

C6636244

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

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

MODEL 700TM H24

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

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

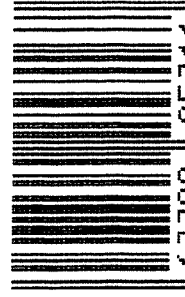
SERIAL NO. C6636244

ORDER NO. 5716

06



UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636244

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 30 91		Rw
600	Proof	4 30 91		Rw
607	Check Headspace	4 30 91		Rw
610	Dis-assemble Gun	4 30 91		Rw
612	Magnaflux Barrel Action	5 6 91		Kcd
	Magnaflux Bolt	5 6 91		Kcd
615	Rollmark Caliber	5 6 91		GL
617	Drill and Tap Sight Holes	5 10 91		FB
618	Polish Barrel	5 10 91		WB
620	Apply Coatings (Barrel Action)		5-30-91	TA
	Apply Coating (Bolt)		5-30-91	TA
625	Final Assembly A) Clean inside of Bolt Assembly		5/30/91	Rw
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/91	Rw
	C) Inspect Ejector Hole for Chamfer		5/30/91	Rw
	D) Oil Firing Pin Ass'y		5/30/91	Rw
	E) Adjust Trigger Pull to Min Setting and Stake		6-5-91	RM

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			6-5-91	JU
	G) Safety Off Force	4	4	4			6-5-91	JU
	H) Trigger Pull Test & Retainability						6-5-91	JU
	I) Firing Pin Indent	.0215	.0215	.0215			6-5-91	JU
	J) Assemble Stock						6-5-91	RW
	K) Assemble Swivel Studs						6-14-91	JU
	L) Attach Front and Rear Sight Assemblies						6/5/91	RW
	M) Iron Sight Alignment						6/5/91	RW
	N) Detach Front & Rear Sights & place in numbered container						6/5/91	RW
	O) Attach Scope to Rifle						6/5/91	RW
	P) Detach & Attach Scope 20 Times						6/5/91	RW
640	Gallery Target & Test						6-6-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						6-6-91	NF
655	Final Inspection							
	A) Headspace						6-14-91	JU
	B) Trigger Pull	2.77	2.65	2.73	2.69	2.70	6-13-91	JU
	C) Function						6-14-91	JU
660	Pack						6-20-91	NF

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6636244
DATE 6-5-91
TESTER JLC

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.20	2.51	2.50	2.77	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.18	2.42	2.55	2.65	
PULL #3	2.57	2.44	2.48	2.73	
PULL #4	2.50	2.48	2.40	2.69	
PULL #5	2.43	2.48	2.46	2.70	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.50	3.49		
PULL #2	3.49	3.18		
PULL #3	3.40	3.37		
PULL #4	3.45	3.41		
PULL #5	3.39	3.28		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.33	4.23		4.35
PULL #2	4.22	4.24		4.60
PULL #3	4.42	4.20		4.44
PULL #4	4.30	4.20		4.31
PULL #5	4.23	4.12		4.57
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636244
6 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.170532
1 TO	2	.228615
1 TO	3	.624641
1 TO	4	.179179
1 TO	5	.469438

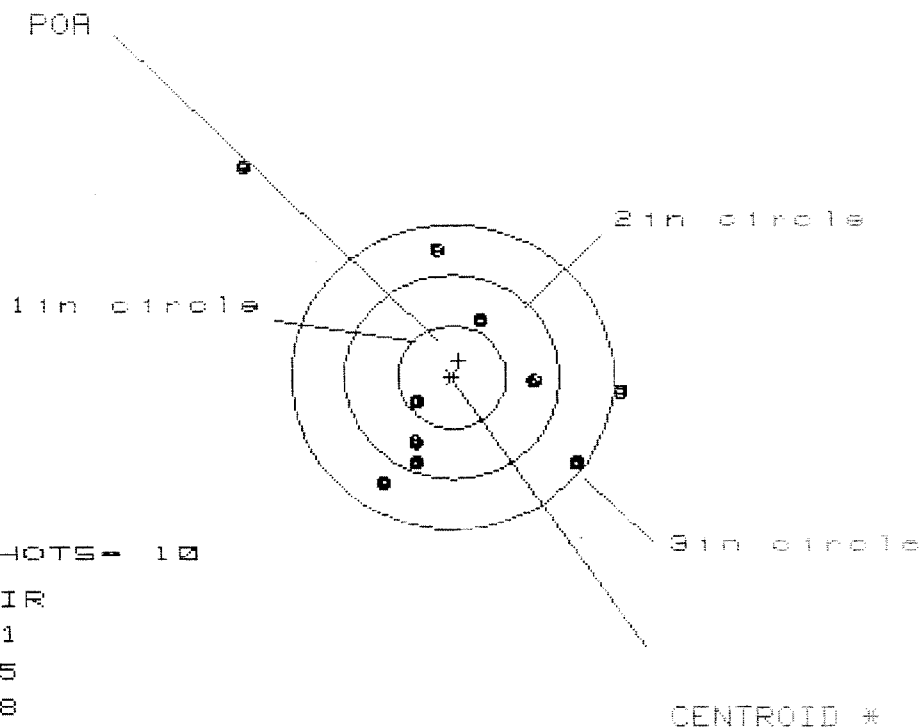
$\bar{x}_s$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1496
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0494
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .157545
THE AMR FOR THIS RIFLE IS: 1.041

6 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C68836244

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in - 1

2in - 5

3in = 8

HS= 3.473

VS= 3.045

GS= 4.177

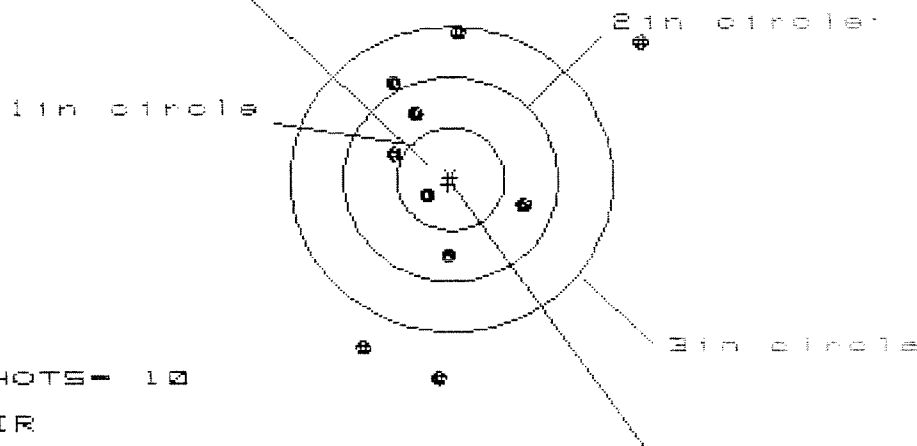
PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.555	1.342	1.093
MINIMUM X	:	-1.918	-.808	-.640
MAXIMUM Y	:	2.018	1.485	1.494
MINIMUM Y	:	-1.027	-.803	-.794
CENTROID X	:	-.059	.154	-.014
CENTROID Y	:	-.160	-.384	-.393
POA TO CENTROID in.	:	.170	.414	.393
MIN RADIUS	:	.456	.545	.406
MEAN RADIUS	:	1.161	.944	.869
MAX RADIUS	:	2.784	1.531	1.508
HORIZONTAL SPREAD	:	3.473	2.150	1.733
VERTICAL SPREAD	:	3.045	2.288	2.288
EXTREME SPREAD	:	4.177	2.460	2.460
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	8		

6 Jun 1991

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CENTERFIRE PATTERNS # 2

POA



OF SHOTS - 10

IN CIR

1in = 1

2in = 5

3in = 7

HS = 2.620

VS = 3.410

GS = 4.009

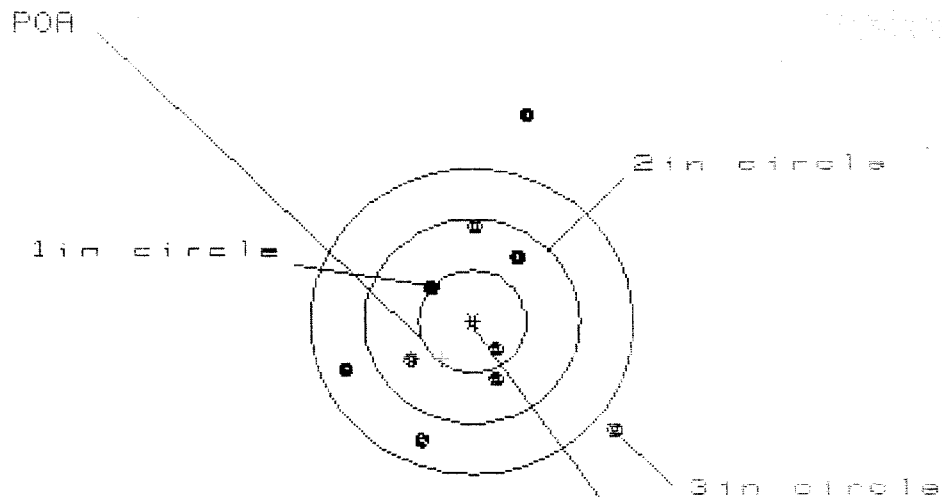
CENTROID #

PATTERN #	2	2	2
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.794	.864	.877
MINIMUM X	-.826	-.627	-.614
MAXIMUM Y	1.447	1.597	1.371
MINIMUM Y	-1.963	-1.813	-1.760
CENTROID X	.029	-.170	-.183
CENTROID Y	.051	-.099	.127
POA TO CENTROID in.	.059	.197	.223
MIN RADIUS	.262	.056	.188
MEAN RADIUS	1.162	1.013	.886
MAX RADIUS	2.246	1.816	1.864
HORIZONTAL SPREAD	2.620	1.491	1.491
VERTICAL SPREAD	3.410	3.410	3.131
EXTREME SPREAD	4.009	3.415	3.253
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		7	

6 Jun 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in - 1

2in - 5

3in = 8

HS= 2.496

VS= 3.155

GS= 3.315

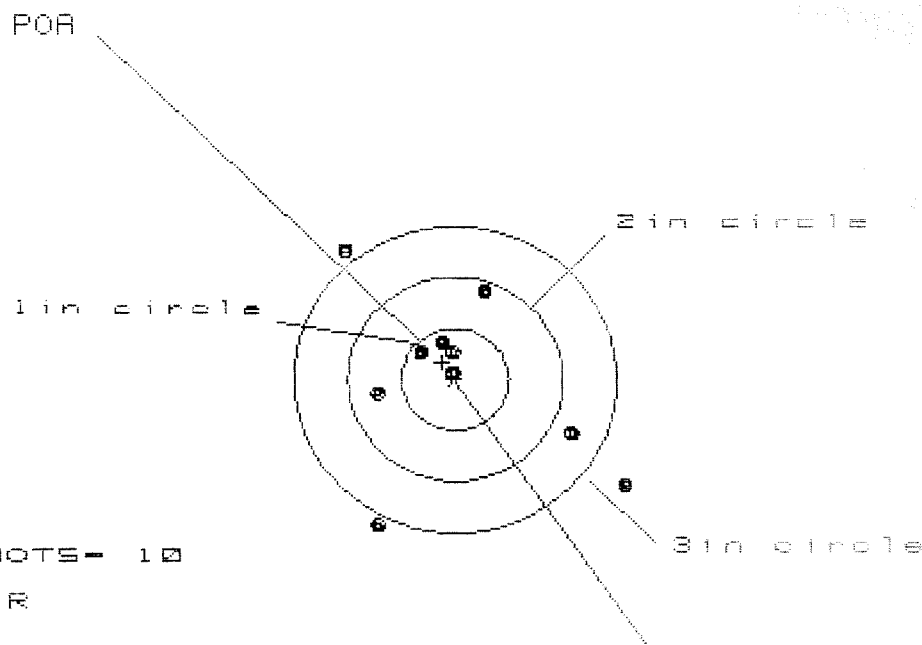
CENTROID #

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.284
MINIMUM X	-1.212
MAXIMUM Y	2.028
MINIMUM Y	-1.127
CENTROID X	.281
CENTROID Y	.364
POA TO CENTROID in.	.460
MIN RADIUS	.297
MEAN RADIUS	1.006
MAX RADIUS	2.092
HORIZONTAL SPREAD	2.496
VERTICAL SPREAD	3.155
EXTREME SPREAD	3.315
NUMBER IN ONE INCH CIRCLE	1
NUMBER IN TWO INCH CIRCLE	5
NUMBER IN THREE INCH CIRCLE	8

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 4

2in = 6

3in = 7

HS= 2.583

VS= 2.679

GS= 3.416

CENTROID #

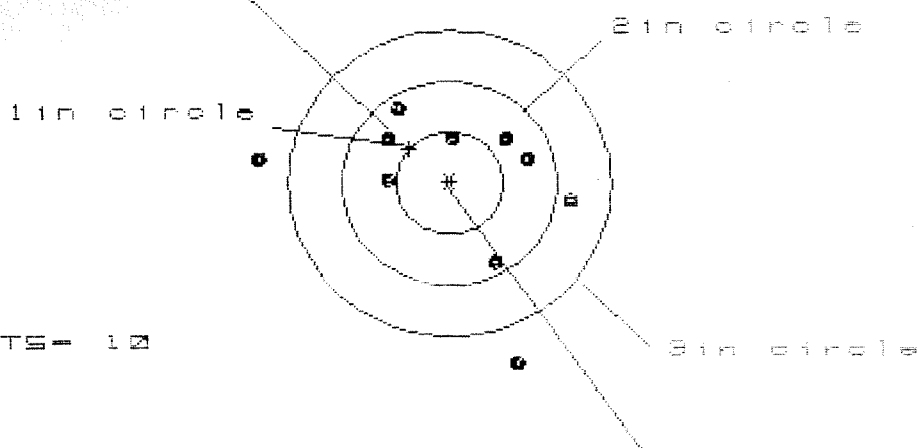
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.578	1.263	1.194
MINIMUM X	:	-1.005	-.830	-.899
MAXIMUM Y	:	1.243	1.132	.939
MINIMUM Y	:	-1.436	-1.547	-.862
CENTROID X	:	.120	-.055	.014
CENTROID Y	:	-.168	-.057	.136
POA TO CENTROID in.	:	.206	.080	.137
MIN RADIUS	:	.072	.135	.070
MEAN RADIUS	:	.914	.758	.607
MAX RADIUS	:	1.864	1.643	1.473
HORIZONTAL SPREAD	:	2.583	2.093	2.093
VERTICAL SPREAD	:	2.679	2.679	1.801
EXTREME SPREAD	:	3.416	2.761	2.761
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 5

FOR



OF SHOTS = 10

IN CIR

1in = 1

2in = 7

3in = 8

HS = 2.846

VS = 2.490

GS = 3.054

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.119
MINIMUM X	-1.727
MAXIMUM Y	.726
MINIMUM Y	-1.764
CENTROID X	.377
CENTROID Y	-.334
POA TO CENTROID in.	.583
MIN RADIUS	.412
MEAN RADIUS	.964
MAX RADIUS	1.857
HORIZONTAL SPREAD	2.846
VERTICAL SPREAD	2.490
EXTREME SPREAD	3.054
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	7
NUMBER IN THREE INCH CIRCLE =	8