

C6649118

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



Remington[®] **DUPONT**
REG. U.S. PAT. & TM. OFF.

MODEL 700TM H24

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

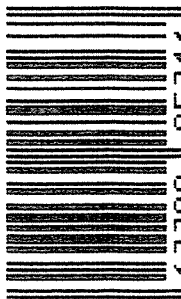
VERY IMPORTANT:
 Instruction Book
 enclosed to assure
 safe use of this
 firearm

SERIAL NO. C6649118	ORDER NO. 5716
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5716 C6649118

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649118

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 30 91		Rw
600	Proof	4 30 91		Rw
607	Check Headspace	4 30 91		Rw
610	Dis-assemble Gun	4 30 91		Rw
612	Magnaflux Barrel Action	5 6 91		KCR
	Magnaflux Bolt	5 6 91		KCR
615	Rollmark Caliber	5 6 91		GB
617	Drill and Tap Sight Holes	5 10 91		FB
618	Polish Barrel	5 10 91		WLB
620	Apply Coatings (Barrel Action)		5/30/91	TA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		5/30/91	Rw
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/91	Rw
	C) Inspect Ejector Hole for Chamfer		5/30/91	Rw
	D) Oil Firing Pin Ass'y		5/30/91	Rw
	E) Adjust Trigger Pull to Min Setting and Stake		5/31/91	JP

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5-31-91	DH
	G) Safety Off Force	2	2	2			5-31-91	DH
	H) Trigger Pull Test & Retainability						5/31/91	JM.
	I) Firing Pin Indent	.020	.021	.020			5-31-91	DH
	J) Assemble Stock						6/3/91	Rw
	K) Assemble Swivel Studs						6-8-91	DH
	L) Attach Front and Rear Sight Assemblies						6/3/91	Rw
	M) Iron Sight Alignment						6/3/91	Rw
	N) Detach Front & Rear Sights & place in numbered container						6/3/91	Rw
	O) Attach Scope to Rifle						6/3/91	Rw
	P) Detach & Attach Scope 20 Times						6/3/91	Rw
640	Gallery Target & Test						6-4-91	DH
	A) Time						6-4-91	DH
	B) Malfunctions						6-4-91	DH
	C) Pierced Primers						6-4-91	DH
	D) Optical Clarity of Scope						6-4-91	DH
645	Inspect for Live Ammo						6-4-91	DH
655	Final Inspection							
	A) Headspace						6-8-91	DH
	B) Trigger Pull	2.55	2.43	2.42	2.34	2.66	6-8-91	JM
	C) Function						6-8-91	DH
660	Pack						6-19-91	N

SWS TRIGGER PULL TEST

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

SERIAL NO C6649118
DATE 5/31/91
TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.51	2.39	2.42	2.55	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.15	2.34	2.40	2.43	
PULL #3	2.43	2.35	2.38	2.42	
PULL #4	2.39	2.40	2.35	2.34	
PULL #5	2.40	2.37	2.39	2.56	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.41	3.46		
PULL #2	3.36	3.41		
PULL #3	3.33	3.40		
PULL #4	3.41	3.45		
PULL #5	3.45	3.49		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.31	4.16		4.19
PULL #2	4.15	4.19		4.17
PULL #3	4.24	4.24		4.21
PULL #4	4.22	4.25		4.26
PULL #5	4.25	4.23		4.21
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649118
4 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.369444
1 TO	2	.641723
1 TO	3	.413048
1 TO	4	.499144
1 TO	5	.0636553

4 3
+ 5
2 <----POA

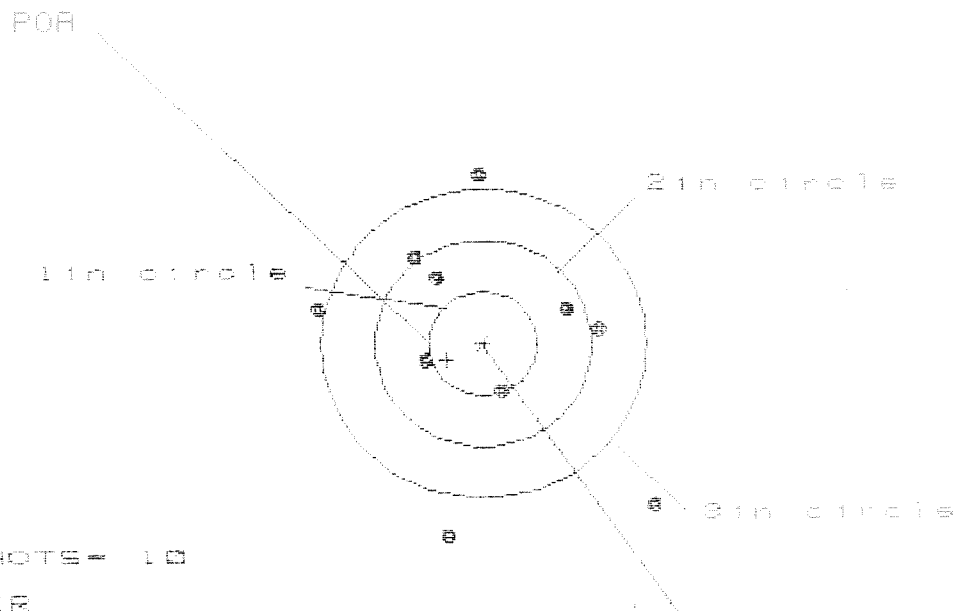
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .152
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1814
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .236064

THE AMR FOR THIS RIFLE IS: 1.079

4 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08649118

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 1

2in = 4

3in = 5

HS = 3.105

VS = 3.540

GS = 3.654

CENTROID =

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.564	1.209	1.191
MINIMUM X	-1.541	-1.367	-1.385
MAXIMUM Y	1.684	1.589	1.255
MINIMUM Y	-1.856	-2.031	-1.847
CENTROID X	.333	.159	.178
CENTROID Y	.160	.335	.503
POA TO CENTROID in.	.369	.371	.615
MIN RADIUS	.445	.498	.316
MEAN RADIUS	1.205	1.062	.914
MAX RADIUS	2.217	2.036	1.387
HORIZONTAL SPREAD	3.105	2.576	2.576
VERTICAL SPREAD	3.540	3.540	2.102
EXTREME SPREAD	3.654	3.549	2.583
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	5		

4 Jun 1991

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CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 3

3 in = 10

HS = 2.286

VS = 2.530

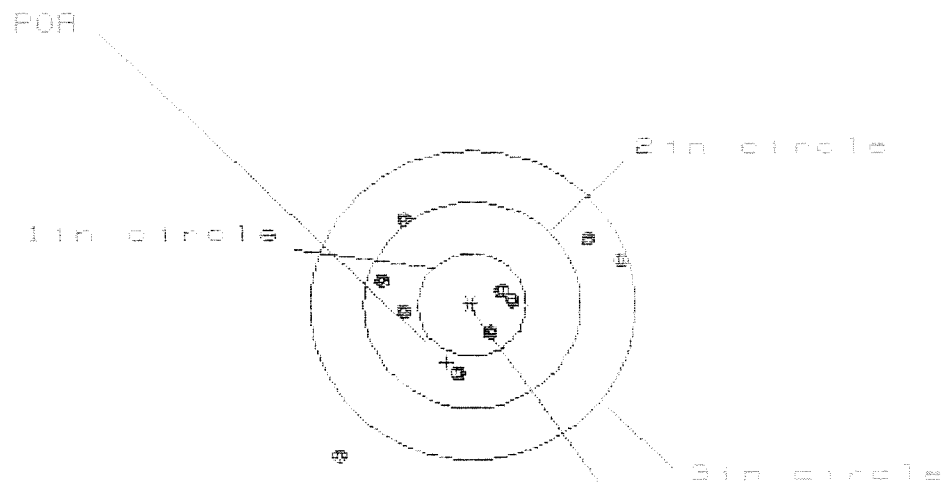
GS = 2.573

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.088	1.085	1.125
MINIMUM X	-1.278	-1.201	-1.161
MAXIMUM Y	1.324	1.190	1.061
MINIMUM Y	-1.266	-1.332	-1.183
CENTROID X	-1.079	-1.156	-1.195
CENTROID Y	-1.332	-1.198	-1.347
POA TO CENTROID in.	.341	.252	.398
MIN RADIUS	.186	.053	.205
MEAN RADIUS	.981	.914	.895
MAX RADIUS	1.391	1.346	1.233
HORIZONTAL SPREAD	2.286	2.286	2.286
VERTICAL SPREAD	2.530	2.522	2.244
EXTREME SPREAD	2.573	2.573	2.386
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		10	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 9

HS= 2.557

VS= 2.297

GS= 3.199

CENTROID *

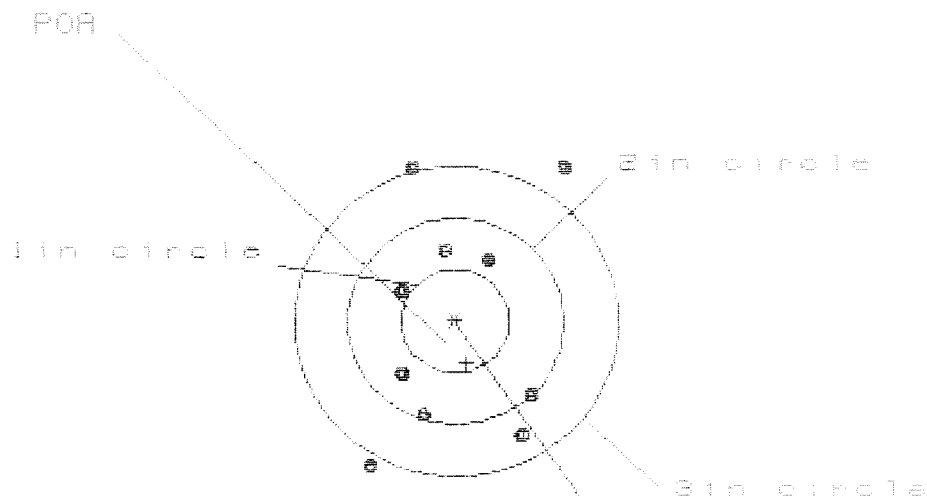
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.344	1.208	1.099
MINIMUM X	-1.223	-1.951	-1.800
MAXIMUM Y	.852	.691	.727
MINIMUM Y	-1.445	-1.794	-1.758
CENTROID X	.238	.366	.215
CENTROID Y	.560	.721	.685
POA TO CENTROID in.	.606	.808	.718
MIN RADIUS	.343	.153	.308
MEAN RADIUS	.876	.746	.686
MAX RADIUS	1.898	1.242	1.321
HORIZONTAL SPREAD	2.567	2.159	1.899
VERTICAL SPREAD	2.297	1.485	1.485
EXTREME SPREAD	3.199	2.172	1.950
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS

4



OF SHOTS- 12

IN CIR

1 in = 0

2 in = 6

3 in = 7

HS= 1.799

VS= 2.910

GS= 3.389

CENTROID #

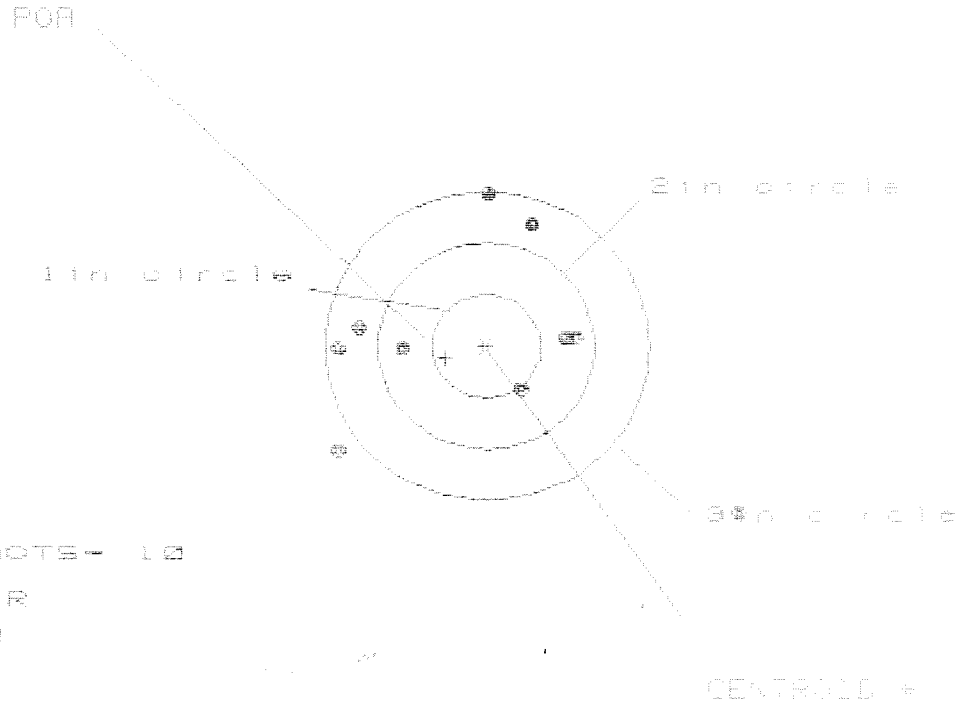
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.021	.775	.692
MINIMUM X	-.777	-.663	-.497
MAXIMUM Y	1.536	1.696	1.545
MINIMUM Y	-1.386	-1.214	-1.081
CENTROID X	-.103	-.217	-.134
CENTROID Y	.403	.237	.388
POA TO CENTROID in.	.416	.321	.411
MIN RADIUS	.522	.538	.502
MEAN RADIUS	1.070	.969	.911
MAX RADIUS	1.809	1.720	1.588
HORIZONTAL SPREAD	1.798	1.438	1.189
VERTICAL SPREAD	2.910	2.910	2.628
EXTREME SPREAD	3.389	2.935	2.800
NUMBER IN ONE INCH CIRCLE =	0	0	0
NUMBER IN TWO INCH CIRCLE =	6	6	6
NUMBER IN THREE INCH CIRCLE =	7	7	7

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CENTERFIRE PATTERNS

5



OF SHOTS - 10

IN CIR

1in = 0

2in = 4

3in = 8

HS = 3.723

VS = 3.092

GS = 4.007

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.013	1.049	1.905
MINIMUM X	-1.413	-1.153	-1.222
MAXIMUM Y	1.465	1.384	1.139
MINIMUM Y	-1.627	-1.159	-1.718
CENTROID X	.379	.122	.267
CENTROID Y	.116	.297	.442
POA TO CENTROID in.	.397	.321	.516
MIN RADIUS	.521	.572	.762
MEAN RADIUS	1.263	1.069	.996
MAX RADIUS	2.028	1.635	1.256
HORIZONTAL SPREAD	3.723	2.262	2.126
VERTICAL SPREAD	3.092	2.443	1.857
EXTREME SPREAD	4.007	2.872	2.141
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	4	
NUMBER IN THREE INCH CIRCLE	=	8	