

C6636213

MODEL 700TM M24

Model **SWS**TM

Action

Barrel Length

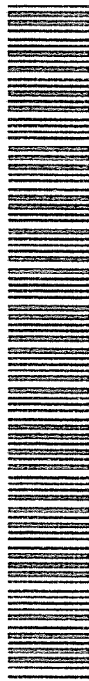
Capacity

Order No. **5715**

*Includes 1 in chamber.

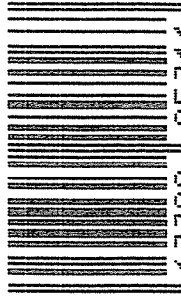
Remington

 		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700TM M24		SERIAL NO. C6636213
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		ORDER NO. 5716



5716 C6636213

UPC

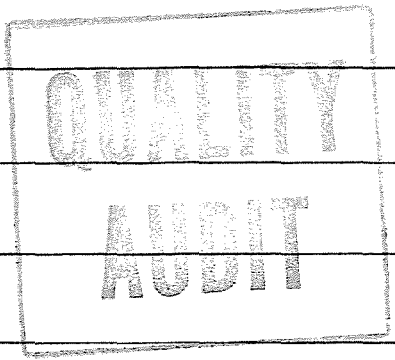


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CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636213

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/24/91	Kd
600	Proof		6/24/91	Kd
607	Check Headspace		6/24/91	Kd
610	Dis-assemble Gun		6/24/91	Kd
612	Magnaflux Barrel Action		JUL 1 1991	KR
	Magnaflux Bolt		JUL 1 1991	KR
615	Rollmark Caliber		JUL 1 1991	SS
617	Drill and Tap Sight Holes		JUL 1 1991	LB
618	Polish Barrel		JUL 2 1991	WB
620	Apply Coatings (Barrel Action)		JUL 23 1991	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/5/91	Kd
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/5/91	Kd
	C) Inspect Ejector Hole for Chamfer		8/5/91	Kd
	D) Oil Firing Pin Ass'y		8/5/91	Kd
	E) Adjust Trigger Pull to Min Setting and Stake		8-6-91	SS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5 $\frac{3}{4}$	6			8-6-91	D/H
	G) Safety Off Force	2	2	2			8-6-91	D/H
	H) Trigger Pull Test & Retainability						8-6-91	JLP
	I) Firing Pin Indent	1.020	1.020	1.020			8-6-91	D/H
	J) Assemble Stock						8/9/91	KR
	K) Assemble Swivel Studs						8-14-91	D/H
	L) Attach Front and Rear Sight Assemblies						8/9/91	KR
	M) Iron Sight Alignment						8/9/91	KR
	N) Detach Front & Rear Sights & place in numbered container						8/9/91	KR
	O) Attach Scope to Rifle						8/9/91	KR
	P) Detach & Attach Scope 20 Times						8/9/91	KR
640	Gallery Target & Test						8-13-91	AC
	A) Time						8-13-91	AC
	B) Malfunctions						8-13-91	AC
	C) Pierced Primers						8-13-91	AC
	D) Optical Clarity of Scope						8-13-91	AC
645	Inspect for Live Ammo						8-13-91	AC
655	Final Inspection							
	A) Headspace						8-14-91	D/H
	B) Trigger Pull	2.42	2.62	2.67	2.44	2.60	8-14-91	JLP
	C) Function						8-14-91	D/H
660	Pack						8-17-91	D/H

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6636213

DATE 8-6-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.56	2.36	2.30	2.62	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.35	2.32	2.36	2.62	
PULL #3	2.30	2.31	2.25	2.67	
PULL #4	2.35	2.20	2.34	2.44	
PULL #5	2.44	2.29	2.30	2.60	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.51	3.30		
PULL #2	3.40	3.35		
PULL #3	3.37	3.34		
PULL #4	3.37	3.41		
PULL #5	3.20	3.39		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.40	4.36		4.37
PULL #2	4.30	4.30		4.28
PULL #3	4.34	4.27		4.36
PULL #4	4.31	4.30		4.33
PULL #5	4.17	4.30		4.47
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C5636213
22 Aug 1991

CENTROIDAL DISTANCES

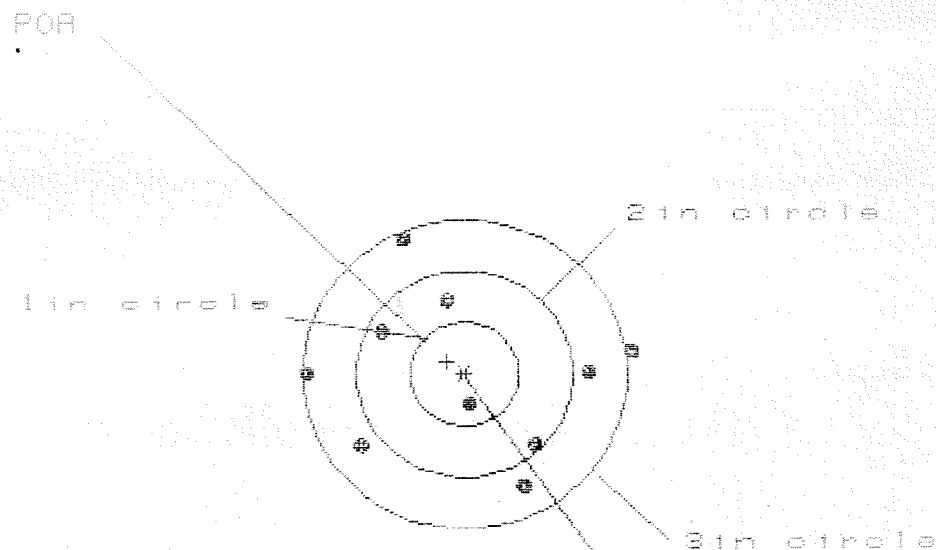
0 TO	1	.197041
1 TO	2	.432823
1 TO	3	.13808
1 TO	4	.0661891
1 TO	5	.284417

etc ² <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1666
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0588
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .176672
THE AMP FOR THIS RIFLE IS: .922

22 Aug 1991 FILE:/PATTERNING/CENTERFIRE_PATT/C8836213

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS = 3.0000

VS = 2.4000

GS = 3.0003

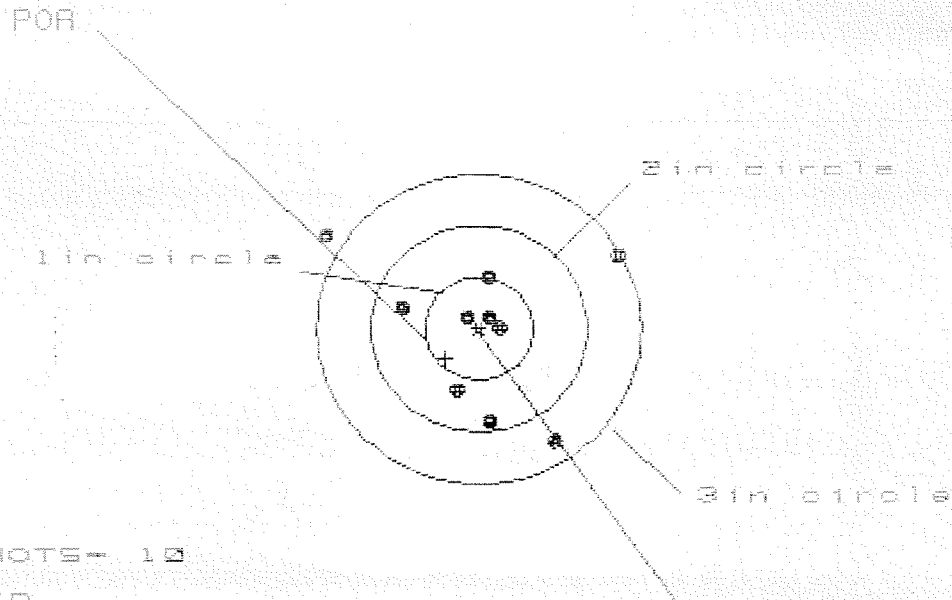
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.563	1.300	1.258
MINIMUM X	-1.437	-1.264	-1.306
MAXIMUM Y	1.358	1.379	1.893
MINIMUM Y	-1.050	-1.029	-1.856
CENTROID X	.160	-.013	.029
CENTROID Y	-.115	-.136	-.309
POA TO CENTROID in.	.197	.137	.310
MIN RADIUS	.313	.335	.171
MEAN RADIUS	1.071	1.004	.928
MAX RADIUS	1.574	1.420	1.329
HORIZONTAL SPREAD	3.000	2.564	2.564
VERTICAL SPREAD	2.400	2.408	1.749
EXTREME SPREAD	3.003	2.624	2.565
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	9		

22 Aug 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 9

HS= 2.663

VS= 1.975

GS= 2.839

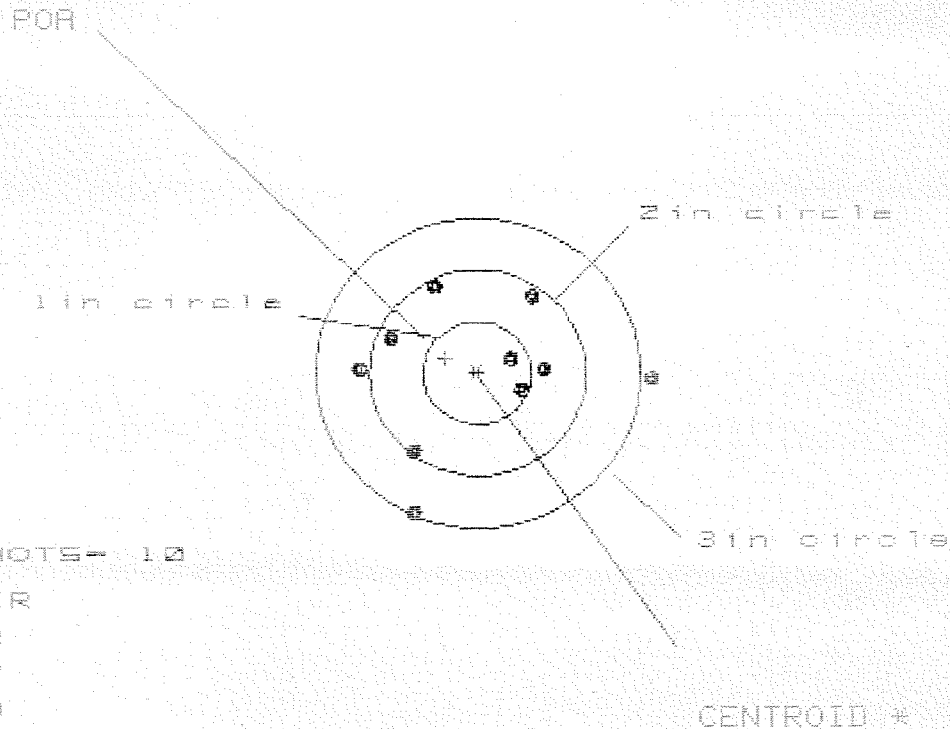
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.268	1.113	.628
MINIMUM X	:	-1.395	-.876	-.736
MAXIMUM Y	:	.888	.791	.670
MINIMUM Y	:	-1.087	-.988	-.889
CENTROID X	:	.310	.465	.326
CENTROID Y	:	.291	.192	.093
POA TO CENTROID in.	:	.425	.503	.339
MIN RADIUS	:	.143	.129	.272
MEAN RADIUS	:	.757	.670	.583
MAX RADIUS	:	1.654	1.366	1.089
HORIZONTAL SPREAD	:	2.663	1.989	1.365
VERTICAL SPREAD	:	1.975	1.779	1.559
EXTREME SPREAD	:	2.839	2.045	1.889
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

22 Aug 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS= 2.714

VS= 2.142

CS= 2.718

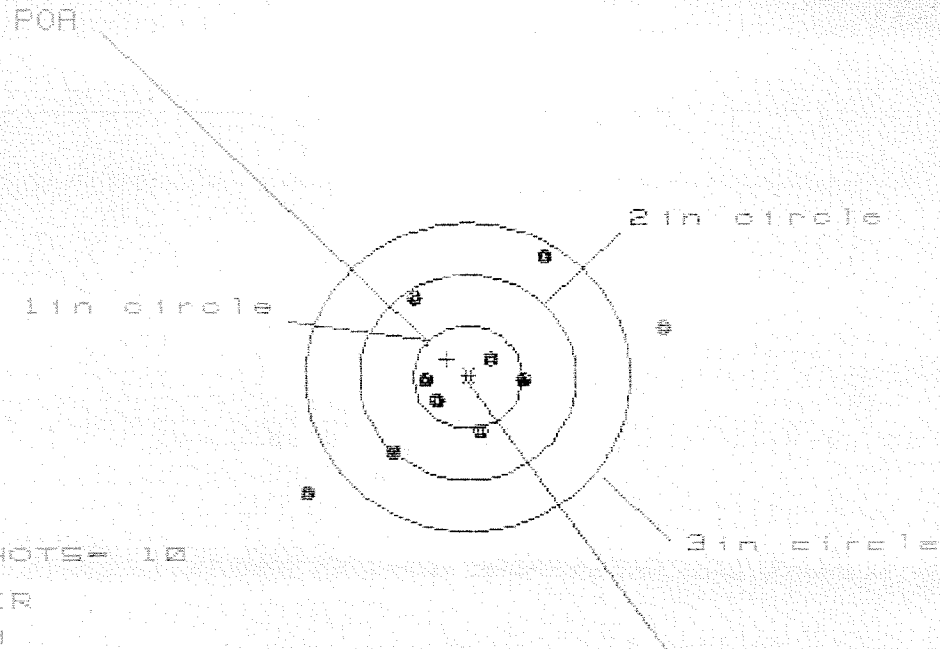
CENTROID *

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.654	.805	.749
MINIMUM X	-1.060	-.876	-.932
MAXIMUM Y	.824	.818	.652
MINIMUM Y	-1.318	-1.324	-.922
CENTROID X	.295	.111	.167
CENTROID Y	-.144	-.138	.028
POA TO CENTROID in.	.328	.177	.170
MIN RADIUS	.327	.494	.415
MEAN RADIUS	.925	.850	.757
MAX RADIUS	1.655	1.398	1.032
HORIZONTAL SPREAD	2.714	1.681	1.681
VERTICAL SPREAD	2.142	2.142	1.574
EXTREME SPREAD	2.718	2.379	1.879
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

22 Aug 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 3

2in = 6

3in = 8

HS= 3.252

VS= 2.295

GS= 3.637

PATTERN # : 4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.775	1.610	.735
MINIMUM X	-1.487	-.877	-.676
MAXIMUM Y	1.170	1.045	1.090
MINIMUM Y	-1.125	-.852	-.807
CENTROID X	.190	.355	.154
CENTROID Y	-.174	-.049	-.094
POA TO CENTROID in.	.258	.358	.180
MIN RADIUS	.315	.108	.309
MEAN RADIUS	.913	.808	.681
MAX RADIUS	1.864	1.650	1.315
HORIZONTAL SPREAD	3.262	2.487	1.411
VERTICAL SPREAD	2.295	1.897	1.897
EXTREME SPREAD	3.637	2.766	2.364
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

22 Aug 1991

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CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS= 2.842

VS= 1.929

GS= 2.982

CENTROID #

PATTERN #

5

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.493	1.069	.921
MINIMUM X	:	-1.349	-1.183	-.813
MAXIMUM Y	:	1.081	1.116	1.047
MINIMUM Y	:	-.848	-.813	-.882
CENTROID X	:	-.122	-.288	-.146
CENTROID Y	:	-.152	-.187	-.118
POA TO CENTROID in.	:	.195	.343	.193
MIN RADIUS	:	.113	.150	.142
MEAN RADIUS	:	.944	.875	.812
MAX RADIUS	:	1.526	1.410	1.325
HORIZONTAL SPREAD	:	2.842	2.252	1.734
VERTICAL SPREAD	:	1.929	1.929	1.929
EXTREME SPREAD	:	2.982	2.676	2.201
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	9		