

C6636009

MODEL 780™ M24

Model SWS™

Action

Barrel Length

Capacity

Order No. 5716

* Includes 1 in chamber.

Remington

MOD. _____ GA. CAL. _____ GUN # 6009

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st		
NF	6/13	Hard Safe + B.H. Hits Stock	KS
	2nd		
	4/13/91	FILED STOCK Repaired	KS
	3rd		
	4th		
		FUNCTION	RD 6554 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

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

Remington[®]

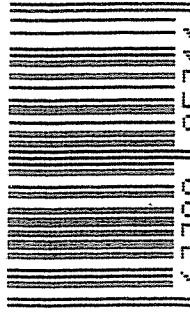
MODEL 700™ H24

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

SERIAL NO.
C6636009

ORDER NO.
5716

UPC



0 47700 25716 7



5716 C6636009

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636009

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		4/23/91	K.S.
600	Proof		4/23/91	K.S.
607	Check Headspace		4/23/91	K.S.
610	Dis-assemble Gun		4/23/91	K.S.
612	Magnaflux Barrel Action	5 8 9 1		Kcl
	Magnaflux Bolt	5 8 9 1		Kcl
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		W/B
620	Apply Coatings (Barrel Action)		5-21-91	
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		4/11/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/11/91	KS
	C) Inspect Ejector Hole for Chamfer		4/11/91	KS
	D) Oil Firing Pin Ass'y		4/11/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		6-12-91	DH

Op. #	Op. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7	7	6 1/2			6-12-91	DH
	G) Safety Off Force	4	4	4			6-12-91	DH
	H) Trigger Pull Test & Retainability						6-12-91	DH
	I) Firing Pin Indent	.021	.021	.021			6-12-91	DH
	J) Assemble Stock						6-12-91	KS
	K) Assemble Swivel Studs						6-14-91	JH
	L) Attach Front and Rear Sight Assemblies						6-12-91	KS
	M) Iron Sight Alignment						6-12-91	KS
	N) Detach Front & Rear Sights & place in numbered container						6-12-91	KS
	O) Attach Scope to Rifle						6-12-91	KS
	P) Detach & Attach Scope 20 Times						6-12-91	KS
640	Gallery Target & Test						6-13-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						6-13-91	AF
655	Final Inspection							
	A) Headspace						6-14-91	JH
	B) Trigger Pull	2.71	2.67	2.65	2.63	2.46	6-14-91	JH
	C) Function						6-14-91	JH
660	Pack						6-20-91	AF

SWS TRIGGER PULL TEST

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

SERIAL NO. 06636009

DATE 6-12-91

TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.61	2.54	2.54	2.71	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.50	2.51	2.55	2.67	
PULL #3	2.44	2.52	2.66	2.65	
PULL #4	2.44	2.49	2.63	2.63	
PULL #5	2.50	2.28	2.66	2.66	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.19	3.20		
PULL #2	3.33	3.15		
PULL #3	3.24	3.20		
PULL #4	3.25	3.24		
PULL #5	3.33	3.20		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.10	4.06		4.49
PULL #2	4.10	4.07		4.54
PULL #3	4.12	4.13		4.61
PULL #4	4.13	4.09		4.31
PULL #5	4.12	3.98		4.59
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636009
13 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.349085
1 TO	2	.227308
1 TO	3	.393554
1 TO	4	.53845
1 TO	5	.381608

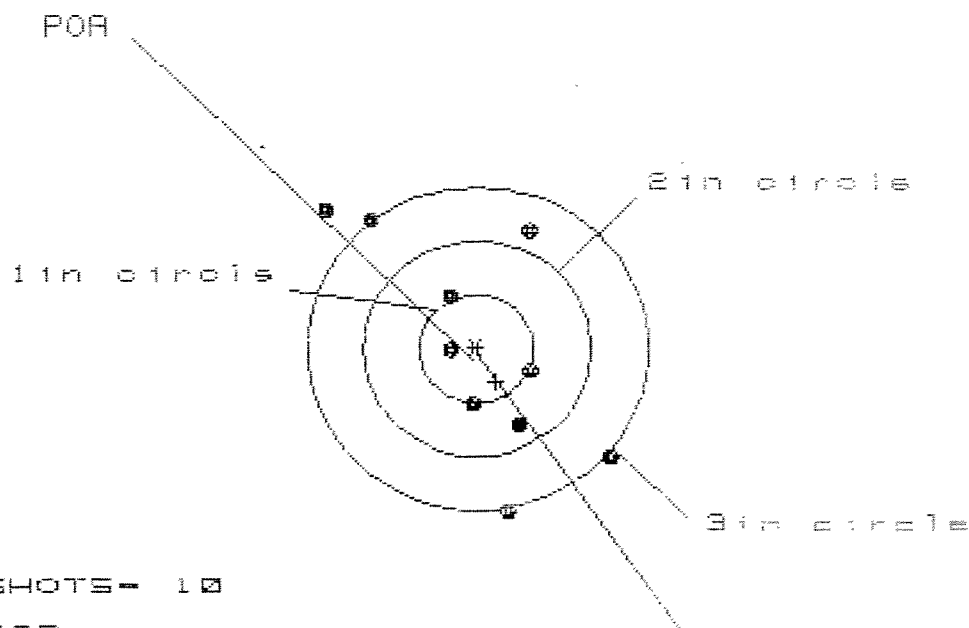
¹²
37 ←----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.145
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0368
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .149597
THE AMR FOR THIS RIFLE IS: 1.027

13 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06635000

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 3

2in = 5

3in = 6

HS = 2.545

VS = 2.839

GS = 3.458

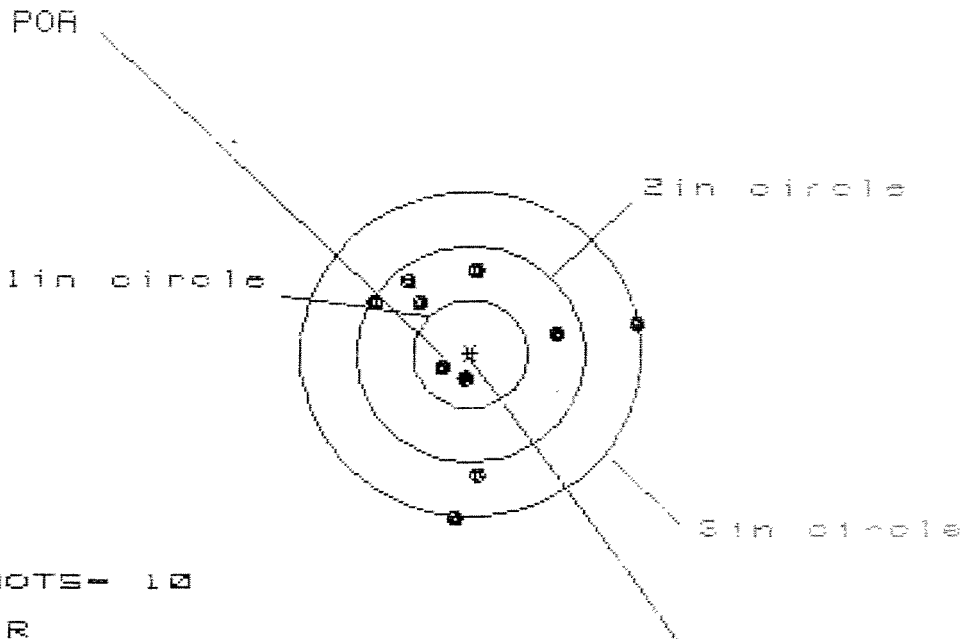
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	6
MAXIMUM X	1.196	1.046	.467
MINIMUM X	-1.349	-1.104	-.973
MAXIMUM Y	1.296	1.312	1.280
MINIMUM Y	-1.544	-1.400	-1.512
CENTROID X	-.166	-.018	-.145
CENTROID Y	.306	.163	.273
POR TO CENTROID in.	.350	.164	.212
MIN RADIUS	.200	.318	.214
MEAN RADIUS	1.017	.900	.937
MAX RADIUS	1.870	1.715	1.545
HORIZONTAL SPREAD	2.545	2.150	1.440
VERTICAL SPREAD	2.839	2.712	2.712
EXTREME SPREAD	3.458	3.086	2.971
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	6		

13 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6635009

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in - 2

2 in - 7

3 in - 9

HS- 2.232

VS- 2.276

GS- 2.426

CENTROID #

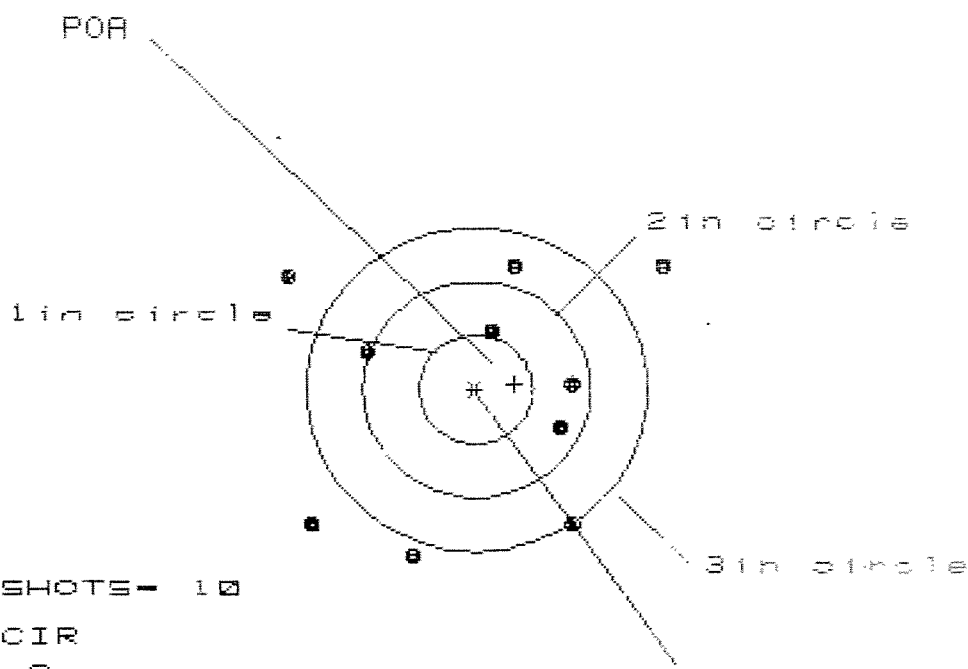
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.413	1.392	.865
MINIMUM X	:	-.819	-.840	-.665
MAXIMUM Y	:	.764	.596	.614
MINIMUM Y	:	-1.512	-1.324	-1.386
CENTROID X	:	.042	.063	-.111
CENTROID Y	:	.219	.387	.369
POA TO CENTROID in.	:	.223	.392	.385
MIN RADIUS	:	.245	.381	.260
MEAN RADIUS	:	.867	.783	.673
MAX RADIUS	:	1.523	1.400	1.324
HORIZONTAL SPREAD	:	2.232	2.232	1.530
VERTICAL SPREAD	:	2.276	1.920	1.920
EXTREME SPREAD	:	2.426	2.241	1.961
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

13 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636006

CENTERFIRE PATTERNS

3



OF SHOTS- 10

IN CIR

1in - 0

2in - 4

3in = 5

HS- 3.320

VS= 2.725

GS= 3.921

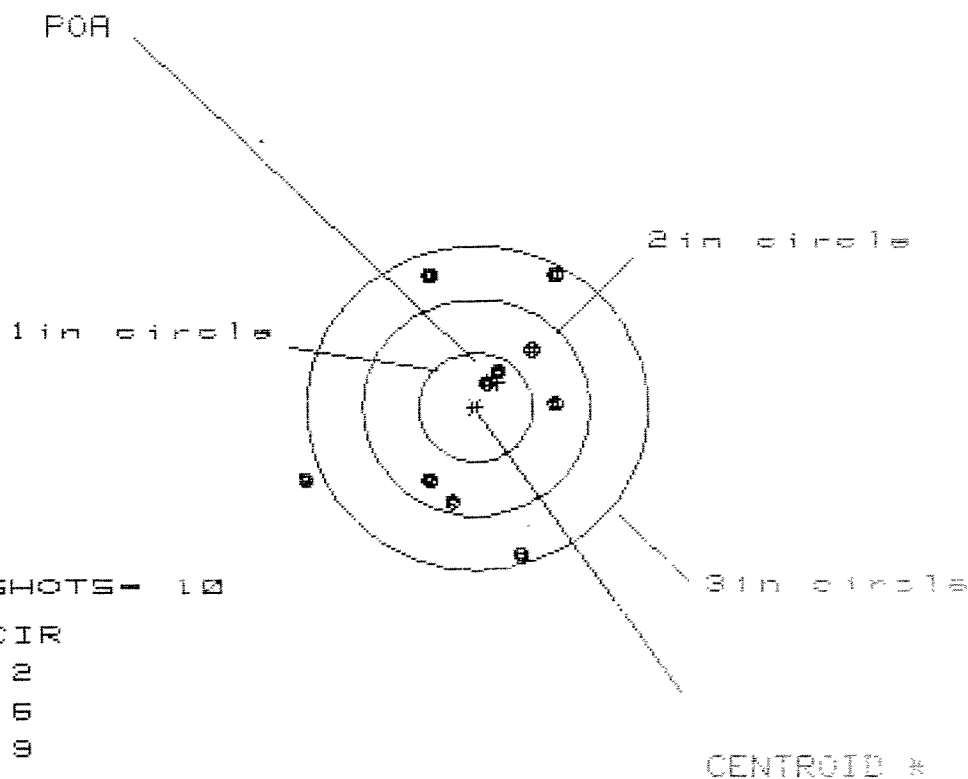
CENTROID +

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.662	1.067	.883
MINIMUM X	:	-1.658	-1.473	-1.475
MAXIMUM Y	:	1.188	1.314	1.465
MINIMUM Y	:	-1.537	-1.411	-1.260
CENTROID X	:	-.342	-.527	-.343
CENTROID Y	:	-.047	-.173	-.324
POA TO CENTROID in.	:	.345	.554	.472
MIN RADIUS	:	.594	.770	.775
MEAN RADIUS	:	1.357	1.298	1.199
MAX RADIUS	:	2.011	1.907	1.750
HORIZONTAL SPREAD	:	2.320	2.540	2.356
VERTICAL SPREAD	:	2.725	2.725	2.725
EXTREME SPREAD	:	3.921	3.458	3.065
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	5		

13 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8638000

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in - 2

2in - 5

3in = 9

HS- 2.195

VS= 2.634

GS= 2.866

CENTROID #

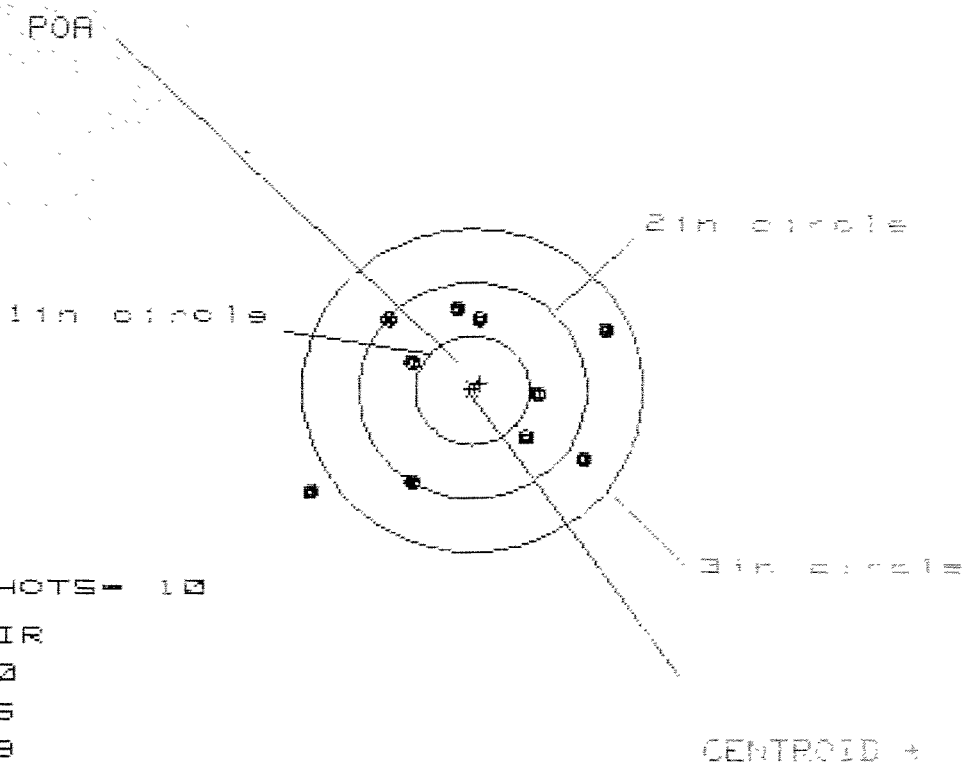
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.693	.526	.586
MINIMUM X	:	-1.502	-.592	-.532
MAXIMUM Y	:	1.275	1.206	1.270
MINIMUM Y	:	-1.359	-1.428	-1.277
CENTROID X	:	-.190	-.023	-.083
CENTROID Y	:	-.232	-.163	-.314
POA TO CENTROID in.	:	.300	.165	.325
MIN RADIUS	:	.209	.185	.294
MEAN RADIUS	:	.942	.831	.791
MAX RADIUS	:	1.625	1.443	1.377
HORIZONTAL SPREAD	:	2.195	1.118	1.118
VERTICAL SPREAD	:	2.634	2.634	2.547
EXTREME SPREAD	:	2.866	2.670	2.670
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

13 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C883E009

CENTERFIRE PATTERNS

5



PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.205	1.043	.955
MINIMUM X	:	-1.461	-.925	-.794
MAXIMUM Y	:	.792	.684	.742
MINIMUM Y	:	-.970	-.921	-.863
CENTROID X	:	-.067	.095	-.036
CENTROID Y	:	-.052	.046	-.012
POA TO CENTROID in.	:	.092	.105	.033
MIN RADIUS	:	.571	.477	.574
MEAN RADIUS	:	.950	.836	.745
MAX RADIUS	:	1.753	1.156	1.200
HORIZONTAL SPREAD	:	2.666	1.968	1.749
VERTICAL SPREAD	:	1.762	1.605	1.605
EXTREME SPREAD	:	3.082	2.220	2.206
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	