

C6649000

MODEL 700™ M24

Model SWS™

Action

Barrel Length

Capacity

Order No. 5715

*Includes 1 in chamber.



Remington® **DUPONT**
REG. U.S. PAT. & TM. OFF.

MODEL 700™ H24

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

SERIAL NO.
C6649000

ORDER NO.
5716

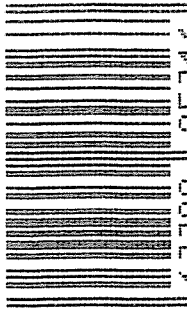
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



5716 C6649000

UPC



0 47700 25716

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649000

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 2 9 1		RW
600	Proof	7 2 9 1		RW
607	Check Headspace	7 2 9 1		RW
610	Dis-assemble Gun	7 2 9 1		RW
612	Magnaflux Barrel Action		JUL 22 1991	GS
	Magnaflux Bolt		JUL 22 1991	GS
615	Rollmark Caliber		JUL 22 1991	GS
617	Drill and Tap Sight Holes		JUL 22 1991	FB
618	Polish Barrel		7/28/91	WB
620	Apply Coatings (Barrel Action)		8-2-91	JS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/9/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/9/91	RW
	C) Inspect Ejector Hole for Chamfer		8/9/91	RW
	D) Oil Firing Pin Ass'y		8/9/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8-19-91	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			8-19-91	JH
	G) Safety Off Force	3	3	3			8-19-91	JH
	H) Trigger Pull Test & Retainability						8-19-91	JH
	I) Firing Pin Indent	.022	.0225	.0225			8-19-91	JH
	J) Assemble Stock						8/21/91	RW
	K) Assemble Swivel Studs						8/22/91	JH
	L) Attach Front and Rear Sight Assemblies						8/21/91	RW
	M) Iron Sight Alignment						8/21/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/21/91	RW
	O) Attach Scope to Rifle						8/21/91	RW
	P) Detach & Attach Scope 20 Times						8/21/91	RW
640	Gallery Target & Test						8-22-91	AC
	A) Time						8-22-91	AC
	B) Malfunctions						8-22-91	AC
	C) Pierced Primers						8-22-91	AC
	D) Optical Clarity of Scope						8-22-91	AC
645	Inspect for Live Ammo						8-22-91	AC
655	Final Inspection							
	A) Headspace						8-22-91	JH
	B) Trigger Pull	269	262	250	250	245	8/22/91	JH
	C) Function						8-22-91	JH
660	Pack						7-17-91	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO C-6649000

DATE 8-19-91

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.22	2.65	2.58	2.59	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.25	2.65	2.64	2.62	
PULL #3	2.53	2.64	2.60	2.50	
PULL #4	2.60	2.63	2.59	2.50	
PULL #5	2.65	2.61	2.60	2.45	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.44	3.25		
PULL #2	3.46	3.21		
PULL #3	3.44	3.33		
PULL #4	3.37	3.34		
PULL #5	3.42	3.37		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.25	4.31		4.43
PULL #2	4.27	4.42		4.51
PULL #3	4.40	4.45		4.51
PULL #4	4.31	4.41		4.53
PULL #5	4.35	4.46		4.43
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS

FOR RIFLE # 06649000

20 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.236072
1 TO	2	.421944
1 TO	3	.247111
1 TO	4	.849588
1 TO	5	.254443

4 <----POR

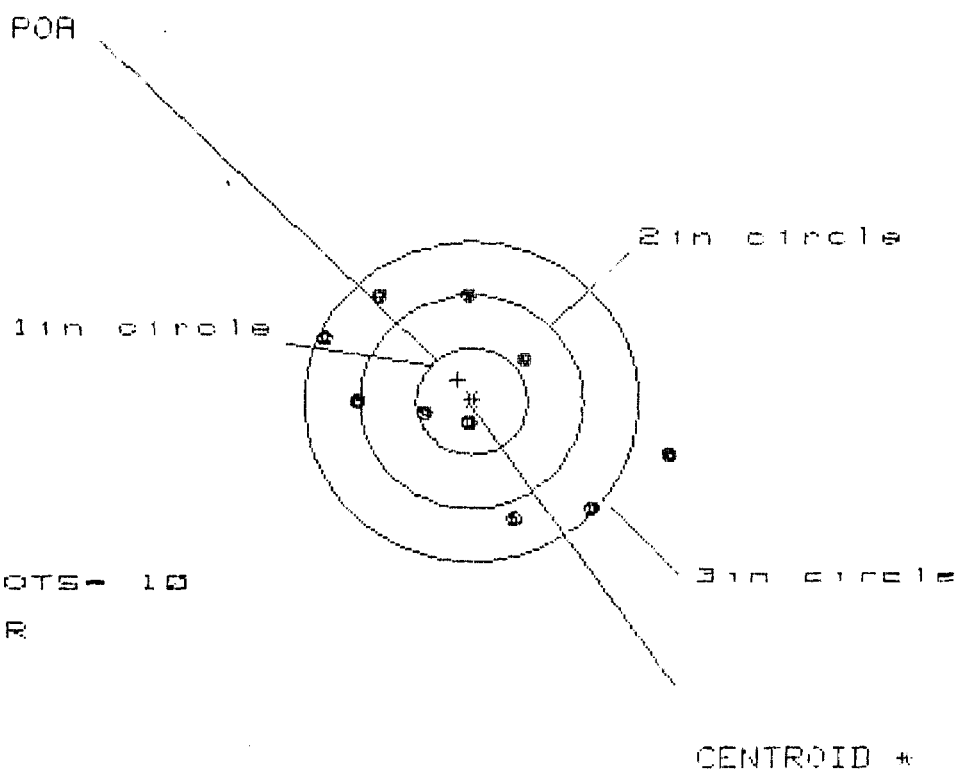
AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0738
AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.147
RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .1244

FOR THIS RIFLE : .9736

Fig 133

FILE:/PATTERNING/CENTERFIRE_PATT/C6649000

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 3

3in = 9

HS= 3.137

VS= 2.157

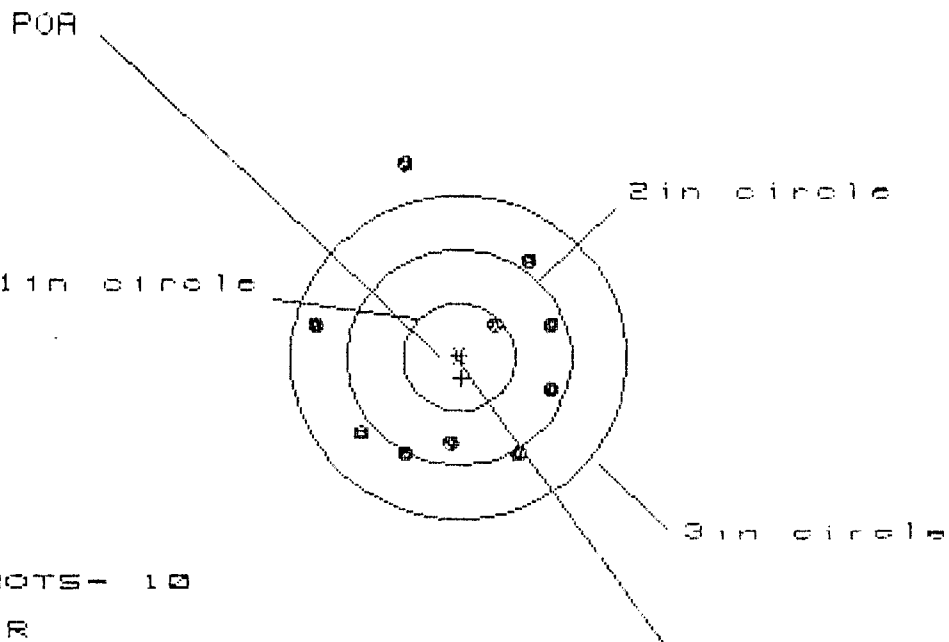
GS= 3.342

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.783	1.273	1.128
MINIMUM X	:	-1.354	-1.155	-1.998
MAXIMUM Y	:	1.021	.963	1.035
MINIMUM Y	:	-1.136	-1.194	-1.122
CENTROID X	:	.127	-.072	.073
CENTROID Y	:	-.199	-.141	-.213
POA TO CENTROID in.	:	.236	.158	.225
1IN RADIUS	:	.212	.333	.205
2IN RADIUS	:	1.064	.956	.906
3IN RADIUS	:	1.858	1.639	1.482
HORIZONTAL SPREAD	:	3.137	2.428	2.117
VERTICAL SPREAD	:	2.157	2.157	2.157
GROUP SPREAD	:	3.342	2.910	2.720
SHOTS IN ONE INCH CIRCLE	=		2	
SHOTS IN TWO INCH CIRCLE	=		3	
SHOTS IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 2.086

VS= 2.709

GS= 2.832

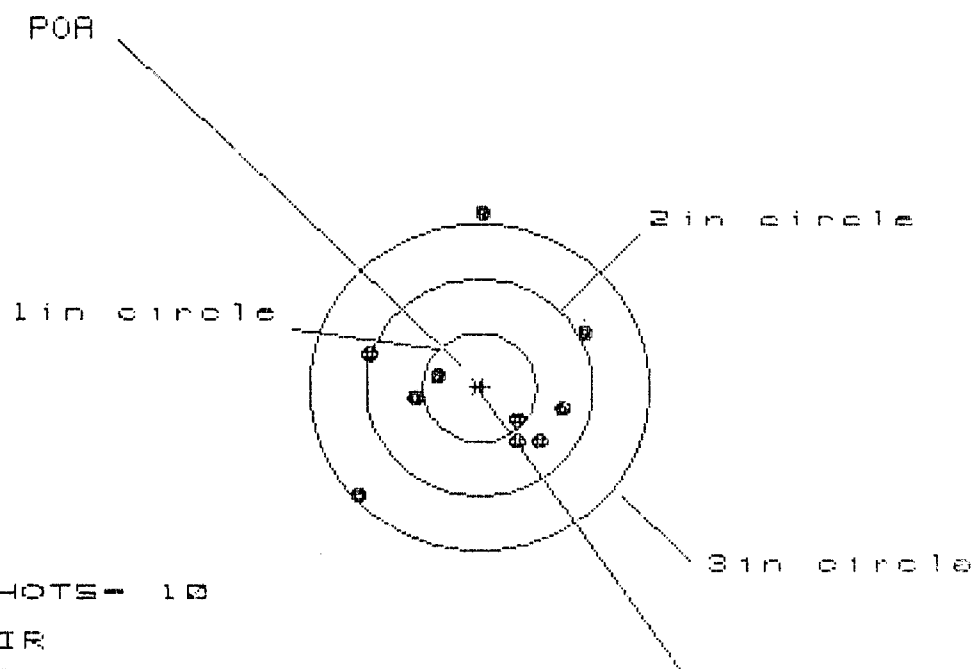
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.860	.804	.643
MINIMUM X	:	-1.226	-1.282	-1.087
MAXIMUM Y	:	1.791	1.142	1.204
MINIMUM Y	:	-.918	-.719	-.657
CENTROID X	:	-.024	.032	.192
CENTROID Y	:	.195	-.004	-.066
POA TO CENTROID in.	:	.196	.032	.203
MIN RADIUS	:	.457	.567	.558
MEAN RADIUS	:	1.043	.920	.836
MAX RADIUS	:	1.861	1.374	1.259
HORIZONTAL SPREAD	:	2.086	2.086	1.730
VERTICAL SPREAD	:	2.709	1.861	1.861
EXTREME SPREAD	:	2.832	2.167	2.166
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 2.009

VS= 2.619

GS= 2.852

CENTROID #

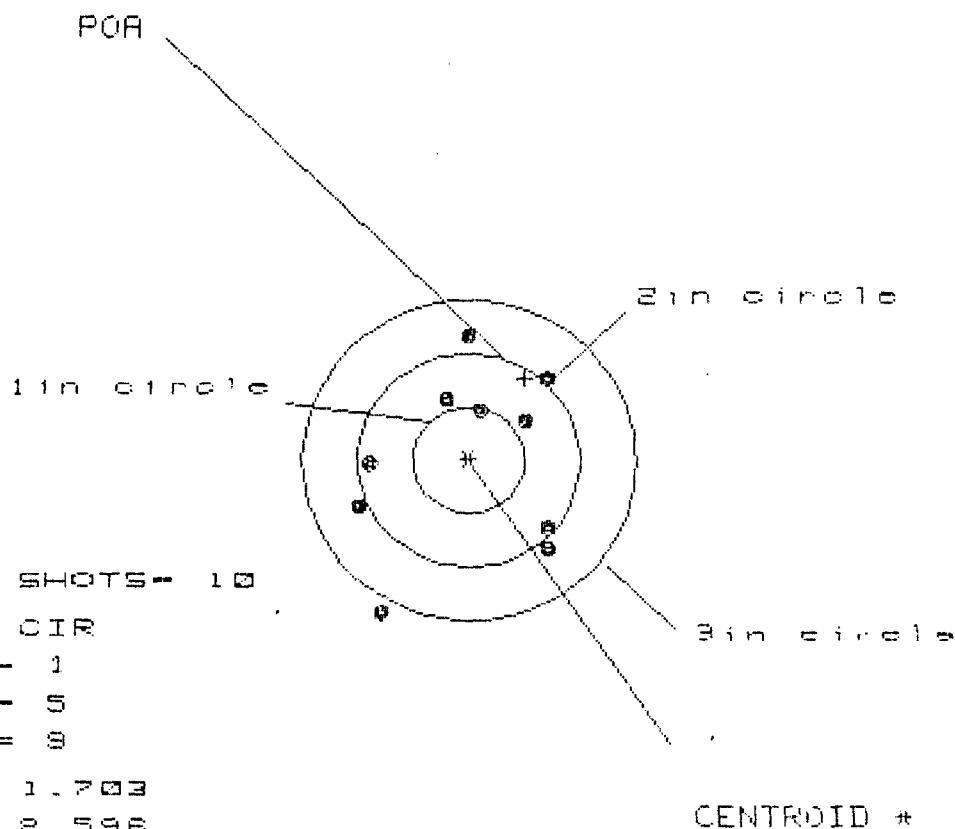
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.946	.953	.821
MINIMUM X	:	-1.063	-1.056	-1.062
MAXIMUM Y	:	1.601	.703	.598
MINIMUM Y	:	-1.018	-.840	-.407
CENTROID X	:	-.031	-.038	.094
CENTROID Y	:	-.009	-.187	-.082
POA TO CENTROID in.	:	.032	.191	.125
MIN RADIUS	:	.373	.334	.259
MEAN RADIUS	:	.860	.753	.663
MAX. RADIUS	:	1.603	1.349	1.100
HORIZONTAL SPREAD	:	2.009	2.009	1.983
VERTICAL SPREAD	:	2.619	1.543	1.005
EXTREME SPREAD	:	2.852	2.533	1.395
NUMBER IN ONE INCH CIRCLE	=		2	
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 = 1

2in = 5

3in = 9

HS= 1.703

VS= 2.596

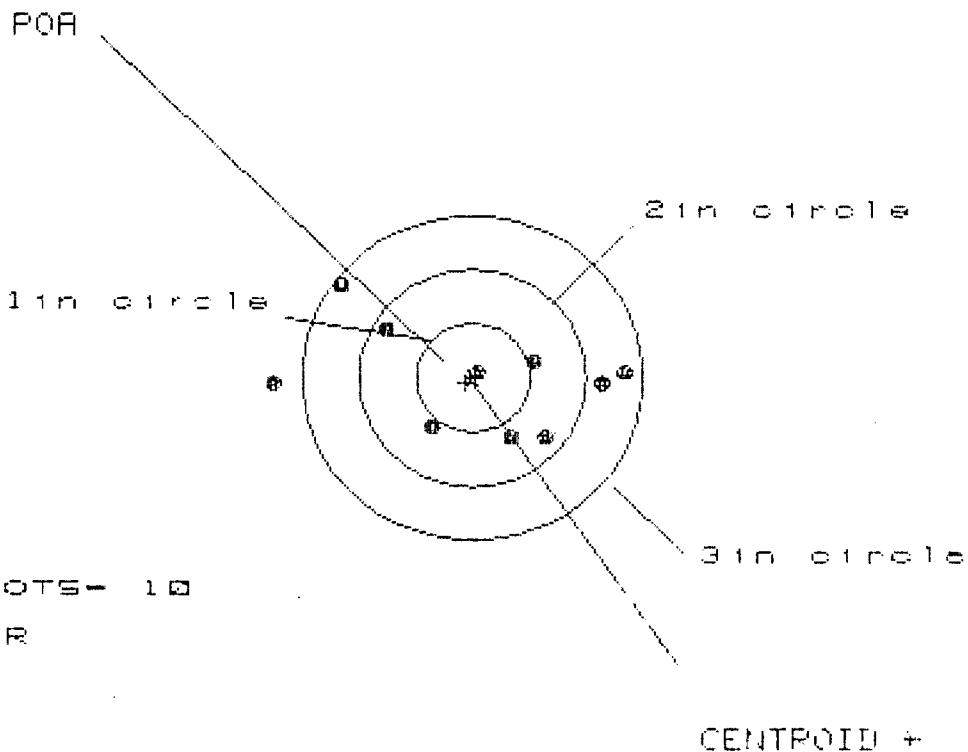
GS= 2.713

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.748	.663	.655
MINIMUM X	:	-.955	-1.040	-1.048
MAXIMUM Y	:	1.176	1.018	.774
MINIMUM Y	:	-1.420	-1.029	-.902
CENTROID X	:	-.503	-.418	-.410
CENTROID Y	:	-.769	-.611	-.738
POA TO CENTROID in.	:	.918	.740	.844
MIN RADIUS	:	.476	.382	.427
MEAN RADIUS	:	.958	.842	.836
MAX RADIUS	:	1.613	1.191	1.142
HORIZONTAL SPREAD	:	1.703	1.703	1.703
VERTICAL SPREAD	:	2.596	2.047	1.676
EXTREME SPREAD	:	2.713	2.143	2.076
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10
 # IN CIR
 1in = 1
 2in = 6
 3in = 9
 HSI = 3.130
 VSI = 1.402
 CSI = 3.130

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.321	1.120	.951
MINIMUM X	-1.809	-1.353	-1.141
MAXIMUM Y	.845	.837	.951
MINIMUM Y	-.557	-.565	-.401
CENTROID X	.062	.263	.400
CENTROID Y	.047	.055	-.043
POA TO CENTROID in.	.078	.268	.404
1IN RADIUS	.098	.199	.214
2IN RADIUS	.943	.822	.890
3IN RADIUS	1.810	1.591	1.267
HORIZONTAL SPREAD	3.130	2.473	2.091
VERTICAL SPREAD	1.402	1.402	1.010
DIAGN SPREAD	3.133	2.596	2.110
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		