C6587665

MODEL 700™ M24

Model SWS ™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

Remington®

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

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

MODEL 700™ M24

01

SERIAL NO.
C6587665

ORDER NO.
5716

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

5716 C6587665

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587665

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10 9	90	RW
600	Proof	10 9	90	RW
607	Check Headspace	10 9	90	RW
610	Dis-assemble Gun	10 9	90	RW
612	Magnaflux Barrel Action		10/11/90	KP
	Magnaflux Bolt		10/11/90	KP
615	Rollmark Caliber		10/11/90	DB
617	Drill and Tap Sight Holes		10/11/90	KB
618	Polish Barrel RB		10/12/90	WB
620	Apply Coatings (Barrel Action)		10-18-90	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/22/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/22/90	RW
	C) Inspect Ejector Hole for Chamfer		10/22/90	RW
	D) Oil Firing Pin Ass'y		10/22/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11/9/90	WB

op. #	OP. NAME	READINGS			DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2	11/9/90	WB
	G) Safety Off Force	3	3	3	11/9/90	WB
	H) Trigger Pull Test & Retainability				11/9/90	GB
	I) Firing Pin Indent	.020	.020	.020	11/9/90	WB
	J) Assemble Stock				11/10/90	RW
	K) Assemble Swivel Studs				11-20-90	DH
	L) Attach Front and Rear Sight Assemblies				11/10/90	RW
	M) Iron Sight Alignment				11/10/90	RW
	N) Detach Front & Rear Sights & place in numbered container				11/10/90	RW
	O) Attach Scope to Rifle				11/10/90	RW
	P) Detach & Attach Scope 20 Times				11/10/90	RW
640	Gallery Target & Test				11-12-90	[illegible]
	A) Time				"	[illegible]
	B) Malfunctions				"	[illegible]
	C) Pierced Primers				"	[illegible]
	D) Optical Clearity of Scope				"	[illegible]
645	Inspect for Live Ammo				11-12-90	[illegible]
655	Final Inspection A) Headspace				11-20-90	DH
	B) Trigger Pull	2.43	2.48	2.49	11-20-90	DH
		2.48	2.48			
	C) Function				11-20-90	DH
660	Pack				12-17-90	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C6587665
DATE 9 NOV 90
TESTER [illegible]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	256	232	221	243	MIN. SETTING,
PULL #2	250	223	212	248	NO AVG. OF 5
PULL #3	252	227	220	249	READINGS ACCEPT-
PULL #4	255	229	227	248	ABLE LESS THAN 2#
PULL #5	244	221	225	248	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	291	283		
PULL #2	283	283		
PULL #3	291	281		
PULL #4	294	281		
PULL #5	282	280		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	401	390		440
PULL #2	393	391		431
PULL #3	391	388		429
PULL #4	386	390		438
PULL #5	381	388		427
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587665
13 Nov 1990

CENTROIDAL DISTANCES

0	TO	1	.239107
1	TO	2	.545015
1	TO	3	.29805
1	TO	4	.275427
1	TO	5	.627405

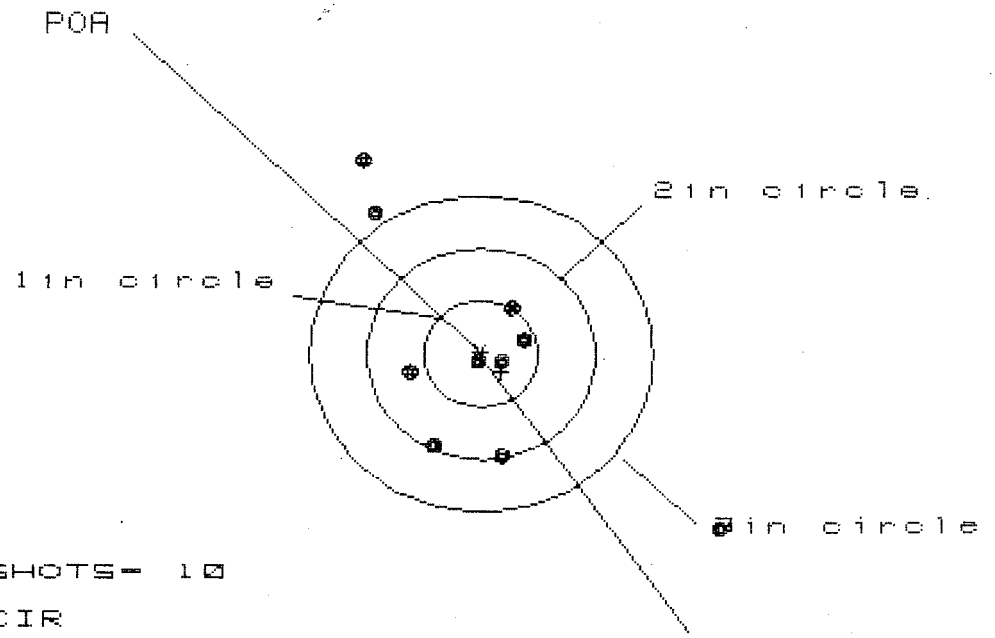
5 $\frac{1}{2}M^2$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1356
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1028
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .170162

THE AMR FOR THIS RIFLE IS: 1.072

12 Nov 1990 FILE:/PATTERNING/CENTERFIRE_PATT/C6587665

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

# IN CIR
1in = 3
2in = 6
3in = 7

HS= 3.122
VS= 3.498
GS= 4.689

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.094	.556	.457
MINIMUM X	:	-1.028	-.796	-.786
MAXIMUM Y	:	1.858	1.676	1.354
MINIMUM Y	:	-1.640	-1.189	-.980
CENTROID X	:	-.174	-.406	-.307
CENTROID Y	:	.164	.346	.137
POA TO CENTROID in.	:	.239	.534	.336
MIN RADIUS	:	.073	.284	.075
MEAN RADIUS	:	1.011	.875	.677
MAX RADIUS	:	2.660	1.855	1.566
HORIZONTAL SPREAD	:	3.122	1.352	1.243
VERTICAL SPREAD	:	3.498	2.865	2.334
EXTREME SPREAD	:	4.689	3.108	2.579
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

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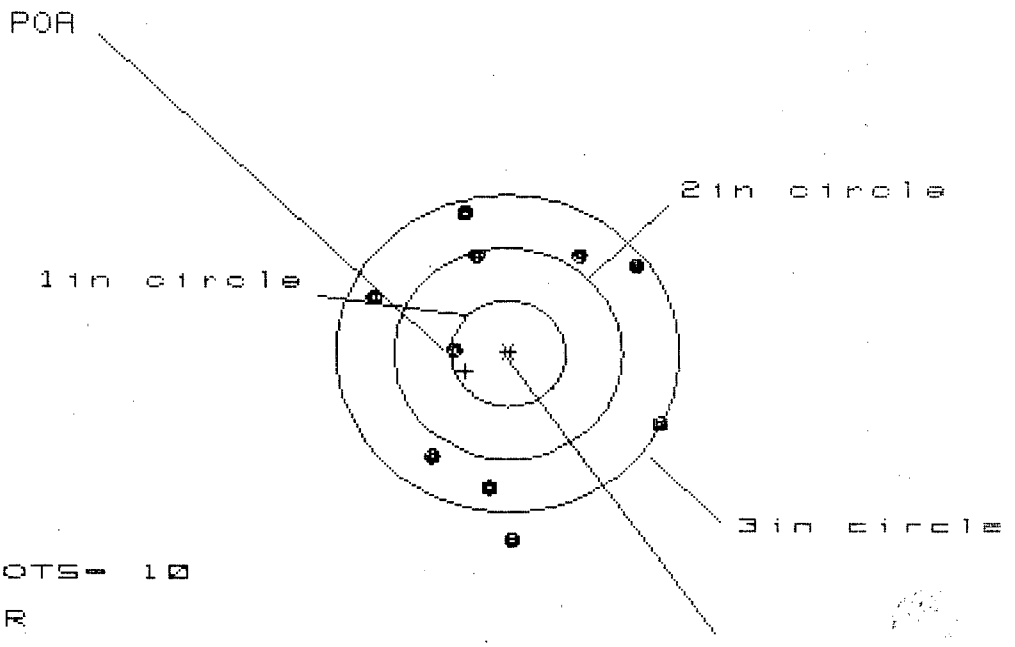
CENTERFIRE PATTERNS # 2



OF SHOTS= 10

# IN CIR	
1in	1
2in	2
3in	8

HS= 2.583
VS= 3.078
GS= 3.104

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.373	1.375	1.265
MINIMUM X	:	-1.210	-1.208	-1.036
MAXIMUM Y	:	1.358	1.167	1.057
MINIMUM Y	:	-1.720	-1.440	-1.550
CENTROID X	:	.371	.369	.197
CENTROID Y	:	.168	.359	.469
POA TO CENTROID in.	:	.407	.515	.509
MIN RADIUS	:	.470	.508	.427
MEAN RADIUS	:	1.238	1.161	1.066
MAX RADIUS	:	1.720	1.631	1.550
HORIZONTAL SPREAD	:	2.583	2.583	2.301
VERTICAL SPREAD	:	3.078	2.607	2.607
EXTREME SPREAD	:	3.104	2.867	2.618
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		8	

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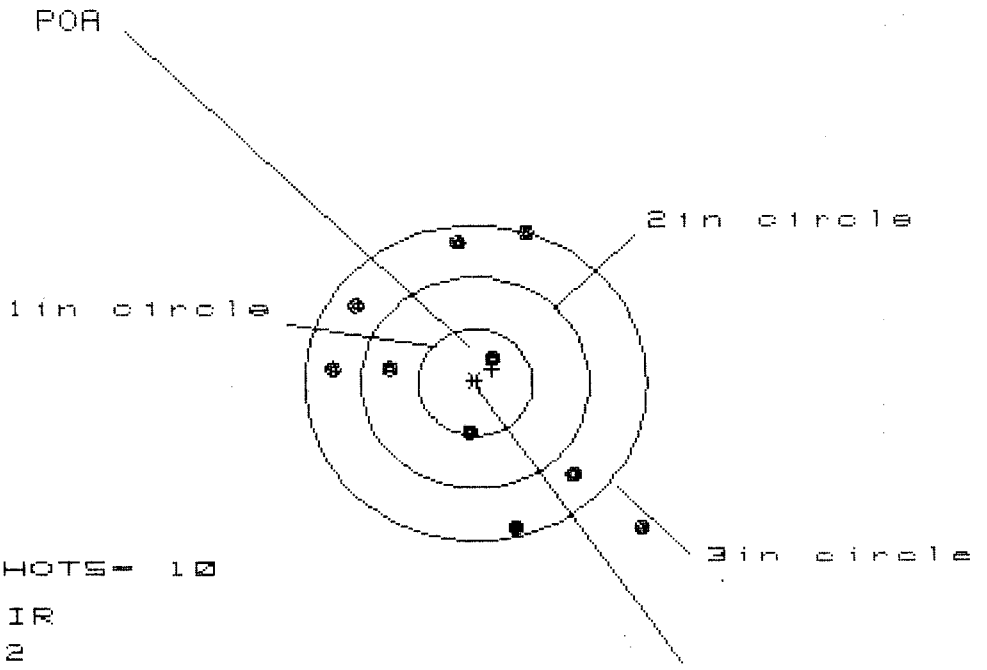
CENTERFIRE PATTERNS # 3



OF SHOTS= 10

# IN CIR
1in = 2
2in = 3
3in = 8

HS= 2.715
VS= 2.859
GS= 3.246

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.428	1.017	1.093
MINIMUM X	:	-1.287	-1.128	-1.051
MAXIMUM Y	:	1.458	1.303	1.303
MINIMUM Y	:	-1.401	-1.477	-1.315
CENTROID X	:	-.149	-.308	-.385
CENTROID Y	:	-.133	.022	-.140
POA TO CENTROID in.	:	.200	.309	.409
MIN RADIUS	:	.298	.335	.456
MEAN RADIUS	:	1.143	1.026	.964
MAX RADIUS	:	2.000	1.562	1.438
HORIZONTAL SPREAD	:	2.715	2.145	2.145
VERTICAL SPREAD	:	2.859	2.780	2.618
EXTREME SPREAD	:	3.246	2.782	2.664
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

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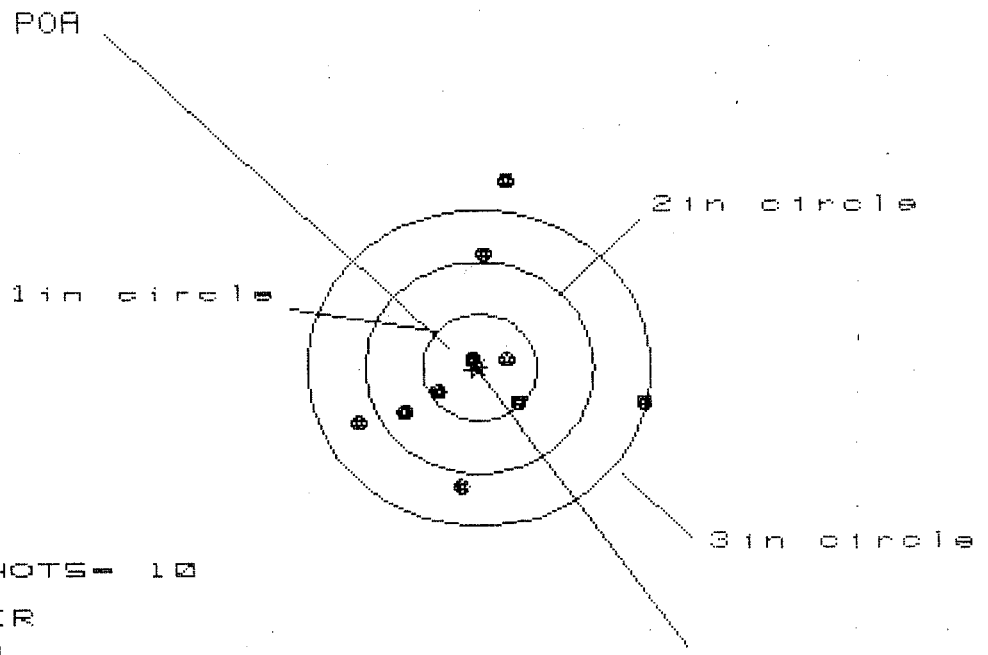
CENTERFIRE PATTERNS # 4



OF SHOTS= 10

# IN CIR
1in = 4
2in = 5
3in = 9

HS= 2.488
VS= 2.956
GS= 2.986

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.452	1.476	.534
MINIMUM X	:	-1.035	-1.012	-.827
MAXIMUM Y	:	1.811	1.261	1.241
MINIMUM Y	:	-1.145	-.944	-.964
CENTROID X	:	.062	.039	-.146
CENTROID Y	:	.022	-.179	-.159
POA TO CENTROID in.	:	.066	.183	.216
MIN RADIUS	:	.123	.320	.147
MEAN RADIUS	:	.877	.763	.653
MAX RADIUS	:	1.824	1.486	1.262
HORIZONTAL SPREAD	:	2.488	2.488	1.361
VERTICAL SPREAD	:	2.956	2.205	2.205
EXTREME SPREAD	:	2.986	2.496	2.217
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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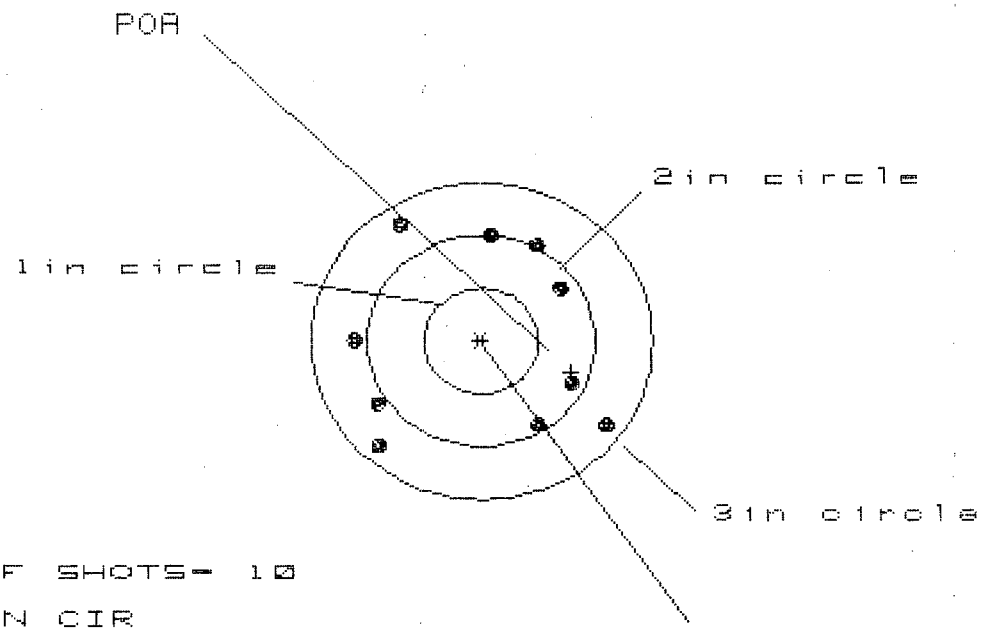
CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 0

2in = 3

3in = 10

HS= 2.258

VS= 2.080

GS= 2.635

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.133	.940	.848
MINIMUM X	:	-1.125	-.999	-1.091
MAXIMUM Y	:	1.073	.982	.845
MINIMUM Y	:	-1.007	-1.098	-1.045
CENTROID X	:	-.788	-.914	-.822
CENTROID Y	:	.293	.384	.521
POA TO CENTROID in.	:	.841	.992	.973
MIN RADIUS	:	.861	.912	.767
MEAN RADIUS	:	1.092	1.051	.994
MAX RADIUS	:	1.395	1.322	1.178
HORIZONTAL SPREAD	:	2.258	1.939	1.939
VERTICAL SPREAD	:	2.080	2.080	1.890
EXTREME SPREAD	:	2.635	2.346	2.213
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		10	