

C6611729

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington




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

MODEL 700TM H24

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

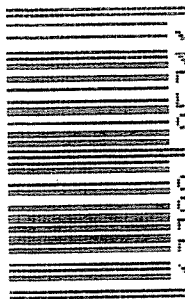
SERIAL NO.
C6611729

ORDER NO.
5716



5716 C6611729

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611729

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 10 91		RW
600	Proof	1 10 91		RW
607	Check Headspace	1 10 91		RW
610	Dis-assemble Gun	1 10 91		RW
612	Magnaflux Barrel Action		1/16/91	KR
	Magnaflux Bolt		11	KR
615	Rollmark Caliber		11	YL
617	Drill and Tap Sight Holes	1 17 91		LB
618	Polish Barrel	1 17 91		WB
620	Apply Coatings (Barrel Action)		2-12-91	TA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/19/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/19/91	RW
	C) Inspect Ejector Hole for Chamfer		2/19/91	RW
	D) Oil Firing Pin Ass'y		2/19/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		3/6/91	SL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			3/6/91	WB
	G) Safety Off Force	3	3	3			3/6/91	WB
	H) Trigger Pull Test & Retainability						3/9/91	JH
	I) Firing Pin Indent	.0215	.0225	.022			3/6/91	WB
	J) Assemble Stock						3/7/91	RW
	K) Assemble Swivel Studs						3-7-91	DH
	L) Attach Front and Rear Sight Assemblies						3/7/91	RW
	M) Iron Sight Alignment						3/7/91	RW
	N) Detach Front & Rear Sights & place in numbered container						3/7/91	RW
	O) Attach Scope to Rifle						3/7/91	RW
	P) Detach & Attach Scope 20 Times						3/7/91	RW
640	Gallery Target & Test						3-7-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						3-7-91	AF
655	Final Inspection							
	A) Headspace						3-7-91	DH
	B) Trigger Pull	2.31	2.26	2.20	2.25	2.25	3/9/91	JH
	C) Function						3-7-91	DH
660	Pack						3-18-91	AF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6611729

DATE 3-6-91

TESTER JJ

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.34	2.55	2.50	2.31	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.38	2.59	2.49	2.26	
PULL #3	2.26	2.32	2.39	2.20	
PULL #4	2.31	2.37	2.36	2.25	
PULL #5	2.31	2.20	2.30	2.25	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.23	3.28		
PULL #2	3.21	3.27		
PULL #3	3.29	3.33		
PULL #4	3.19	3.28		
PULL #5	3.26	3.39		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.39	4.31		4.39
PULL #2	4.27	4.20		4.31
PULL #3	4.22	4.23		4.30
PULL #4	4.13	4.16		4.36
PULL #5	4.23	4.31		
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611729
7 Mar 1991

CENTROIDAL DISTANCES

0 TO 1	.624943
1 TO 2	.558033
1 TO 3	.728437
1 TO 4	.883704
1 TO 5	.490254

POA

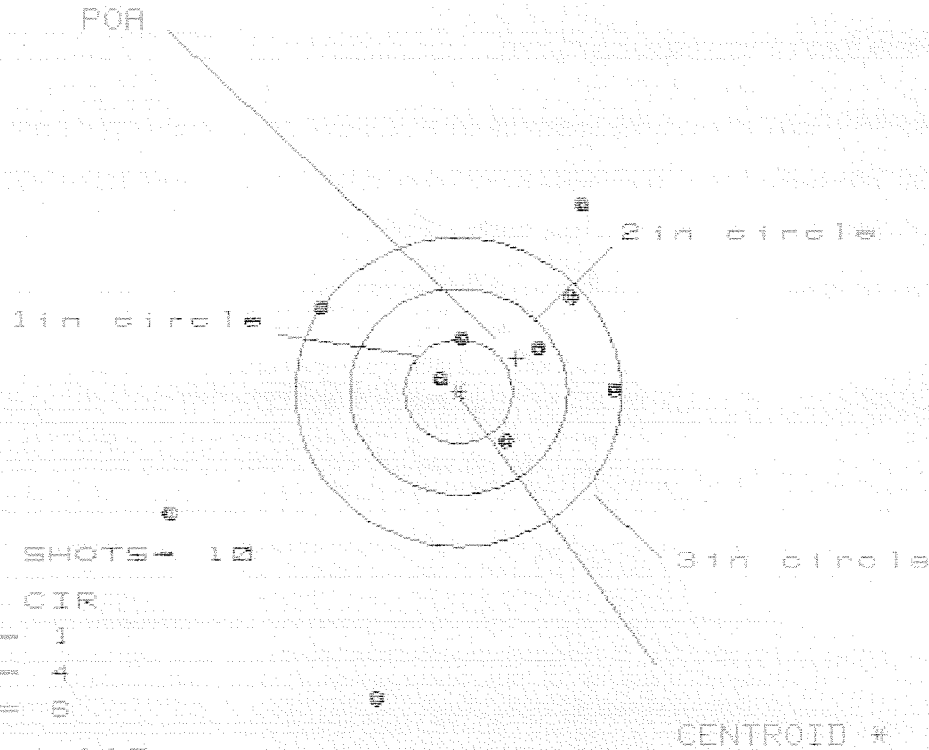
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -1.0366
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -1.1432
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .147883

THE AMR FOR THIS RIFLE IS: 1.055

7 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611729

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in - 1

2in - 4

3in - 5

HS- 4.119

VS- 4.741

GS- 5.109

PATTERN #

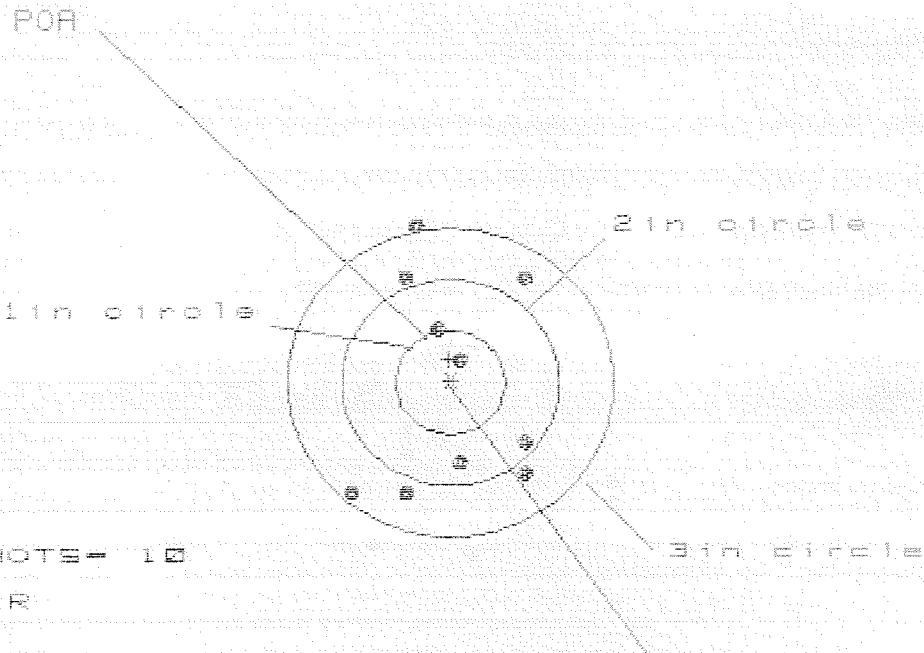
1

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.444	1.363	1.019
MINIMUM X	-2.675	-2.756	-1.702
MAXIMUM Y	1.794	1.467	1.273
MINIMUM Y	-2.947	-1.553	-1.046
CENTROID X	-.535	-.454	-.110
CENTROID Y	-.323	.004	.190
POA TO CENTROID in.	.625	.454	.227
MIN RADIUS	.262	.223	.340
MEAN RADIUS	1.401	1.233	.944
MAX RADIUS	3.034	3.163	1.727
HORIZONTAL SPREAD	4.119	4.119	2.721
VERTICAL SPREAD	4.741	3.020	2.319
EXTREME SPREAD	5.109	4.898	2.824
NUMBER IN ONE INCH CIRCLE	=	1	
NUMBER IN TWO INCH CIRCLE	=	4	
NUMBER IN THREE INCH CIRCLE	=	5	

7 Mar 1991

FILE: PATTERNING/CENTERFIRE_PATT/05611729

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 1

2in = 4

3in = 9

HS = 1.565

VS = 2.570

GS = 2.627

CENTROID #

PATTERN #	:	2
SHOTS (BEST OF)	:	10 9 8
MAXIMUM X	:	.690 .653 .539
MINIMUM X	:	-.875 -.912 -.594
MAXIMUM Y	:	1.408 1.217 1.103
MINIMUM Y	:	-1.082 -.917 -.982
CENTROID X	:	.014 .051 .165
CENTROID Y	:	-.223 -.388 -.274
POA TO CENTROID in.	:	.223 .392 .320
MIN RADIUS	:	.210 .370 .274
MEAN RADIUS	:	.981 .914 .853
MAX RADIUS	:	1.525 1.317 1.253
HORIZONTAL SPREAD	:	1.565 1.565 1.133
VERTICAL SPREAD	:	2.570 2.134 2.085
EXTREME SPREAD	:	2.627 2.582 2.275
NUMBER IN ONE INCH CIRCLE	=	1
NUMBER IN TWO INCH CIRCLE	=	4
NUMBER IN THREE INCH CIRCLE	=	9

7 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CGB11723

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID *

* OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 10

HS= 2.382

VS= 2.108

GS= 2.558

PATTERN #

SHOTS (BEST OF)

MAXIMUM X

MINIMUM X

MAXIMUM Y

MINIMUM Y

CENTROID X

CENTROID Y

POA TO CENTROID in.

MIN RADIUS

MEAN RADIUS

MAX RADIUS

HORIZONTAL SPREAD

VERTICAL SPREAD

EXTREME SPREAD

NUMBER IN ONE INCH CIRCLE =

NUMBER IN TWO INCH CIRCLE =

NUMBER IN THREE INCH CIRCLE =

10

9

8

1.395

-1.987

1.090

-1.018

.151

-.078

.170

.294

.969

1.434

2.382

2.108

2.558

1

4

10

1.473

-1.832

1.053

-1.055

-.004

-.041

.041

.171

.870

1.578

2.305

2.108

2.558

1

4

10

.783

-.648

-.982

-1.126

-.188

.030

.191

.149

.725

1.193

1.431

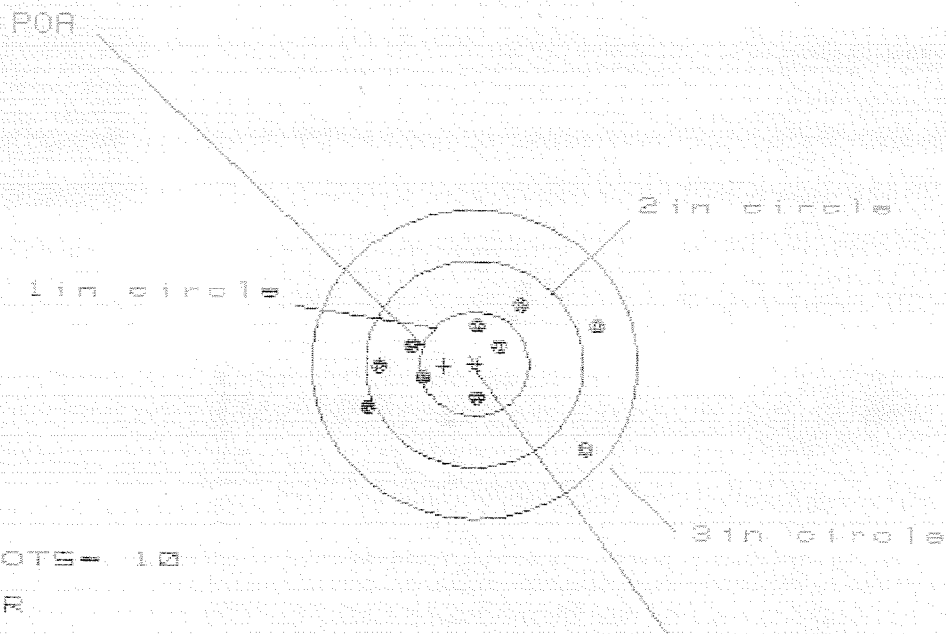
2.108

2.186

7 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611729

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 10

HS= 2.093

VS= 1.395

CS= 2.248

CENTROID *

PATTERN #

4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.163	1.278	.649
MINIMUM X	-.930	-.815	-.655
MAXIMUM Y	.586	.496	.534
MINIMUM Y	-.809	-.521	-.483
CENTROID X	.279	.164	.004
CENTROID Y	.021	.111	.073
POA TO CENTROID in.	.279	.198	.073
MIN RADIUS	.281	.327	.266
MEAN RADIUS	.723	.641	.541
MAX RADIUS	1.312	1.313	.840
HORIZONTAL SPREAD	2.093	2.093	1.304
VERTICAL SPREAD	1.395	1.017	1.017
EXTREME SPREAD	2.248	2.248	1.654
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

2 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611729

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 8

HS= 2.745

VS= 2.683

GS= 2.874

CENTROID *

PATTERN #

:

5

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

.876

.668

.689

MINIMUM X

:

-1.869

-1.350

-1.329

MAXIMUM Y

:

1.113

1.115

.919

MINIMUM Y

:

-1.570

-1.568

-1.536

CENTROID X

:

-.092

.116

.095

CENTROID Y

:

-.113

-.115

.081

POA TO CENTROID in.

:

.146

.163

.125

MIN RADIUS

:

.450

.408

.559

MEAN RADIUS

:

1.122

1.006

.923

MAX RADIUS

:

1.869

1.577

1.540

HORIZONTAL SPREAD

:

2.745

2.018

2.018

VERTICAL SPREAD

:

2.683

2.683

2.455

EXTREME SPREAD

:

2.874

2.687

2.495

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

4

NUMBER IN THREE INCH CIRCLE =

8