

C6636045

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Remington® **DUPONT** REG. U.S. PAT. & TM. OFF.

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

MODEL 700™ H24

SERIAL NO.
C6636045

ORDER NO.
5716

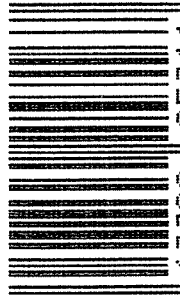
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

20



5716 C6636045

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6636045

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		5/1/91	KS
600	Proof		5/1/91	KS
607	Check Headspace		5/1/91	KS
610	Dis-assemble Gun		5/1/91	KS
612	Magnaflux Barrel Action	5 8 9 1		KCR
	Magnaflux Bolt	5 8 9 1		KCR
615	Rollmark Caliber	5 8 9 1		CS
617	Drill and Tap Sight Holes	5 15 9 1		FB
618	Polish Barrel	5 15 9 1		WB
620	Apply Coatings (Barrel Action)		5/31/91	DA
	Apply Coating (Bolt)		5/31/91	DA
625	Final Assembly A) Clean inside of Bolt Assembly		7/15/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/15/91	KL
	C) Inspect Ejector Hole for Chamfer		7/15/91	KL
	D) Oil Firing Pin Ass'y		7/15/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		7-17-91	KL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			7-17-91	SH
	G) Safety Off Force	3	3	3			7-17-91	SH
	H) Trigger Pull Test & Retainability						7-17-91	SH
	I) Firing Pin Indent	.0215	.0215	.0215			7-17-91	SH
	J) Assemble Stock						7/18/91	KS
	K) Assemble Swivel Studs						7-24-91	D/H
	L) Attach Front and Rear Sight Assemblies						7/18/91	KS
	M) Iron Sight Alignment						7/18/91	KS
	N) Detach Front & Rear Sights & place in numbered container						7/18/91	KS
	O) Attach Scope to Rifle						7/18/91	KS
	P) Detach & Attach Scope 20 Times						7/18/91	KS
640	Gallery Target & Test						7/23/91	KT
	A) Time						1	KT
	B) Malfunctions						1	KT
	C) Pierced Primers						1	KT
	D) Optical Clarity of Scope						1	KT
645	Inspect for Live Ammo						7/23/91	KT
655	Final Inspection							
	A) Headspace						7-24-91	D/H
	B) Trigger Pull	2.30	2.30	2.31	2.24	2.25	7-24-91	SH
	C) Function						7-24-91	D/H
660	Pack						9-18-91	VF

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6636045
DATE 7-17-91
TESTER JEL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.41	2.40	2.30	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.39	2.37	2.43	2.30	
PULL #3	2.36	2.34	2.36	2.31	
PULL #4	2.35	2.43	2.35	2.24	
PULL #5	2.35	2.35	2.43	2.25	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.48	3.50		
PULL #2	3.43	3.46		
PULL #3	3.45	3.54		
PULL #4	3.41	3.53		
PULL #5	3.48	3.55		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.35	4.33		4.29
PULL #2	4.35	4.36		4.38
PULL #3	4.32	4.35		4.33
PULL #4	4.32	4.31		4.35
PULL #5	4.38	4.38		4.29
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636045
29 Jul 1991

CENTROIDAL DISTANCES

0 TO	1	.243479
1 TO	2	.241207
1 TO	3	.162865
1 TO	4	.331127
1 TO	5	.128082

 ----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0942
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.087
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .128229
THE AMR FOR THIS RIFLE IS: .7028

23 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08636045

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

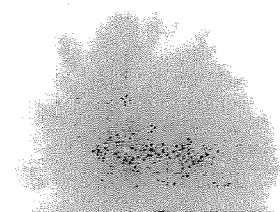
3 in = 10

HS= 1.756

VS= 2.489

GS= 2.551

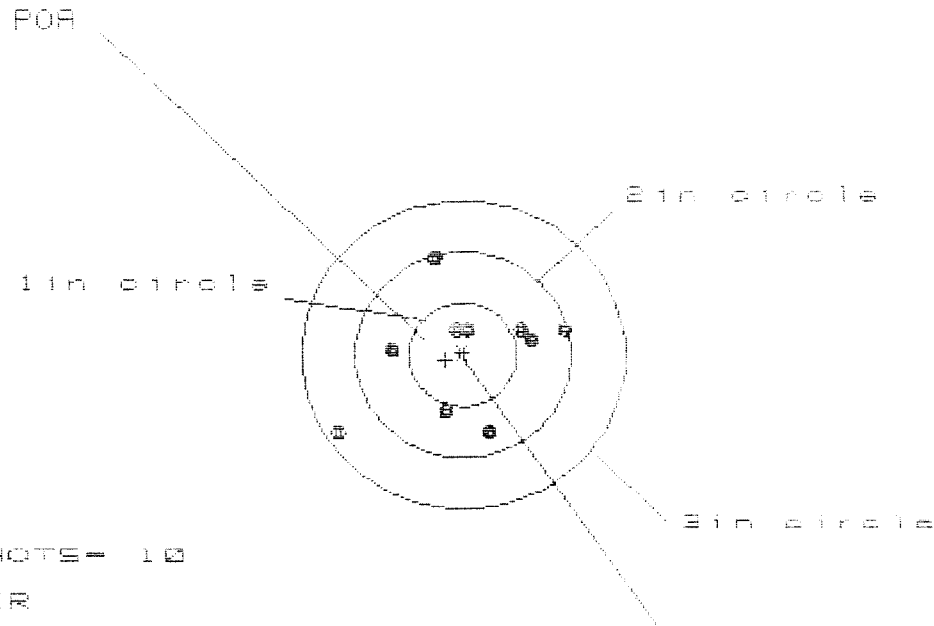
PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.697	.674	.715
MINIMUM X	-1.059	-1.082	-1.041
MAXIMUM Y	1.131	.980	.838
MINIMUM Y	-1.358	-1.151	-1.028
CENTROID X	.151	.174	.133
CENTROID Y	-.191	-.040	-.163
POA TO CENTROID in.	.244	.179	.210
MIN RADIUS	.350	.443	.344
MEAN RADIUS	.955	.896	.871
MAX RADIUS	1.373	1.252	1.156
HORIZONTAL SPREAD	1.756	1.756	1.756
VERTICAL SPREAD	2.489	2.131	1.866
EXTREME SPREAD	2.551	2.169	1.991
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		



23 Jul 1981

FILE:/PATTERNING/CENTERFIRE_PATT/CS636045

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 8

3 in = 10

HS = 0.107

VS = 1.712

GS = 0.297

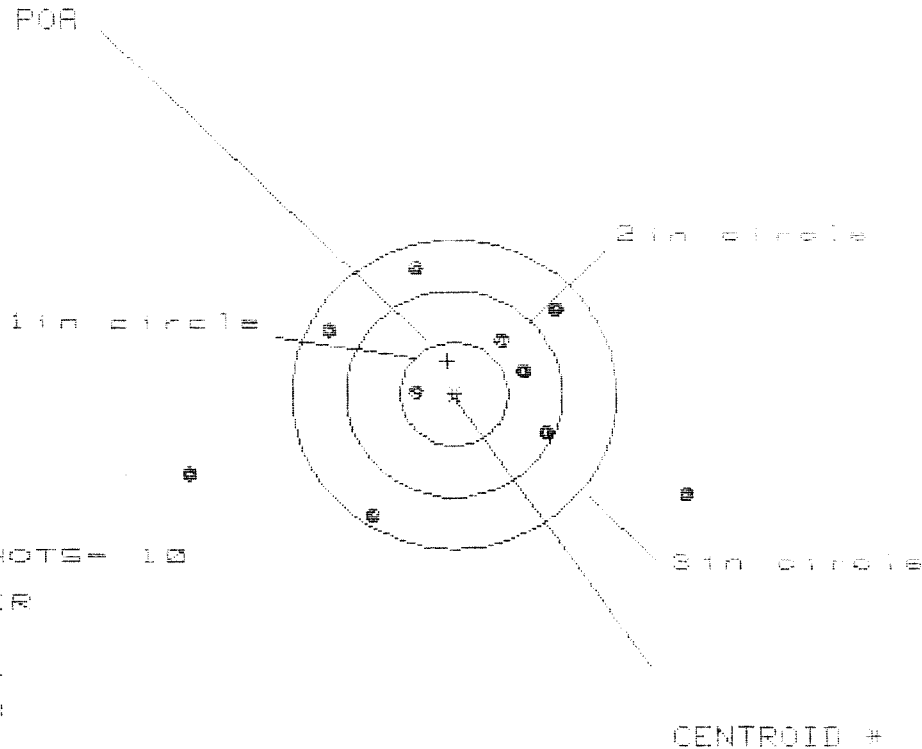
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.909	.776	.721
MINIMUM X	:	-1.198	-.840	-.895
MAXIMUM Y	:	.994	.915	.253
MINIMUM Y	:	-.718	-.797	-.683
CENTROID X	:	.161	.294	.349
CENTROID Y	:	.050	.129	.015
POA TO CENTROID in.	:	.169	.321	.349
MIN RADIUS	:	.208	.183	.305
MEAN RADIUS	:	.715	.619	.575
MAX RADIUS	:	1.393	1.015	.897
HORIZONTAL SPREAD	:	2.107	1.616	1.616
VERTICAL SPREAD	:	1.712	1.712	.936
EXTREME SPREAD	:	2.297	1.812	1.627
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

23 JUL 1981

FILE:/PATTERNING/CENTERFIRE_PATT/C8636045

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 5

HBI = 4.607

VS = 2.382

GS = 4.611

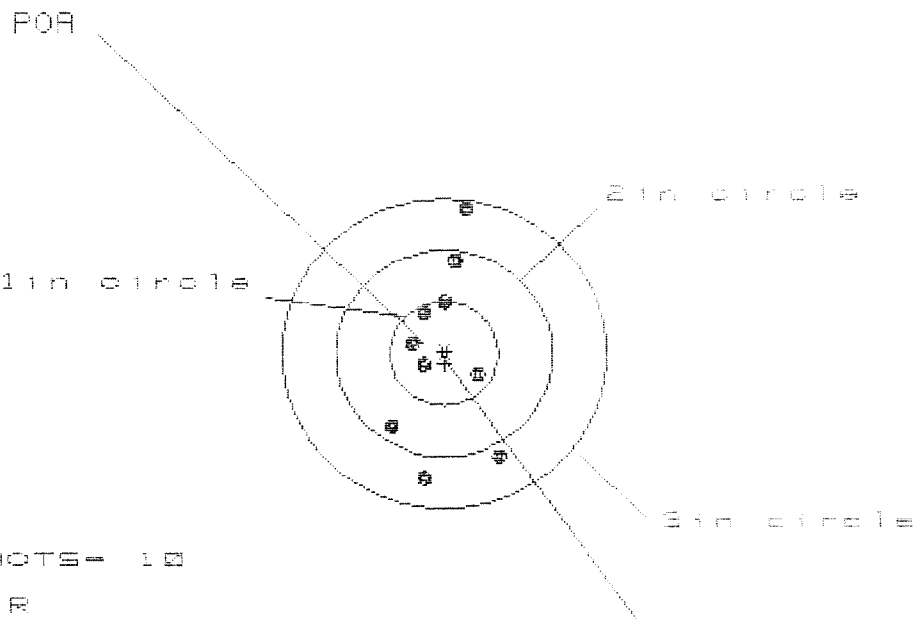
CENTROID +

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	2.133
MINIMUM X	-2.474
MAXIMUM Y	1.210
MINIMUM Y	-1.172
CENTROID X	.057
CENTROID Y	-.324
POR TO CENTROID in.	.329
MIN RADIUS	.312
MEAN RADIUS	1.279
MAX RADIUS	2.607
HORIZONTAL SPREAD	4.607
VERTICAL SPREAD	2.382
EXTREME SPREAD	4.611
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	5

23 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636045

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 5

2in = 7

3in = 10

HS= 1.065

VS= 2.603

GS= 2.633

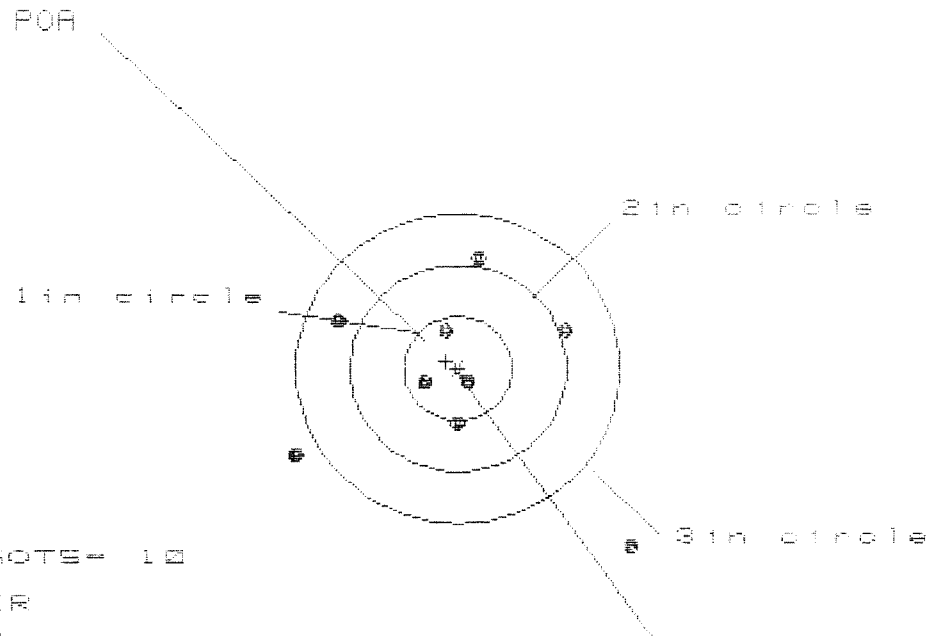
CENTROID #

PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	.547
MINIMUM X	-.518
MAXIMUM Y	1.400
MINIMUM Y	-1.203
CENTROID X	-.007
CENTROID Y	.100
POA TO CENTROID in.	.100
MIN RADIUS	.167
MEAN RADIUS	.725
MAX RADIUS	1.419
HORIZONTAL SPREAD	1.065
VERTICAL SPREAD	2.603
EXTREME SPREAD	2.633
NUMBER IN ONE INCH CIRCLE =	5
NUMBER IN TWO INCH CIRCLE =	7
NUMBER IN THREE INCH CIRCLE =	10

23 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636045

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 3

2in = 4

3in = 8

HS= 2.140

VS= 2.846

QS= 3.476

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.628
MINIMUM X	-1.512
MAXIMUM Y	1.110
MINIMUM Y	-1.736
CENTROID X	.109
CENTROID Y	-.070
POA TO CENTROID in.	.129
MIN RADIUS	.152
MEAN RADIUS	.991
MAX RADIUS	2.380
HORIZONTAL SPREAD	3.140
VERTICAL SPREAD	2.846
EXTREME SPREAD	3.476
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	8