

C6611590

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington[®]

MODEL 700TM H24

DU PONT
REG. U.S. PAT. & TM. OFF.

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

SERIAL NO.
C6611590

ORDER NO.
5716

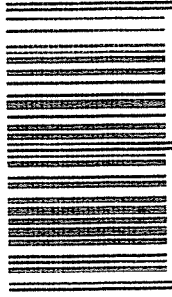
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MADE IN LION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



5716 C6611590

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

C

GUN SERIAL # C6611590

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		Kcd
	Magnaflux Bolt	5 6 91		Kcd
615	Rollmark Caliber	5 6 91		GS
617	Drill and Tap Sight Holes	5 10 91		FB
618	Polish Barrel	5 10 91		WB
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)		5-30-91	JA
625	Final Assembly			
	A) Clean inside of Bolt Assembly		6/19/91	Rw
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6/19/91	Rw
	C) Inspect Ejector Hole for Chamfer		6/19/91	Rw
	D) Oil Firing Pin Ass'y		6/19/91	Rw
	E) Adjust Trigger Pull to Min Setting and Stake		7-18-91	JH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			7-18-91	RL
	G) Safety Off Force	3	3	3			7-18-91	RL
	H) Trigger Pull Test & Retainability						7-18-91	RL
	I) Firing Pin Indent	.021	.021	.0215			7-18-91	RL
	J) Assemble Stock						7/23/91	RW
	K) Assemble Swivel Studs						7-24-91	D/H
	L) Attach Front and Rear Sight Assemblies						7/23/91	RW
	M) Iron Sight Alignment						7/23/91	RW
	N) Detach Front & Rear Sights & place in numbered container						7/23/91	RW
	O) Attach Scope to Rifle						7/23/91	RW
	P) Detach & Attach Scope 20 Times						7/23/91	RW
640	Gallery Target & Test						7/23/91	RF
	A) Time						"	RF
	B) Malfunctions						"	RF
	C) Pierced Primers						"	RF
	D) Optical Clarity of Scope						"	RF
645	Inspect for Live Ammo						7/23/91	RF
655	Final Inspection							
	A) Headspace						7-24-91	D/H
	B) Trigger Pull	2.18	2.20	2.15	2.18	2.22	7-24-91	RL
	C) Function						7-24-91	D/H
660	Pack						9-18-91	RF

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6611590
DATE 7-18-91
TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.60	2.60	2.43	2.18	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.58	2.49	2.40	2.20	
PULL #3	2.60	2.33	2.25	2.15	
PULL #4	2.63	2.24	2.24	2.18	
PULL #5	2.52	2.23	2.124	2.22	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.31	3.39		
PULL #2	3.49	3.44		
PULL #3	3.47	3.44		
PULL #4	3.20	3.46		
PULL #5	3.37	3.37		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.37	4.20		4.22
PULL #2	4.22	4.15		4.15
PULL #3	4.15	4.16		4.32
PULL #4	4.20	4.15		4.35
PULL #5	4.19	4.23		4.30
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611590
23 Jul 1991

CENTROIDAL DISTANCES

0 TO	1	.0859127
1 TO	2	.242909
1 TO	3	.108167
1 TO	4	.226771
1 TO	5	.280879

⊗ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1836
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .014
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .184133
THE AMR FOR THIS RIFLE IS: .9542

23 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611590

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 8

HS= 3.199

VS= 1.679

GS= 3.388

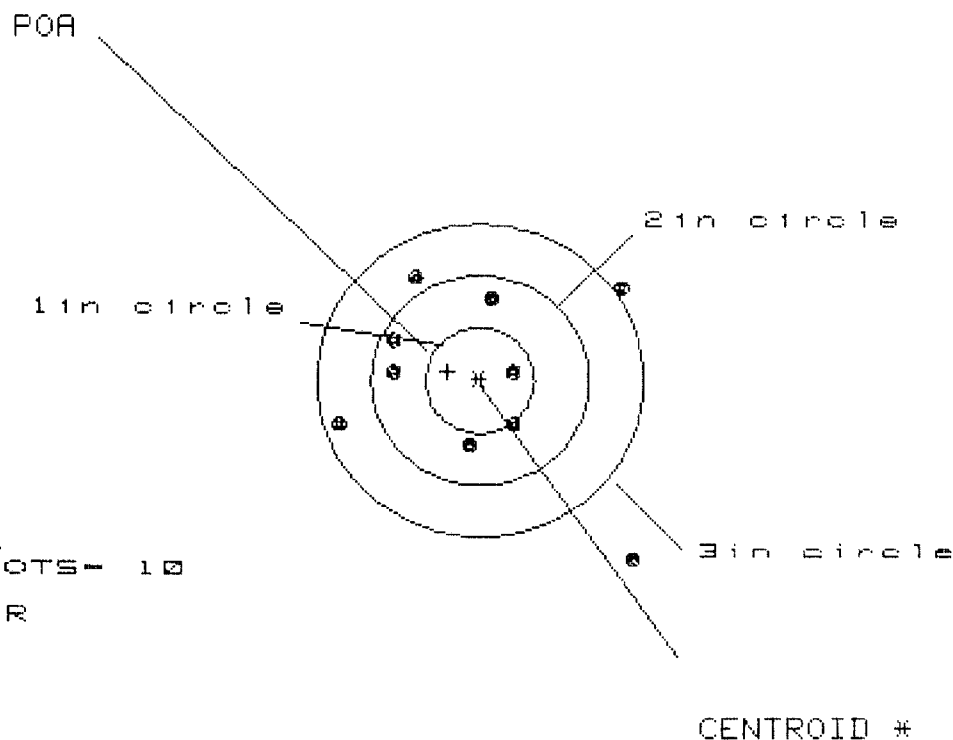
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.802	1.286	1.138
MINIMUM X	:	-1.397	-1.196	-1.344
MAXIMUM Y	:	.986	.922	.987
MINIMUM Y	:	-.693	-.757	-.692
CENTROID X	:	.055	-.146	.002
CENTROID Y	:	-.066	-.002	-.067
POA TO CENTROID in.	:	.085	.146	.067
MIN RADIUS	:	.540	.362	.504
MEAN RADIUS	:	1.039	.918	.871
MAX RADIUS	:	1.891	1.378	1.354
HORIZONTAL SPREAD	:	3.199	2.482	2.482
VERTICAL SPREAD	:	1.679	1.679	1.679
EXTREME SPREAD	:	3.388	2.669	2.551
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 8

HS= 2.701

VS= 2.626

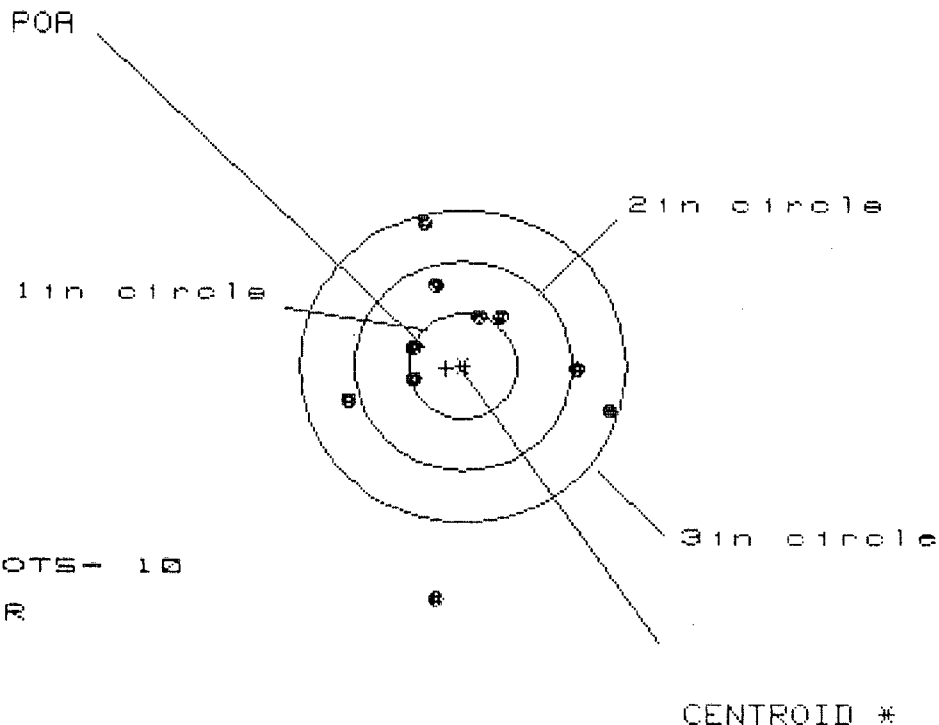
GS= 3.323

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.442	1.475	.677
MINIMUM X	:	-1.260	-1.099	-.915
MAXIMUM Y	:	.955	.769	.861
MINIMUM Y	:	-1.671	-.847	-.755
CENTROID X	:	.297	.136	-.048
CENTROID Y	:	-.087	.099	.007
POA TO CENTROID in.	:	.309	.169	.049
MIN RADIUS	:	.340	.506	.407
MEAN RADIUS	:	1.022	.870	.750
MAX RADIUS	:	2.207	1.648	1.046
HORIZONTAL SPREAD	:	2.701	2.574	1.592
VERTICAL SPREAD	:	2.626	1.616	1.616
EXTREME SPREAD	:	3.323	2.900	1.850
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10
 # IN CIR
 1in = 2
 2in = 5
 3in = 9
 HS= 2.325
 VS= 3.570
 GS= 3.571

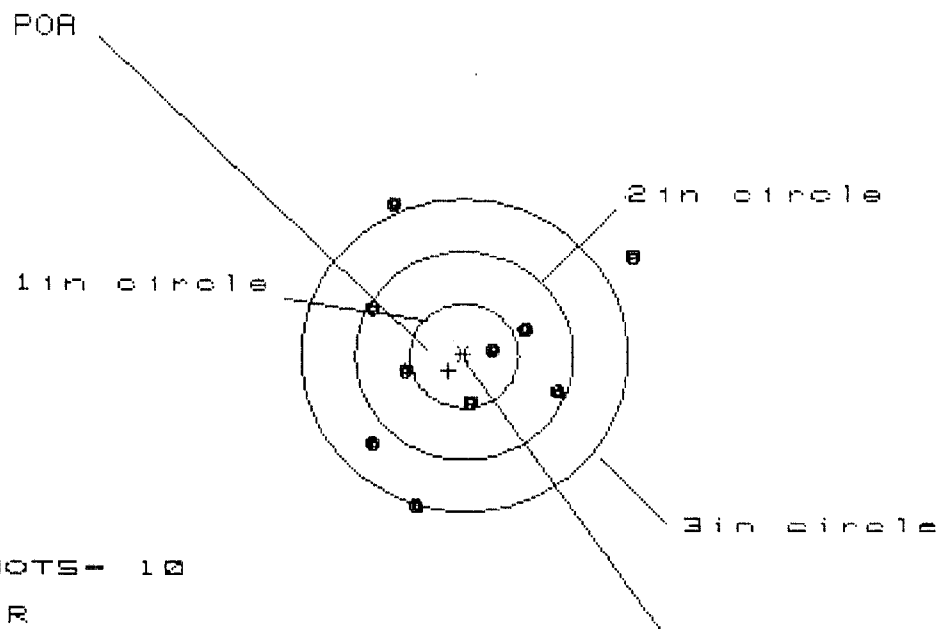
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.307	1.279	1.233
MINIMUM X	:	-1.018	-1.046	-1.092
MAXIMUM Y	:	1.341	1.093	.675
MINIMUM Y	:	-2.229	-.698	-.561
CENTROID X	:	.155	.183	.229
CENTROID Y	:	.024	.272	.135
POA TO CENTROID in.	:	.157	.327	.266
MIN RADIUS	:	.452	.247	.368
MEAN RADIUS	:	.994	.801	.772
MAX RADIUS	:	2.243	1.457	1.355
HORIZONTAL SPREAD	:	2.325	2.325	2.325
VERTICAL SPREAD	:	3.570	1.791	1.236
EXTREME SPREAD	:	3.571	2.435	2.329
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	9		

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CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 2.475

VS= 2.917

GS= 3.115

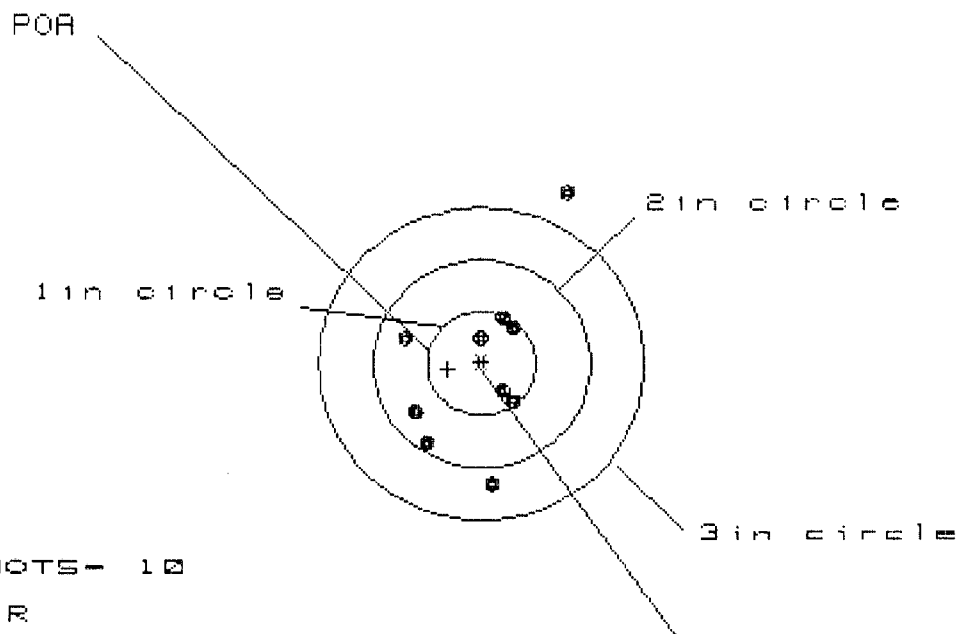
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.595	1.020	.967
MINIMUM X	:	-.880	-.702	-.755
MAXIMUM Y	:	1.498	1.599	.787
MINIMUM Y	:	-1.419	-1.318	-1.118
CENTROID X	:	.143	-.035	.018
CENTROID Y	:	.143	.042	-.158
POA TO CENTROID in.	:	.202	.054	.159
MIN RADIUS	:	.290	.366	.244
MEAN RADIUS	:	.997	.894	.779
MAX RADIUS	:	1.836	1.654	1.172
HORIZONTAL SPREAD	:	2.475	1.722	1.722
VERTICAL SPREAD	:	2.917	2.917	1.905
EXTREME SPREAD	:	3.115	2.920	1.965
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 5

2in = 8

3in = 9

HS= 1.513

VS= 2.758

GS= 2.844

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.784	.403	.425
MINIMUM X	:	-.729	-.642	-.620
MAXIMUM Y	:	1.633	.639	.521
MINIMUM Y	:	-1.125	-.943	-.680
CENTROID X	:	.308	.221	.199
CENTROID Y	:	.056	-.126	-.008
POA TO CENTROID in.	:	.313	.254	.199
MIN RADIUS	:	.218	.293	.297
MEAN RADIUS	:	.719	.597	.542
MAX RADIUS	:	1.812	.959	.784
HORIZONTAL SPREAD	:	1.513	1.045	1.045
VERTICAL SPREAD	:	2.758	1.582	1.201
EXTREME SPREAD	:	2.844	1.595	1.387
NUMBER IN ONE INCH CIRCLE =			5	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			9	