

06522355

MODEL 700™ M24

Model SWS™

Action

Barrel Length

Capacity

Order No. 5716

* Includes 1 in chamber.

Remington

Remington®

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

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

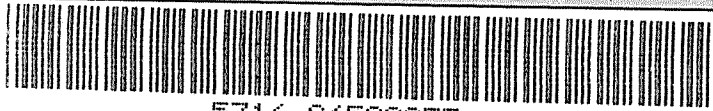
MODEL 700™ H24

SERIAL NO.
C6522355

ORDER NO.
5716

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

Ø1



5716 C6522355

UPC



0 47700 25716 7

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522355
21 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.295169
1 TO	2	.567101
1 TO	3	.0798123
1 TO	4	.527978
1 TO	5	.762342

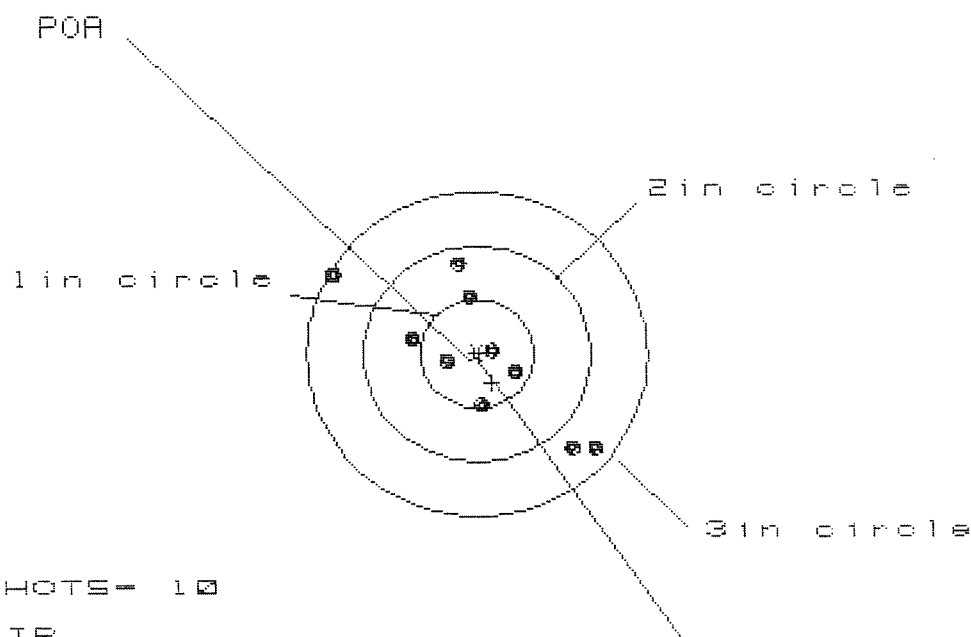
$\begin{matrix} 3 \\ + \\ 5 \end{matrix} \begin{matrix} 2 \\ + \\ 2 \end{matrix}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1598
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0176
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .160766
THE AMR FOR THIS RIFLE IS: .8208

28 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522355

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 4

2in = 7

3in = 10

HS = 2.374

VS = 1.690

GS = 2.876

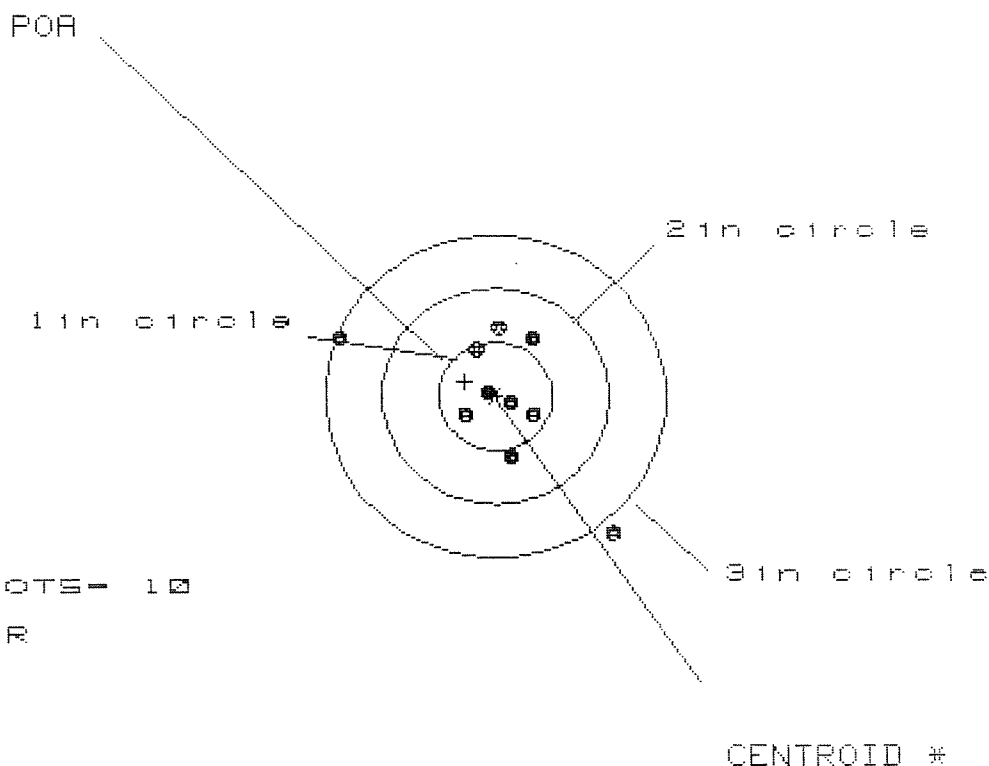
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.074	.930	.759
MINIMUM X	:	-1.300	-.748	-.632
MAXIMUM Y	:	.807	.889	.789
MINIMUM Y	:	-.883	-.801	-.835
CENTROID X	:	-.130	.014	-.102
CENTROID Y	:	.265	.183	.283
POR TO CENTROID in.	:	.295	.183	.301
MIN RADIUS	:	.153	.126	.121
MEAN RADIUS	:	.733	.642	.554
MAX RADIUS	:	1.496	1.227	1.128
HORIZONTAL SPREAD	:	2.374	1.678	1.391
VERTICAL SPREAD	:	1.690	1.690	1.624
EXTREME SPREAD	:	2.876	2.103	1.889
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 5

2in = 8

3in = 9

HS= 2.427

VS= 1.959

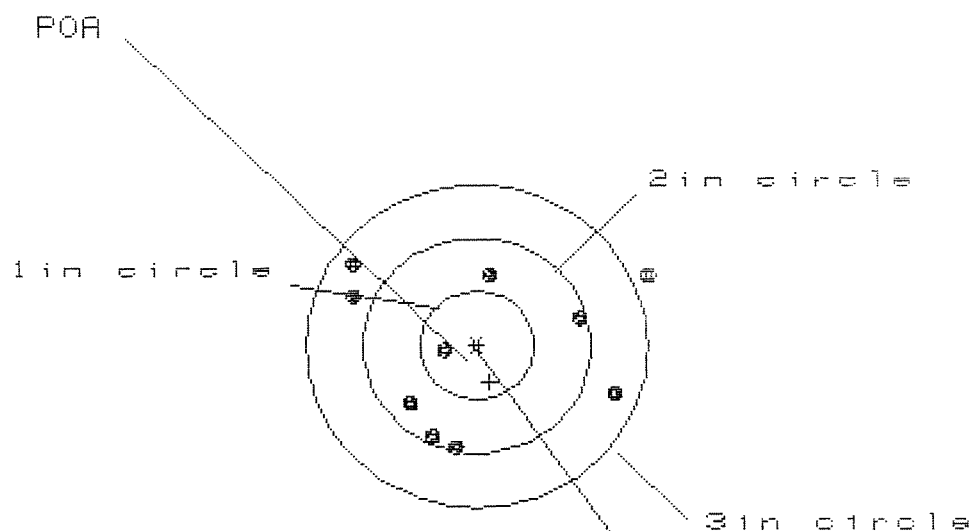
CS= 3.009

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.010	.472	.309
MINIMUM X	:	-1.417	-1.305	-.368
MAXIMUM Y	:	.672	.529	.573
MINIMUM Y	:	-1.287	-.750	-.707
CENTROID X	:	.270	.158	.321
CENTROID Y	:	-.137	.006	-.037
POA TO CENTROID in.	:	.303	.158	.323
MIN RADIUS	:	.069	.144	.148
MEAN RADIUS	:	.645	.546	.420
MAX RADIUS	:	1.636	1.350	.710
HORIZONTAL SPREAD	:	2.427	1.777	.677
VERTICAL SPREAD	:	1.959	1.279	1.279
EXTREME SPREAD	:	3.009	1.887	1.282
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 2.611

VS= 1.615

GS= 2.618

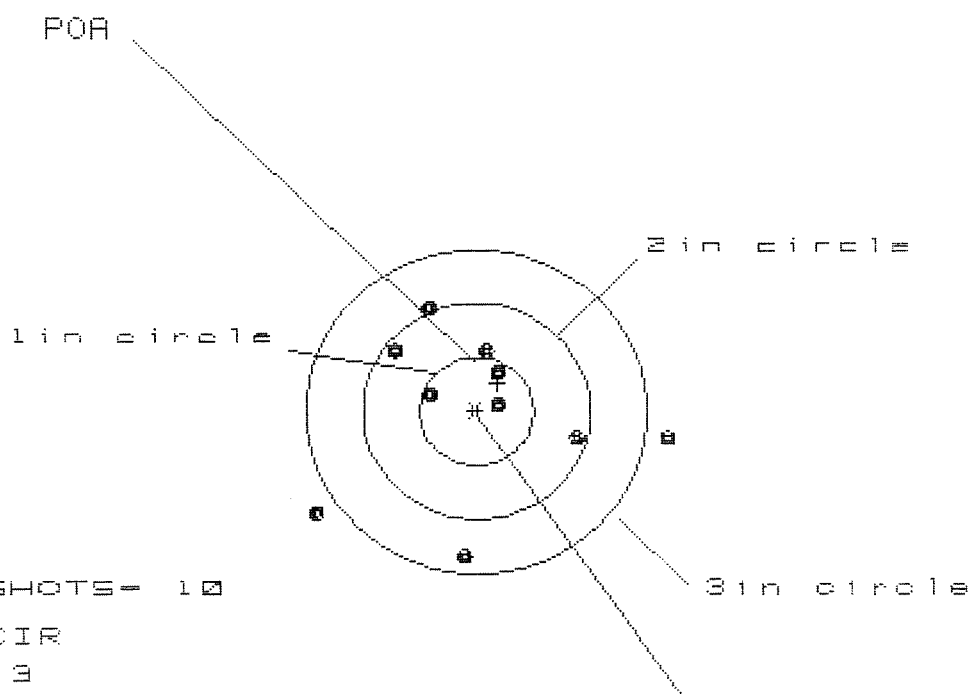
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.499	1.354	1.236
MINIMUM X	:	-1.112	-.945	-1.063
MAXIMUM Y	:	.708	.782	.781
MINIMUM Y	:	-.907	-.833	-.735
CENTROID X	:	-.109	-.276	-.158
CENTROID Y	:	.342	.268	.170
POA TO CENTROID in.	:	.359	.384	.232
MIN RADIUS	:	.291	.120	.262
MEAN RADIUS	:	.989	.879	.842
MAX RADIUS	:	1.642	1.416	1.277
HORIZONTAL SPREAD	:	2.611	2.299	2.299
VERTICAL SPREAD	:	1.615	1.615	1.516
EXTREME SPREAD	:	2.618	2.587	2.498
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 6

3 in = 8

HS= 3.163

VS= 2.292

GS= 3.239

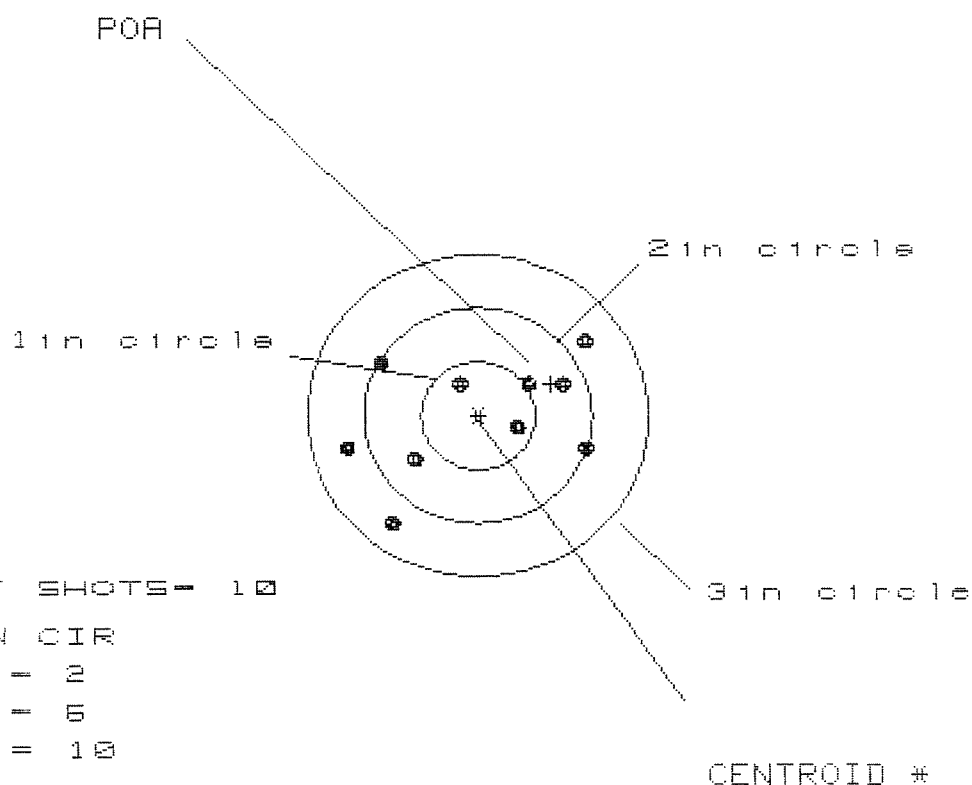
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.714	1.058	.901
MINIMUM X	:	-1.449	-1.259	-.637
MAXIMUM Y	:	.978	.956	.842
MINIMUM Y	:	-1.314	-1.336	-1.450
CENTROID X	:	-.186	-.376	-.219
CENTROID Y	:	-.260	-.238	-.124
POA TO CENTROID in.	:	.320	.445	.252
MIN RADIUS	:	.196	.238	.258
MEAN RADIUS	:	.916	.825	.686
MAX RADIUS	:	1.725	1.556	1.456
HORIZONTAL SPREAD	:	3.163	2.317	1.538
VERTICAL SPREAD	:	2.292	2.292	2.292
EXTREME SPREAD	:	3.239	2.414	2.302
NUMBER IN ONE INCH CIRCLE	=		3	
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 = 2

2in = 6

3in = 10

HS = 2.044

VS = 1.722

GS = 2.411

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.923	.839	.688
MINIMUM X	:	-1.121	-1.285	-1.123
MAXIMUM Y	:	.688	.573	.525
MINIMUM Y	:	-1.034	-.486	-.534
CENTROID X	:	-.644	-.560	-.409
CENTROID Y	:	-.298	-.183	-.135
POA TO CENTROID in.	:	.710	.589	.431
MIN RADIUS	:	.277	.246	.223
MEAN RADIUS	:	.821	.747	.652
MAX RADIUS	:	1.286	1.265	1.175
HORIZONTAL SPREAD	:	2.044	2.044	1.811
VERTICAL SPREAD	:	1.722	1.059	1.059
EXTREME SPREAD	:	2.411	2.257	1.954
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6522355

DATE 8/15/90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.43	2.50	2.21	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.36	2.37	2.53	2.17	
PULL #3	2.25	2.35	2.43	2.17	
PULL #4	2.31	2.22	2.50	2.19	
PULL #5	2.22	2.36	2.53	2.15	
TOTAL	11.52	11.73	12.49	10.89	
AVG.	2.304	2.346	2.498	2.178	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.23	3.20		
PULL #2	3.23	3.34		
PULL #3	3.12	3.30		
PULL #4	3.20	3.35		
PULL #5	3.26	3.30		
TOTAL	16.04	16.49		
AVG.	3.208	3.298		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.23	4.17		4.28
PULL #2	4.34	4.20		4.34
PULL #3	4.33	4.16		4.30
PULL #4	4.28	4.29		4.37
PULL #5	4.22	4.23		4.34
TOTAL	21.40	21.05		21.83
AVG.	4.28	4.21		4.366

B31
Needs
Touch up
at missile
gating

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522355

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		7/10/90	KS
600	Proof		7/10/90	K4
607	Check Headspace		7/10/90	K4
610	Dis-assemble Gun		7/10/90	KS
612	Magnaflux Barrel Action		7/17/90	KR
	Magnaflux Bolt		7/17/90	KR
615	Rollmark Caliber		7/17/90	LS
617	Drill and Tap Sight Holes		7/23/90	LB
618	Polish Barrel RB		7/24/90	WB
620	Apply Coatings (Barrel Action)		8/6/90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/16/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/16/90	KS
	C) Inspect Ejector Hole for Chamfer		8/16/90	KS
	D) Oil Firing Pin Ass'y		8/16/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		8/17/90	ML

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			8/13/90	JL
	G) Safety Off Force	2	2	2			8/13/90	JL
	H) Trigger Pull Test & Retainability						8/17/90	JL
	I) Firing Pin Indent	.0225	.0225	.0225			8/13/90	JL
	J) Assemble Stock						8/17/90	KS
	K) Assemble Swivel Studs						8/29/90	KS
	L) Attach Front and Rear Sight Assemblies						8/17/90	KS
	M) Iron Sight Alignment						8/17/90	KS
	N) Detach Front & Rear Sights & place in numbered container						8/17/90	KS
	O) Attach Scope to Rifle						8/17/90	KS
	P) Detach & Attach Scope 20 Times						8/17/90	KS
640	Gallery Target & Test						8-20-90	A
	A) Time						8-20-90	A
	B) Malfunctions						8-20-90	A
	C) Pierced Primers						8-20-90	A
	D) Optical Clarity of Scope						8-20-90	A
645	Inspect for Live Ammo						8-20-90	A
655	Final Inspection						8/29/90	KS
	A) Headspace						8/22/90	JL
	B) Trigger Pull	2.21	2.17	2.17	2.19	2.15	8/22/90	JL
	C) Function						8/29/90	KS
660	Pack						1/20/90	AF