

06587729

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Smead®

Remington®

MODEL 700™ H24

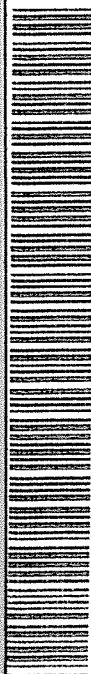
DUPONT
REG. U.S. PAT. & TM. OFF.

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

SERIAL NO.
C6587729

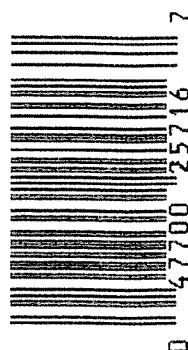
ORDER NO.
5716

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



5716 C6587729

UPC



0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587729

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10 9	90	RW
600	Proof	10 9	90	RW
607	Check Headspace	10 9	90	RW
610	Dis-assemble Gun	10	90	RW
612	Magnaflux Barrel Action		10/17/90	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	LL
617	Drill and Tap Sight Holes		10/18/90	LB
618	Polish Barrel RWB		10/19/90	WB
620	Apply Coatings (Barrel Action)		11-5-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/7/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/7/90	RW
	C) Inspect Ejector Hole for Chamfer		11/7/90	RW
	D) Oil Firing Pin Ass'y		11/7/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11-13-90	MM

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	3 $\frac{3}{4}$	3 $\frac{3}{4}$	3 $\frac{3}{4}$			11/13/90	WLB
	G) Safety Off Force	2	2	2			11/13/90	WLB
	H) Trigger Pull Test & Retainability						11-13-90	JH
	I) Firing Pin Indent	.021	.021	.021			11/13/90	WLB
	J) Assemble Stock						11/13/90	RW
	K) Assemble Swivel Studs						11-19-90	DH
	L) Attach Front and Rear Sight Assemblies						11/13/90	RW
	M) Iron Sight Alignment						11/13/90	RW
	N) Detach Front & Rear Sights & place in numbered container						11/13/90	RW
	O) Attach Scope to Rifle						11/13/90	RW
	P) Detach & Attach Scope 20 Times						11/13/90	RW
	640	Gallery Target & Test						11/14/90
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						11/14/90	NF
655	Final Inspection							
	A) Headspace						11-19-90	DH
	B) Trigger Pull	2.72	2.92	2.83	2.93	2.84	11-19-90	DH
	C) Function						11-19-90	DH
660	Pack						12-17-90	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6587729

DATE 11-13-90

TESTER JEL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.47	2.39	2.46	2.72	MIN. SETTING,
PULL #2	2.28	2.43	2.45	2.92	NO AVG. OF 5
PULL #3	2.29	2.38	2.39	2.83	READINGS ACCEPT-
PULL #4	2.45	2.47	2.42	2.93	ABLE LESS THAN 2#
PULL #5	2.45	2.41	2.48	2.89	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.38	3.24		
PULL #2	3.31	3.36		
PULL #3	3.26	3.46		
PULL #4	3.39	3.36		
PULL #5	3.42	3.36		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.27	4.27		4.28
PULL #2	4.27	4.13		4.25
PULL #3	4.21	4.16		4.25
PULL #4	4.29	4.15		4.32
PULL #5	4.26	4.12		4.30
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587729
15 Nov 1990

CENTROIDAL DISTANCES

0 TO 1	.240832
1 TO 2	.337535
1 TO 3	.553914
1 TO 4	.50612
1 TO 5	.399451

$\frac{2.1}{4.5}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0096
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0666
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0672083
THE AMR FOR THIS RIFLE IS: .0522

15 Nov 1990

FILE:/PATTERNING/CENTERFIRE_PATT/06587729

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS = 10

IN CIR

1 in = 6

2 in = 9

3 in = 10

HS = 1.103

VS = 2.285

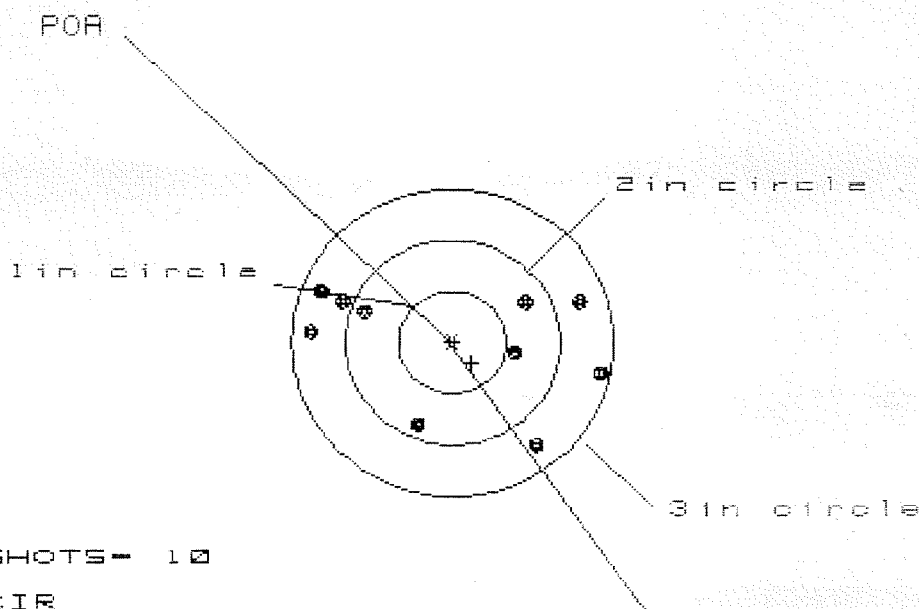
GS = 2.287

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.435	.466	.491
MINIMUM X	:	-.667	-.637	-.612
MAXIMUM Y	:	1.394	.573	.480
MINIMUM Y	:	-.891	-.736	-.409
CENTROID X	:	.160	.130	.105
CENTROID Y	:	.180	.025	.118
POA TO CENTROID in.	:	.241	.133	.157
MIN RADIUS	:	.184	.110	.101
MEAN RADIUS	:	.558	.443	.393
MAX RADIUS	:	1.420	.764	.639
HORIZONTAL SPREAD	:	1.103	1.103	1.103
VERTICAL SPREAD	:	2.285	1.309	.890
EXTREME SPREAD	:	2.287	1.322	1.206
NUMBER IN ONE INCH CIRCLE	=	6		
NUMBER IN TWO INCH CIRCLE	=	9		
NUMBER IN THREE INCH CIRCLE	=	10		

15 Nov 1998

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 10

HS= 2.693

VS= 1.461

GS= 2.724

CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.329	1.178	1.205
MINIMUM X	:	-1.364	-1.347	-1.200
MAXIMUM Y	:	.512	.526	.493
MINIMUM Y	:	-.949	-.935	-.968
CENTROID X	:	-.177	-.026	-.173
CENTROID Y	:	.199	.185	.218
POA TO CENTROID in.	:	.266	.186	.278
MIN RADIUS	:	.636	.486	.636
MEAN RADIUS	:	1.076	1.024	1.004
MAX RADIUS	:	1.370	1.447	1.298
HORIZONTAL SPREAD	:	2.693	2.525	2.405
VERTICAL SPREAD	:	1.461	1.461	1.461
EXTREME SPREAD	:	2.724	2.646	2.480
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS= 2.293

VS= 2.153

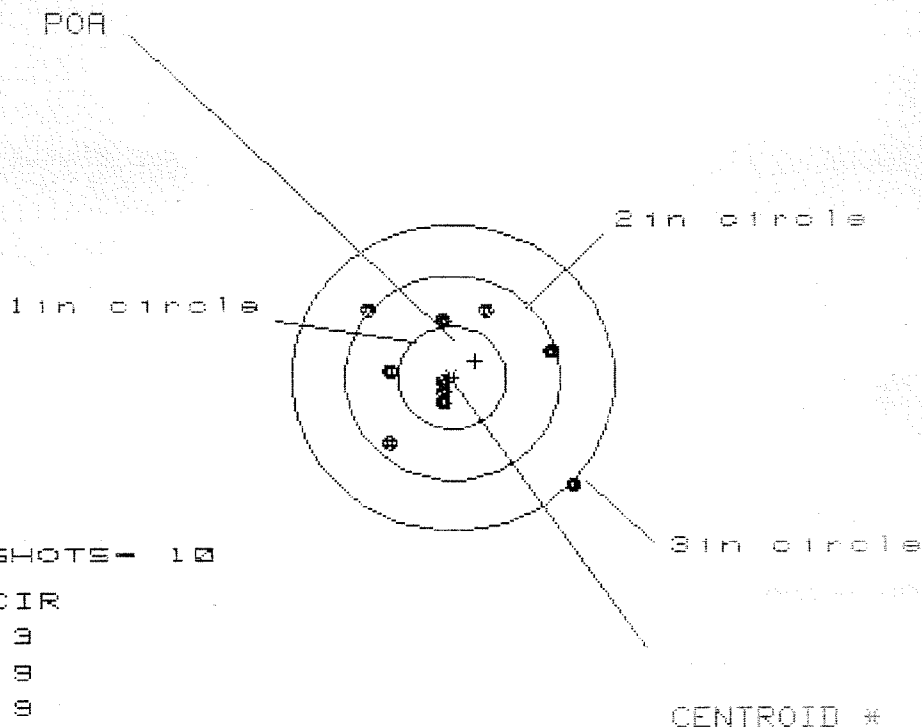
GS= 2.831

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.869	.711	.524
MINIMUM X	:	-1.424	-1.501	-1.455
MAXIMUM Y	:	.768	.614	.642
MINIMUM Y	:	-1.385	-.793	-.765
CENTROID X	:	-.001	.157	.344
CENTROID Y	:	-.350	-.196	-.224
POA TO CENTROID in.	:	.350	.251	.411
MIN RADIUS	:	.248	.129	.126
MEAN RADIUS	:	.924	.726	.542
MAX RADIUS	:	1.986	1.517	1.498
HORIZONTAL SPREAD	:	2.293	2.212	1.979
VERTICAL SPREAD	:	2.153	1.407	1.407
EXTREME SPREAD	:	2.831	2.288	2.135
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 3

2in = 9

3in = 9

HS= 1.866

VS= 1.675

GS= 2.508

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.130	1.010	.933
MINIMUM X	:	-.736	-.610	-.573
MAXIMUM Y	:	.659	.546	.572
MINIMUM Y	:	-1.016	-.723	-.655
CENTROID X	:	-.214	-.340	-.263
CENTROID Y	:	-.161	-.048	-.116
POA TO CENTROID in.	:	.268	.343	.288
MIN RADIUS	:	.069	.186	.099
MEAN RADIUS	:	.661	.564	.514
MAX RADIUS	:	1.520	1.019	.955
HORIZONTAL SPREAD	:	1.866	1.620	1.506
VERTICAL SPREAD	:	1.675	1.269	1.227
EXTREME SPREAD	:	2.508	1.717	1.717
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			9	
NUMBER IN THREE INCH CIRCLE =			9	

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CENTERFIRE PATTERNS

5

POB

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 9

HS= 2.813

VS= 1.884

GS= 2.817

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.415	1.260	1.063
MINIMUM X	:	-1.398	-1.197	-1.040
MAXIMUM Y	:	1.031	.965	.900
MINIMUM Y	:	-.853	-.919	-.984
CENTROID X	:	.280	.435	.278
CENTROID Y	:	-.201	-.135	-.070
POB TO CENTROID in.	:	.344	.455	.286
MIN RADIUS	:	.475	.341	.511
MEAN RADIUS	:	1.042	.977	.928
MAX RADIUS	:	1.519	1.363	1.153
HORIZONTAL SPREAD	:	2.813	2.457	2.102
VERTICAL SPREAD	:	1.884	1.884	1.884
EXTREME SPREAD	:	2.817	2.685	2.206
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	