MAX RADIUS	:	1.491	1.198	1.203
HORIZONTAL SPREAD	:	2.812	2.194	1.837
VERTICAL SPREAD	:	1.507	1.507	1.507
EXTREME SPREAD	:	2.828	2.287	2.109
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	