

C6636280

MODEL 700™ M24

Model **SWS**™

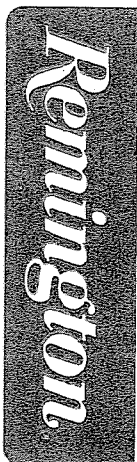
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636280

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	5/3/91	K.S.
600	Proof		5/3/91	K.S.
607	Check Headspace		5/3/91	K.S.
610	Dis-assemble Gun		5/3/91	K.S.
612	Magnaflux Barrel Action	5 8 9 1		KCR
	Magnaflux Bolt	5 8 9 1		KCR
615	Rollmark Caliber	5 8 9 1		G.B.
617	Drill and Tap Sight Holes	5 15 9 1		LB
618	Polish Barrel	5 15 9 1		WB
620	Apply Coatings (Barrel Action)		5-29-91	15
	Apply Coating (Bolt)			15
625	Final Assembly			
	A) Clean inside of Bolt Assembly		5/30/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/91	KS
	C) Inspect Ejector Hole for Chamfer		5/30/91	KS
	D) Oil Firing Pin Ass'y		5/30/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		6-4-91	9/1

22222

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			6-4-91	JK
	G) Safety Off Force	4	4	4			6-4-91	JK
	H) Trigger Pull Test & Retainability						6-4-91	JK
	I) Firing Pin Indent	10205	10205	10205			6-4-91	JK
	J) Assemble Stock						4/4/91	KS
	K) Assemble Swivel Studs						6-8-91	DH
	L) Attach Front and Rear Sight Assemblies						4/4/91	KS
	M) Iron Sight Alignment						4/4/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/4/91	KS
	O) Attach Scope to Rifle						4/4/91	KS
	P) Detach & Attach Scope 20 Times						4/4/91	KS
640	Gallery Target & Test						6-5-91	DH
	A) Time						6-5-91	DH
	B) Malfunctions						6-5-91	DH
	C) Pierced Primers						6-5-91	DH
	D) Optical Clarity of Scope						6-5-91	DH
645	Inspect for Live Ammo						6-5-91	DH
655	Final Inspection							
	A) Headspace						6-8-91	DH
	B) Trigger Pull	2.22	2.24	2.18	2.28	2.30	6-8-91	JK
	C) Function						6-8-91	DH
660	Pack						6-20-91	VF

Remington
 MODEL 700™ H24

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

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

SERIAL NO.
 C6636280

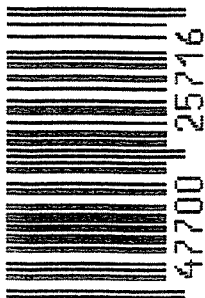
ORDER NO.
5716

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

20



LPC



SWS TRIGGER PULL TEST

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

SERIAL NO. E6636280

DATE 6-4-91

TESTER JK

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.48	2.43	2.38	2.22	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.15	2.35	2.24	
PULL #3	2.36	2.59	2.30	2.18	
PULL #4	2.16	2.21	2.48	2.28	
PULL #5	2.58	2.31	2.50	2.30	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.49	3.37		
PULL #2	3.38	3.39		
PULL #3	3.30	3.32		
PULL #4	3.32	3.15		
PULL #5	3.41	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	4.58	4.63		4.28
PULL #2	4.52	4.59		4.54
PULL #3	4.59	4.51		4.62
PULL #4	4.58	4.61		4.54
PULL #5	4.57	4.60		4.54
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636280
5 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.43115
1 TO	2	.647185
1 TO	3	.488938
1 TO	4	.453256
1 TO	5	.551599

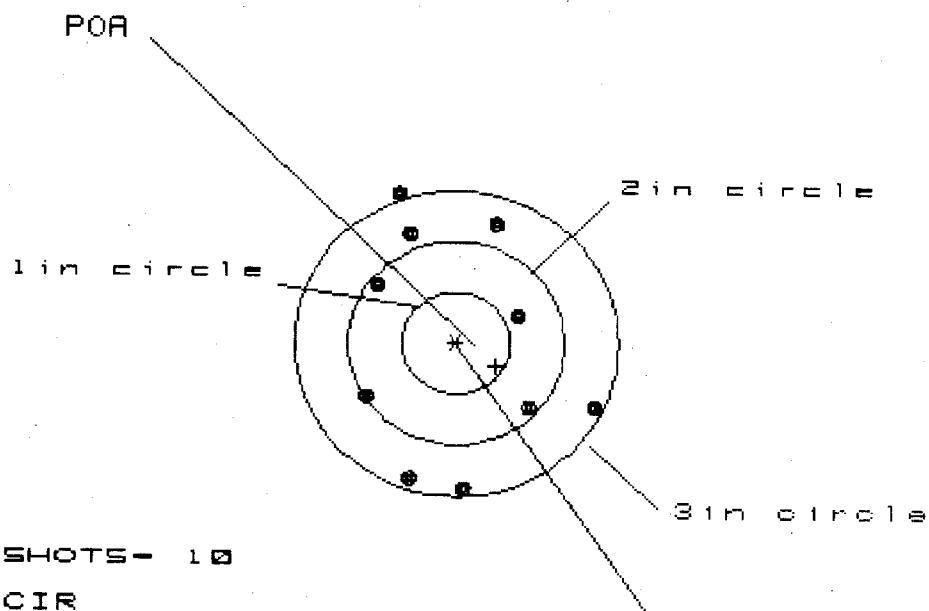
1.2 <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0366
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0216
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0424985
THE AMR FOR THIS RIFLE IS: .9828

5 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636280

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 4

3 in = 9

HS= 2.090

VS= 2.877

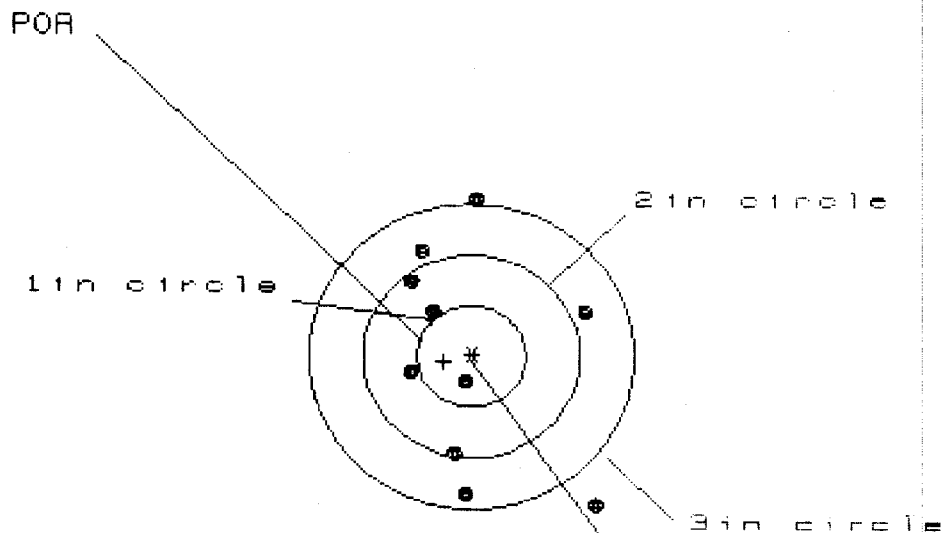
GS= 2.947

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.301	1.240	.786
MINIMUM X	:	-.789	-.850	-.695
MAXIMUM Y	:	1.438	1.325	1.262
MINIMUM Y	:	-1.439	-1.279	-1.342
CENTROID X	:	-.369	-.308	-.463
CENTROID Y	:	.223	.063	.126
POA TO CENTROID in.	:	.431	.314	.480
MIN RADIUS	:	.585	.624	.714
MEAN RADIUS	:	1.158	1.107	1.070
MAX RADIUS	:	1.539	1.362	1.355
HORIZONTAL SPREAD	:	2.090	2.090	1.481
VERTICAL SPREAD	:	2.877	2.604	2.604
EXTREME SPREAD	:	2.947	2.620	2.620
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

5 Jun 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 1.708

VS= 3.051

GS= 3.259

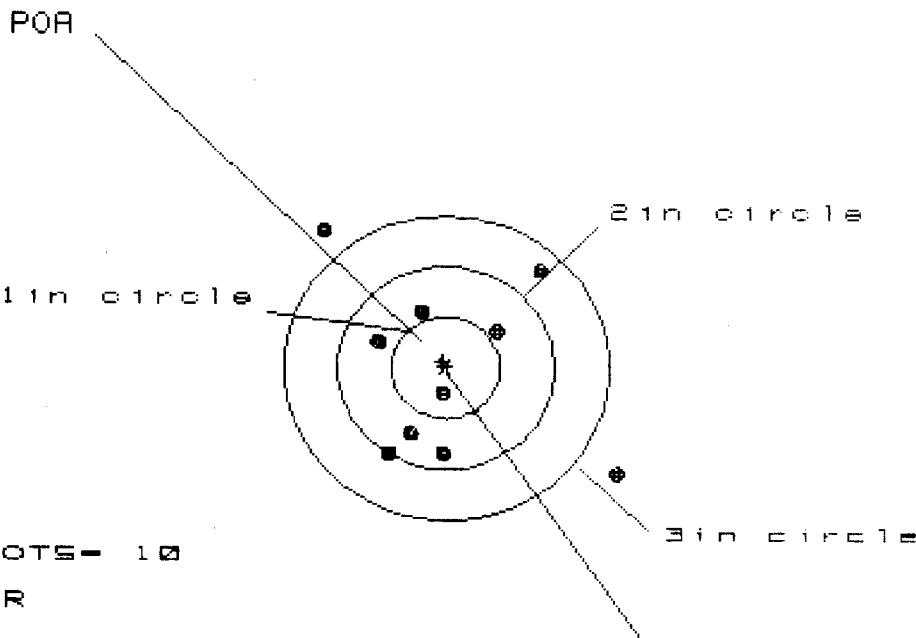
CENTROID #

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.149	1.140	1.157
MINIMUM X	:	-.559	-.432	-.415
MAXIMUM Y	:	1.553	1.386	1.060
MINIMUM Y	:	-1.498	-1.486	-1.312
CENTROID X	:	.256	.129	.112
CENTROID Y	:	.055	.222	.048
POA TO CENTROID in.	:	.262	.256	.122
MIN RADIUS	:	.256	.334	.276
MEAN RADIUS	:	1.026	.904	.828
MAX RADIUS	:	1.888	1.487	1.315
HORIZONTAL SPREAD	:	1.708	1.572	1.572
VERTICAL SPREAD	:	3.051	2.872	2.372
EXTREME SPREAD	:	3.259	2.873	2.412
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	8		

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 8

HS= 2.685

VS= 2.454

GS= 3.637

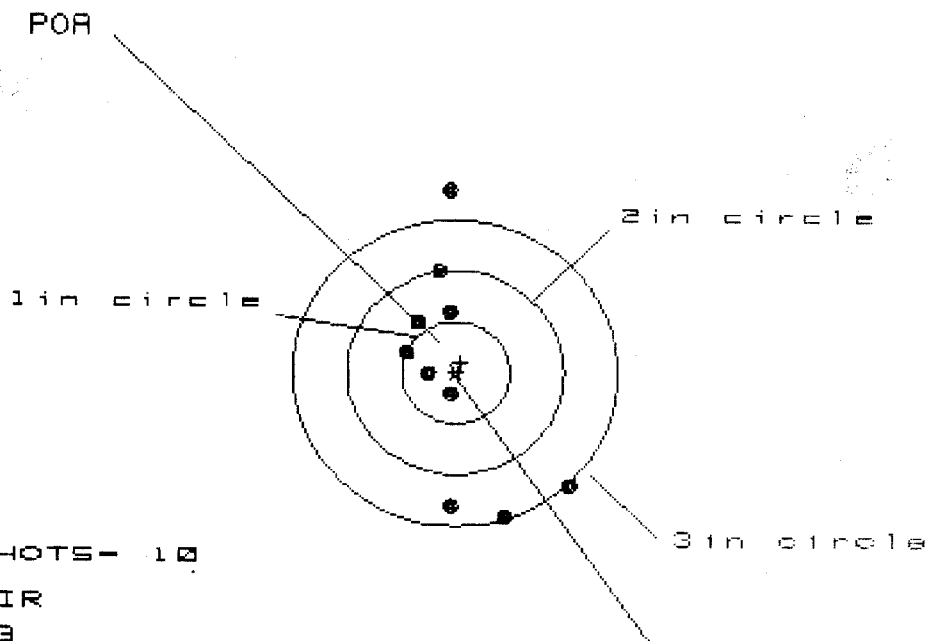
CENTROID #

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.577	1.039	.922
MINIMUM X	:	-1.108	-.933	-.546
MAXIMUM Y	:	1.401	1.284	1.004
MINIMUM Y	:	-1.053	-1.002	-.842
CENTROID X	:	.029	-.146	-.029
CENTROID Y	:	-.061	.056	-.104
POA TO CENTROID in.	:	.067	.157	.108
MIN RADIUS	:	.224	.372	.183
MEAN RADIUS	:	.966	.852	.736
MAX RADIUS	:	1.896	1.587	1.364
HORIZONTAL SPREAD	:	2.685	1.972	1.469
VERTICAL SPREAD	:	2.454	2.286	1.846
EXTREME SPREAD	:	3.637	2.517	2.266
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	8		

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 8

HS= 1.545

VS= 3.142

GS= 3.182

CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.091	1.080	.538
MINIMUM X	:	-.455	-.465	-.330
MAXIMUM Y	:	1.757	1.170	1.062
MINIMUM Y	:	-1.385	-1.190	-1.298
CENTROID X	:	-.049	-.038	-.173
CENTROID Y	:	-.098	-.293	-.185
POA TO CENTROID in.	:	.110	.296	.254
MIN RADIUS	:	.249	.106	.143
MEAN RADIUS	:	.920	.834	.712
MAX RADIUS	:	1.760	1.384	1.405
HORIZONTAL SPREAD	:	1.545	1.545	.868
VERTICAL SPREAD	:	3.142	2.360	2.360
EXTREME SPREAD	:	3.182	2.427	2.427
NUMBER IN ONE INCH CIRCLE =	:	3		
NUMBER IN TWO INCH CIRCLE =	:	6		
NUMBER IN THREE INCH CIRCLE =	:	8		

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 10

HS= 1.922

VS= 2.261

GS= 2.447

CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.186	1.250	1.170
MINIMUM X	:	-.736	-.672	-.752
MAXIMUM Y	:	.970	.827	.681
MINIMUM Y	:	-1.291	-1.160	-.543
CENTROID X	:	-.050	-.114	-.034
CENTROID Y	:	-.227	-.084	.061
POA TO CENTROID in.	:	.232	.142	.070
MIN RADIUS	:	.118	.271	.293
MEAN RADIUS	:	.844	.765	.695
MAX RADIUS	:	1.416	1.327	1.290
HORIZONTAL SPREAD	:	1.922	1.922	1.922
VERTICAL SPREAD	:	2.261	1.987	1.225
EXTREME SPREAD	:	2.447	2.280	2.063
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	