

C6611574

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

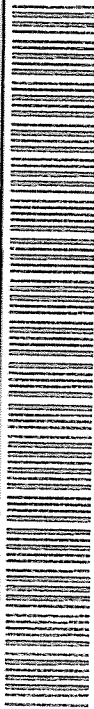
Capacity

Order No. **5716**

*Includes 1 in chamber.

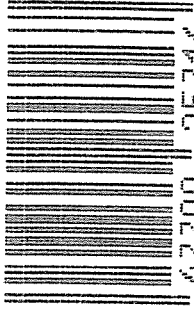
Remington.

Remington®		DUPONT	VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700™ N24			SERIAL NO. C6611674
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off. Marca Registrada Marque Deposee.		20	ORDER NO. 5716



5716 C6611674

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611674

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 30	91	RW
600	Proof	4 30	91	RW
607	Check Headspace	4 30	91	RW
610	Dis-assemble Gun	4 30	91	RW
612	Magnaflux Barrel Action	5 6	91	KCR
	Magnaflux Bolt	5 6	91	KCR
615	Rollmark Caliber	5 6	91	CB
617	Drill and Tap Sight Holes	5 10	91	FB
618	Polish Barrel	5 10	91	WB
620	Apply Coatings (Barrel Action)		5-30-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		6/19/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6/18/91	RW
	C) Inspect Ejector Hole for Chamfer		6/19/91	RW
	D) Oil Firing Pin Ass'y		6/18/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		7-17-91	RU

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			7-17-91	JH
	G) Safety Off Force	3	3	3			7-17-91	JH
	H) Trigger Pull Test & Retainability						7-17-91	JH
	I) Firing Pin Indent	.0205	.0205	.021			7-17-91	JH
	J) Assemble Stock						7/18/91	RW
	K) Assemble Swivel Studs						7-23-91	D/H
	L) Attach Front and Rear Sight Assemblies						7/18/91	RW
	M) Iron Sight Alignment						7/18/91	RW
	N) Detach Front & Rear Sights & place in numbered container						7/18/91	RW
	O) Attach Scope to Rifle						7/18/91	RW
	P) Detach & Attach Scope 20 Times						7/18/91	RW
640	Gallery Target & Test						7-22-91	AC
	A) Time						7-22-91	AC
	B) Malfunctions						7-22-91	AC
	C) Pierced Primers						7-22-91	AC
	D) Optical Clarity of Scope						7-22-91	AC
645	Inspect for Live Ammo						7-22-91	AC
655	Final Inspection						7-23-91	D/H
	A) Headspace						7-23-91	JH
	B) Trigger Pull	2.37	2.23	2.25	2.30	2.34	7-23-91	JH
	C) Function						7-23-91	D/H
660	Pack						9-18-91	AC

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6611674

DATE 7-17-91

TESTER [Signature]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.22	2.26	2.38	2.37	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.27	2.30	2.36	2.23	
PULL #3	2.29	2.30	2.33	2.25	
PULL #4	2.29	2.34	2.39	2.30	
PULL #5	2.33	2.34	2.35	2.34	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.27	3.35		
PULL #2	3.34	3.36		
PULL #3	3.33	3.46		
PULL #4	3.34	3.44		
PULL #5	3.38	3.46		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.41	4.45		4.54
PULL #2	4.33	4.45		4.56
PULL #3	4.39	4.49		4.56
PULL #4	4.35	4.51		4.55
PULL #5	4.40	4.51		4.50
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611674
23 Jul 1991

CENTROIDAL DISTANCES

0 TO	1	.229271
1 TO	2	.237457
1 TO	3	.230957
1 TO	4	.321056
1 TO	5	.130419

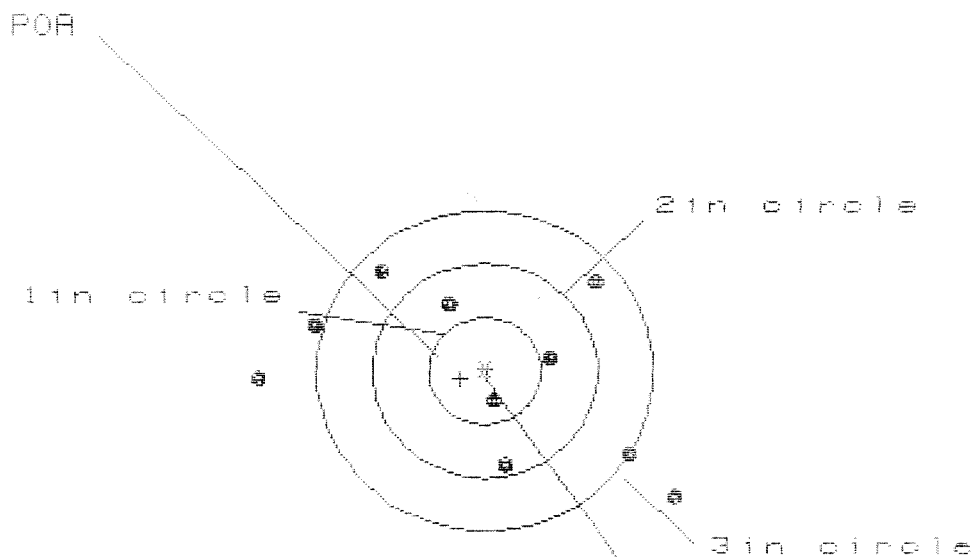
47 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1584
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.034
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .162008
THE AMR FOR THIS RIFLE IS: 1.176

23 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611874

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 1

2in = 4

3in = 7

HS= 3.678

VS= 2.121

GS= 3.839

CENTROID *

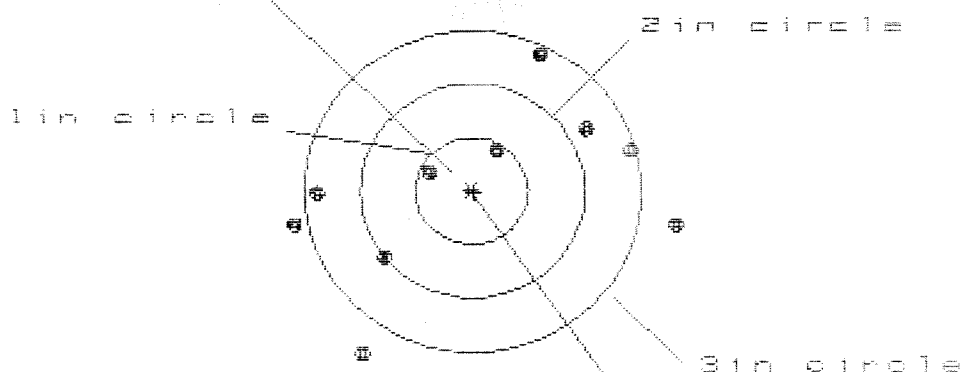
PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.634	1.407	1.209
MINIMUM X	:	-2.044	-1.727	-1.552
MAXIMUM Y	:	.974	.969	.824
MINIMUM Y	:	-1.147	-1.152	-1.993
CENTROID X	:	.218	.445	.270
CENTROID Y	:	.071	.076	.221
FOR TO CENTROID in.	:	.230	.452	.348
MIN RADIUS	:	.254	.272	.386
MEAN RADIUS	:	1.214	1.094	1.006
MAX RADIUS	:	2.045	1.818	1.584
HORIZONTAL SPREAD	:	3.678	3.134	2.761
VERTICAL SPREAD	:	2.121	2.121	1.817
EXTREME SPREAD	:	3.839	3.525	3.041
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	7		

23 Jul 1991

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CENTERFIRE PATTERNS # 2

POA



OF SHOTS = 10

IN CIR

1in = 2

2in = 2

3in = 7

HS = 3.431

VS = 2.814

GS = 3.432

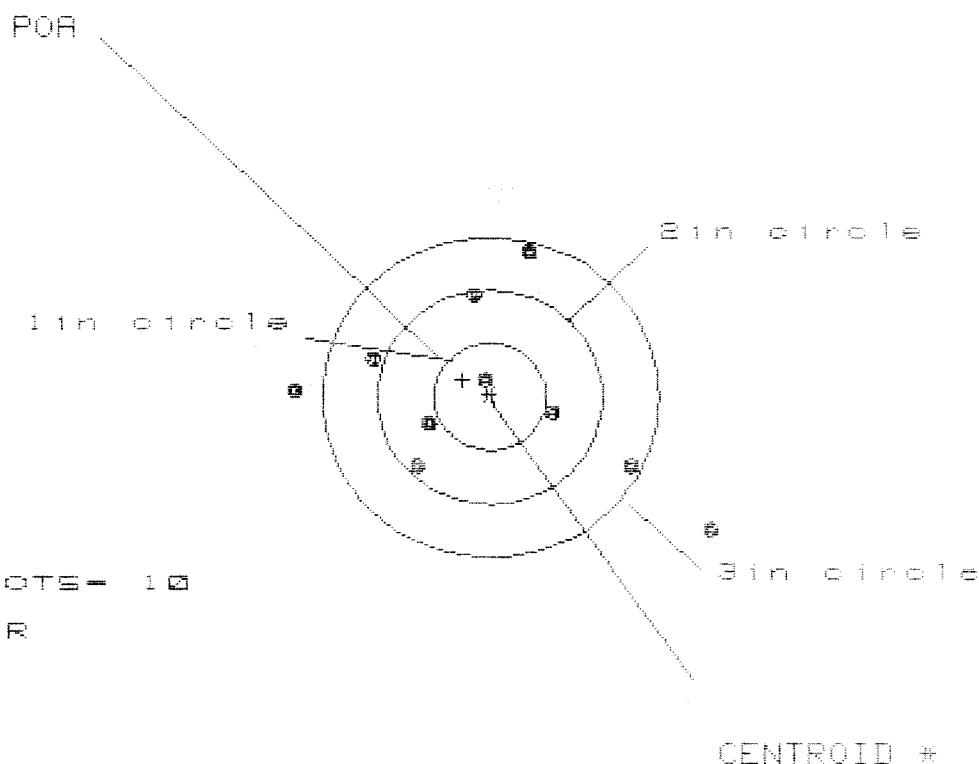
CENTROID *

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.853	1.656	1.561
MINIMUM X	:	-1.578	-1.372	-1.467
MAXIMUM Y	:	1.311	1.271	1.078
MINIMUM Y	:	-1.503	-1.543	-1.897
CENTROID X	:	-.013	-.219	-.124
CENTROID Y	:	.016	.056	.249
POA TO CENTROID in.	:	.021	.226	.278
MIN RADIUS	:	.429	.224	.306
MEAN RADIUS	:	1.272	1.174	1.090
MAX RADIUS	:	1.888	1.719	1.566
HORIZONTAL SPREAD	:	3.431	3.028	3.028
VERTICAL SPREAD	:	2.814	2.814	1.975
EXTREME SPREAD	:	3.432	3.211	3.099
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	2		
NUMBER IN THREE INCH CIRCLE	=	7		

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS = 3.746

VS = 2.663

GS = 3.968

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.985	1.506	1.313
MINIMUM X	:	-1.761	-1.540	-1.088
MAXIMUM Y	:	1.379	1.236	1.222
MINIMUM Y	:	-1.284	-.801	-.815
CENTROID X	:	.248	.027	.219
CENTROID Y	:	-.158	-.015	-.001
POA TO CENTROID in.	:	.294	.031	.220
MIN RADIUS	:	.168	.147	.046
MEAN RADIUS	:	1.137	.965	.884
MAX RADIUS	:	2.365	1.706	1.546
HORIZONTAL SPREAD	:	3.746	3.046	2.322
VERTICAL SPREAD	:	2.663	2.037	2.037
EXTREME SPREAD	:	3.969	3.122	2.522
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

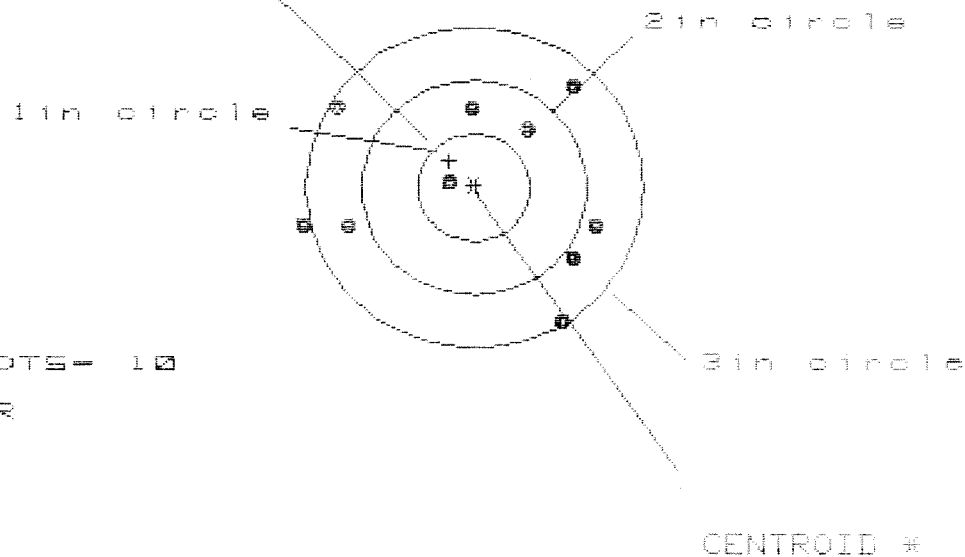
23 JUL 1991

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CENTERFIRE PATTERNS

4

POA



OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 9

HS= 2.528

VS= 2.224

GS= 2.843

PATTERN #

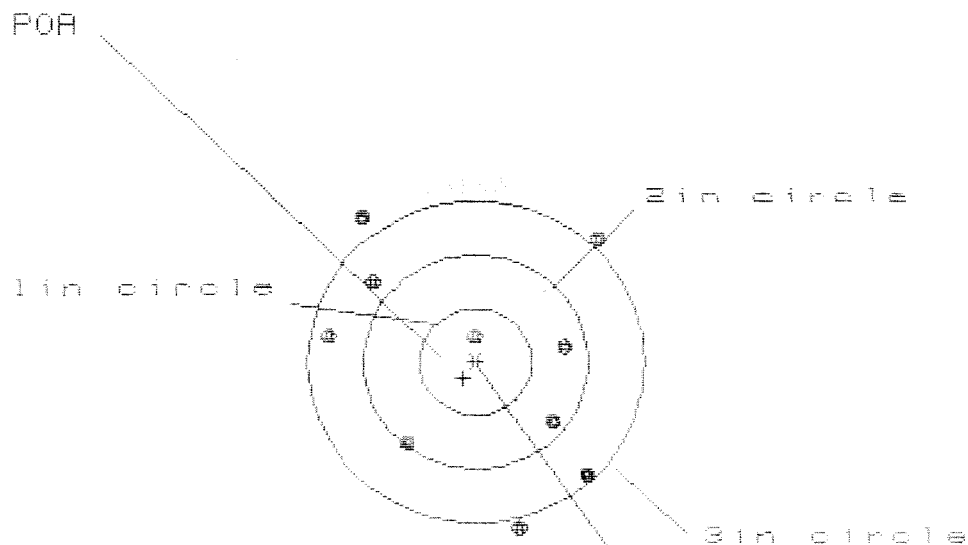
4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.030	.864	.942
MINIMUM X	-1.498	-1.409	-1.331
MAXIMUM Y	.949	.909	.745
MINIMUM Y	-1.275	-1.315	-.852
CENTROID X	.224	.390	.313
CENTROID Y	-.250	-.210	-.046
POA TO CENTROID in.	.335	.443	.316
MIN RADIUS	.219	.381	.343
MEAN RADIUS	1.084	1.021	.944
MAX RADIUS	1.539	1.562	1.426
HORIZONTAL SPREAD	2.528	2.273	2.273
VERTICAL SPREAD	2.224	2.224	1.597
EXTREME SPREAD	2.843	2.843	2.554
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1in = 1

2in = 4

3in = 7

HS = 2.339

VS = 2.856

GS = 3.161

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.046	.934	.964
MINIMUM X	:	-1.293	-1.405	-1.375
MAXIMUM Y	:	1.330	1.263	1.091
MINIMUM Y	:	-1.526	-1.379	-1.075
CENTROID X	:	.115	.227	.197
CENTROID Y	:	.151	.004	.176
POA TO CENTROID in.	:	.190	.227	.264
MIN RADIUS	:	.295	.454	.280
MEAN RADIUS	:	1.173	1.109	1.055
MAX RADIUS	:	1.668	1.571	1.456
HORIZONTAL SPREAD	:	2.339	2.339	2.339
VERTICAL SPREAD	:	2.856	2.642	2.166
EXTREME SPREAD	:	3.161	2.733	2.634
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	