

66636330

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

M2400033152

CONFIDENTIAL SUBJECT TO PROTECTIVE ORDER

Remington[®]


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

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

MODEL 700 TM N24	SERIAL NO. C6636330
	ORDER NO. 5716

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

20



5716 C6636330



GUN SERIAL #

C6636330

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		5/3/91	KS
600	Proof		5/3/91	KS
607	Check Headspace		5/3/91	KS
610	Dis-assemble Gun		5/3/91	KS
612	Magnaflux Barrel Action	5 8 9 1		Kcd
	Magnaflux Bolt	5 8 9 1		Kcd
615	Rollmark Caliber	5 8 9 1		GB
617	Drill and Tap Sight Holes	5 15 9 1		FB
618	Polish Barrel	5 15 9 1		WB
620	Apply Coatings (Barrel Action)		5/29/91	JA
	Apply Coating (Bolt)		5/29/91	JA
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		6/3/91	SM

Op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6	6	6	6/3/91	RL
	G) Safety Off Force	4	4	4	4	4	6/3/91	RL
	H) Trigger Pull Test & Retainability						6/3/91	RL
	I) Firing Pin Indent	.023	.0235	.0235	.0235	.0235	6/3/91	RL
	J) Assemble Stock						6/3/91	KS
	K) Assemble Swivel Studs						6-8-91	D/H
	L) Attach Front and Rear Sight Assemblies						6/3/91	KS
	M) Iron Sight Alignment						6/3/91	KS
	N) Detach Front & Rear Sights & place in numbered container						6/3/91	KS
	O) Attach Scope to Rifle						6/3/91	KS
	P) Detach & Attach Scope 20 Times						6/3/91	KS
640	Gallery Target & Test						6/4/91	KT
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	KT
645	Inspect for Live Ammo						6/4/91	KT
655	Final Inspection							
	A) Headspace						6-8-91	D/H
	B) Trigger Pull	2.65	2.56	2.55	2.51	2.52	6-8-91	RL
	C) Function						6-8-91	D/H
660	Pack						6-20-91	RF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C.6636330DATE 6/3/91TESTER JH.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.56	2.48	2.30	2.65	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.57	2.48	2.38	2.56	
PULL #3	2.58	2.47	2.32	2.55	
PULL #4	2.57	2.32	2.27	2.51	
PULL #5	2.58	2.28	2.32	2.52	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.68	3.21		
PULL #2	3.56	3.18		
PULL #3	3.34	3.15		
PULL #4	3.27	3.17		
PULL #5	3.31	3.15		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.48	4.31		4.43
PULL #2	4.48	4.48		4.28
PULL #3	4.50	4.44		4.30
PULL #4	4.52	4.45		4.32
PULL #5	4.53	4.47		4.46
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS

FOR RIFLE # C6636330

4 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.236882
1 TO	2	.543568
1 TO	3	.179611
1 TO	4	.462041
1 TO	5	.431074

$\frac{135}{4}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0642
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0502
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0814965

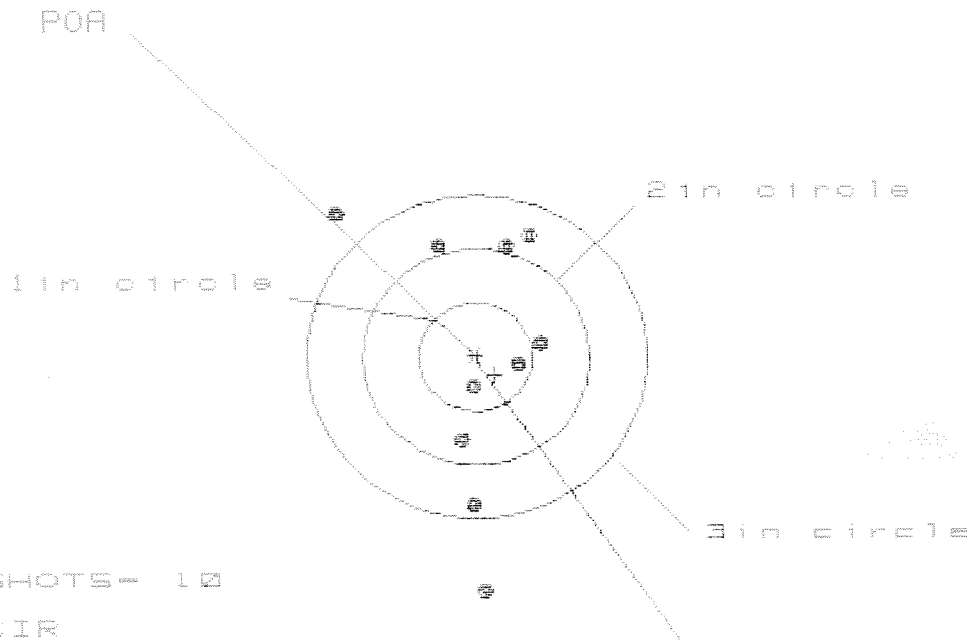
THE AMR FOR THIS RIFLE IS: .8534

4 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C663B330

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 1.850

VS= 3.486

GS= 3.734

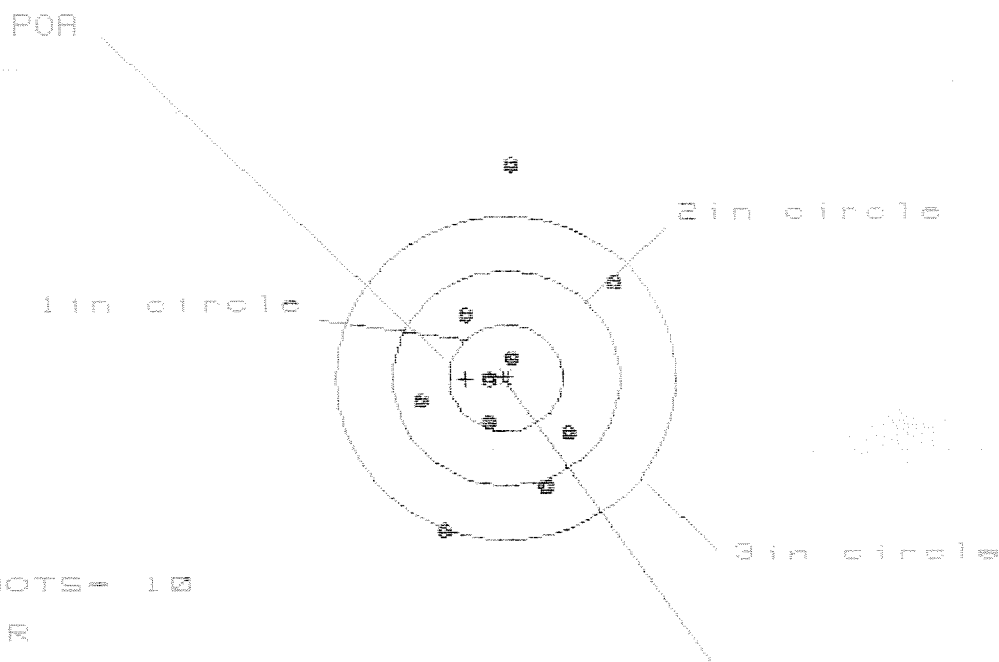
CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.610	.621	.467
MINIMUM X	-1.240	-1.229	-.503
MAXIMUM Y	1.321	1.080	1.045
MINIMUM Y	-2.165	-1.609	-1.474
CENTROID X	-.168	-.179	-.025
CENTROID Y	.167	.408	.273
POA TO CENTROID in.	.237	.445	.274
MIN RADIUS	.266	.469	.265
MEAN RADIUS	1.082	.962	.835
MAX RADIUS	2.167	1.636	1.480
HORIZONTAL SPREAD	1.850	1.850	.978
VERTICAL SPREAD	3.486	2.689	2.519
EXTREME SPREAD	3.734	2.964	2.568
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 8

HS= 1.649

VS= 3.405

GS= 3.457

CENTROID #

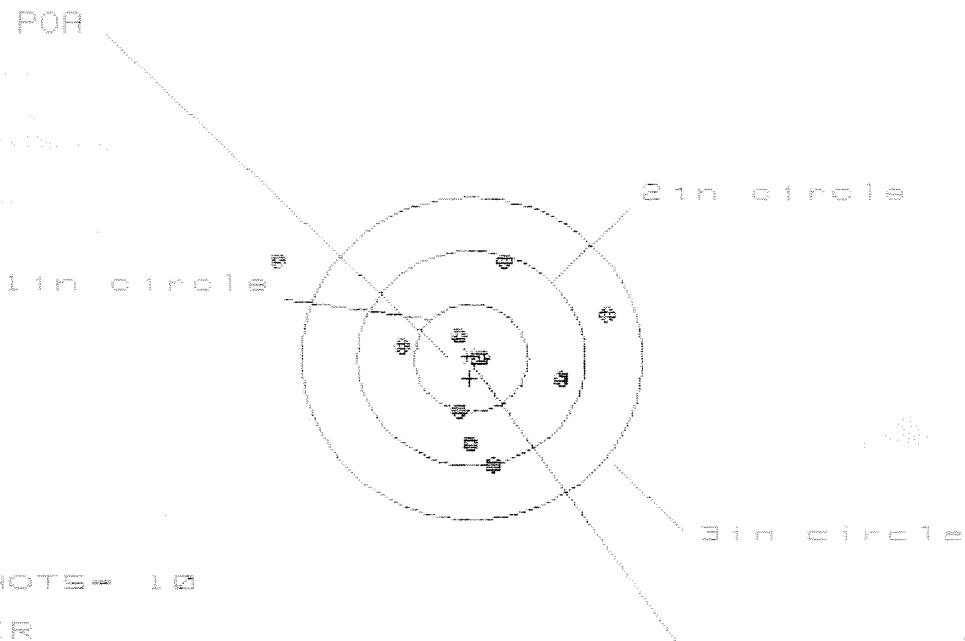
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.917	.919	.847
MINIMUM X	:	-.732	-.730	-.802
MAXIMUM Y	:	1.989	1.070	.921
MINIMUM Y	:	-1.416	-1.195	-.922
CENTROID X	:	.353	.351	.423
CENTROID Y	:	.012	-.209	-.060
POA TO CENTROID in.	:	.353	.408	.427
MIN RADIUS	:	.168	.209	.229
MEAN RADIUS	:	.883	.745	.671
MAX RADIUS	:	1.989	1.411	1.251
HORIZONTAL SPREAD	:	1.649	1.649	1.649
VERTICAL SPREAD	:	3.405	2.265	1.843
EXTREME SPREAD	:	3.457	2.715	1.959
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			8	

4 Jun 1931

FILE:/PATTERNING/CENTERFIRE_PATT/C663B330

CENTERFIRE PATTERNS

3



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 2.930

VS= 1.928

GS= 2.979

CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.220	1.030	.733
MINIMUM X	-1.710	-1.792	-.664
MAXIMUM Y	.916	1.007	1.067
MINIMUM Y	-1.012	-.911	-.851
CENTROID X	.010	.200	.072
CENTROID Y	.191	.090	.030
POA TO CENTROID in.	.192	.219	.078
MIN RADIUS	.119	.131	.179
MEAN RADIUS	.831	.700	.628
MAX RADIUS	1.940	1.135	1.092
HORIZONTAL SPREAD	2.930	1.822	1.397
VERTICAL SPREAD	1.928	1.918	1.918
EXTREME SPREAD	2.979	1.924	1.924
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 5

2in = 7

3in = 9

HS= 1.334

VS= 2.750

GS= 2.753

CENTROID #

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.847	.843	.821
MINIMUM X	-.487	-.491	-.513
MAXIMUM Y	1.130	.950	.920
MINIMUM Y	-1.620	-.803	-.684
CENTROID X	-.137	-.133	-.111
CENTROID Y	-.294	-.114	-.233
POA TO CENTROID in.	.324	.175	.258
MIN RADIUS	.114	.140	.123
MEAN RADIUS	.694	.603	.527
MAX RADIUS	1.621	.966	1.054
HORIZONTAL SPREAD	1.334	1.334	1.334
VERTICAL SPREAD	2.750	1.753	1.605
EXTREME SPREAD	2.753	1.756	1.619
NUMBER IN ONE INCH CIRCLE	=	5	
NUMBER IN TWO INCH CIRCLE	=	7	
NUMBER IN THREE INCH CIRCLE	=	9	

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CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 4

2in = 8

3in = 9

HS= 2.310

VS= 2.334

GS= 2.792

CENTROID *

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X	: .915	.760	.759
MINIMUM X	: -1.395	-.572	-.574
MAXIMUM Y	: 1.205	1.079	.975
MINIMUM Y	: -1.129	-1.052	-.917
CENTROID X	: .263	.418	.420
CENTROID Y	: .175	.301	.166
POA TO CENTROID in.	: .316	.515	.452
MIN RADIUS	: .165	.270	.136
MEAN RADIUS	: .777	.673	.588
MAX RADIUS	: 1.795	1.143	1.021
HORIZONTAL SPREAD	: 2.310	1.332	1.332
VERTICAL SPREAD	: 2.334	2.131	1.892
EXTREME SPREAD	: 2.792	2.174	1.936
NUMBER IN ONE INCH CIRCLE	=	4	
NUMBER IN TWO INCH CIRCLE	=	8	
NUMBER IN THREE INCH CIRCLE	=	9	