

C6587582

MODEL 700™ N24

Model **SWS**™

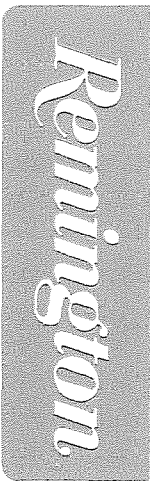
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Remington
REG. U.S. PAT. & TM. OFF.

MODEL 700™ M24

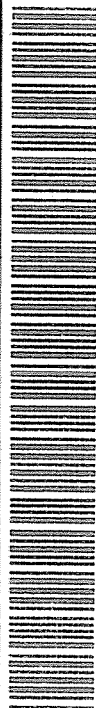
VERY IMPORTANT:
 Instruction Book
 enclosed to assure
 safe use of this
 firearm.

DU PONT

SERIAL NO.
 C6587582

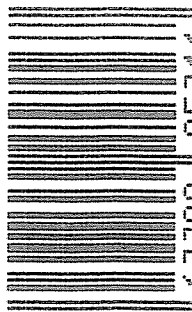
ORDER NO.
 5716

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



5716 C6587582

UPC



0 47700 25716 2

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587582

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1228	90	RW
600	Proof	1228	90	RW
607	Check Headspace	1228	90	RW
610	Dis-assemble Gun			RW
612	Magnaflux Barrel Action		1-7-91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	LL
617	Drill and Tap Sight Holes			FB
618	Polish Barrel	1 10 91		WB
620	Apply Coatings (Barrel Action)		1-26-91	TH
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		4/10/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/10/91	RW
	C) Inspect Ejector Hole for Chamfer		4/10/91	RW
	D) Oil Firing Pin Ass'y		4/10/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4/24/91	JM

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			4/24/91	SP
	G) Safety Off Force	3	3	3			4/24/91	SP
	H) Trigger Pull Test & Retainability						4/24/91	SP
	I) Firing Pin Indent	1023	1023	1023			4/24/91	SP
	J) Assemble Stock						4/25/91	RW
	K) Assemble Swivel Studs						5-11-91	DH
	L) Attach Front and Rear Sight Assemblies						4/25/91	RW
	M) Iron Sight Alignment						4/25/91	RW
	N) Detach Front & Rear Sights & place in numbered container						4/25/91	RW
	O) Attach Scope to Rifle						4/25/91	RW
	P) Detach & Attach Scope 20 Times						4/25/91	RW
640	Gallery Target & Test						4-26-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						4-26-91	NF
655	Final Inspection							
	A) Headspace						5-11-91	DH
	B) Trigger Pull	2.47	2.36	2.38	2.42	2.45	5/11/91	SP
	C) Function						5-11-91	DH
660	Pack						6-18-91	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6587582

DATE 4/24/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.45	2.36	2.44	2.47	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.42	2.45	2.40	2.36	
PULL #3	2.39	2.27	2.39	2.38	
PULL #4	2.38	2.45	2.40	2.42	
PULL #5	2.38	2.39	2.34	2.45	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.54	3.13		
PULL #2	3.33	3.19		
PULL #3	3.33	3.18		
PULL #4	3.29	3.17		
PULL #5	3.39	3.18		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.30		4.53
PULL #2	4.25	4.46		4.41
PULL #3	4.22	4.45		4.50
PULL #4	4.20	4.43		4.55
PULL #5	4.20	4.37		4.35
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587582
26 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.153395
1 TO	2	.365919
1 TO	3	.253332
1 TO	4	.139946
1 TO	5	.354346

 <----POI

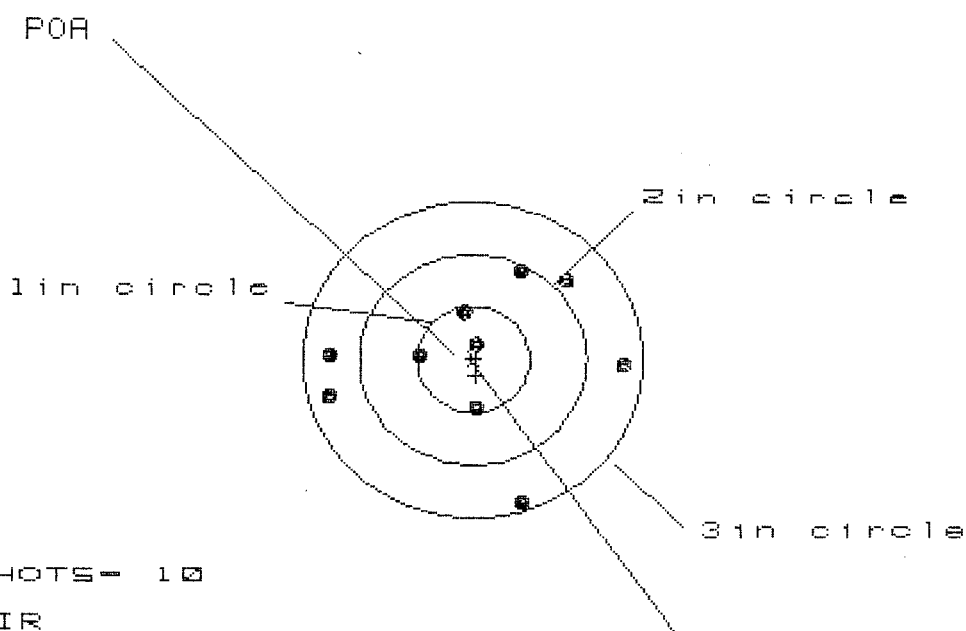
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1232
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0368
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .128579
THE AMR FOR THIS RIFLE IS: .8506

26 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C65875B2

CENTERFIRE PATTERNS

1



OF SHOTS - 10

IN CIR

1in = 3

2in = 5

3in = 10

HS= 2.570

VS= 2.189

GS= 2.572

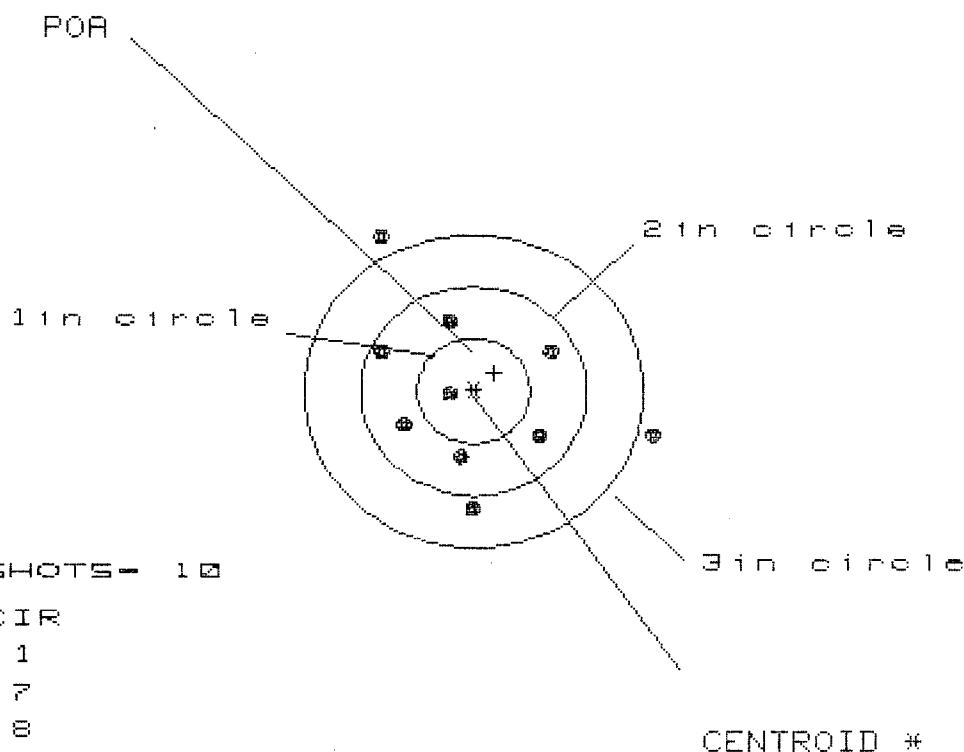
CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.301	1.354	1.029
MINIMUM X	:	-1.269	-1.216	-1.047
MAXIMUM Y	:	.830	.679	.650
MINIMUM Y	:	-1.359	-.612	-.641
CENTROID X	:	-.027	-.080	-.249
CENTROID Y	:	.151	.302	.331
POA TO CENTROID in.	:	.154	.313	.414
MIN RADIUS	:	.185	.092	.256
MEAN RADIUS	:	.890	.799	.727
MAX RADIUS	:	1.439	1.373	1.183
HORIZONTAL SPREAD	:	2.570	2.570	2.076
VERTICAL SPREAD	:	2.189	1.291	1.291
EXTREME SPREAD	:	2.572	2.572	2.324
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	10		

26 Apr 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 1

2in = 7

3in = 8

HS = 2.400

VS = 2.508

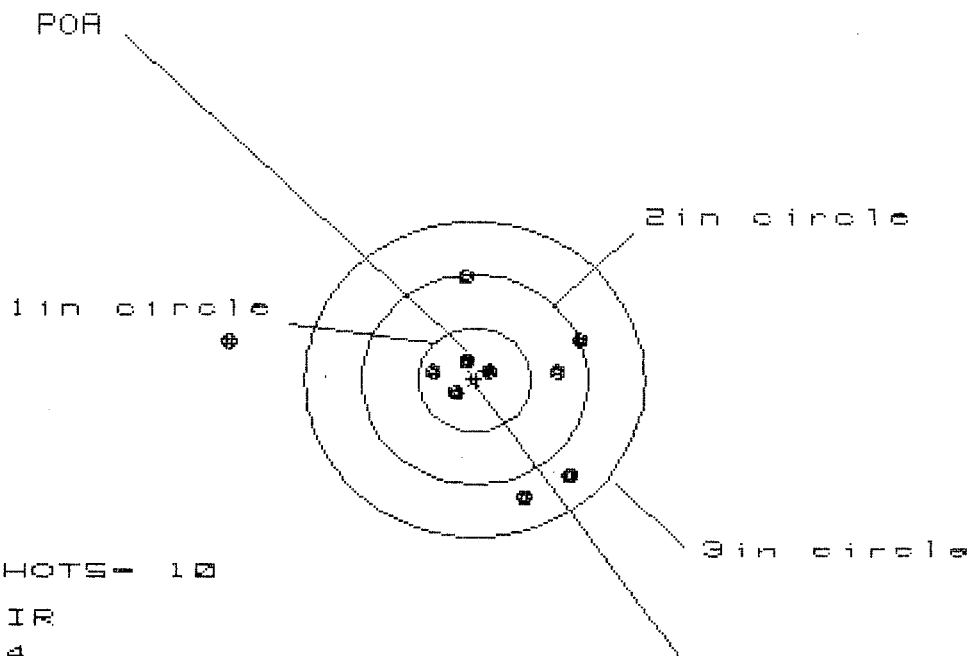
GS = 3.065

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.564	1.471	.815
MINIMUM X	:	-.836	-.913	-.729
MAXIMUM Y	:	1.438	.828	.790
MINIMUM Y	:	-1.070	-.910	-.948
CENTROID X	:	-.183	-.090	-.274
CENTROID Y	:	-.180	-.340	-.302
POA TO CENTROID in.	:	.257	.352	.408
MIN RADIUS	:	.235	.355	.175
MEAN RADIUS	:	.902	.811	.689
MAX RADIUS	:	1.663	1.503	.964
HORIZONTAL SPREAD	:	2.400	2.384	1.544
VERTICAL SPREAD	:	2.508	1.738	1.738
EXTREME SPREAD	:	3.065	2.540	1.748
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			8	

26 Apr 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 4

2 in = 6

3 in = 9

HS = 3.022

VS = 2.174

GS = 3.183

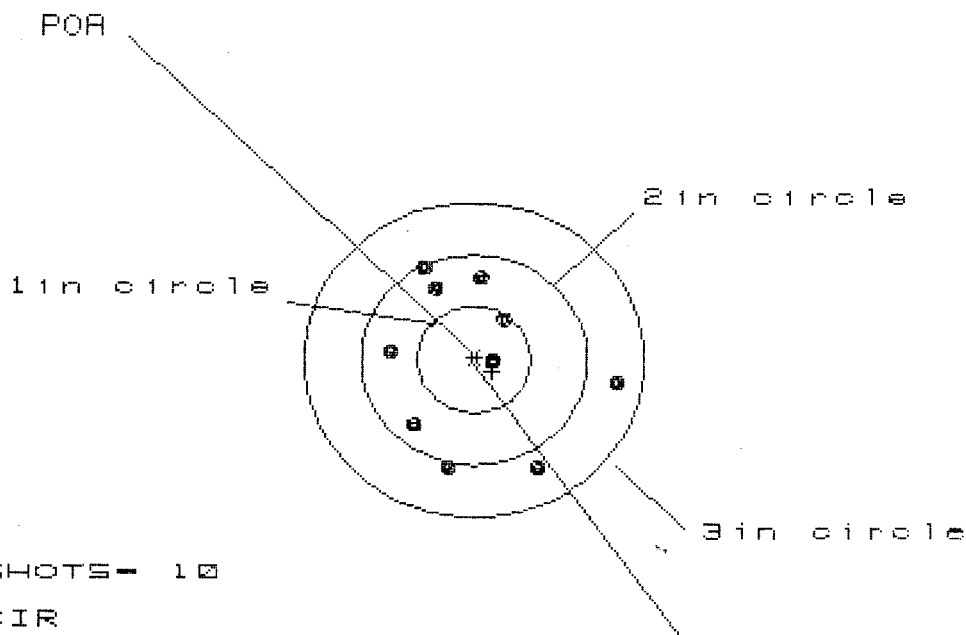
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.882	.644	.662
MINIMUM X	:	-2.140	-.656	-.638
MAXIMUM Y	:	1.012	1.051	.910
MINIMUM Y	:	-1.162	-1.123	-.988
CENTROID X	:	-.131	.107	.089
CENTROID Y	:	-.080	-.119	.022
POA TO CENTROID in.	:	.153	.160	.091
MIN RADIUS	:	.130	.175	.117
MEAN RADIUS	:	.825	.684	.605
MAX RADIUS	:	2.169	1.133	1.143
HORIZONTAL SPREAD	:	3.022	1.300	1.300
VERTICAL SPREAD	:	2.174	2.174	1.898
EXTREME SPREAD	:	3.183	2.219	2.081
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

26 Apr 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1in = 2

2in = 7

3in = 10

HS = 2.067

VS = 1.868

GS = 2.157

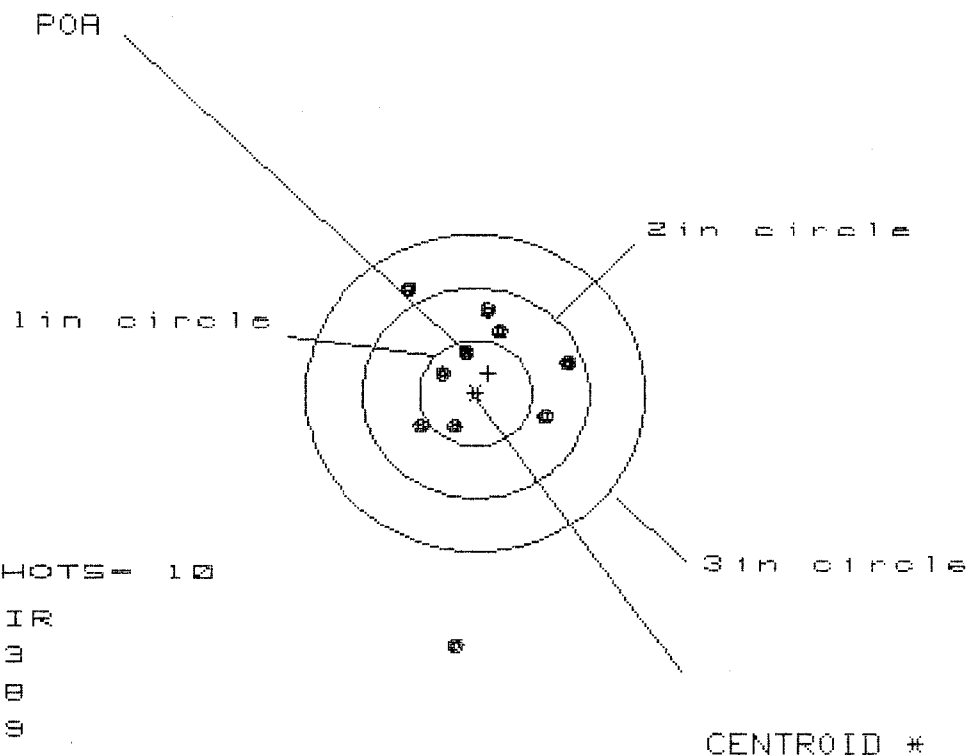
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.308	.740	.502
MINIMUM X	:	-.759	-.614	-.522
MAXIMUM Y	:	.863	.838	.710
MINIMUM Y	:	-1.005	-1.030	-1.153
CENTROID X	:	-.163	-.308	-.400
CENTROID Y	:	.118	.143	.271
POA TO CENTROID in.	:	.201	.339	.484
MIN RADIUS	:	.162	.305	.416
MEAN RADIUS	:	.826	.763	.677
MAX RADIUS	:	1.326	1.268	1.153
HORIZONTAL SPREAD	:	2.067	1.354	1.024
VERTICAL SPREAD	:	1.868	1.868	1.863
EXTREME SPREAD	:	2.157	2.157	1.878
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			10	

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 3

2in = 8

3in = 9

HS= 1.383

VS= 3.380

GS= 3.403

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.814
MINIMUM X	-.569
MAXIMUM Y	1.019
MINIMUM Y	-2.361
CENTROID X	-.112
CENTROID Y	-.193
POA TO CENTROID in.	.223
MIN RADIUS	.285
MEAN RADIUS	.810
MAX RADIUS	2.367
HORIZONTAL SPREAD	1.383
VERTICAL SPREAD	3.380
EXTREME SPREAD	3.403
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	8
NUMBER IN THREE INCH CIRCLE =	9