

06636339

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 M24

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

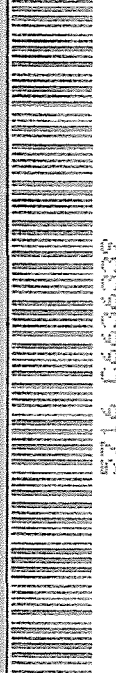
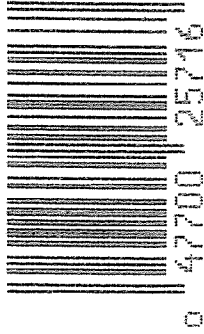
VERY IMPORTANT:
 Instruction Book
 enclosed to assure
 safe use of this
 firearm.

SERIAL NO.
 C6636339

ORDER NO.
 5716

20

UPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636339

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		JUN 2 1991	KR
	Magnaflux Bolt		JUN 2 1991	KR
615	Rollmark Caliber		JUN 2 1991	KR
617	Drill and Tap Sight Holes		JUL 2 1991	EB
618	Polish Barrel		JUL 7 1991	WB
620	Apply Coatings (Barrel Action)		5-6-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/16/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/16/91	KL
	C) Inspect Ejector Hole for Chamfer		8/16/91	KL
	D) Oil Firing Pin Ass'y		8/16/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		8/17/91	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7 1/2	7 1/2	7 1/2			8-17-91	DH
	G) Safety Off Force	2 1/2	2 1/2	3			8-17-91	DH
	H) Trigger Pull Test & Retainability						8/17/91	WB
	I) Firing Pin Indent	.021	.020	.020			8-17-91	DH
	J) Assemble Stock						8/17/91	KH
	K) Assemble Swivel Studs						8-21-91	AC
	L) Attach Front and Rear Sight Assemblies						8/17/91	KH
	M) Iron Sight Alignment						8/17/91	KH
	N) Detach Front & Rear Sights & place in numbered container						8/17/91	KH
	O) Attach Scope to Rifle						8/17/91	KH
	P) Detach & Attach Scope 20 Times						8/17/91	KH
640	Gallery Target & Test						8-19-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						8-19-91	NF
655	Final Inspection							
	A) Headspace						8-21-91	AC
	B) Trigger Pull	2.59	2.42	2.50	2.45	2.61	8-20-91	DH
	C) Function						8-21-91	AC
660	Pack						9-19-91	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 6636339
DATE 8/17/91
TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.48	2.30	2.44	2.59	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.51	2.59	2.43	2.42	
PULL #3	2.20	2.56	2.35	2.50	
PULL #4	2.51	2.58	2.41	2.45	
PULL #5	2.51	2.59	2.38	2.61	
TOTAL	12.21	12.62	12.01		
AVG.	2.44	2.52	2.40		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.04	3.13		
PULL #2	3.12	3.11		
PULL #3	3.22	3.18		
PULL #4	3.29	3.35		
PULL #5	3.26	3.25		
TOTAL	15.93	16.02		
AVG.	3.18	3.20		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.02	4.25		4.07
PULL #2	3.85	4.00		3.80
PULL #3	4.13	4.33		4.03
PULL #4	4.24	4.38		3.95
PULL #5	4.16	4.30		4.00
TOTAL	20.40	21.26		19.85
AVG.	4.08	4.25		3.97

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636339
23 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.101005
1 TO	2	.226824
1 TO	3	.172409
1 TO	4	.215295
1 TO	5	.148246

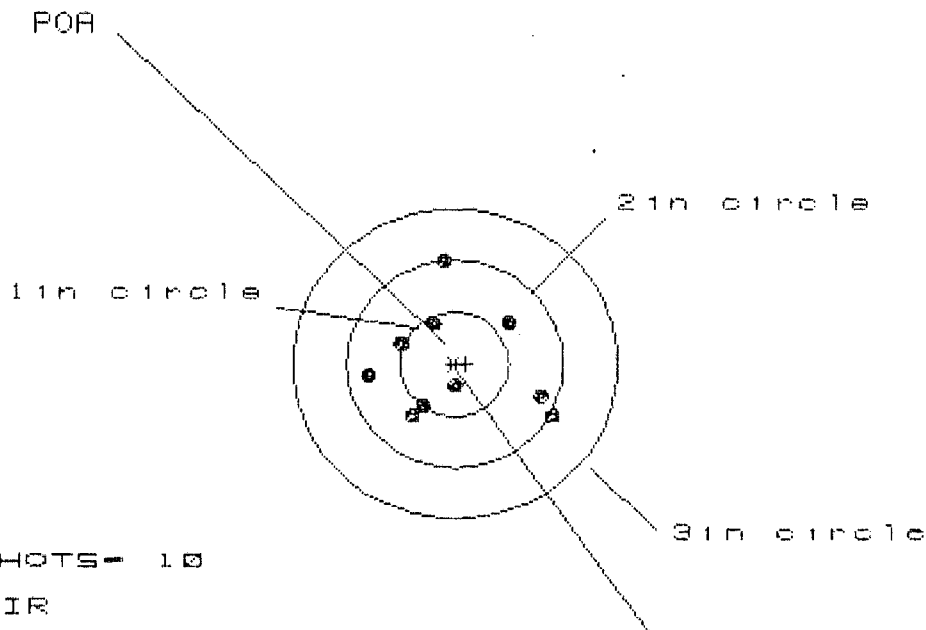
● <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0152
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0886
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0898944
THE AMR FOR THIS RIFLE IS: .7188

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636339

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 3

2in = 9

3in = 10

IS= 1.658

VS= 1.460

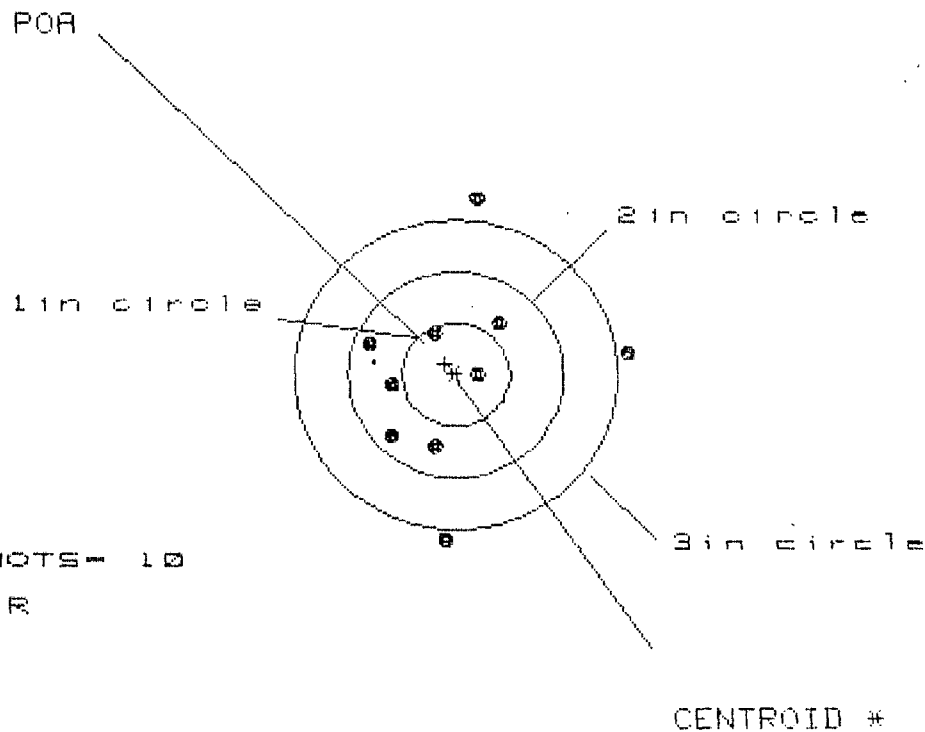
GS= 1.735

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.893	.882	.885
MINIMUM X	-.765	-.666	-.663
MAXIMUM Y	.987	.937	.453
MINIMUM Y	-.473	-.523	-.406
CENTROID X	-.101	-.200	-.203
CENTROID Y	.001	.051	-.066
POA TO CENTROID in.	.101	.206	.213
MIN RADIUS	.206	.288	.195
MEAN RADIUS	.654	.604	.545
MAX RADIUS	1.001	.942	.910
HORIZONTAL SPREAD	1.658	1.548	1.548
VERTICAL SPREAD	1.460	1.460	.859
EXTREME SPREAD	1.735	1.558	1.558
NUMBER IN ONE INCH CIRCLE	= 3		
NUMBER IN TWO INCH CIRCLE	= 9		
NUMBER IN THREE INCH CIRCLE	= 10		

23 Aug 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 7

3 in = 7

HS = 2.335

VS = 3.282

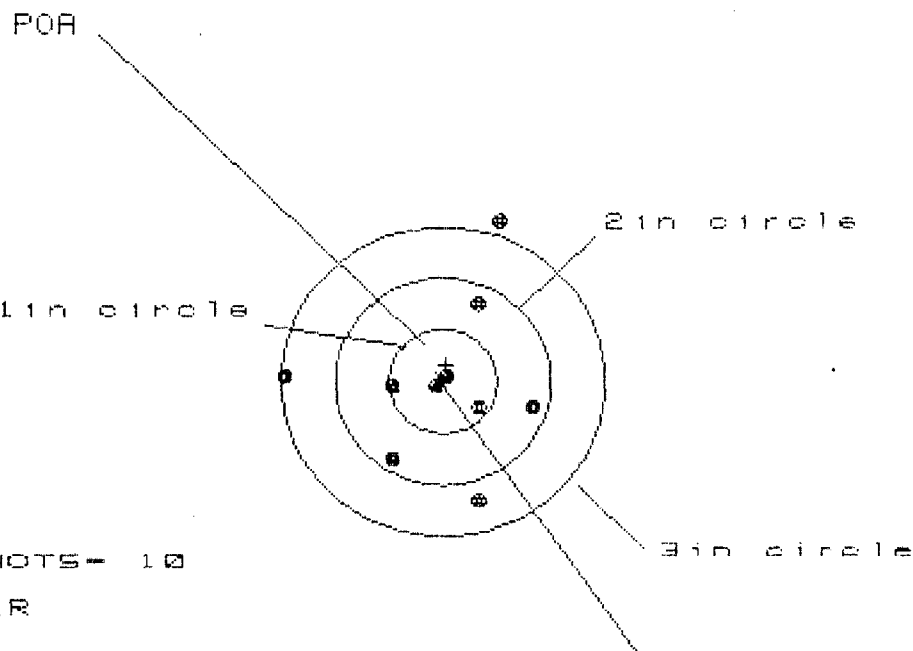
GS = 3.297

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.559	1.587	1.583
MINIMUM X	:	-.776	-.748	-.752
MAXIMUM Y	:	1.676	.654	.477
MINIMUM Y	:	-1.606	-1.420	-.725
CENTROID X	:	.099	.071	.075
CENTROID Y	:	-.106	-.292	-.115
POA TO CENTROID in.	:	.145	.301	.137
MIN RADIUS	:	.194	.299	.218
MEAN RADIUS	:	.920	.834	.736
MAX RADIUS	:	1.694	1.647	1.604
HORIZONTAL SPREAD	:	2.335	2.335	2.335
VERTICAL SPREAD	:	3.282	2.074	1.202
EXTREME SPREAD	:	3.297	2.467	2.336
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		7	

23 Aug 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 9

HS= 2.231

VS= 2.765

GS= 2.770

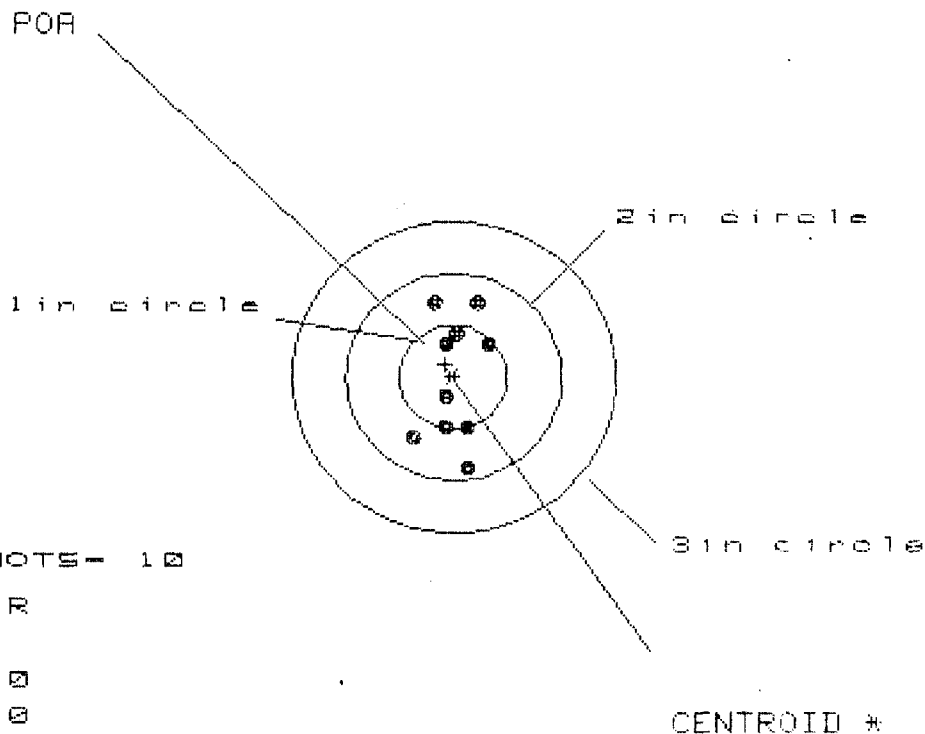
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.811	.865	.695
MINIMUM X	:	-1.420	-1.366	-.579
MAXIMUM Y	:	1.581	.981	1.006
MINIMUM Y	:	-1.184	-1.009	-.984
CENTROID X	:	-.032	-.086	.084
CENTROID Y	:	-.157	-.332	-.357
POA TO CENTROID in.	:	.160	.343	.366
MIN RADIUS	:	.101	.140	.269
MEAN RADIUS	:	.800	.703	.614
MAX RADIUS	:	1.656	1.379	1.035
HORIZONTAL SPREAD	:	2.231	2.231	1.274
VERTICAL SPREAD	:	2.765	1.990	1.990
EXTREME SPREAD	:	2.770	2.249	1.990
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

23 Aug 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 5

2 in = 10

3 in = 10

HS= .678

VS= 1.587

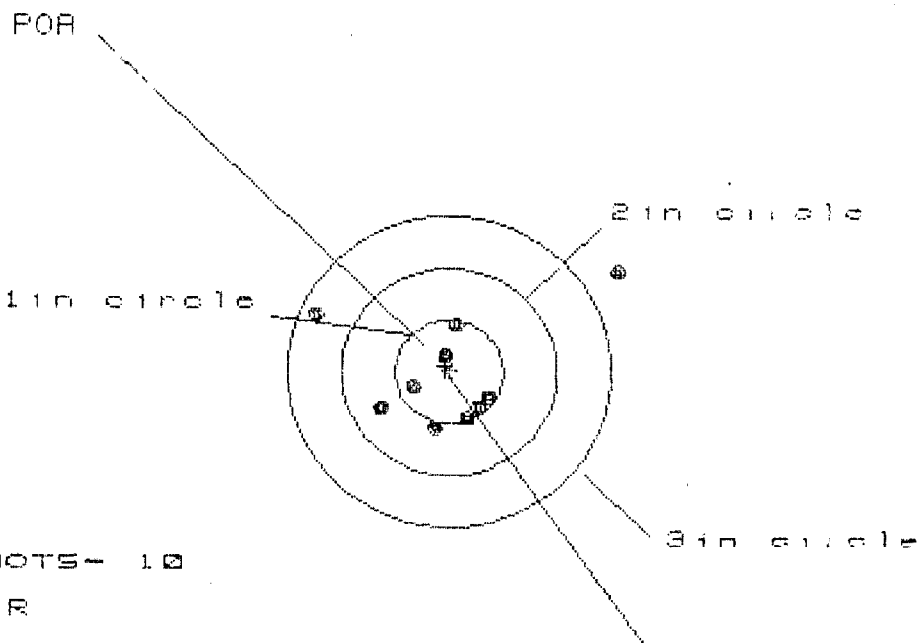
GS= 1.636

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.298	.318	.292
MINIMUM X	:	-.380	-.360	-.386
MAXIMUM Y	:	.741	.647	.675
MINIMUM Y	:	-.846	-.657	-.577
CENTROID X	:	.075	.055	.081
CENTROID Y	:	-.123	-.029	-.109
POA TO CENTROID in.	:	.144	.062	.136
MIN RADIUS	:	.189	.224	.204
MEAN RADIUS	:	.542	.497	.473
MAX RADIUS	:	.864	.750	.701
HORIZONTAL SPREAD	:	.678	.678	.678
VERTICAL SPREAD	:	1.587	1.304	1.252
EXTREME SPREAD	:	1.636	1.377	1.377
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		10	
NUMBER IN THREE INCH CIRCLE	=		10	

23 Aug 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 6

2 in = 8

3 in = 9

HS = 2.775

VS = 1.463

GS = 2.797

CENTROID +

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.533	.538	.404
MINIMUM X	:	-1.242	-1.072	-.619
MAXIMUM Y	:	.954	.713	.606
MINIMUM Y	:	-.589	-.403	-.314
CENTROID X	:	.035	-.135	-.001
CENTROID Y	:	-.058	-.164	-.253
POA TO CENTROID in.	:	.068	.213	.253
MIN RADIUS	:	.174	.117	.263
MEAN RADIUS	:	.678	.531	.412
MAX RADIUS	:	1.805	1.288	.646
HORIZONTAL SPREAD	:	2.775	1.610	1.023
VERTICAL SPREAD	:	1.463	1.116	.920
EXTREME SPREAD	:	2.797	1.839	1.056
NUMBER IN ONE INCH CIRCLE	=		6	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	