

C6636190

MODEL 700TM M24

Model **SWS** TM

Action

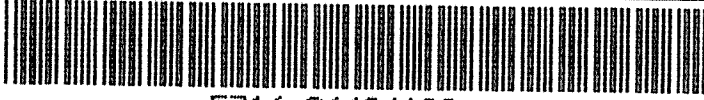
Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

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. C6636190	ORDER NO. 5716
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		20	
 5716 C6636190			

UPC



0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6636190

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		4/3/91	K.S.
600	Proof		4/3/91	K.S.
607	Check Headspace		4/3/91	K.S.
610	Dis-assemble Gun		4/3/91	K.S.
612	Magnaflux Barrel Action		4/10/91	KR
	Magnaflux Bolt		4/10/91	"
615	Rollmark Caliber		4/10/91	218
617	Drill and Tap Sight Holes		APR 19 1991	FAB
618	Polish Barrel		APR 19 1991	WB
620	Apply Coatings (Barrel Action)		5-10-91	1st
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/22/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/22/91	KS
	C) Inspect Ejector Hole for Chamfer		5/22/91	KS
	D) Oil Firing Pin Ass'y		5/22/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		5/24/91	JK

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5/24/91	JS
	G) Safety Off Force	4	4	4			5/24/91	JS
	H) Trigger Pull Test & Retainability						5/24/91	JS
	I) Firing Pin Indent	.021	.021	.021			5/24/91	JS
	J) Assemble Stock						5/29/91	KS
	K) Assemble Swivel Studs						6-1-91	DH
	L) Attach Front and Rear Sight Assemblies						5/29/91	KS
	M) Iron Sight Alignment						5/29/91	KS
	N) Detach Front & Rear Sights & place in numbered container						5/29/91	KS
	O) Attach Scope to Rifle						5/29/91	KS
	P) Detach & Attach Scope 20 Times						5/29/91	KS
640	Gallery Target & Test						5-30-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						5-30-91	NF
655	Final Inspection							
	A) Headspace						6-1-91	DH
	B) Trigger Pull	2.32	2.25	2.35	2.30	2.42	6/1/91	JS
	C) Function						6-1-91	DH
660	Pack						6-20-91	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6636190

DATE 5/24/91

TESTER JRL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.22	2.36	2.38	2.32	MIN. SETTING,
PULL #2	2.18	2.39	2.46	2.25	NO AVG. OF 5
PULL #3	2.35	2.45	2.48	2.35	READINGS ACCEPT-
PULL #4	2.35	2.45	2.50	2.30	ABLE LESS THAN 2#
PULL #5	2.36	2.42	2.44	2.42	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.15	3.52		
PULL #2	3.41	3.38		
PULL #3	3.34	3.44		
PULL #4	3.56	3.22		
PULL #5	3.52	3.42		
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	4.60		4.20
PULL #2	4.41	4.20		4.18
PULL #3	4.38	4.24		4.14
PULL #4	4.42	4.22		4.18
PULL #5	4.56	4.21		4.18
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636190
30 May 1991

CENTROIDAL DISTANCES

0	TO	1	.469234
1	TO	2	.380789
1	TO	3	.272721
1	TO	4	.323215
1	TO	5	.244076

1 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1376
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1906
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .235079

THE AMR FOR THIS RIFLE IS: 1.009

30 May 1991

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CENTERFIRE PATTERNS

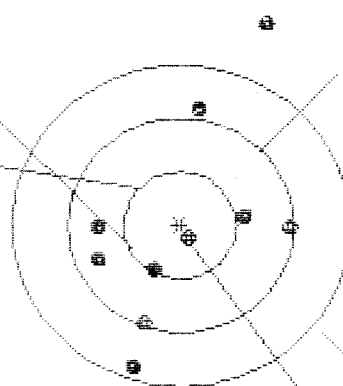
1

POA

1 in circle

2 in circle

3 in circle



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS= 1.728

VS= 3.178

GS= 3.382

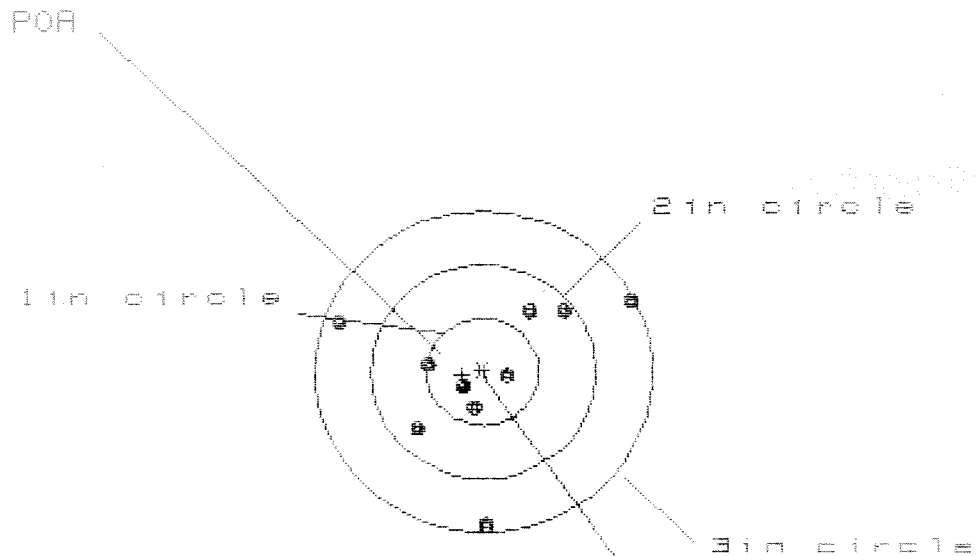
CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.949	1.035	.998
MINIMUM X	:	-.779	-.693	-.731
MAXIMUM Y	:	1.848	1.266	1.125
MINIMUM Y	:	-1.338	-1.125	-.882
CENTROID X	:	.238	.144	.181
CENTROID Y	:	.489	.204	.345
POA TO CENTROID in.	:	.469	.258	.389
MIN RADIUS	:	.168	.181	.156
MEAN RADIUS	:	.907	.746	.698
MAX RADIUS	:	2.002	1.288	1.143
HORIZONTAL SPREAD	:	1.728	1.728	1.728
VERTICAL SPREAD	:	3.178	2.391	1.927
EXTREME SPREAD	:	3.382	2.451	1.996
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

30 May 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 9

HS= 2.640

VS= 2.113

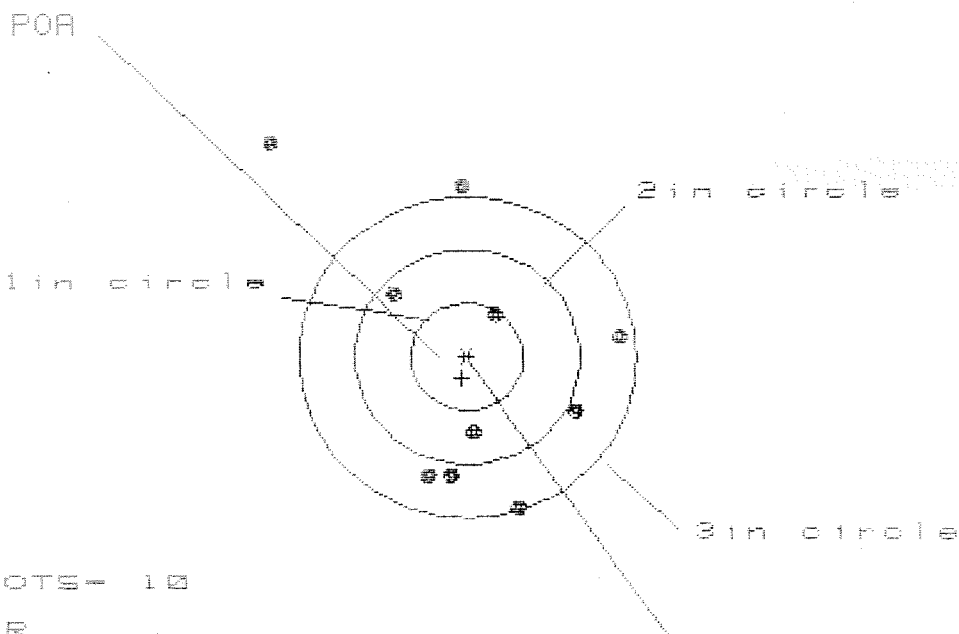
GS= 2.649

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.329	.881	.736
MINIMUM X	:	-1.311	-1.164	-.558
MAXIMUM Y	:	.712	.663	.735
MINIMUM Y	:	-1.401	-1.322	-1.250
CENTROID X	:	.184	.037	.182
CENTROID Y	:	.031	-.048	-.120
POA TO CENTROID in.	:	.187	.061	.218
MIN RADIUS	:	.236	.071	.189
MEAN RADIUS	:	.797	.688	.618
MAX RADIUS	:	1.508	1.329	1.250
HORIZONTAL SPREAD	:	2.640	2.045	1.294
VERTICAL SPREAD	:	2.113	1.985	1.985
EXTREME SPREAD	:	2.649	2.299	2.079
NUMBER IN ONE INCH CIRCLE	=	4		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	9		

30 May 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 8

HS= 3.0990

VS= 3.373

GS= 4.034

CENTROID #

PATTERN #

3

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.320	1.123	1.091
MINIMUM X	-1.770	-.887	-.919
MAXIMUM Y	1.963	1.824	1.064
MINIMUM Y	-1.410	-1.192	-.964
CENTROID X	.049	.246	.278
CENTROID Y	.205	-.013	-.241
POA TO CENTROID in.	.211	.246	.368
MIN RADIUS	.453	.471	.282
MEAN RADIUS	1.246	1.039	.892
MAX RADIUS	2.643	1.842	1.406
HORIZONTAL SPREAD	3.090	2.010	2.010
VERTICAL SPREAD	3.373	3.016	2.028
EXTREME SPREAD	4.034	3.057	2.323
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		8	

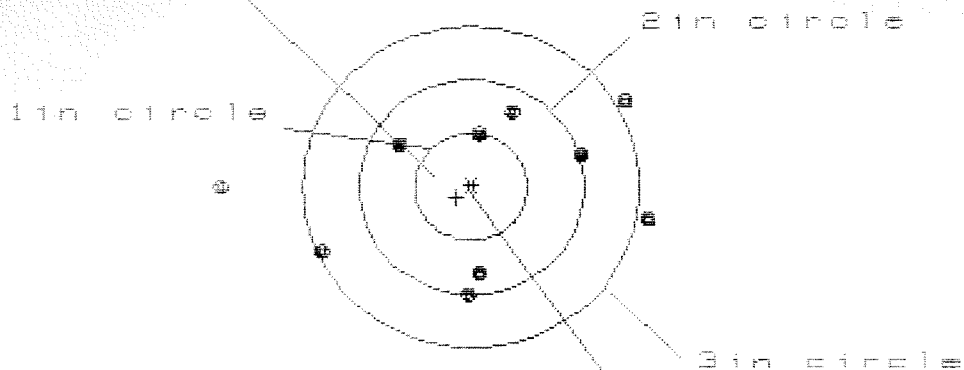
30 May 1991

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CENTERFIRE PATTERNS

4

POA



OF SHOTS= 10

IN CIR

1in = 0

2in = 4

3in = 7

HS= 3.849

VS= 1.787

GS= 3.859

CENTROID #

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.574	1.322	1.256
MINIMUM X	:	-2.275	-1.616	-1.451
MAXIMUM Y	:	.784	.780	.740
MINIMUM Y	:	-1.003	-1.007	-1.047
CENTROID X	:	.132	.384	.219
CENTROID Y	:	.101	.105	.145
POA TO CENTROID in.	:	.166	.399	.263
MIN RADIUS	:	.508	.511	.452
MEAN RADIUS	:	1.188	1.042	.991
MAX RADIUS	:	2.275	1.718	1.579
HORIZONTAL SPREAD	:	3.849	2.938	2.707
VERTICAL SPREAD	:	1.787	1.787	1.787
EXTREME SPREAD	:	3.859	3.030	3.030
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	7		

30 May 1931

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CENTERFIRE PATTERNS

5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 8

HS= 3.204

VS= 2.319

GS= 3.594

PATTERN #

5

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.673	1.503	.853
MINIMUM X	:	-1.531	-.951	-.764
MAXIMUM Y	:	1.311	.735	.714
MINIMUM Y	:	-1.008	-.862	-.883
CENTROID X	:	.093	.263	.076
CENTROID Y	:	.207	.062	.083
POA TO CENTROID in.	:	.228	.271	.112
MIN RADIUS	:	.079	.155	.138
MEAN RADIUS	:	.909	.766	.665
MAX RADIUS	:	2.016	1.512	1.000
HORIZONTAL SPREAD	:	3.204	2.454	1.617
VERTICAL SPREAD	:	2.319	1.597	1.597
EXTREME SPREAD	:	3.594	2.593	1.801
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	