

C5522307

MODEL 700™ M24

Model **SWS**™

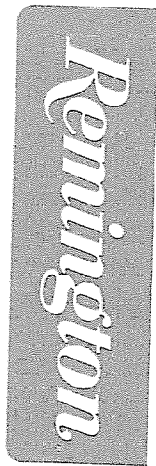
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522307

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/25/90	KA
600	Proof		6/25/90	KA
607	Check Headspace		6/25/90	KA
610	Dis-assemble Gun		6/25/90	KA
612	Magnaflux Barrel Action		7/10/90	KR
	Magnaflux Bolt		7/10/90	KR
615	Rollmark Caliber		7/10/90	G.S.
617	Drill and Tap Sight Holes		7/11/90	LB
618	Polish Barrel RB		7/13/90	WB
620	Apply Coatings (Barrel Action)		7-23-90	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/30/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/30/90	KS
	C) Inspect Ejector Hole for Chamfer		7/30/90	KS
	D) Oil Firing Pin Ass'y		7/30/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		8/23/90	KS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	4	4			7/27/90	RL
	G) Safety Off Force	3	2	2			7/27/90	RL
	H) Trigger Pull Test & Retainability						8/23/90	RL
	I) Firing Pin Indent	.0235	.0235	.0235			7/27/90	RL
	J) Assemble Stock						7/31/90	KS
	K) Assemble Swivel Studs						8/29/90	KS
	L) Attach Front and Rear Sight Assemblies						7/31/90	KS
	M) Iron Sight Alignment						7/31/90	KS
	N) Detach Front & Rear Sights & place in numbered container						7/31/90	KS
	O) Attach Scope to Rifle						7/31/90	KS
	P) Detach & Attach Scope 20 Times						7/31/90	KS
640	Gallery Target & Test						8-1-90	DH
	A) Time						8-1-90	DH
	B) Malfunctions						8-1-90	DH
	C) Pierced Primers						8-1-90	DH
	D) Optical Clarity of Scope						8-1-90	DH
645	Inspect for Live Ammo						8-1-90	DH
655	Final Inspection							
	A) Headspace						8/23/90	RL
	B) Trigger Pull	2.50	2.51	2.50	2.45	2.39	8/23/90	RL
	C) Function						8/29/90	RL
660	Pack						9/20/90	AF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6522307

DATE 8/23/90

TESTER 821

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.49	2.47	2.50	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.34	2.50	2.51	
PULL #3	2.45	2.50	2.41	2.50	
PULL #4	2.44	2.51	2.46	2.45	
PULL #5	2.40	2.50	2.49	2.39	
TOTAL	12.11	12.34	12.33	12.35	
AVG.	2.422	2.468	2.466	2.47	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.42	3.48		
PULL #2	3.44	3.48		
PULL #3	3.38	3.47		
PULL #4	3.40	3.49		
PULL #5	3.42	3.45		
TOTAL	17.06	17.37		
AVG.	3.412	3.474		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.39	4.30		4.30
PULL #2	4.26	4.33		4.33
PULL #3	4.22	4.33		4.40
PULL #4	4.34	4.33		4.41
PULL #5	4.27	4.31		4.40
TOTAL	21.48	21.60		21.84
AVG.	4.296	4.32		4.368

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06522307
1 Aug 1990

CENTROIDAL DISTANCES

0 TO 1	.111503
1 TO 2	.140007
1 TO 3	.0480104
1 TO 4	.186698
1 TO 5	.290016

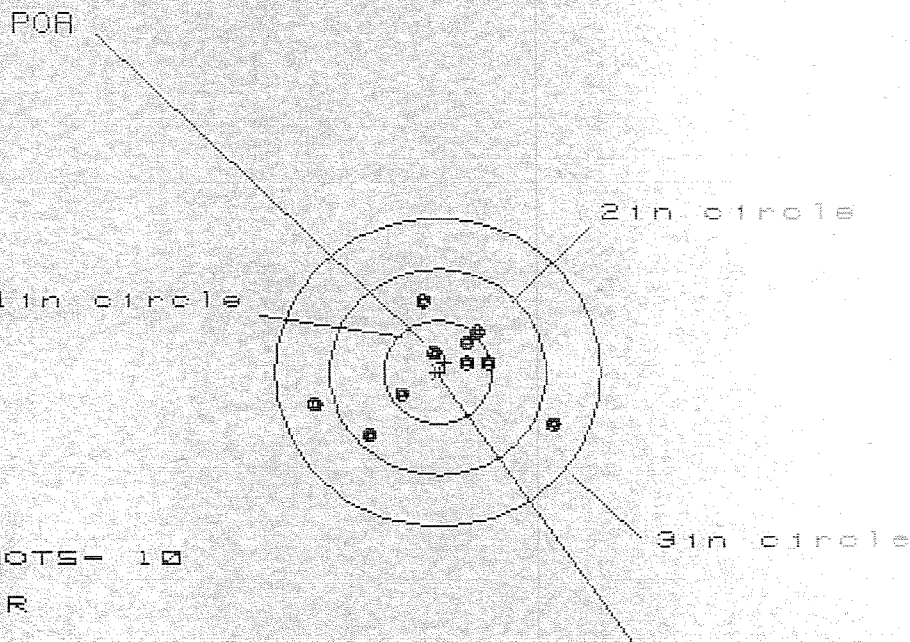
5 (---POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.119
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0124
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .119644
THE AMR FOR THIS RIFLE IS: .7638

1 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522307

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 5

2in = 8

3in = 10

HS= 2.222

VS= 1.279

GS= 2.232

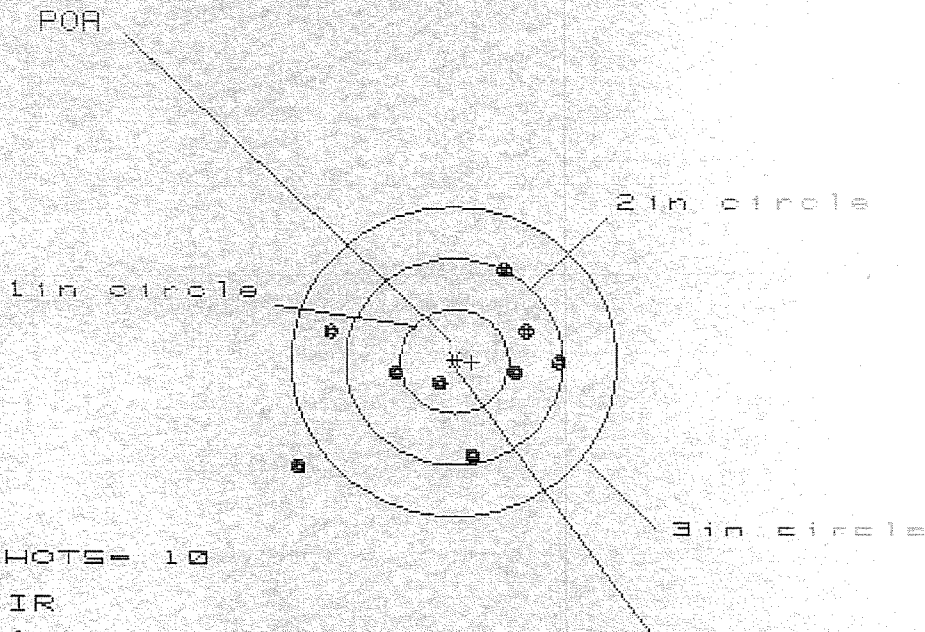
CENTROID *

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.038	.906	.395
MINIMUM X	:	-1.184	-.761	-.647
MAXIMUM Y	:	.653	.620	.552
MINIMUM Y	:	-.626	-.659	-.727
CENTROID X	:	-.063	.069	-.045
CENTROID Y	:	-.092	-.059	.009
POA TO CENTROID in.	:	.111	.090	.045
MIN RADIUS	:	.156	.144	.058
MEAN RADIUS	:	.610	.512	.434
MAX RADIUS	:	1.220	1.056	.973
HORIZONTAL SPREAD	:	2.222	1.667	1.042
VERTICAL SPREAD	:	1.279	1.279	1.279
EXTREME SPREAD	:	2.232	1.671	1.388
NUMBER IN ONE INCH CIRCLE =	:	5		
NUMBER IN TWO INCH CIRCLE =	:	8		
NUMBER IN THREE INCH CIRCLE =	:	10		

1 Aug 1998

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 6

3 in = 9

HS= 2.356

VS= 1.931

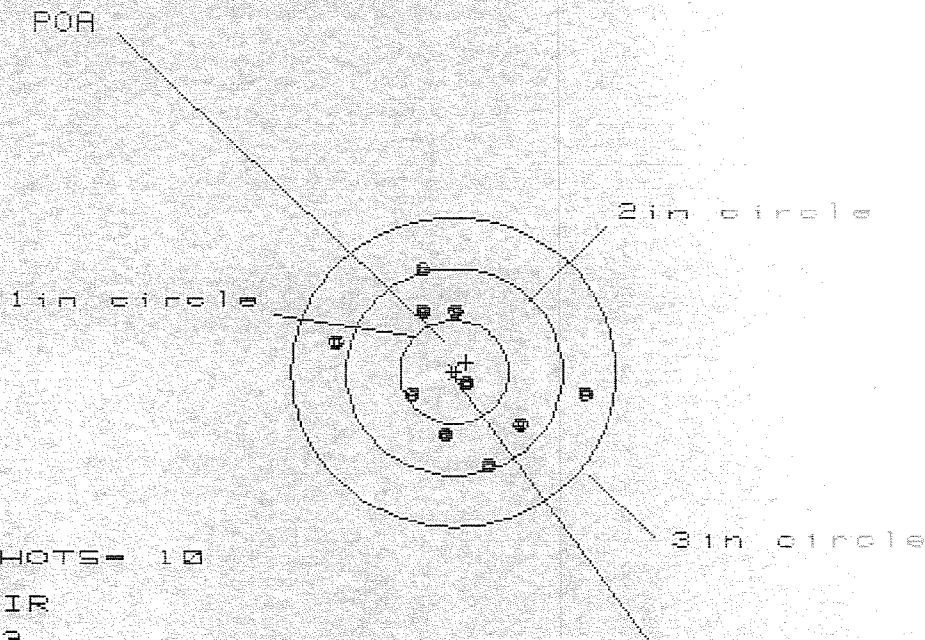
GS= 2.713

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.915	.755	.591
MINIMUM X	:	-1.441	-1.314	-.870
MAXIMUM Y	:	.906	.792	.821
MINIMUM Y	:	-1.025	-1.033	-1.004
CENTROID X	:	-.162	-.002	.162
CENTROID Y	:	.007	.121	.092
POA TO CENTROID in.	:	.162	.121	.187
MIN RADIUS	:	.264	.449	.367
MEAN RADIUS	:	.904	.788	.690
MAX RADIUS	:	1.768	1.333	1.024
HORIZONTAL SPREAD	:	2.356	2.069	1.461
VERTICAL SPREAD	:	1.931	1.825	1.825
EXTREME SPREAD	:	2.713	2.101	1.854
NUMBER IN ONE INCH CIRCLE	=		1	
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 = 2

2in = 7

3in = 10

HS= 2.338

VS= 1.890

GS= 2.396

CENTROID #

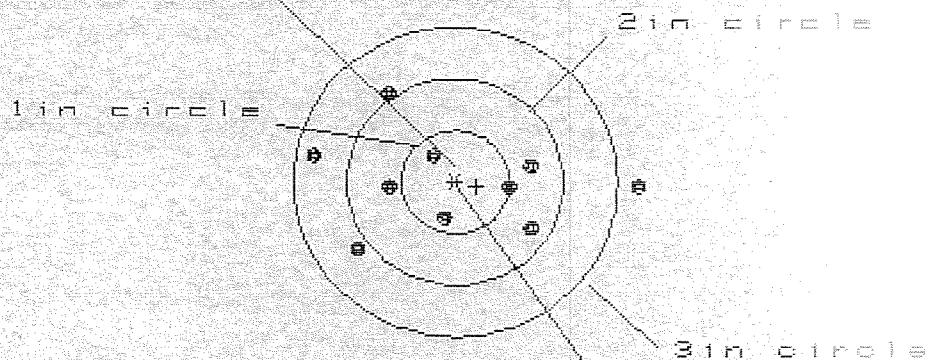
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.245	.734	.615
MINIMUM X	:	-1.093	-.955	-.377
MAXIMUM Y	:	.964	.941	.978
MINIMUM Y	:	-.926	-.949	-.911
CENTROID X	:	-.111	-.249	-.130
CENTROID Y	:	-.093	-.071	-.108
POA TO CENTROID in.	:	.145	.259	.169
MIN RADIUS	:	.121	.247	.125
MEAN RADIUS	:	.756	.695	.643
MAX RADIUS	:	1.261	1.045	1.022
HORIZONTAL SPREAD	:	2.338	1.689	.992
VERTICAL SPREAD	:	1.890	1.890	1.890
EXTREME SPREAD	:	2.396	1.987	1.987
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

1 Aug 1990

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CENTERFIRE PATTERNS # 4

POA



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

CENTROID *

HS= 2.977

VS= 1.516

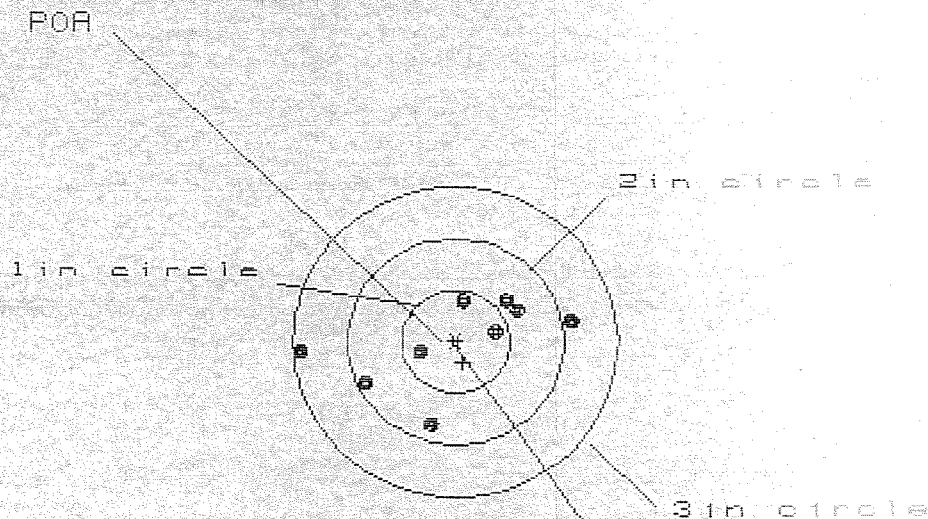
GS= 2.993

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.707	.893	.758
MINIMUM X	:	-1.270	-1.080	-.817
MAXIMUM Y	:	.879	.871	.900
MINIMUM Y	:	-.637	-.645	-.616
CENTROID X	:	-.193	-.383	-.248
CENTROID Y	:	.042	.050	.022
POA TO CENTROID in.:	:	.198	.386	.249
MIN RADIUS	:	.326	.285	.290
MEAN RADIUS	:	.845	.735	.679
MAX RADIUS	:	1.709	1.104	1.051
HORIZONTAL SPREAD	:	2.977	1.973	1.575
VERTICAL SPREAD	:	1.516	1.516	1.516
EXTREME SPREAD	:	2.993	2.073	1.825
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10
 # IN CIR
 1 in = 4
 2 in = 8
 3 in = 10
 HS= 2.475
 VS= 1.217
 GS= 2.501

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.040	.880	.494
MINIMUM X	:	-1.435	-1.036	-.926
MAXIMUM Y	:	.426	.410	.434
MINIMUM Y	:	-.791	-.807	-.782
CENTROID X	:	-.066	.094	-.016
CENTROID Y	:	.198	.214	.190
POA TO CENTROID in.	:	.209	.234	.190
MIN RADIUS	:	.331	.205	.318
MEAN RADIUS	:	.704	.582	.559
MAX RADIUS	:	1.443	1.116	1.005
HORIZONTAL SPREAD	:	2.475	1.916	1.420
VERTICAL SPREAD	:	1.217	1.217	1.217
EXTREME SPREAD	:	2.501	2.012	1.593
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

Remington®

MODEL 700™ 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.

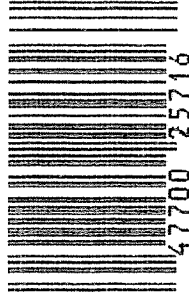
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C6522307

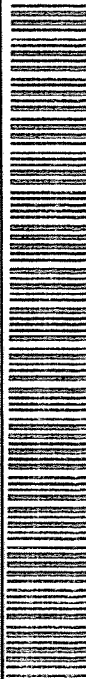
ORDER NO.
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