

06587667

MODEL 700™ N24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington®



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

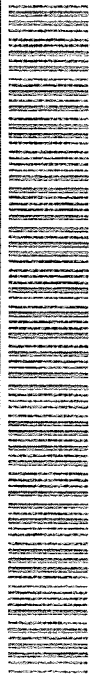
MODEL 700™ M24

SERIAL NO.
C6587667

ORDER NO.
5716

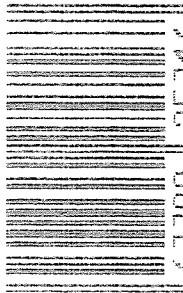
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



5716 C6587667

LPC



0 47700 25716

7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587667

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	1228	90	RW
612	Magnaflux Barrel Action		1-7-91	KR
	Magnaflux Bolt		1-7-91	KR
615	Rollmark Caliber		1-7-91	LS
617	Drill and Tap Sight Holes	1 10 91		KB
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		1/28/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/28/91	RW
	C) Inspect Ejector Hole for Chamfer		1/28/91	RW
	D) Oil Firing Pin Ass'y		1/28/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2-4-91	PM

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			2/4/91	WB
	G) Safety Off Force	2	2	2			2/4/91	WB
	H) Trigger Pull Test & Retainability						2/4/91	HL
	I) Firing Pin Indent	.021	.021	.021			2/4/91	WB
	J) Assemble Stock						2/5/91	RW
	K) Assemble Swivel Studs						2-19-91	A
	L) Attach Front and Rear Sight Assemblies						2/5/91	RW
	M) Iron Sight Alignment						2/5/91	RW
	N) Detach Front & Rear Sights & place in numbered container						2/5/91	RW
	O) Attach Scope to Rifle						2/5/91	RW
	P) Detach & Attach Scope 20 Times						2/5/91	RW
640	Gallery Target & Test						2-6-91	AC
	A) Time						2-6-91	AC
	B) Malfunctions						2-6-91	AC
	C) Pierced Primers						2-6-91	AC
	D) Optical Clarity of Scope						2-6-91	AC
645	Inspect for Live Ammo						2-6-91	AC
655	Final Inspection							
	A) Headspace						2-19-91	A
	B) Trigger Pull	2.20	2.37	2.25	2.40	2.21	2/18/91	WB
	C) Function						2-19-91	AC
660	Pack						3-19-91	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS.

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. CC587667

DATE 2-4-91

TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.33	2.24	2.39	2.20	MIN. SETTING,
PULL #2	2.43	2.13	2.32	2.37	NO AVG. OF 5
PULL #3	2.44	2.36	2.25	2.25	READINGS ACCEPT-
PULL #4	2.29	2.35	2.34	2.40	ABLE LESS THAN 2#
PULL #5	2.40	2.32	2.21	2.21	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.47	3.17		
PULL #2	3.40	3.28		
PULL #3	3.37	3.18		
PULL #4	3.32	3.49		
PULL #5	3.27	3.42		
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	4.39		4.20
PULL #2	4.33	4.31		4.49
PULL #3	4.15	4.25		4.38
PULL #4	4.14	4.22		4.29
PULL #5	4.20	4.35		4.28
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587667
7 Feb 1991

CENTROIDAL DISTANCES

0 TO	1	.356396
1 TO	2	.46494
1 TO	3	.342301
1 TO	4	.317855
1 TO	5	.0738241

35
9 <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .042
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1238
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .13073
THE AMR FOR THIS RIFLE IS: .8802

7 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6587667

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 0

2in = 5

3in = 9

HS= 1.830

VS= 3.163

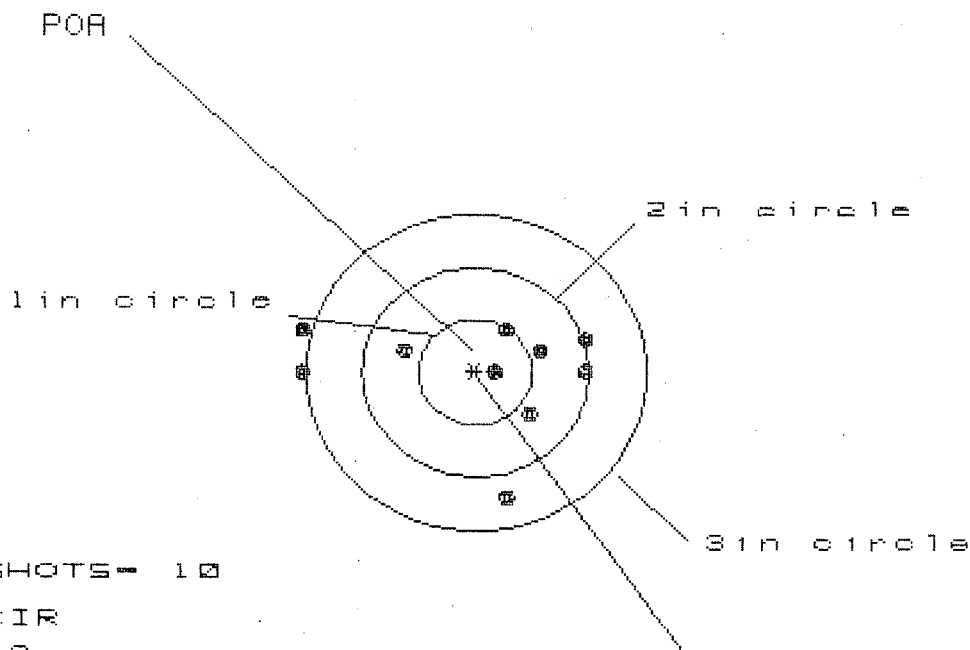
GS= 3.163

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.050	1.086	1.127
MINIMUM X	:	-.780	-.744	-.703
MAXIMUM Y	:	1.737	1.283	1.129
MINIMUM Y	:	-1.426	-1.233	-.849
CENTROID X	:	.197	.161	.120
CENTROID Y	:	-.297	-.490	-.336
POA TO CENTROID in.	:	.356	.516	.357
MIN RADIUS	:	.535	.454	.612
MEAN RADIUS	:	1.050	.953	.908
MAX RADIUS	:	1.767	1.483	1.363
HORIZONTAL SPREAD	:	1.830	1.830	1.830
VERTICAL SPREAD	:	3.163	2.516	1.978
EXTREME SPREAD	:	3.163	2.733	2.636
NUMBER IN ONE INCH CIRCLE =			0	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			9	

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS = 2.507

VS = 1.607

GS = 2.508

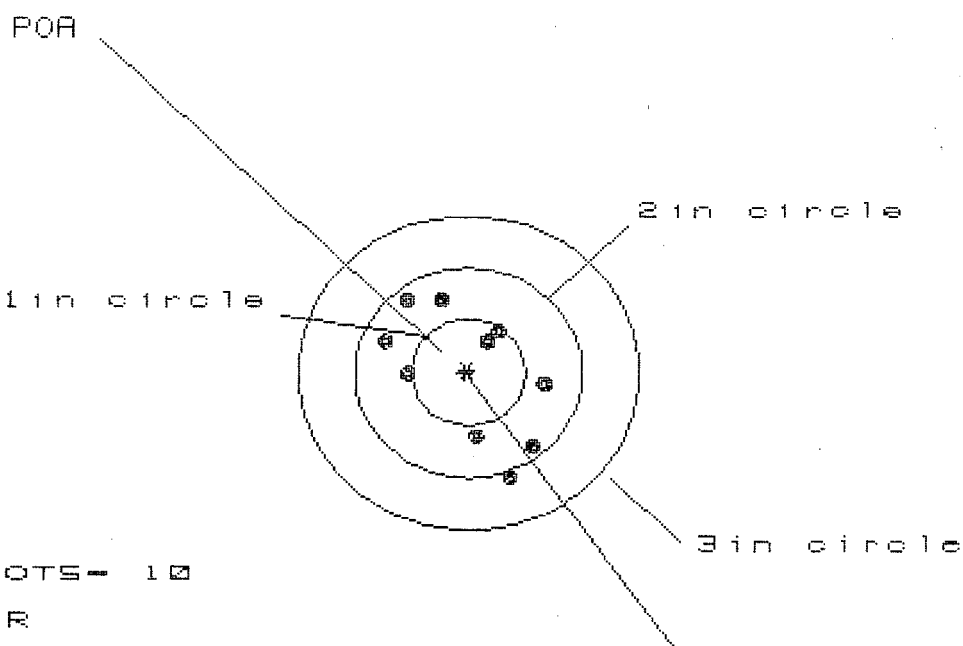
CENTROID #

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.960	.788	.576
MINIMUM X	:	-1.547	-1.698	-1.049
MAXIMUM Y	:	.392	.410	.422
MINIMUM Y	:	-1.215	-1.171	-1.159
CENTROID X	:	-.168	.004	.216
CENTROID Y	:	-.009	-.053	-.065
POA TO CENTROID in.	:	.168	.053	.226
MIN RADIUS	:	.146	.033	.243
MEAN RADIUS	:	.890	.757	.606
MAX RADIUS	:	1.596	1.701	1.162
HORIZONTAL SPREAD	:	2.507	2.486	1.625
VERTICAL SPREAD	:	1.607	1.581	1.581
EXTREME SPREAD	:	2.508	2.502	1.720
NUMBER IN ONE INCH CIRCLE =	:	2		
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 = 3

2in = 9

3in = 10

HS= 1.315

VS= 1.691

GS= 1.916

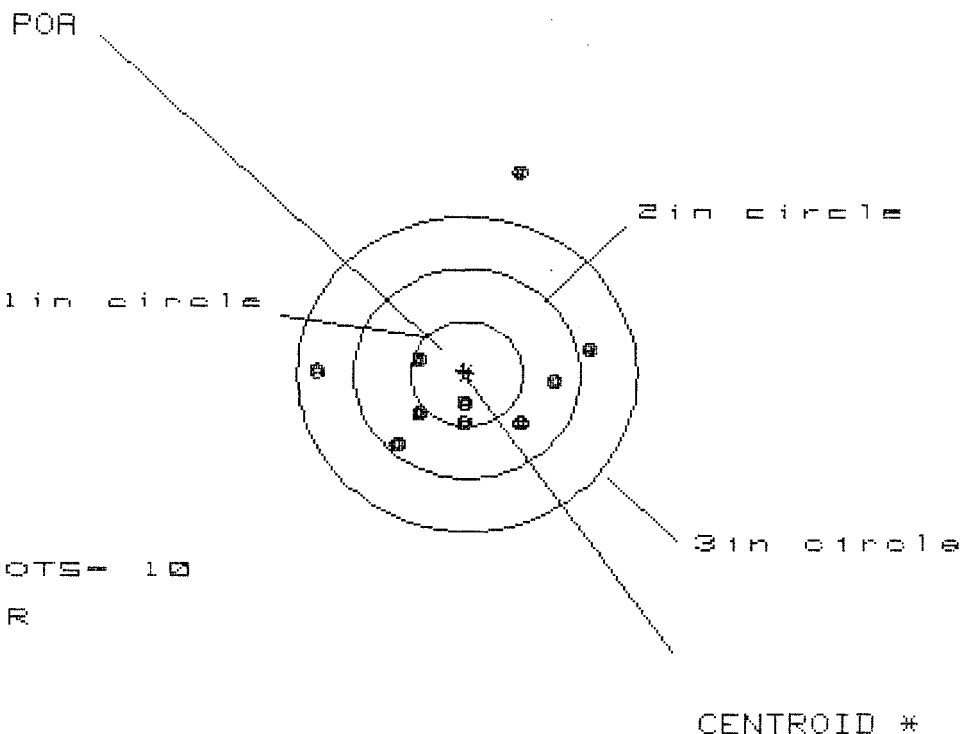
CENTROID *

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.618	.655	.736
MINIMUM X	:	-.698	-.660	-.580
MAXIMUM Y	:	.734	.628	.523
MINIMUM Y	:	-.957	-.840	-.818
CENTROID X	:	.034	-.003	-.084
CENTROID Y	:	.004	.110	.215
POA TO CENTROID in.	:	.035	.110	.231
MIN RADIUS	:	.284	.224	.255
MEAN RADIUS	:	.687	.632	.561
MAX RADIUS	:	1.014	1.058	.836
HORIZONTAL SPREAD	:	1.315	1.315	1.315
VERTICAL SPREAD	:	1.691	1.468	1.341
EXTREME SPREAD	:	1.916	1.877	1.477
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 8

HS= 2.470

VS= 2.603

GS= 2.821

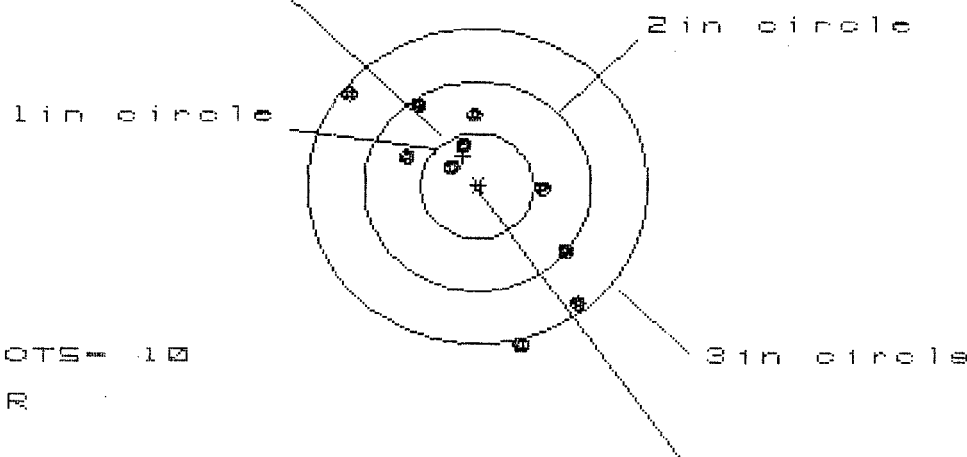
PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.110	1.165	1.001
MINIMUM X	:	-1.360	-1.305	-.705
MAXIMUM Y	:	1.901	.483	.511
MINIMUM Y	:	-.702	-.491	-.463
CENTROID X	:	.023	-.032	.132
CENTROID Y	:	-.031	-.242	-.270
POA TO CENTROID in.	:	.038	.244	.300
MIN RADIUS	:	.315	.098	.184
MEAN RADIUS	:	.864	.674	.597
MAX RADIUS	:	1.963	1.324	1.124
HORIZONTAL SPREAD	:	2.470	2.470	1.706
VERTICAL SPREAD	:	2.603	.974	.974
EXTREME SPREAD	:	2.821	2.484	1.964
NUMBER IN ONE INCH CIRCLE =	:		3	
NUMBER IN TWO INCH CIRCLE =	:		7	
NUMBER IN THREE INCH CIRCLE =	:		9	

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CENTERFIRE PATTERNS # 5

POA



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.027

VS= 2.439

GS= 2.898

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.880	.927	.789
MINIMUM X	:	-1.147	-1.100	-.710
MAXIMUM Y	:	.925	.757	.723
MINIMUM Y	:	-1.514	-1.258	-1.164
CENTROID X	:	.124	.077	.215
CENTROID Y	:	-.286	-.118	-.212
POA TO CENTROID in.	:	.312	.141	.302
MIN RADIUS	:	.307	.183	.344
MEAN RADIUS	:	.910	.784	.746
MAX RADIUS	:	1.571	1.563	1.406
HORIZONTAL SPREAD	:	2.027	2.027	1.499
VERTICAL SPREAD	:	2.439	2.015	1.887
EXTREME SPREAD	:	2.898	2.858	2.368
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			9	