

C6636175

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington
REG. U.S. PAT. & TM. OFF.

MODEL 700™ H24

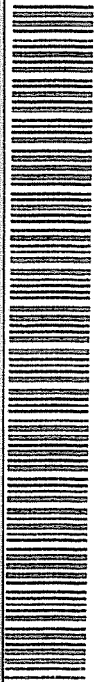
VERY IMPORTANT:
 Instruction Book
 enclosed to assure
 safe use of this
 firearm.

DU PONT

SERIAL NO.
 C6636175

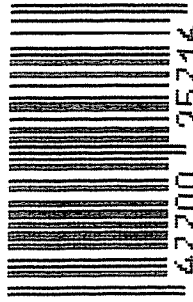
ORDER NO.
 5716

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



5716 C6636175

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636175

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		Ked
	Magnaflux Bolt	5 6 91		Ked
615	Rollmark Caliber	5 6 91		GB
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	DA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/30/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/91	RW
	C) Inspect Ejector Hole for Chamfer		5/30/91	RW
	D) Oil Firing Pin Ass'y		5/30/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		6-12-91	JH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			6-12-91	DH
	G) Safety Off Force	3	3	3			6-12-91	DH
	H) Trigger Pull Test & Retainability						6-12-91	SH
	I) Firing Pin Indent	.021	.022	.020			6-12-91	DH
	J) Assemble Stock						6-13/91	RW
	K) Assemble Swivel Studs						6-14-91	SH
	L) Attach Front and Rear Sight Assemblies						6/13/91	RW
	M) Iron Sight Alignment						6/13/91	RW
	N) Detach Front & Rear Sights & place in numbered container						6/13/91	RW
	O) Attach Scope to Rifle						6/13/91	RW
	P) Detach & Attach Scope 20 Times						6/13/91	RW
640	Gallery Target & Test						6-14-91	DH
	A) Time						6-14-91	DH
	B) Malfunctions						6-14-91	DH
	C) Pierced Primers						6-14-91	DH
	D) Optical Clarity of Scope						6-14-91	DH
645	Inspect for Live Ammo						6-14-91	DH
655	Final Inspection							
	A) Headspace						6-14-91	SH
	B) Trigger Pull	2.48	2.40	2.36	2.37	2.37	6-14-91	SH
	C) Function						6-14-91	SH
660	Pack						6-20-91	RF

SWS TRIGGER PULL TEST

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

SERIAL NO C-6636175
DATE C-12-91
TESTER JUL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.60	2.59	2.55	2.48	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.53	2.60	2.50	2.40	
PULL #3	2.54	2.53	2.54	2.36	
PULL #4	2.62	2.57	2.49	2.37	
PULL #5	2.44	2.57	2.51	2.37	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.46	3.37		
PULL #2	3.37	3.19		
PULL #3	3.43	3.39		
PULL #4	3.45	3.16		
PULL #5	3.43	3.30		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.42	4.37		4.39
PULL #2	4.21	4.22		4.37
PULL #3	4.25	4.40		4.36
PULL #4	4.32	4.39		4.14
PULL #5	4.36	4.38		4.41
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636175
14 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.157334
1 TO	2	.247111
1 TO	3	.363849
1 TO	4	.160378
1 TO	5	.369542

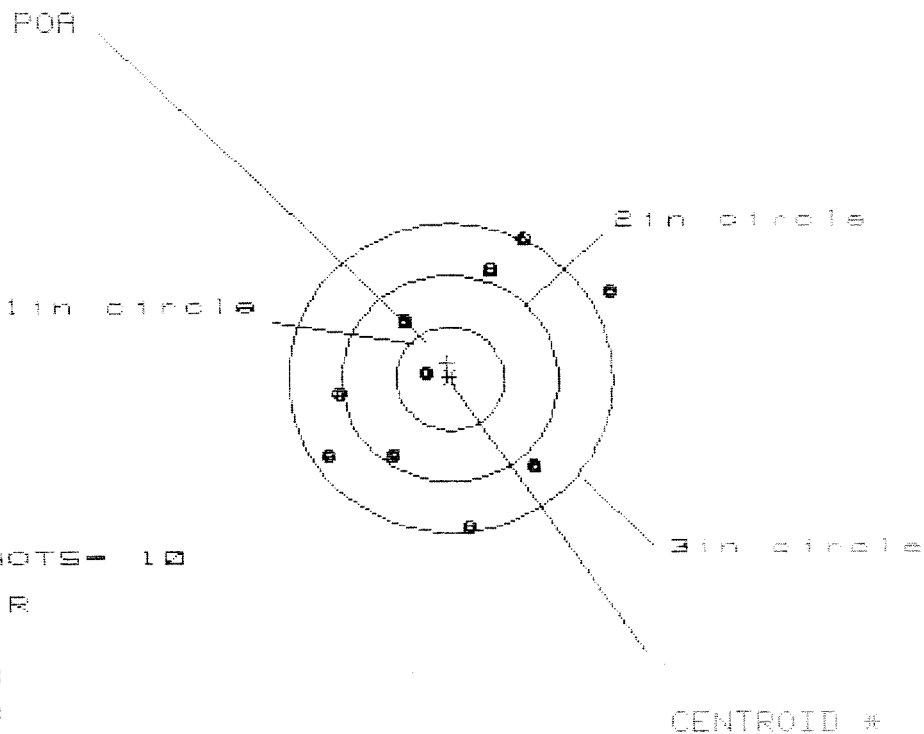
3.45 (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1246
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0662
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .141094
THE AMR FOR THIS RIFLE IS: .8456

14 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636175

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 1

2in = 3

3in = 6

HS = 2.603

VS = 2.853

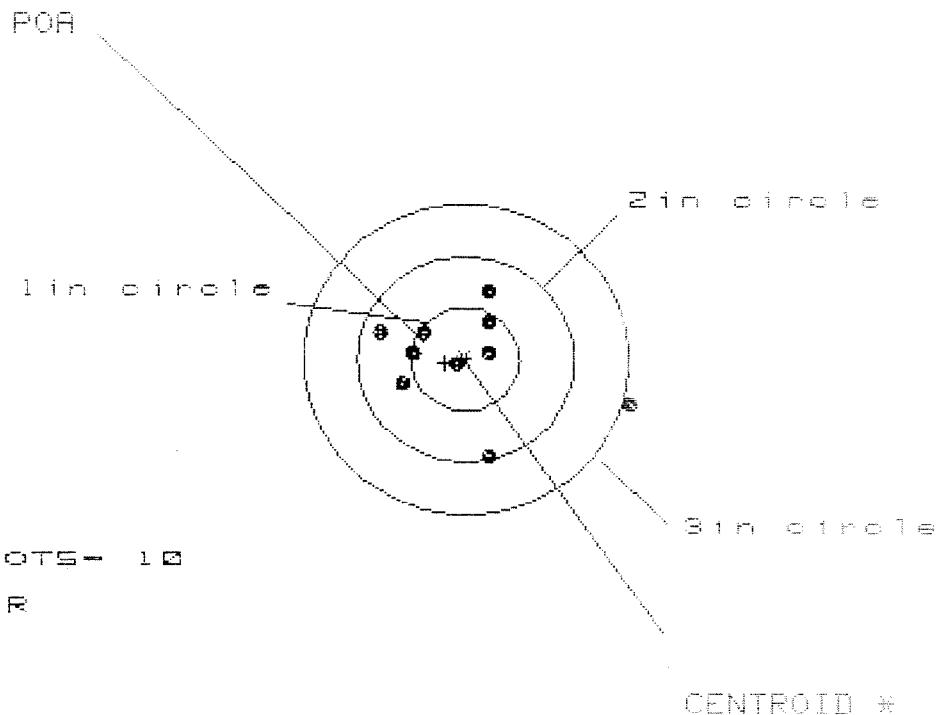
GS = 3.068

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.430	.909	1.016
MINIMUM X	-1.173	-1.014	-.907
MAXIMUM Y	1.402	1.499	1.388
MINIMUM Y	-1.451	-1.354	-1.167
CENTROID X	.027	-.132	-.239
CENTROID Y	-.155	-.252	-.439
POA TO CENTROID in.	.157	.284	.500
MIN RADIUS	.274	.165	.306
MEAN RADIUS	1.126	1.027	.921
MAX RADIUS	1.675	1.726	1.520
HORIZONTAL SPREAD	2.603	1.923	1.923
VERTICAL SPREAD	2.853	2.853	2.555
EXTREME SPREAD	3.068	2.906	2.563
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	6		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 4

2in = 9

3in = 9

HS= 2.328

VS= 1.618

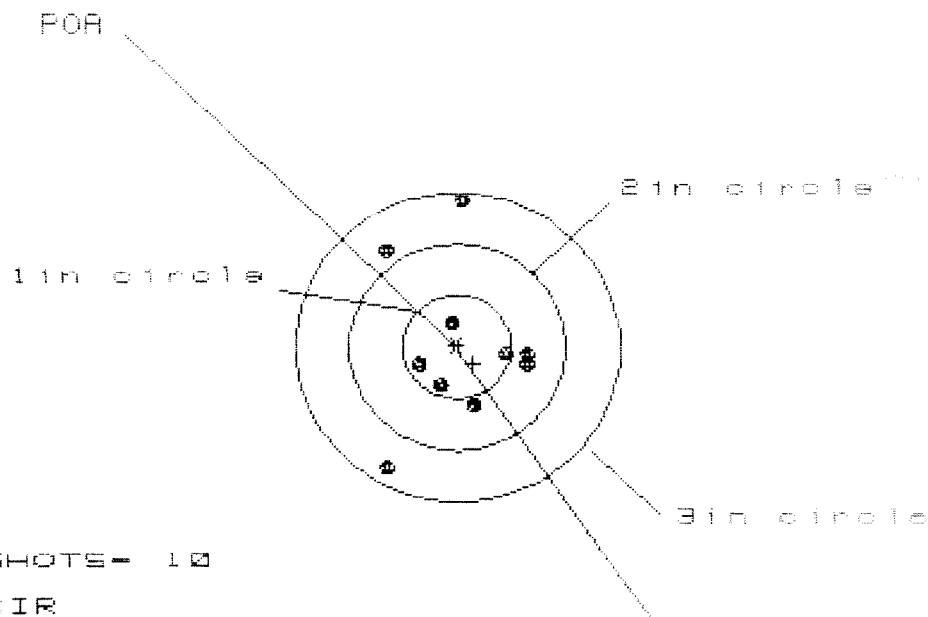
GS= 2.458

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.507	.430	.479
MINIMUM X	:	-.821	-.654	-.605
MAXIMUM Y	:	.652	.598	.471
MINIMUM Y	:	-.966	-1.020	-.433
CENTROID X	:	.185	.018	-.031
CENTROID Y	:	.035	.089	.216
POA TO CENTROID in.	:	.189	.091	.219
MIN RADIUS	:	.071	.169	.220
MEAN RADIUS	:	.660	.536	.455
MAX RADIUS	:	1.582	1.092	.618
HORIZONTAL SPREAD	:	2.328	1.084	1.084
VERTICAL SPREAD	:	1.618	1.618	.904
EXTREME SPREAD	:	2.458	1.648	1.208
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 10

HS= 1.304

VS= 2.627

GS= 2.724

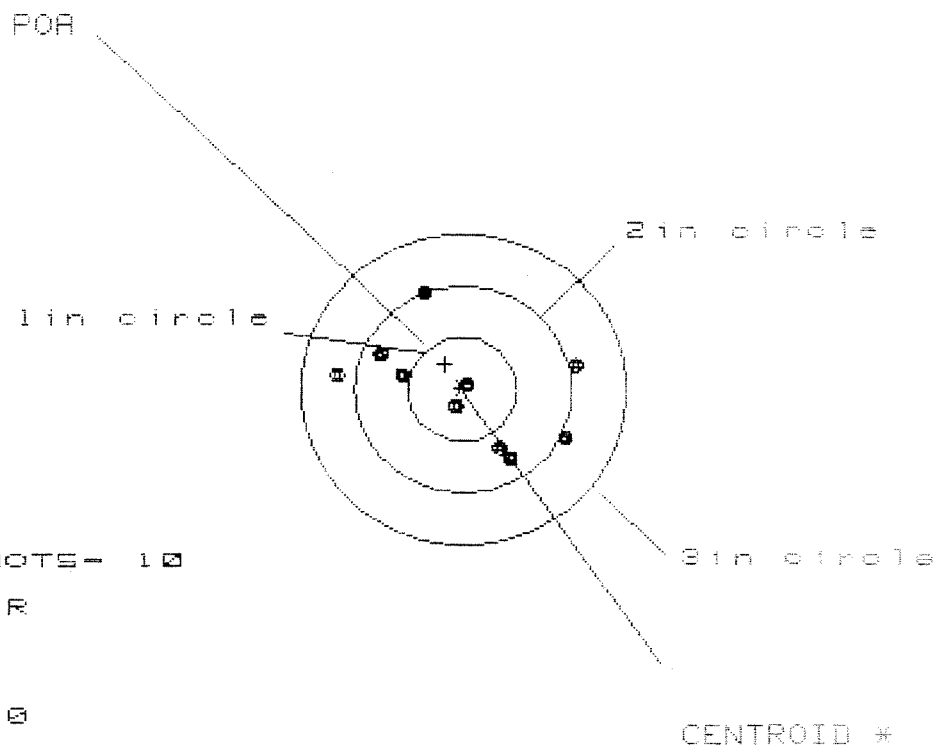
CENTROID #

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.639	.646	.564
MINIMUM X	-.665	-.658	-.718
MAXIMUM Y	1.456	1.089	.963
MINIMUM Y	-1.171	-1.009	-.548
CENTROID X	-.148	-.154	-.072
CENTROID Y	.164	.002	.128
POA TO CENTROID in.	.220	.154	.147
MIN RADIUS	.243	.270	.297
MEAN RADIUS	.730	.628	.550
MAX RADIUS	1.457	1.261	1.201
HORIZONTAL SPREAD	1.304	1.304	1.281
VERTICAL SPREAD	2.627	2.098	1.511
EXTREME SPREAD	2.724	2.098	1.713
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 2.201

VS= 1.680

GS= 2.204

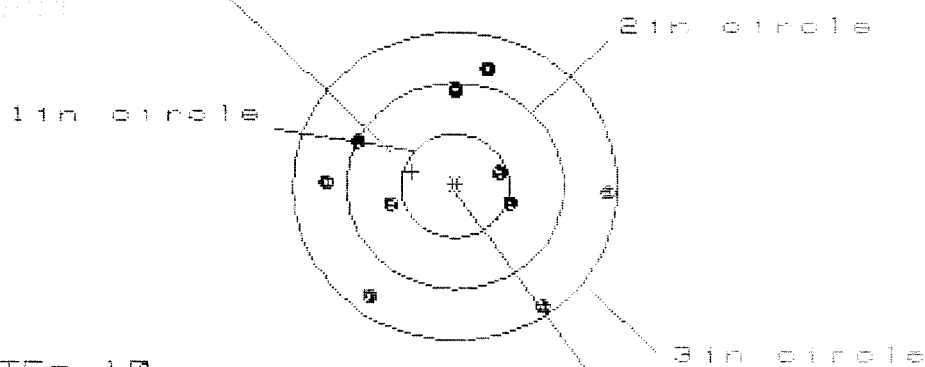
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.076	.951	.887
MINIMUM X	:	-1.125	-.838	-.719
MAXIMUM Y	:	.971	.984	1.013
MINIMUM Y	:	-.709	-.696	-.667
CENTROID X	:	.163	.288	.169
CENTROID Y	:	-.240	-.253	-.282
POA TO CENTROID in.	:	.290	.383	.329
MIN RADIUS	:	.072	.082	.096
MEAN RADIUS	:	.724	.681	.622
MAX RADIUS	:	1.131	1.098	1.078
HORIZONTAL SPREAD	:	2.201	1.739	1.606
VERTICAL SPREAD	:	1.680	1.680	1.680
EXTREME SPREAD	:	2.204	1.897	1.897
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 5

POA



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 2.617

VS= 2.247

GS= 2.619

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.399	.923	.783
MINIMUM X	:	-1.218	-1.063	-.948
MAXIMUM Y	:	1.128	1.119	.978
MINIMUM Y	:	-1.119	-1.128	-1.252
CENTROID X	:	.396	.240	.125
CENTROID Y	:	-.135	-.126	.015
POA TO CENTROID in.	:	.418	.271	.126
MIN RADIUS	:	.400	.447	.453
MEAN RADIUS	:	.988	.936	.855
MAX RADIUS	:	1.401	1.457	1.345
HORIZONTAL SPREAD	:	2.617	1.986	1.731
VERTICAL SPREAD	:	2.247	2.247	2.230
EXTREME SPREAD	:	2.619	2.490	2.490
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	