

C6648928

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington®

MODEL 700™ 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.

DUPONT
REG. U.S. PAT. & T.M. OFF.

SERIAL NO. C6648928	ORDER NO. 5716
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5716 C6648928

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GFM

GUN SERIAL # C6648928

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 2	9 1	RW
600	Proof	7 2	9 1	RW
607	Check Headspace	7 2	9 1	RW
610	Dis-assemble Gun	7 2	9 1	RW
612	Magnaflux Barrel Action		JUL 22 1991	LS
	Magnaflux Bolt		JUL 22 1991	LS
615	Rollmark Caliber		JUL 22 1991	LS
617	Drill and Tap Sight Holes		JUL 22 1991	LB
618	Polish Barrel		7/22/91	WB
620	Apply Coatings (Barrel Action)		7-22-91	HA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/29/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/29/91	RW
	C) Inspect Ejector Hole for Chamfer		8/29/91	RW
	D) Oil Firing Pin Ass'y		8/29/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		7-6-91	DH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	5 1/2	5			9-6-91	DH
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			9-6-91	DH
	H) Trigger Pull Test & Retainability						9-6-91	DH
	I) Firing Pin Indent	.023	.022	.021			9-6-91	DH
	J) Assemble Stock						9/11/91	RW
	K) Assemble Swivel Studs						9-12-91	DH
	L) Attach Front and Rear Sight Assemblies						9/11/91	RW
	M) Iron Sight Alignment						9/11/91	RW
	N) Detach Front & Rear Sights & place in numbered container						9/11/91	RW
	O) Attach Scope to Rifle						9/11/91	RW
	P) Detach & Attach Scope 20 Times						9/11/91	RW
640	Gallery Target & Test						9-11-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						9-11-91	NF
655	Final Inspection							
	A) Headspace						9-12-91	DH
	B) Trigger Pull	2.49	2.60	2.49	2.49	2.10	9/12/91	DH
	C) Function						9-12-91	DH
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. CCG 48 928

DATE 9-6-91

TESTER D/H

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.46	2.54	2.49	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.55	2.48	2.60	
PULL #3	2.45	2.48	2.52	2.49	
PULL #4	2.42	2.50	2.52	2.49	
PULL #5	2.44	2.43	2.53	2.60	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.07	3.22		
PULL #2	3.14	3.19		
PULL #3	3.03	3.14		
PULL #4	3.16	3.01		
PULL #5	3.11	3.13		
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	4.60		4.18
PULL #2	4.40	4.63		4.26
PULL #3	4.55	4.63		4.00
PULL #4	4.67	4.28		4.10
PULL #5	4.64	4.67		4.17
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS

FOR RIFLE # C6648928

12 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.114403
1 TO	2	.192284
1 TO	3	.367022
1 TO	4	.161793
1 TO	5	.395505

←----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.07
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0706
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0994201

THE ANR FOR THIS RIFLE IS: 1.158

(1 Sep 1991)

FILE:/PATTERNING/CENTERFIRE_PATT/C6648328

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 6

HS= 3.448

VS= 3.760

GS= 4.146

CENTROID *

PATTERN #

1

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.551

1.341

1.456

MINIMUM X

-1.897

-1.457

-1.342

MAXIMUM Y

1.910

2.061

1.181

MINIMUM Y

-1.850

-1.699

-1.442

CENTROID X

.092

.302

.182

CENTROID Y

.068

-.083

-.348

POA TO CENTROID in.

.114

.314

.388

MIN RADIUS

.187

.246

.258

MEAN RADIUS

1.337

1.225

1.055

MAX RADIUS

2.329

2.256

1.788

HORIZONTAL SPREAD

3.448

2.798

2.798

VERTICAL SPREAD

3.760

3.760

2.623

EXTREME SPREAD

4.146

3.780

3.289

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

3

NUMBER IN THREE INCH CIRCLE =

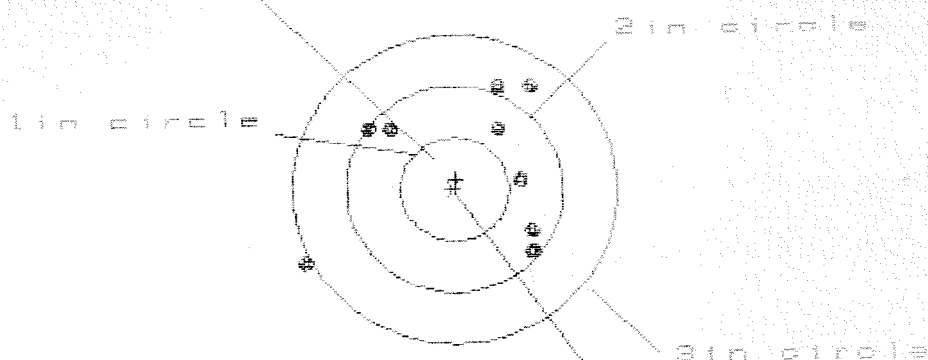
6

(1 Sep 1991)

FILE:/PATTERNING/CENTERFIRE_PATT/C6648928

CENTERFIRE PATTERNS # 2

POA



OF SHOTS= 10

IN CIR

1in = 0

2in = 5

3in = 5

HS= 2.124

VS= 2.986

GS= 3.336

PATTERN #

2

SHOTS (BEST OF)

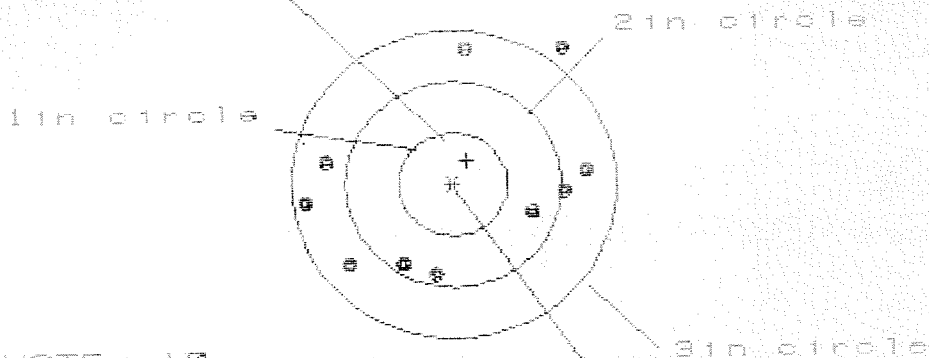
MAXIMUM X	10	9	8
MINIMUM X	.725	.639	.454
MAXIMUM Y	-1.399	-1.485	-1.033
MINIMUM Y	.967	.743	.623
CENTROID X	-2.019	-.954	-.943
CENTROID Y	-.010	.076	.261
POA TO CENTROID in.	-.095	.129	.249
MIN RADIUS	.096	.150	.361
MEAN RADIUS	.634	.429	.226
MAX RADIUS	1.083	.905	.739
HORIZONTAL SPREAD	2.160	1.765	1.054
VERTICAL SPREAD	2.124	2.124	1.487
EXTREME SPREAD	2.986	1.697	1.566
NUMBER IN ONE INCH CIRCLE	3.336	2.715	1.882
NUMBER IN TWO INCH CIRCLE	=	0	
NUMBER IN THREE INCH CIRCLE	=	6	
	=	0	

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CENTERFIRE PATTERNS # 3

FOR



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 3

3 in = 9

HS= 2.603

VS= 2.169

GS= 2.867

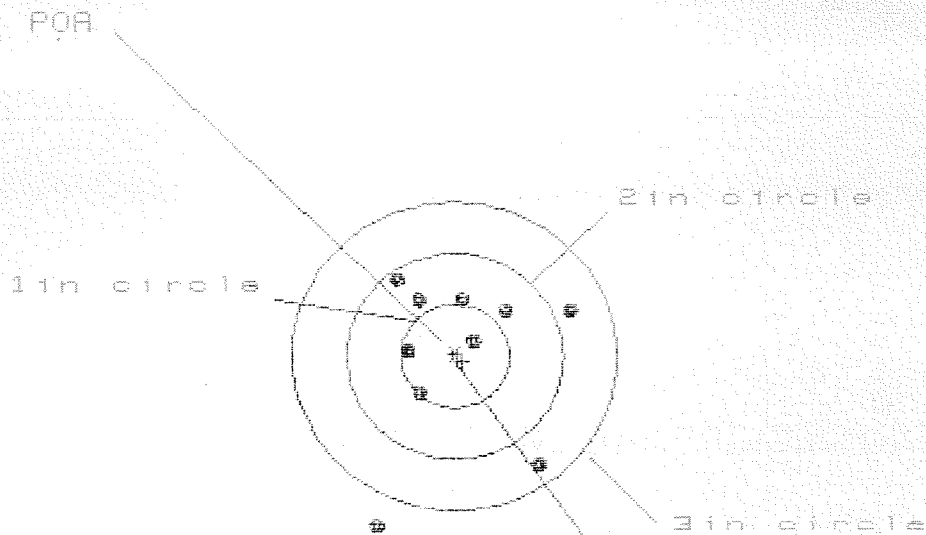
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.265	1.383	1.230
MINIMUM X	:	-1.338	-1.220	-1.250
MAXIMUM Y	:	1.331	1.476	1.468
MINIMUM Y	:	-.838	-.693	-.701
CENTROID X	:	-.125	-.243	-.090
CENTROID Y	:	-.228	-.373	-.365
PDA TO CENTROID in.	:	.260	.445	.376
MIN RADIUS	:	.801	.700	.738
MEAN RADIUS	:	1.169	1.084	1.058
MAX RADIUS	:	1.682	1.499	1.472
HORIZONTAL SPREAD	:	2.603	2.603	2.480
VERTICAL SPREAD	:	2.169	2.169	2.169
EXTREME SPREAD	:	2.867	2.619	2.483
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		9	

(1 Sep 1991)

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 1.841

VS= 2.433

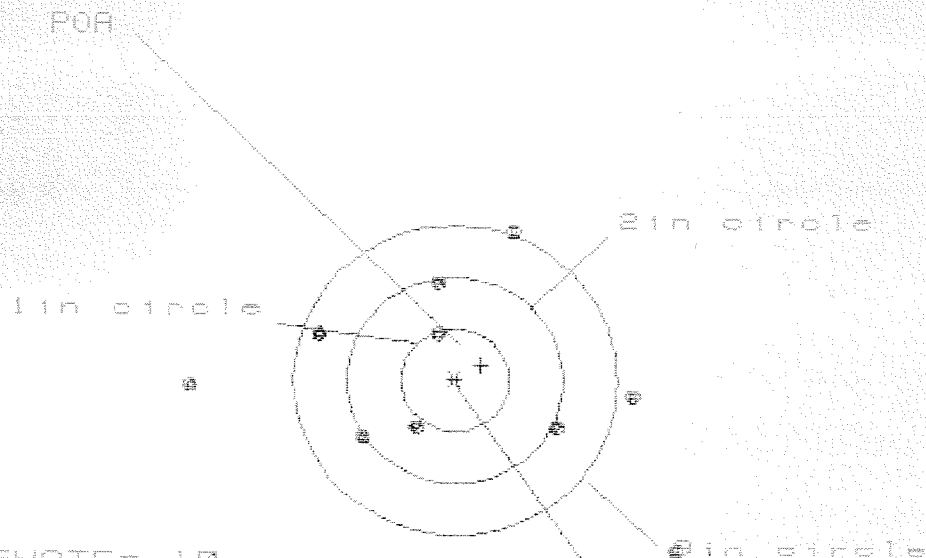
GS= 2.771

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.077	.992	1.074
MINIMUM X	-.764	-.633	-.551
MAXIMUM Y	.797	.615	.465
MINIMUM Y	-1.636	-1.202	-.698
CENTROID X	-.069	.016	-.066
CENTROID Y	.052	.234	.384
POA TO CENTROID in.	.086	.234	.390
MIN RADIUS	.182	.093	.263
MEAN RADIUS	.825	.675	.566
MAX RADIUS	1.806	1.369	1.079
HORIZONTAL SPREAD	1.841	1.625	1.625
VERTICAL SPREAD	2.433	1.817	1.163
EXTREME SPREAD	2.771	2.228	1.665
NUMBER IN ONE INCH CIRCLE	=	3	
NUMBER IN TWO INCH CIRCLE	=	7	
NUMBER IN THREE INCH CIRCLE	=	9	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS= 4.562

VS= 3.166

CS= 4.859

CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.054	1.906	1.621
MINIMUM X	-2.508	-2.280	-1.315
MAXIMUM Y	1.489	1.303	1.279
MINIMUM Y	-1.677	-1.695	-1.719
CENTROID X	-.238	-.466	-.181
CENTROID Y	-.150	.036	.060
POA TO CENTROID in.	.282	.468	.191
MIN RADIUS	.482	.296	.315
MEAN RADIUS	1.374	1.192	1.054
MAX RADIUS	2.652	2.288	1.664
HORIZONTAL SPREAD	4.562	4.186	2.936
VERTICAL SPREAD	3.166	1.998	1.938
EXTREME SPREAD	4.859	4.189	2.996
NUMBER IN ONE INCH CIRCLE =	1	1	1
NUMBER IN TWO INCH CIRCLE =	4	4	4
NUMBER IN THREE INCH CIRCLE =	6	6	6