

C6587563

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

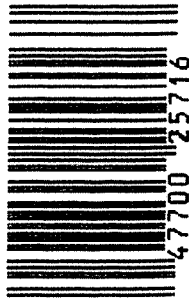
Remington

Remington®  REG. U.S. PAT. & TM. OFF.		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700™ H24		SERIAL NO. C6587563
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.		ORDER NO. 5716



5716 C6587563

UPC



0 47700 25716 7

O/K. SIKHIS

O/K E.S. P.W

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 65875 **63**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/22/90	KJ
600	Proof		10/22/90	KJ
607	Check Headspace		10/22/90	KJ
610	Dis-assemble Gun		10/22/90	KJ
612	Magnaflux Barrel Action		10/24/90	KR
	Magnaflux Bolt		11	KR
615	Rollmark Caliber		11	JS
617	Drill and Tap Sight Holes		10/25/90	LB
618	Polish Barrel RB		10/26/90	WB
- 620	Apply Coatings (Barrel Action)		11-7-90	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		12/4/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/4/90	KS
	C) Inspect Ejector Hole for Chamfer		12/4/90	KS
	D) Oil Firing Pin Ass'y		12/4/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		12/5/90	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2			12/5/90	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			12/5/90	WB
	H) Trigger Pull Test & Retainability						12/5/90	RL
	I) Firing Pin Indent	.024	.024	.024			12/5/90	WB
	J) Assemble Stock						12/7/90	KS
	K) Assemble Swivel Studs						12-8-90	KS
	L) Attach Front and Rear Sight Assemblies						12/7/90	KS
	M) Iron Sight Alignment						12/7/90	KS
	N) Detach Front & Rear Sights & place in numbered container						12/7/90	KS
	O) Attach Scope to Rifle						12/7/90	KS
	P) Detach & Attach Scope 20 Times						12/7/90	KS
640	Gallery Target & Test						12/7/90	KS
	A) Time						12/7/90	KS
	B) Malfunctions						12/7/90	KS
	C) Pierced Primers						12/7/90	KS
	D) Optical Clarity of Scope						12/7/90	KS
645	Inspect for Live Ammo						12/7/90	KS
655	Final Inspection						12-8-90	KS
	A) Headspace						12-8-90	KS
	B) Trigger Pull	238	232	212	240	230	12-8-90	KS
	C) Function						12-8-90	KS
660	Pack						12/14/90	KS

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50#+.50#
3.00#+.75#
4.00#+1.00#

SERIAL NO. E6587563

DATE 12-5-90

TESTER JG

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.40	2.40	238	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.39	2.40	232	
PULL #3	2.39	2.39	2.38	212	
PULL #4	2.40	2.39	2.40	240	
PULL #5	2.40	2.39	2.38	230	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.26	3.22		
PULL #2	3.20	3.18		
PULL #3	3.29	3.26		
PULL #4	3.26	3.28		
PULL #5	3.28	3.24		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.24	4.21		4.22
PULL #2	4.14	4.15		4.22
PULL #3	4.23	4.22		4.25
PULL #4	4.22	4.24		4.24
PULL #5	4.25	4.20		4.15
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587563
8 Dec 1990

CENTROIDAL DISTANCES

0 TO	1	.0551725
1 TO	2	.152
1 TO	3	.238665
1 TO	4	.245837
1 TO	5	.240801

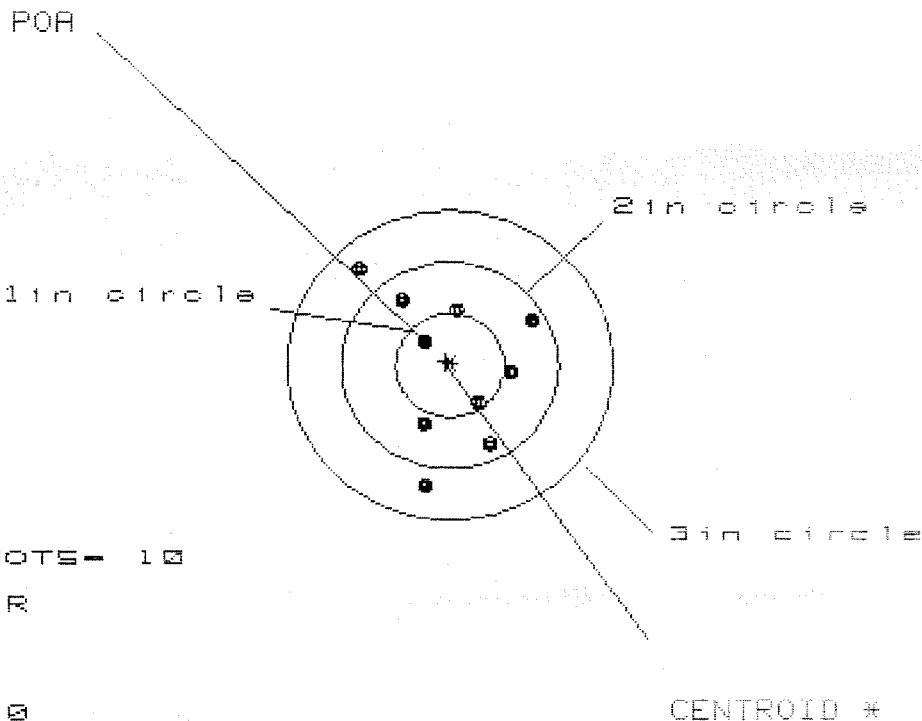
$\bar{x}$ (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0436
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.138
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .144724
THE AMR FOR THIS RIFLE IS: .7768

8 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8587583

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in - 2

2in - 8

3in - 10

HS- 1.592

VS= 2.163

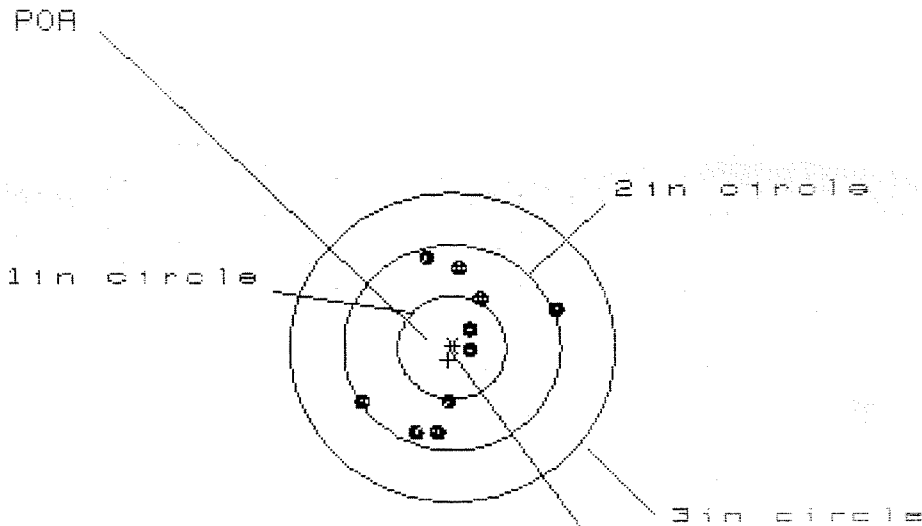
GS= 2.238

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.760	.667	.624
MINIMUM X	-.832	-.550	-.593
MAXIMUM Y	.985	.714	.580
MINIMUM Y	-1.178	-1.069	-.752
CENTROID X	.038	.131	.174
CENTROID Y	-.040	-.149	-.016
POA TO CENTROID in.	.055	.198	.175
MIN RADIUS	.354	.290	.382
MEAN RADIUS	.743	.667	.601
MAX RADIUS	1.289	1.124	.830
HORIZONTAL SPREAD	1.592	1.217	1.217
VERTICAL SPREAD	2.163	1.783	1.332
EXTREME SPREAD	2.238	1.900	1.554
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 9

3in = 10

HS= 1.819

VS= 1.685

GS= 2.049

CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.001	.377	.288
MINIMUM X	:	-.818	-.706	-.339
MAXIMUM Y	:	.867	.914	.855
MINIMUM Y	:	-.818	-.771	-.830
CENTROID X	:	.038	-.074	.015
CENTROID Y	:	.122	.075	.134
POA TO CENTROID in.	:	.127	.105	.135
MIN RADIUS	:	.190	.302	.214
MEAN RADIUS	:	.696	.663	.616
MAX RADIUS	:	1.087	.924	.896
HORIZONTAL SPREAD	:	1.819	1.083	.627
VERTICAL SPREAD	:	1.685	1.685	1.685
EXTREME SPREAD	:	2.049	1.689	1.689
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 4

2in = 9

3in = 10

HS= 1.571

VS= 1.642

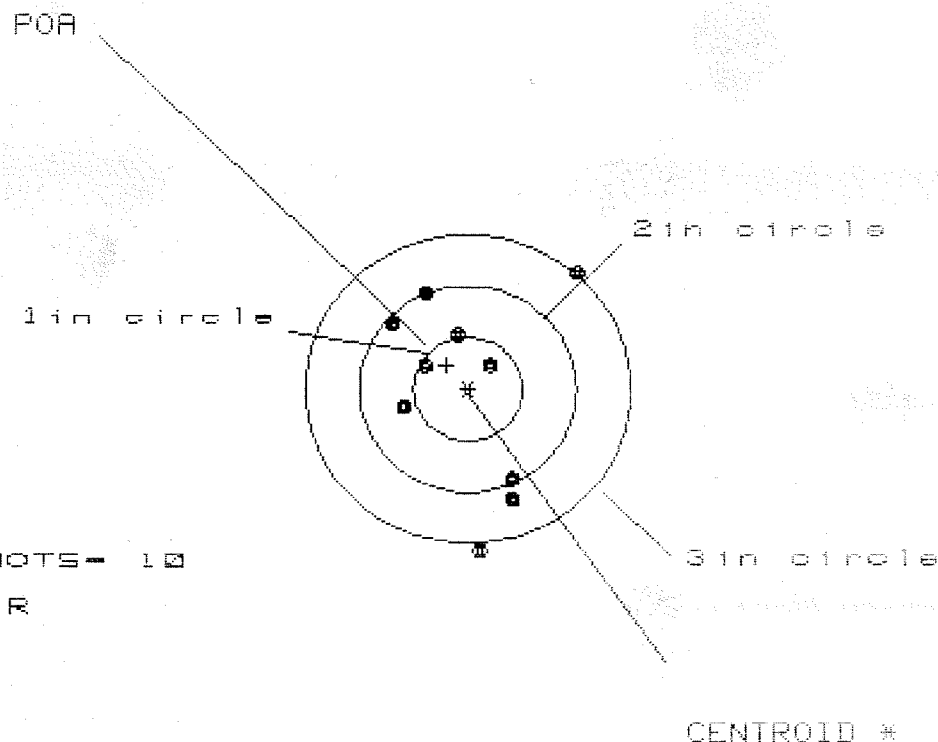
GS= 1.831

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.891	.799	.257
MINIMUM X	:	-.680	-.581	-.481
MAXIMUM Y	:	.788	.722	.790
MINIMUM Y	:	-.854	-.920	-.852
CENTROID X	:	-.022	-.121	-.221
CENTROID Y	:	-.271	-.205	-.273
POA TO CENTROID in.	:	.272	.238	.351
MIN RADIUS	:	.229	.186	.079
MEAN RADIUS	:	.651	.584	.503
MAX RADIUS	:	1.073	.967	.890
HORIZONTAL SPREAD	:	1.571	1.380	.738
VERTICAL SPREAD	:	1.642	1.642	1.642
EXTREME SPREAD	:	1.831	1.659	1.659
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 8

HS= 1.702

VS= 2.692

GS= 2.841

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.045	.566	.598
MINIMUM X	:	-.657	-.541	-.509
MAXIMUM Y	:	1.158	1.013	.837
MINIMUM Y	:	-1.534	-1.405	-1.135
CENTROID X	:	.194	.078	.046
CENTROID Y	:	-.230	-.359	-.183
POA TO CENTROID in.	:	.301	.367	.189
MIN RADIUS	:	.292	.460	.326
MEAN RADIUS	:	.907	.836	.713
MAX RADIUS	:	1.560	1.428	1.253
HORIZONTAL SPREAD	:	1.702	1.107	1.107
VERTICAL SPREAD	:	2.692	2.418	1.972
EXTREME SPREAD	:	2.841	2.475	2.117
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			8	

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 10

HS= 2.023

VS= 2.581

GS= 2.691

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.964	.935	.993
MINIMUM X	-1.059	-1.088	-1.030
MAXIMUM Y	1.349	.553	.417
MINIMUM Y	-1.232	-1.082	-.721
CENTROID X	-.030	-.001	-.059
CENTROID Y	-.271	-.421	-.285
POA TO CENTROID in.	.272	.421	.291
MIN RADIUS	.350	.477	.377
MEAN RADIUS	.887	.846	.773
MAX RADIUS	1.375	1.178	1.135
HORIZONTAL SPREAD	2.023	2.023	2.023
VERTICAL SPREAD	2.581	1.635	1.138
EXTREME SPREAD	2.691	2.069	2.069
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		