

C6349140

MODEL 700TM N24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

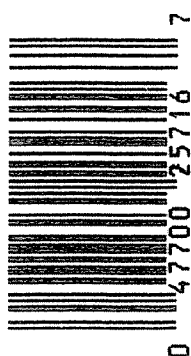
Remington




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

MODEL 700™ M24	SERIAL NO. C6349140
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off; Marca Registrada Marque Deposee.	ORDER NO. 5716

UPC



5716 C6349140

RC-15
Replace

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349140

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	12-20 89	RW
600	Proof		12-20 89	A
607	Check Headspace		12-20 89	A
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	FB
620	Apply Coatings (Barrel Action)		1-5-90	TJA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		1/1/90 1/16/90	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/16/90	RW
	C) Inspect Ejector Hole for Chamfer		1/16/90	RW
	D) Oil Firing Pin Ass'y		1/16/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		1/17/90	J. U.

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			1-17-90	gll
	G) Safety Off Force	3	3	3			1-17-90	gll
	H) Trigger Pull Test & Retainability						1-16-90	ES.
	I) Firing Pin Indent	.021	.021	.021			1-17-90	gll
	J) Assemble Stock						3/9/90	RW
	K) Assemble Swivel Studs						3/13/90	WB
	L) Attach Front and Rear Sight Assemblies						3/9/90	RW
	M) Iron Sight Alignment						3/9/90	RW
	N) Detach Front & Rear Sights & place in numbered container						3/9/90	RW
	O) Attach Scope to Rifle						3-9-90	JD
	P) Detach & Attach Scope 20 Times						3-9-90	JD
640	Gallery Target & Test						3-9-90	A
	A) Time						"	A
	B) Malfunctions						"	A
	C) Pierced Primers						"	A
	D) Optical Clarity of Scope						"	A
645	Inspect for Live Ammo						3-9-90	A
655	Final Inspection						3/13/90	WB
	A) Headspace						3/13/90	WB
	B) Trigger Pull	2.63	2.57	2.79	2.38	2.34	3/13/90	ES
	C) Function						3/13/90	WB
660	Pack						20 MAR 90	JD

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6349140

DATE 11/1/90

TESTER gjs

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.35	2.49	2.63	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.48	2.42	2.07	2.57	
PULL #3	2.48	2.42	2.24	2.79	
PULL #4	2.32	2.36	2.22	2.38	
PULL #5	2.47	2.32	2.09	2.34	
TOTAL	12.21	11.87	11.13		
AVG.	2.442	2.374	2.226		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	2.93	2.84		
PULL #2	3.05	2.90		
PULL #3	3.03	2.82		
PULL #4	2.91	2.84		
PULL #5	2.99	3.02		
TOTAL	14.91	14.42		
AVG.	2.982	2.884		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.03	4.06		4.06
PULL #2	4.09	4.07		4.10
PULL #3	4.03	4.03		3.97
PULL #4	3.88	4.02		4.00
PULL #5	4.05	4.03		3.94
TOTAL	20.08	20.21		20.07
AVG.	4.016	4.042		4.014

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349140
9 Mar 1990

CENTROIDAL DISTANCES

0 TO	1	.673962
1 TO	2	.53372
1 TO	3	.880355
1 TO	4	.918615
1 TO	5	.849781

453
1 <----POA

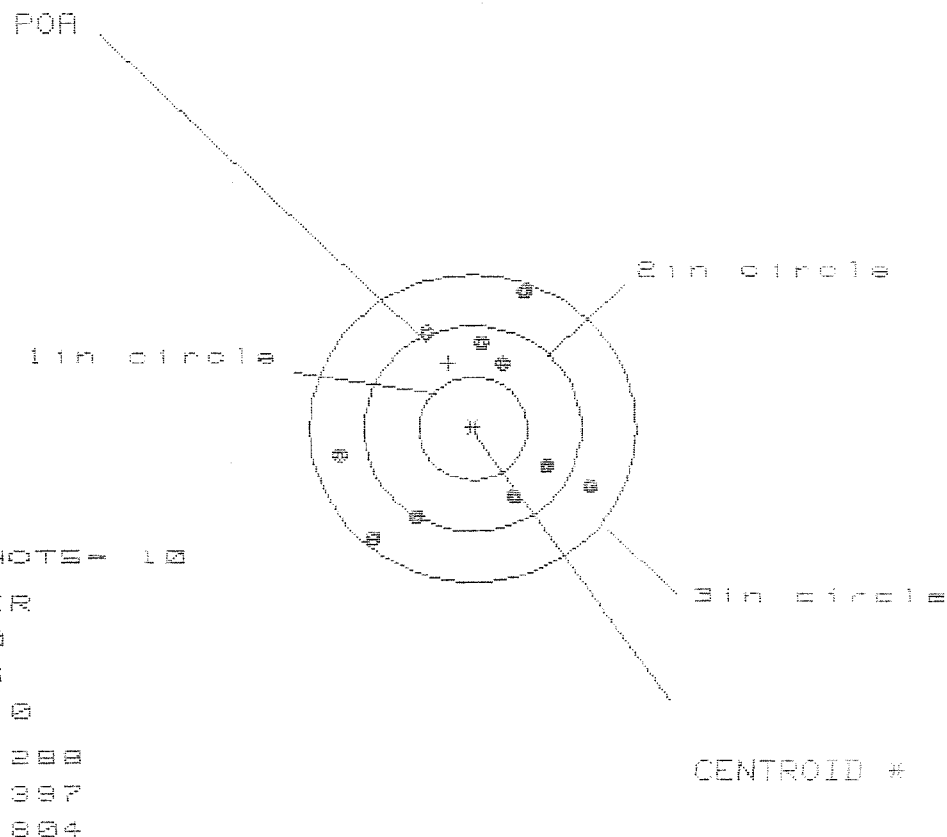
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.009
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0554
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0561263

THE AMR FOR THIS RIFLE IS: 1.149

8 Mar 1998

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CENTERFIRE PATTERNS # 1



PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.115	1.008	1.057
MINIMUM X	:	-1.173	-1.280	-1.231
MAXIMUM Y	:	1.337	1.219	.948
MINIMUM Y	:	-1.060	-.961	-.808
CENTROID X	:	.223	.330	.281
CENTROID Y	:	-.636	-.518	-.671
POA TO CENTROID in.	:	.674	.614	.727
MIN RADIUS	:	.670	.518	.677
MEAN RADIUS	:	1.038	.974	.936
MAX RADIUS	:	1.429	1.344	1.258
HORIZONTAL SPREAD	:	2.288	2.288	2.288
VERTICAL SPREAD	:	2.397	2.180	1.756
EXTREME SPREAD	:	2.804	2.420	2.301
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 0

2in = 4

3in = 8

HS= 2.766

VS= 2.100

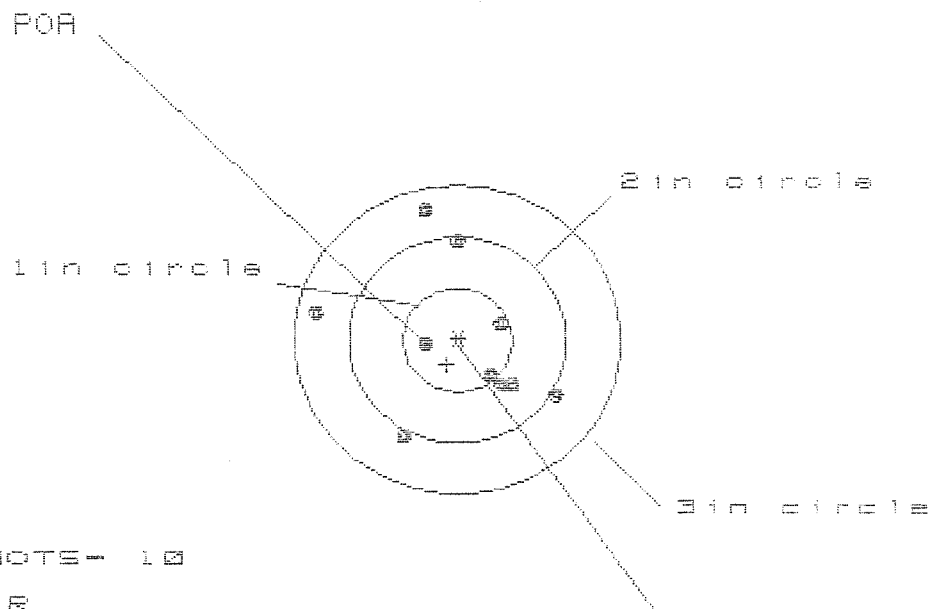
GS= 3.426

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.280	1.115	1.145
MINIMUM X	:	-1.486	-1.218	-1.078
MAXIMUM Y	:	.958	.831	.923
MINIMUM Y	:	-1.150	-1.221	-1.129
CENTROID X	:	.039	.204	.064
CENTROID Y	:	-.135	-.008	-.101
POA TO CENTROID in.	:	.141	.204	.119
MIN RADIUS	:	.572	.572	.554
MEAN RADIUS	:	1.153	1.063	1.013
MAX RADIUS	:	1.879	1.373	1.364
HORIZONTAL SPREAD	:	2.766	2.333	2.223
VERTICAL SPREAD	:	2.108	2.052	2.052
EXTREME SPREAD	:	3.426	2.572	2.572
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 10

HS= 2.225

VS= 2.212

GS= 2.378

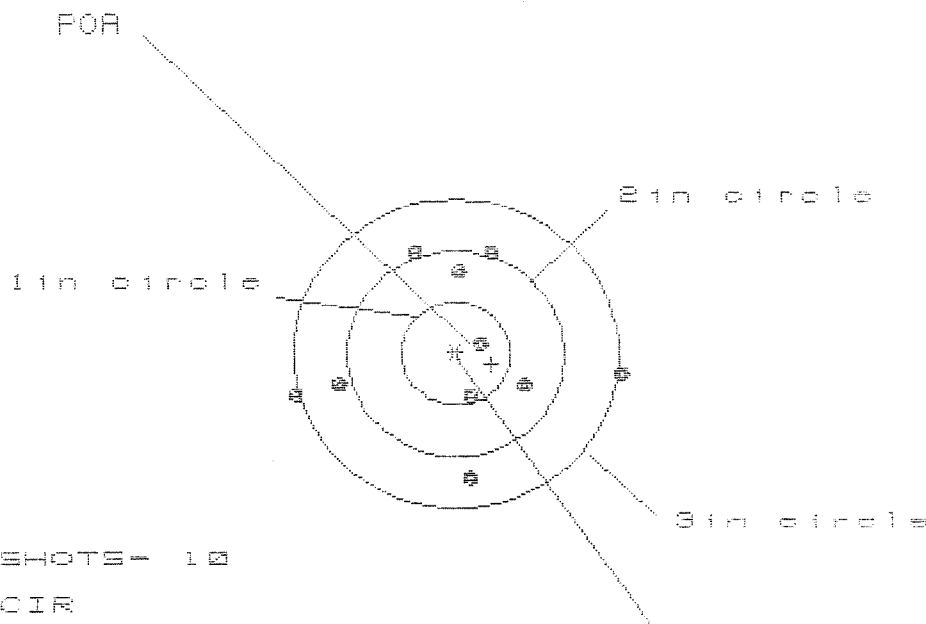
CENTROID *

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	.899
MINIMUM X	-1.326
MAXIMUM Y	1.257
MINIMUM Y	-.955
CENTROID X	.102
CENTROID Y	.236
POA TO CENTROID in.	.257
MIN RADIUS	.343
MEAN RADIUS	.811
MAX RADIUS	1.359
HORIZONTAL SPREAD	2.225
VERTICAL SPREAD	2.212
EXTREME SPREAD	2.378
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	10

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1in = 2

2in = 4

3in = 8

HS = 3.013

VS = 2.236

GS = 3.026

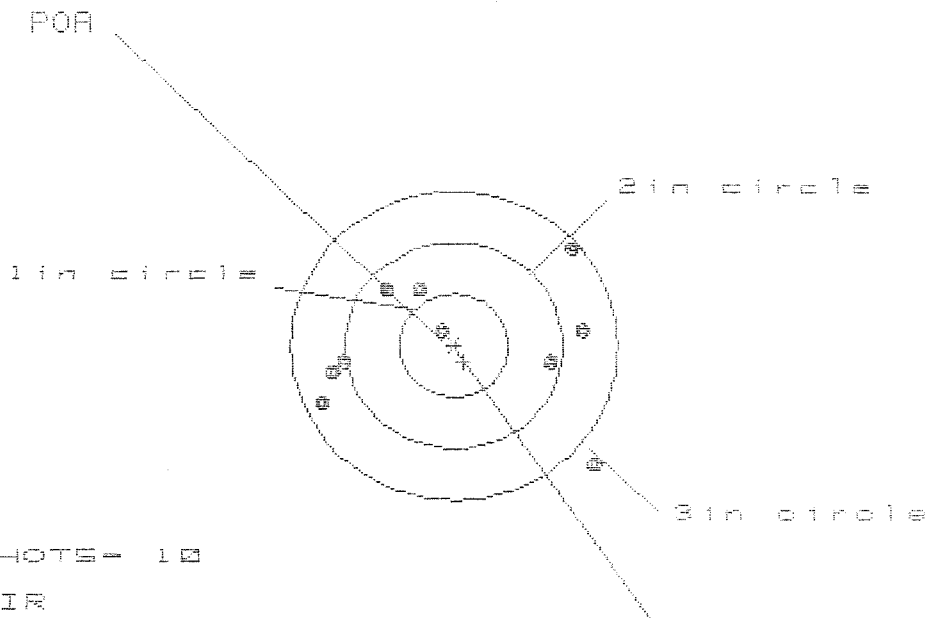
CENTROID *

PATTERN #	1	4	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.501	1.333	.622
MINIMUM X	-1.512	-1.232	-1.065
MAXIMUM Y	1.036	.986	.958
MINIMUM Y	-1.200	-1.250	-1.278
CENTROID X	-.324	-.156	-.323
CENTROID Y	.102	.152	.180
POA TO CENTROID in.	.340	.219	.370
MIN. RADIUS	.233	.058	.220
MEAN RADIUS	.979	.880	.835
MAX RADIUS	1.578	1.352	1.282
HORIZONTAL SPREAD	3.013	2.565	1.687
VERTICAL SPREAD	2.236	2.236	2.236
EXTREME SPREAD	3.026	2.570	2.284
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		8	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS= 2.531

VS= 2.079

GS= 2.701

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.321
MINIMUM X	-1.210
MAXIMUM Y	.913
MINIMUM Y	-1.166
CENTROID X	-.085
CENTROID Y	.156
POA TO CENTROID in.	.177
MIN RADIUS	.183
MEAN RADIUS	1.044
MAX RADIUS	1.762
HORIZONTAL SPREAD	2.531
VERTICAL SPREAD	2.079
EXTREME SPREAD	2.701
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	9