

C6636294

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 700™ H24

SERIAL NO.
 C6606294

ORDER NO.
 5716

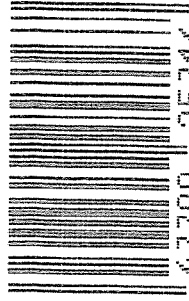
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada. Marque Deposee.

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



5716 C6606294

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636294

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 25	9 1	RW
600	Proof	6 25	9 1	RW
607	Check Headspace	6 25	9 1	RW
610	Dis-assemble Gun	6 25		RW
612	Magnaflux Barrel Action	JUL	1 1991	KR
	Magnaflux Bolt	JUL	1 1991	KR
615	Rollmark Caliber	JUL	1 1991	LS
617	Drill and Tap Sight Holes	JUL	1 1991	LB
618	Polish Barrel	JUL	2 1991	WB
620	Apply Coatings (Barrel Action)		8-27-91	AS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/28/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/28/91	RW
	C) Inspect Ejector Hole for Chamfer		8/28/91	RW
	D) Oil Firing Pin Ass'y		8/28/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9-3-91	AM

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			9/3/91	SH
	G) Safety Off Force	4	4	4			9/3/91	SH
	H) Trigger Pull Test & Retainability						9-3-91	SH
	I) Firing Pin Indent	.0205	.020	.020			9/3/91	SH
	J) Assemble Stock						9/3/91	RW
	K) Assemble Swivel Studs						9-3-91	AC
	L) Attach Front and Rear Sight Assemblies						9/3/91	RW
	M) Iron Sight Alignment						9/3/91	RW
	N) Detach Front & Rear Sights & place in numbered container						9/3/91	RW
	O) Attach Scope to Rifle						9/3/91	RW
	P) Detach & Attach Scope 20 Times						9/3/91	RW
640	Gallery Target & Test						9-4-91	DH
	A) Time						9-4-91	DH
	B) Malfunctions						9-4-91	DH
	C) Pierced Primers						9-4-91	DH
	D) Optical Clarity of Scope						9-4-91	DH
645	Inspect for Live Ammo						9-4-91	DH
655	Final Inspection							
	A) Headspace						9-10-91	AC
	B) Trigger Pull	260	266	254	255	261	9-6-91	SH
	C) Function						9-10-91	AC
660	Pack						9-18-91	NF

SWS TRIGGER PULL TEST

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

SERIAL NO. 06636294DATE 9-3-91TESTER JH.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.21	2.38	2.60	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.26	2.29	2.55	2.66	
PULL #3	2.19	2.24	2.29	2.54	
PULL #4	2.20	2.28	2.30	2.55	
PULL #5	2.35	2.30	2.33	2.61	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.49	3.22		
PULL #2	3.28	3.19		
PULL #3	3.23	3.24		
PULL #4	3.20	3.29		
PULL #5	3.28	3.41		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.47	4.41		4.39
PULL #2	4.42	4.36		4.40
PULL #3	4.25	4.46		4.44
PULL #4	4.40	4.44		4.48
PULL #5	4.41	4.48		4.43
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636294
4 Sep 1991

CENTROIDAL DISTANCES

0 TO 1	.368257
1 TO 2	.505641
1 TO 3	.331694
1 TO 4	.676114
1 TO 5	.215418

$\frac{1}{5}$ <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .085
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0726
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .111784
THE AMR FOR THIS RIFLE IS: .9532

+ Sep 1931

FILE: /PATTERNING/CENTERFIRE_PATT/08836294

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS = 1.570

VS = 3.826

GS = 3.834

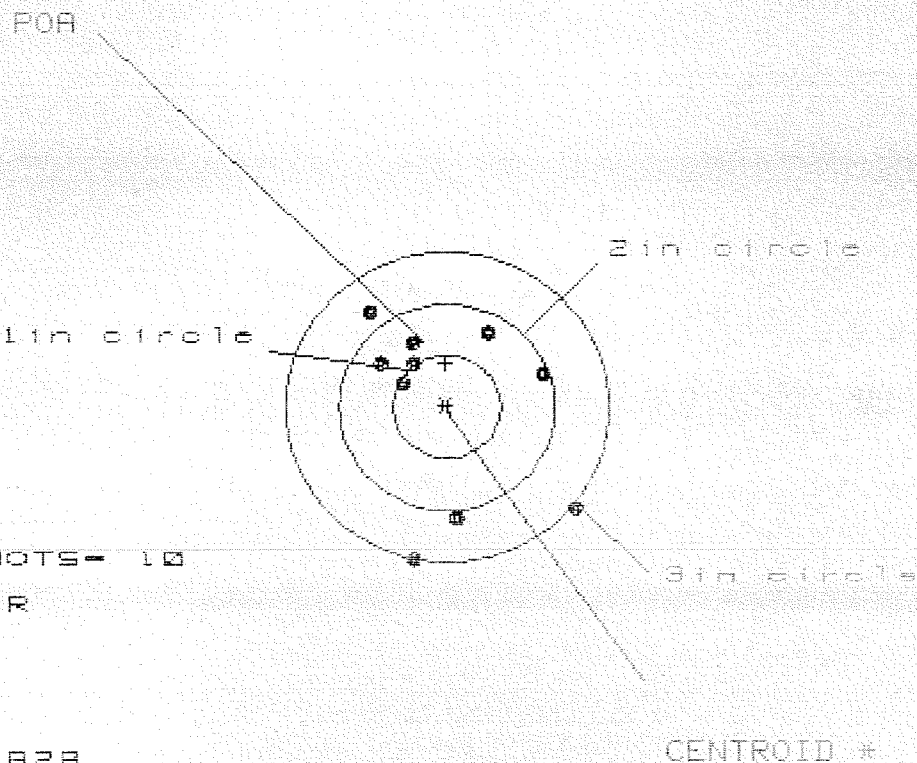
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.915	.873	.790
MINIMUM X	-.655	-.697	-.780
MAXIMUM Y	1.484	1.223	.648
MINIMUM Y	-2.342	-1.534	-1.381
CENTROID X	.363	.405	.488
CENTROID Y	-.862	.198	.045
POA TO CENTROID in.	.368	.450	.490
MIN RADIUS	.236	.205	.272
MEAN RADIUS	.983	.785	.699
MAX RADIUS	2.372	1.536	1.391
HORIZONTAL SPREAD	1.570	1.570	1.570
VERTICAL SPREAD	3.826	2.757	2.029
EXTREME SPREAD	3.834	2.817	2.118
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

4 Sep 1991

FILE: PATTERNING/CENTERFIRE_PATT/C8536294

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 1

2in = 6

3in = 8

HS = 1.828

VS = 2.403

GS = 2.629

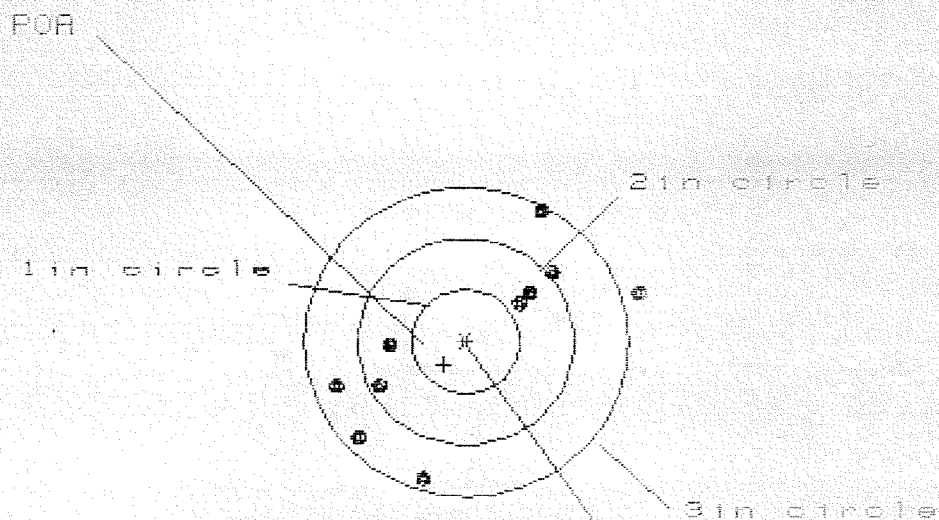
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.167	1.130	1.017
MINIMUM X	-.661	-.698	-.557
MAXIMUM Y	.902	.735	.591
MINIMUM Y	-1.501	-1.238	-1.382
CENTROID X	.011	.048	-.093
CENTROID Y	-.425	-.258	-.114
POA TO CENTROID in.	.425	.262	.147
MIN RADIUS	.475	.441	.259
MEAN RADIUS	.942	.835	.658
MAX RADIUS	1.538	1.616	1.401
HORIZONTAL SPREAD	1.828	1.828	1.574
VERTICAL SPREAD	2.403	1.973	1.973
EXTREME SPREAD	2.629	2.629	2.123
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 0

2in = 5

3in = 9

HS= 2.776

VS= 2.626

GS= 2.925

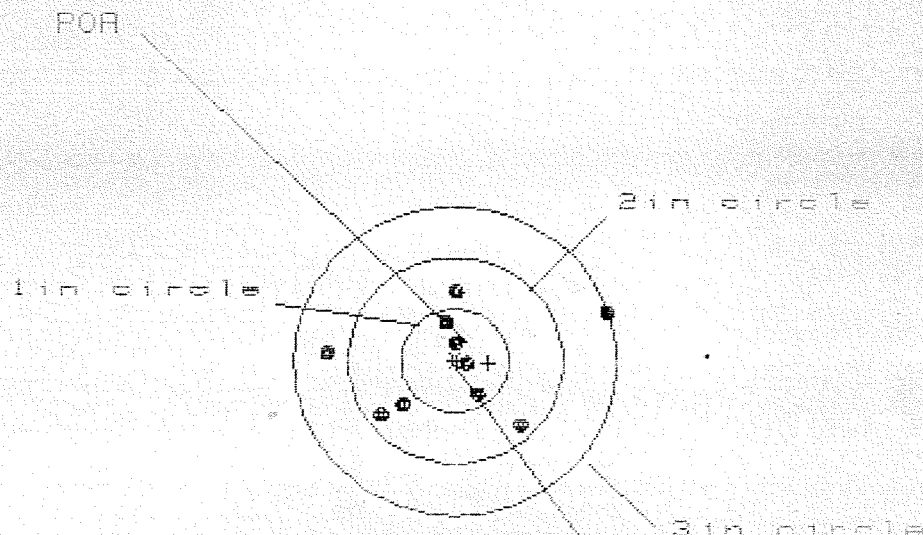
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.565	.939	1.052
MINIMUM X	:	-1.211	-1.037	-.924
MAXIMUM Y	:	1.272	1.324	.855
MINIMUM Y	:	-1.354	-1.302	-1.136
CENTROID X	:	.202	.028	-.085
CENTROID Y	:	.228	.176	.011
POA TO CENTROID in.	:	.305	.178	.086
MIN RADIUS	:	.581	.528	.458
MEAN RADIUS	:	1.114	1.041	.944
MAX RADIUS	:	1.635	1.603	1.356
HORIZONTAL SPREAD	:	2.776	1.976	1.976
VERTICAL SPREAD	:	2.626	2.626	1.992
EXTREME SPREAD	:	2.925	2.871	2.365
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4



* OF SHOTS = 10

IN CIR

1in = 4

2in = 8

3in = 9

HS = 2.596

VS = 1.275

GS = 2.622

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.433	.781	.655
MINIMUM X	:	-1.163	-1.003	-.609
MAXIMUM Y	:	.666	.720	.743
MINIMUM Y	:	-.609	-.555	-.532
CENTROID X	:	-.308	-.468	-.342
CENTROID Y	:	.021	-.033	-.056
POA TO CENTROID in.	:	.309	.469	.347
MIN RADIUS	:	.059	.226	.123
MEAN RADIUS	:	.665	.584	.505
MAX RADIUS	:	1.515	1.019	.844
HORIZONTAL SPREAD	:	2.596	1.784	1.264
VERTICAL SPREAD	:	1.275	1.275	1.275
EXTREME SPREAD	:	2.622	1.929	1.416
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS

5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS = 2.248

VS = 2.830

GS = 2.871

CENTROID #

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.259	1.271	1.239
MINIMUM X	-.989	-.977	-1.009
MAXIMUM Y	1.140	.953	.760
MINIMUM Y	-1.690	-1.473	-.946
CENTROID X	.157	.145	.177
CENTROID Y	-.125	.062	.247
POA TO CENTROID in.	.201	.158	.304
MIN RADIUS	.440	.321	.243
MEAN RADIUS	1.062	.958	.867
MAX RADIUS	1.693	1.496	1.244
HORIZONTAL SPREAD	2.248	2.240	2.248
VERTICAL SPREAD	2.830	2.426	1.714
EXTREME SPREAD	2.871	2.577	2.253
NUMBER IN ONE INCH CIRCLE =	1	1	1
NUMBER IN TWO INCH CIRCLE =	4	4	4
NUMBER IN THREE INCH CIRCLE =	9	9	9