

C6587626

MODEL 700™ M24

Model **SWS**

Action _____™

Barrel Length _____

Capacity _____

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington
REG. U.S. PAT. & TM. OFF.

DU PONT

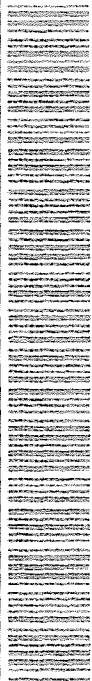
VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.

MODEL 700™ H24

SERIAL NO. C6587626

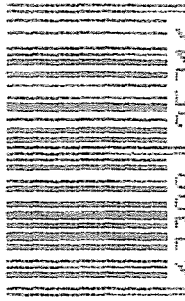
ORDER NO. 5716

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



5716 C6587626

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587626

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1024	90	RW
600	Proof	1024	90	RW
607	Check Headspace	1024	90	RW
610	Dis-assemble Gun	1024	90	RW
612	Magnaflux Barrel Action		10/30/90	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	GA
617	Drill and Tap Sight Holes		11/3/90	FB
618	Polish Barrel RWB		11/6/90	WB
620	Apply Coatings (Barrel Action)		11-26-90	GA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		12/12/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/12/90	RW
	C) Inspect Ejector Hole for Chamfer		12/12/90	RW
	D) Oil Firing Pin Ass'y		12/12/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		1-3-91	GM

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 3/4	4 3/4	4 3/4			1/7/91	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			1/7/91	WB
	H) Trigger Pull Test & Retainability						1-3-91	JH
	I) Firing Pin Indent	021	021	0215			1/3/91	WB
	J) Assemble Stock						1/14/91	RW
	K) Assemble Swivel Studs						1-17-91	JH
	L) Attach Front and Rear Sight Assemblies						1/14/91	RW
	M) Iron Sight Alignment						1/14/91	RW
	N) Detach Front & Rear Sights & place in numbered container						1/14/91	RW
	O) Attach Scope to Rifle						1/14/91	RW
	P) Detach & Attach Scope 20 Times						1/14/91	RW
640	Gallery Target & Test						1-16-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						1-16-91	NF
655	Final Inspection							
	A) Headspace						1-17-91	JH
	B) Trigger Pull	2.41	2.27	2.33	2.31	2.28	1-17-91	JH
	C) Function						1-17-91	JH
660	Pack						3-19-91	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO C6587626

DATE 1-3-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.22	2.50	2.48	2.41	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.50	2.48	2.45	2.27	
PULL #3	2.47	2.49	2.46	2.33	
PULL #4	2.47	2.42	2.49	2.31	
PULL #5	2.48	2.33	2.47	2.28	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.23	3.45		
PULL #2	3.49	3.41		
PULL #3	3.50	3.36		
PULL #4	3.39	3.39		
PULL #5	3.48	3.35		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.46	4.35		4.28
PULL #2	4.40	4.18		4.20
PULL #3	4.43	4.27		4.23
PULL #4	4.42	4.27		4.29
PULL #5	4.50	4.30		4.30
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587626
17 Jan 1991

CENTROIDAL DISTANCES

Ø TO	1	.0878635
1 TO	2	.141032
1 TO	3	.306111
1 TO	4	.310058
1 TO	5	.387769

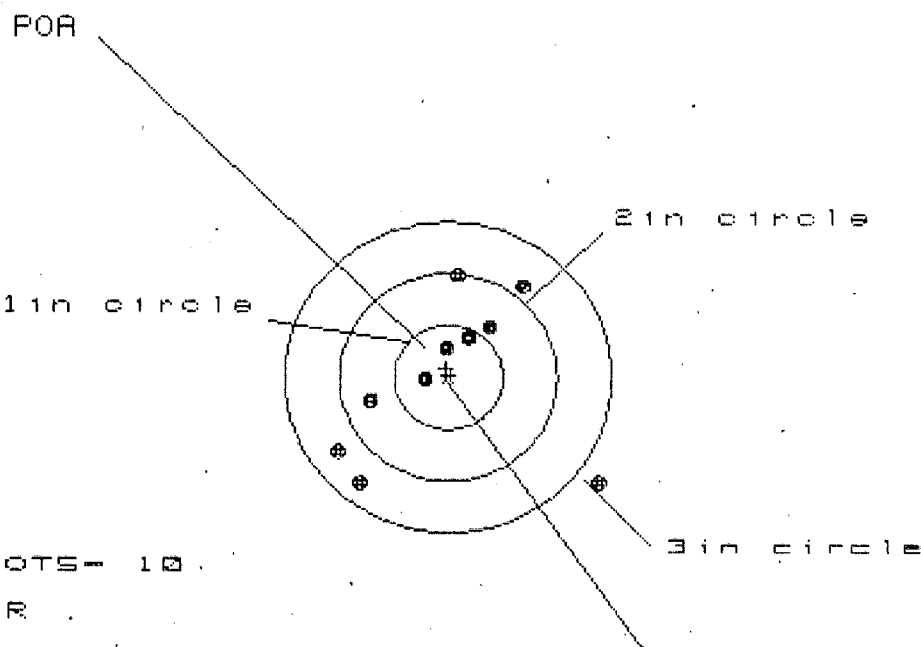
$\frac{5}{1}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .048
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1382
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .146298
THE AMR FOR THIS RIFLE IS: .9358

17 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06587626

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 3

2in = 6

3in = 9

HS = 2.357

VS = 2.041

GS = 2.456

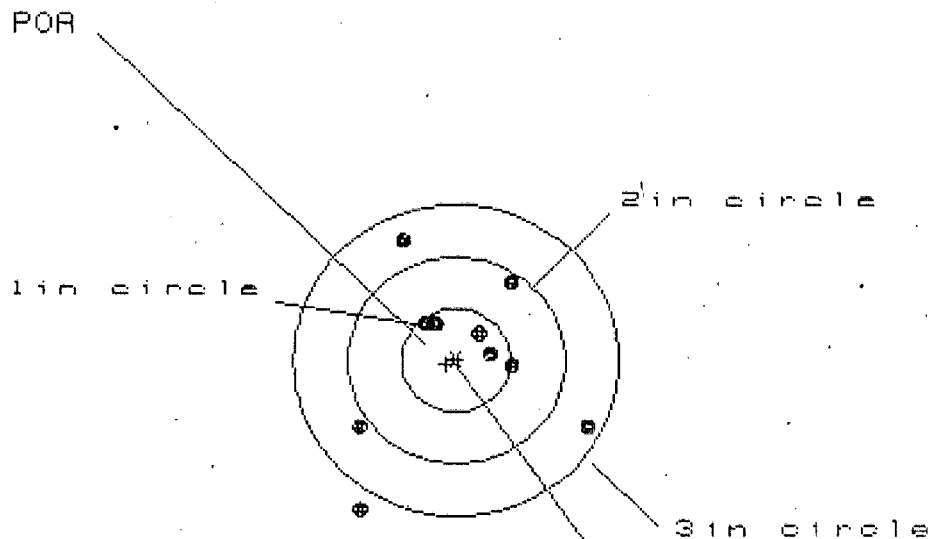
CENTROID #

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.370	.798	.709
MINIMUM X	-.987	-.835	-.924
MAXIMUM Y	.994	.877	.733
MINIMUM Y	-1.047	-1.157	-1.023
CENTROID X	.018	-.134	-.045
CENTROID Y	-.086	.031	.175
POA TO CENTROID in.	.088	.138	.181
MIN RADIUS	.187	.095	.064
MEAN RADIUS	.862	.733	.621
MAX RADIUS	1.725	1.358	1.378
HORIZONTAL SPREAD	2.357	1.633	1.633
VERTICAL SPREAD	2.041	2.034	1.756
EXTREME SPREAD	2.456	2.456	2.328
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

17 Jan 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 4

2in = 6

3in = 9

HS= 2.156

VS= 2.606

GS= 2.651

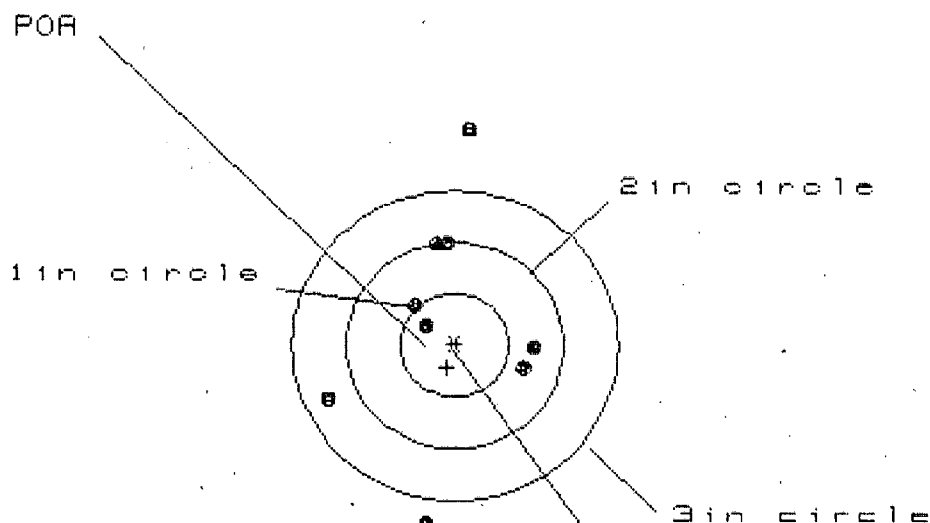
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.225	1.121	.550
MINIMUM X	:	-.931	-1.003	-.863
MAXIMUM Y	:	1.127	.962	.865
MINIMUM Y	:	-1.479	-.835	-.932
CENTROID X	:	.087	.191	.051
CENTROID Y	:	.037	.202	.299
POA TO CENTROID in.	:	.095	.278	.304
MIN RADIUS	:	.291	.107	.195
MEAN RADIUS	:	.834	.676	.585
MAX RADIUS	:	1.748	1.367	1.270
HORIZONTAL SPREAD	:	2.156	2.124	1.413
VERTICAL SPREAD	:	2.606	1.797	1.797
EXTREME SPREAD	:	2.651	2.415	1.960
NUMBER IN ONE INCH CIRCLE =			4	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			9	

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in - 1

2in - 6

3in - 7

HS - 2.044

VS - 4.153

GS - 4.226

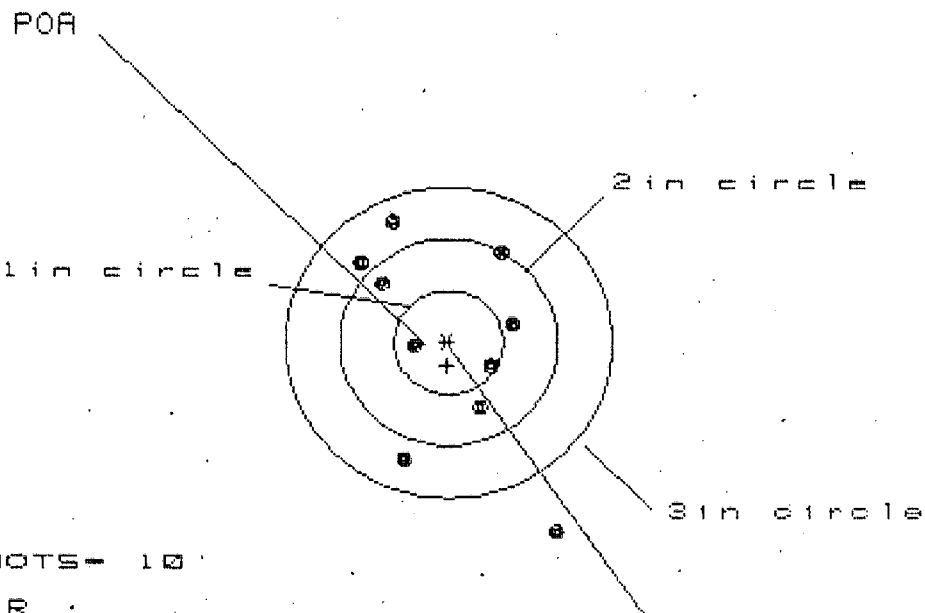
CENTROID #

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.863	.829	.851
MINIMUM X	-1.181	-1.085	-1.063
MAXIMUM Y	2.131	1.906	1.953
MINIMUM Y	-2.022	-1.958	-1.719
CENTROID X	.068	-.028	-.050
CENTROID Y	.216	.441	.202
POA TO CENTROID in.	.226	.442	.209
MIN RADIUS	.283	.150	.209
MEAN RADIUS	1.141	.972	.880
MAX RADIUS	2.199	1.963	1.724
HORIZONTAL SPREAD	2.044	1.914	1.914
VERTICAL SPREAD	4.153	3.864	2.672
EXTREME SPREAD	4.226	3.877	2.675
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	7		

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1in = 2

2in = 5

3in = 9

HS = 1.757

VS = 3.013

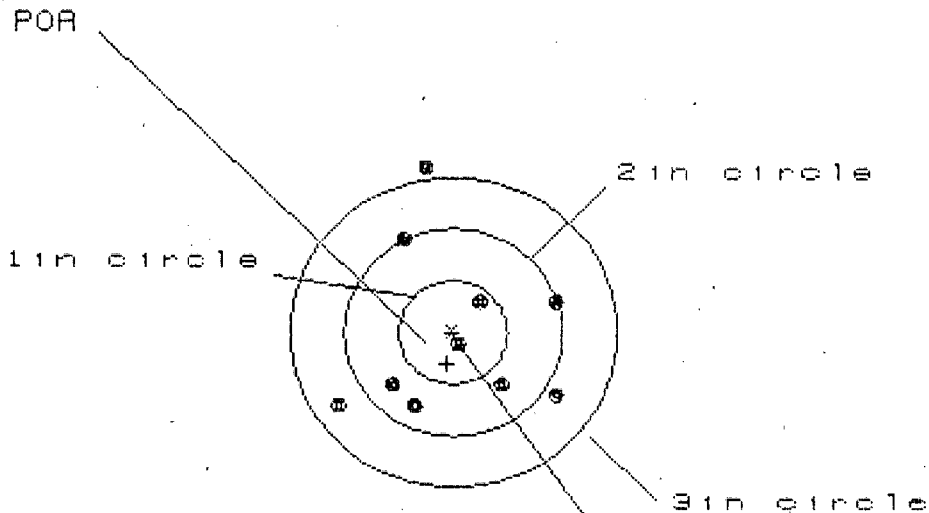
GS = 3.352

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.955	.685	.634
MINIMUM X	:	-.802	-.696	-.747
MAXIMUM Y	:	1.224	1.025	.837
MINIMUM Y	:	-1.789	-1.289	-1.161
CENTROID X	:	.012	-.094	-.043
CENTROID Y	:	.224	.423	.295
POA TO CENTROID in.	:	.225	.434	.298
MIN RADIUS	:	.313	.295	.271
MEAN RADIUS	:	.959	.825	.778
MAX RADIUS	:	2.028	1.334	1.226
HORIZONTAL SPREAD	:	1.757	1.381	1.381
VERTICAL SPREAD	:	3.013	2.314	1.998
EXTREME SPREAD	:	3.352	2.315	2.192
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			9	

17 Jan 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.019

VS= 2.338

GS= 2.491

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.961	.936	.801
MINIMUM X	-1.058	-1.083	-.758
MAXIMUM Y	1.612	1.123	1.055
MINIMUM Y	-.726	-.547	-.615
CENTROID X	.055	.080	.215
CENTROID Y	.300	.121	.189
POA TO CENTROID in.	.305	.145	.287
MIN RADIUS	.167	.069	.083
MEAN RADIUS	.883	.768	.700
MAX RADIUS	1.628	1.212	1.209
HORIZONTAL SPREAD	2.019	2.019	1.559
VERTICAL SPREAD	2.338	1.670	1.670
EXTREME SPREAD	2.491	2.252	2.047
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	