

C6536206

MODEL 700™ N24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

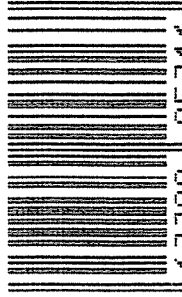


Remington® REG. U.S. PAT. & TM. OFF. 		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.	
MODEL 700™ M24		SERIAL NO. C6636206	ORDER NO. 5716
MADE IN ILION, N.Y., U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.			



5716 C6636206

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636206

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/27/91	KL
600	Proof		6/27/91	KL
607	Check Headspace		6/27/91	KL
610	Dis-assemble Gun		6/27/91	KL
612	Magnaflux Barrel Action		JUL 2 1991	KR
	Magnaflux Bolt		JUL 2 1991	KR
615	Rollmark Caliber		JUL 2 1991	GS
617	Drill and Tap Sight Holes		JUL 2 1991	LB
618	Polish Barrel		JUL 11 7-1986	WB
620	Apply Coatings (Barrel Action)		8/10/91	KL
	Apply Coating (Bolt)		8/10/91	KL
625	Final Assembly A) Clean inside of Bolt Assembly		8/15/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/15/91	KL
	C) Inspect Ejector Hole for Chamfer		8/15/91	KL
	D) Oil Firing Pin Ass'y		8/15/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		8/16/91	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	5	5			8-17-91	D/H
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			8-17-91	D/H
	H) Trigger Pull Test & Retainability						8/17/91	WB
	I) Firing Pin Indent	.020	.020	.020			8-17-91	D/H
	J) Assemble Stock						8/17/91	KK
	K) Assemble Swivel Studs						8-22-91	D/H
	L) Attach Front and Rear Sight Assemblies						8/17/91	KK
	M) Iron Sight Alignment						8/17/91	KK
	N) Detach Front & Rear Sights & place in numbered container						8/17/91	KK
	O) Attach Scope to Rifle						8/17/91	KK
	P) Detach & Attach Scope 20 Times						8/17/91	KK
640	Gallery Target & Test						8/20/91	KJ
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	KT
645	Inspect for Live Ammo						8/20/91	KT
655	Final Inspection							
	A) Headspace						8-22-91	D/H
	B) Trigger Pull	2.41	2.44	2.55	2.56	2.64	8-22-91	D/H
	C) Function						8-22-91	D/H
660	Pack						9-18-91	RF

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636206
23 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.119331
1 TO	2	.112446
1 TO	3	.251072
1 TO	4	.0820061
1 TO	5	.352278

45 (----POA

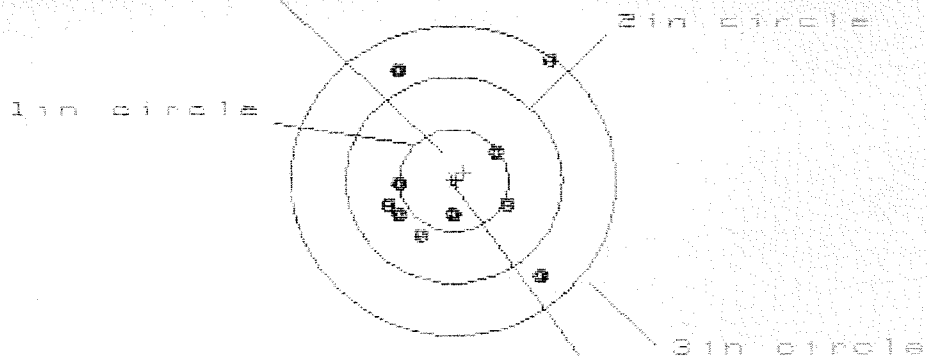
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0066
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0318
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0324777
THE AMR FOR THIS RIFLE IS: .9388

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B36286

CENTERFIRE PATTERNS # 1

POR



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

HS= 1.512

VS= 2.047

GS= 2.401

CENTROID #

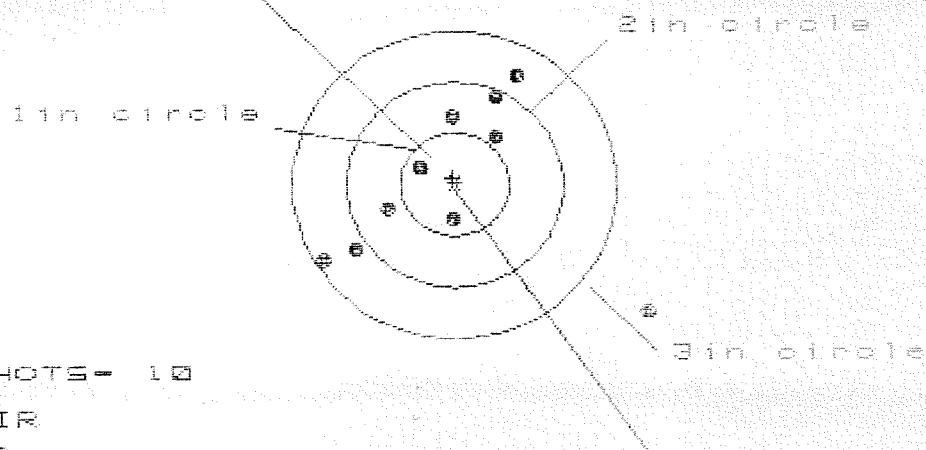
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.934	.848	.795
MINIMUM X	-.578	-.474	-.527
MAXIMUM Y	1.127	1.244	.577
MINIMUM Y	-.920	-.795	-.639
CENTROID X	-.092	-.196	-.143
CENTROID Y	-.076	-.201	-.357
POR TO CENTROID in.	.119	.281	.384
MIN RADIUS	.351	.261	.105
MEAN RADIUS	.757	.640	.532
MAX RADIUS	1.464	1.313	1.020
HORIZONTAL SPREAD	1.512	1.322	1.322
VERTICAL SPREAD	2.047	2.039	1.216
EXTREME SPREAD	2.401	2.401	1.563
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 2

POA



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.986

VS= 2.310

GS= 3.034

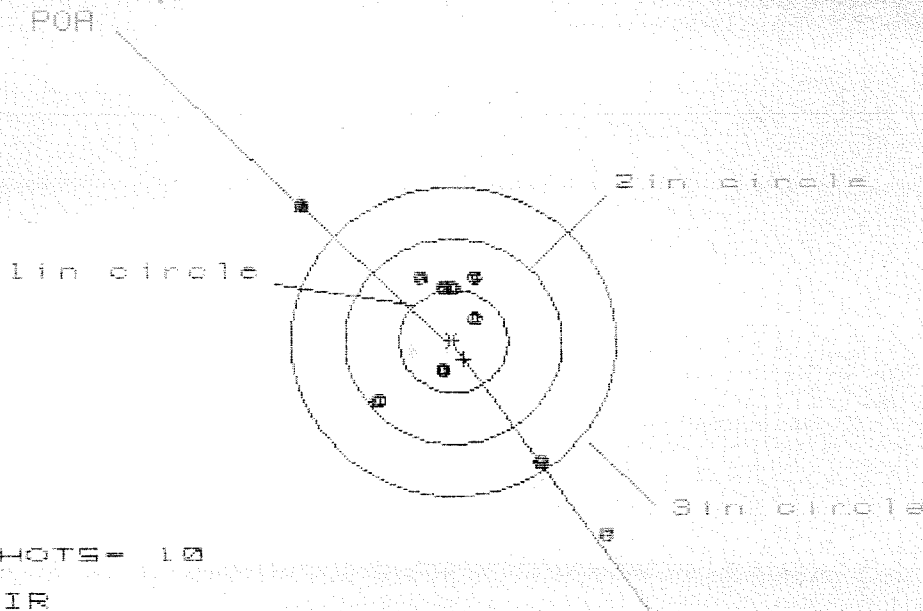
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.755	.760	.631
MINIMUM X	:	-1.231	-1.036	-.850
MAXIMUM Y	:	1.052	.912	.804
MINIMUM Y	:	-1.258	-.863	-.843
CENTROID X	:	.020	-.175	-.046
CENTROID Y	:	-.066	.074	.182
POA TO CENTROID in.	:	.069	.190	.188
MIN RADIUS	:	.379	.153	.299
MEAN RADIUS	:	.954	.781	.701
MAX RADIUS	:	2.160	1.348	1.197
HORIZONTAL SPREAD	:	2.986	1.796	1.481
VERTICAL SPREAD	:	2.310	1.775	1.647
EXTREME SPREAD	:	3.034	2.525	2.215
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 8

HS= 2.870

VS= 3.239

GS= 4.328

CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.420	1.003	.842
MINIMUM X	-1.450	-1.293	-.749
MAXIMUM Y	1.355	1.146	.600
MINIMUM Y	-1.884	-1.363	-1.220
CENTROID X	-.098	-.255	-.094
CENTROID Y	.175	.384	.241
POR TO CENTROID in.	.200	.481	.259
MIN RADIUS	.294	.299	.245
MEAN RADIUS	.974	.770	.657
MAX RADIUS	2.359	1.727	1.482
HORIZONTAL SPREAD	2.870	2.296	1.591
VERTICAL SPREAD	3.239	2.509	1.820
EXTREME SPREAD	4.328	3.401	2.119
NUMBER IN ONE INCH CIRCLE	= 2		
NUMBER IN TWO INCH CIRCLE	= 7		
NUMBER IN THREE INCH CIRCLE	= 8		

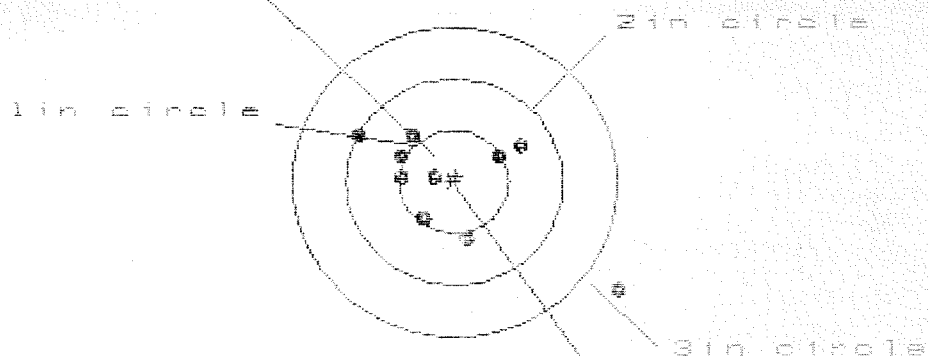
29 Aug 1991

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CENTERFIRE PATTERNS

4

POA



OF SHOTS = 10

IN CIR

1in = 4

2in = 8

3in = 9

HS = 2.447

VS = 1.551

GS = 2.888

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.535	.786	.693
MINIMUM X	-.912	-.741	-.482
MAXIMUM Y	.491	.373	.418
MINIMUM Y	-1.060	-.686	-.641
CENTROID X	-.013	-.184	-.091
CENTROID Y	-.054	.064	.019
POA TO CENTROID in.	.055	.195	.093
MIN RADIUS	.163	.103	.103
MEAN RADIUS	.690	.512	.479
MAX RADIUS	1.865	.836	.768
HORIZONTAL SPREAD	2.447	1.527	1.095
VERTICAL SPREAD	1.551	1.059	1.059
EXTREME SPREAD	2.888	1.529	1.186
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	9		

23 Aug 1991

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 2.418

VS= 1.473

GS= 2.667

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.473	1.459	1.915
MINIMUM X	:	-.945	-.781	-.599
MAXIMUM Y	:	.686	.560	.627
MINIMUM Y	:	-.867	-.913	-.846
CENTROID X	:	.150	-.014	-.196
CENTROID Y	:	.180	.226	.159
POA TO CENTROID in.	:	.234	.226	.253
MIN RADIUS	:	.361	.197	.190
MEAN RADIUS	:	.819	.691	.550
MAX RADIUS	:	1.530	1.554	1.037
HORIZONTAL SPREAD	:	2.418	2.240	1.514
VERTICAL SPREAD	:	1.473	1.473	1.473
EXTREME SPREAD	:	2.667	2.667	1.706
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C6636206
DATE 8/17/91
TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.37	2.39	2.48	2.41	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.30	2.33	2.28	2.44	
PULL #3	2.54	2.29	2.40	2.55	
PULL #4	2.54	2.47	2.43	2.56	
PULL #5	2.46	2.43	2.35	2.64	
TOTAL	12.21	11.91	11.94		
AVG.	2.44	2.38	2.39		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.20	3.14		
PULL #2	3.17	3.20		
PULL #3	3.31	3.08		
PULL #4	3.30	3.38		
PULL #5	3.29	3.21		
TOTAL	16.27	16.01		
AVG.	3.25	3.20		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.32	4.73		4.15
PULL #2	4.02	4.23		4.13
PULL #3	4.27	4.28		4.31
PULL #4	4.31	4.39		4.27
PULL #5	4.39	4.26		4.14
TOTAL	21.31	21.29		21.00
AVG.	4.26	4.26		4.20