

C6348831

MODEL 760™ M24

Model SWS™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

Smead®

Remington
MODEL 700™ H24

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

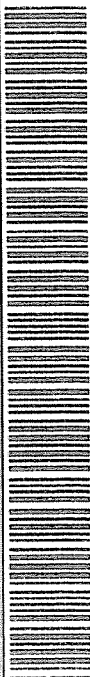
REG. U.S. PAT. & TM. OFF.

SERIAL NO.
D6348831

ORDER NO.
5716

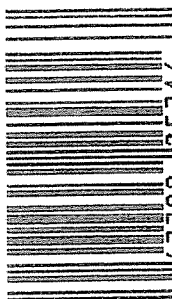
MADE IN ILLION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

Ø 1



5716 D6348831

LPC



0 47700 125716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348831

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 21	89	RW
600	Proof	7 21	89	RW
607	Check Headspace	21	89	RW
610	Dis-assemble Gun	0 21	89	RW
612	Magnaflux Barrel Action		7/25/89	KR
	Magnaflux Bolt		7/25/89	KR
615	Rollmark Caliber		7/25/89	sd
7	Drill and Tap Sight Holes		7/27/89	W.C.
618	Polish Barrel AB		7/31/89	W.B.
620	Apply Coatings (Barrel Action)		8/2/89	TJA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		8/7/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/7/89	RW
	C) Inspect Ejector Hole for Chamfer		8/7/89	RW
	D) Oil Firing Pin Ass'y		8/7/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/11/89	J.U.

op. #	OP. NAME	READINGS				DATE	INIT
625 cont.	F) Safety On Force	6	6	6		8/11/89	JH
	G) Safety Off Force	4	4	4		8/11/89	JH
	H) Trigger Pull Test & Retainability					8/11/89	JH
	I) Firing Pin Indent	215	21	215		8/11/89	JH
	J) Assemble Stock					8/15/89	RW
	K) Assemble Swivel Studs					8/15/89	JS
	L) Attach Front and Rear Sight Assemblies					8/15/89	RW
	M) Iron Sight Alignment					8/15/89	RW
	N) Detach Front & Rear Sights & place in numbered container					8/15/89	RW
	O) Attach Scope to Rifle					8/15/89	JH
	P) Detach & Attach Scope 20 Times					8/15/89	JH
640	Gallery Target & Test	54	R	99L		8-21-89	DH
	A) Time					8-21-89	DH
	B) Malfunctions					8-21-89	DH
	C) Pierced Primers					8-21-89	DH
	D) Optical Clarity of Scope					8-21-89	DH
645	Inspect for Live Ammo					8-21-89	DH
655	Final Inspection					8/21/89	JS
	A) Headspace					8/21/89	JS
	B) Trigger Pull	2.12	2.03	2.21	2.09	8/21/89	JS
	C) Function					8/21/89	JS
660	Pack					8/21/89	JS

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6348831

DATE 9 NOV 90

TESTER WJ

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.17	243	2.45		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.12	243	2.41		
PULL #3	2.07	241	2.46		
PULL #4	2.09	237	2.44		
PULL #5	2.44	238	2.40		
TOTAL	10.89	1202	1216		
AVG.	2.178	2.404	2.432		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	326	325		
PULL #2	320	326		
PULL #3	320	323		
PULL #4	321	321		
PULL #5	320	322		
TOTAL	1607	1617		
AVG.	3.214	3.234		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	403	400		
PULL #2	391	402		
PULL #3	403	399		
PULL #4	402	399		
PULL #5	402	402		
TOTAL	2001	2002		
AVG.	4.002	4.004		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348831
21 Aug 1989

CENTROIDAL DISTANCES

0 TO 1	.607593
1 TO 2	.0908735
1 TO 3	.908273
1 TO 4	.271892
1 TO 5	.170496

$\frac{3}{4}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .3232
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2766
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .425401
THE AMR FOR THIS RIFLE IS: 1.07

21 Aug 1985

FILE:/PATTERNING/CENTERFIRE_PATT/C934B831

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 6

HS = 2.852

VS = 3.406

GS = 3.412

CENTROID #

PATTERN #

SHOTS (BEST OF)

MAXIMUM X

MINIMUM X

MAXIMUM Y

MINIMUM Y

CENTROID X

CENTROID Y

POA TO CENTROID in.

MIN RADIUS

MEAN RADIUS

MAX RADIUS

HORIZONTAL SPREAD

VERTICAL SPREAD

EXTREME SPREAD

NUMBER IN ONE INCH CIRCLE

NUMBER IN TWO INCH CIRCLE

NUMBER IN THREE INCH CIRCLE

51

10

1.471

-1.381

1.704

-1.702

.535

.288

.607

.208

1.015

1.802

2.852

3.406

3.412

=

=

=

9

1.318

-.927

1.833

-1.573

.688

.159

.706

.071

.887

1.843

2.245

3.406

3.412

2

6

6

8

1.318

-.927

1.636

-.836

.688

.356

.775

.266

.843

1.647

2.245

2.472

2.501

21 Aug 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C534B831

CENTERFIRE PATTERNS

2

POA

1 in circle

2 in circle

3 in circle

* OF SHOTS= 10

IN CIR

1 in = 2

2 in = 3

3 in = 7

HS= 2.828

VS= 2.832

GS= 3.192

CENTROID *

PATTERN #

2

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.661

1.537

1.561

MINIMUM X

-1.167

-1.231

-1.098

MAXIMUM Y

1.345

1.352

1.385

MINIMUM Y

-1.486

-1.337

-1.304

CENTROID X

.452

.576

.383

CENTROID Y

.251

.101

.068

POA TO CENTROID in.

.517

.584

.389

MIN RADIUS

.458

.265

.414

MEAN RADIUS

1.227

1.130

1.091

MAX RADIUS

1.746

1.649

1.592

HORIZONTAL SPREAD

2.828

2.828

2.659

VERTICAL SPREAD

2.832

2.689

2.689

EXTREME SPREAD

3.192

2.871

2.871

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

3

NUMBER IN THREE INCH CIRCLE =

7

21 Aug 1989

FILE:/PATTERNING/CENTERFIRE_PATT/CS348831

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

* OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.743

VS= 2.068

GS= 2.935

CENTROID #

PATTERN #

3

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.706

.830

.724

MINIMUM X

-1.037

-.847

-.935

MAXIMUM Y

.877

.856

.960

MINIMUM Y

-1.191

-1.212

-1.100

CENTROID X

-.369

-.559

-.453

CENTROID Y

.376

.397

.293

POA TO CENTROID (in.)

.527

.686

.540

MIN RADIUS

.261

.221

.227

MEAN RADIUS

.958

.854

.803

MAX RADIUS

1.717

1.391

1.249

HORIZONTAL SPREAD

2.743

1.677

1.659

VERTICAL SPREAD

2.068

2.068

2.068

EXTREME SPREAD

2.935

2.554

2.173

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

6

NUMBER IN THREE INCH CIRCLE =

9

21 Aug 1985

FILE:/PATTERNING/CENTERFIRE_PATT/0634B031

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 0

2 in = 4

3 in = 7

HS = 2.464

VS = 3.022

GS = 3.045

CENTROID #

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.283	1.331	1.186
MINIMUM X	-1.181	-1.133	-.967
MAXIMUM Y	1.501	1.332	1.203
MINIMUM Y	-1.521	-1.107	-1.236
CENTROID X	.513	.465	.299
CENTROID Y	.017	.186	.315
POA TO CENTROID in.	.514	.501	.434
MIN RADIUS	.643	.527	.551
MEAN RADIUS	1.155	1.080	.964
MAX RADIUS	1.581	1.682	1.713
HORIZONTAL SPREAD	2.464	2.464	2.153
VERTICAL SPREAD	3.022	2.439	2.439
EXTREME SPREAD	3.045	2.788	2.624
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

21 Aug 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C8346831

CENTERFIRE PATTERNS

5

FOR

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 10

HS= 2.248

VS= 2.234

GS= 2.713

CENTROID #

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.130

1.008

.884

MINIMUM X

-1.118

-.993

-1.079

MAXIMUM Y

1.108

1.206

1.138

MINIMUM Y

-1.126

-1.028

-1.096

CENTROID X

.485

.360

.484

CENTROID Y

.451

.353

.421

FOR TO CENTROID in

.662

.504

.642

MIN RADIUS

.113

.267

.126

MEAN RADIUS

.995

.949

.904

MAX RADIUS

1.430

1.286

1.200

HORIZONTAL SPREAD

2.248

2.001

1.963

VERTICAL SPREAD

2.234

2.234

2.234

EXTREME SPREAD

2.713

2.370

2.316

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

4

NUMBER IN THREE INCH CIRCLE =

10

INTERCHANGEABILITY
INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6340879
19 Sep 1989

CENTROIDAL DISTANCES

0 TO 1	.323446
1 TO 2	.155077
1 TO 3	.199
1 TO 4	.318247
1 TO 5	.230703

4.5 ←---POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2202
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.131
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .256221
THE AMR FOR THIS RIFLE IS: .992

INTERCHANGEABILITY

19 Sep 1989

FILE:~PATTERNING/CENTERFIRE_PATT/C634B879.1

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 1

2in = 4

3in = 9

HS = 2.823

VS = 2.368

GS = 2.942

CENTROID *

PATTERN #

1

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.418

.877

.721

MINIMUM X

-1.405

-1.248

-.891

MAXIMUM Y

1.191

1.248

1.215

MINIMUM Y

-1.177

-1.120

-1.153

CENTROID X

.204

.047

.203

CENTROID Y

-.251

-.308

-.275

POA TO CENTROID in.

.324

.311

.341

MIN RADIUS

.240

.387

.236

MEAN RADIUS

1.053

1.010

.946

MAX RADIUS

1.505

1.401

1.363

HORIZONTAL SPREAD

2.823

2.125

1.612

VERTICAL SPREAD

2.368

2.368

2.368

EXTREME SPREAD

2.942

2.644

2.644

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

4

NUMBER IN THREE INCH CIRCLE =

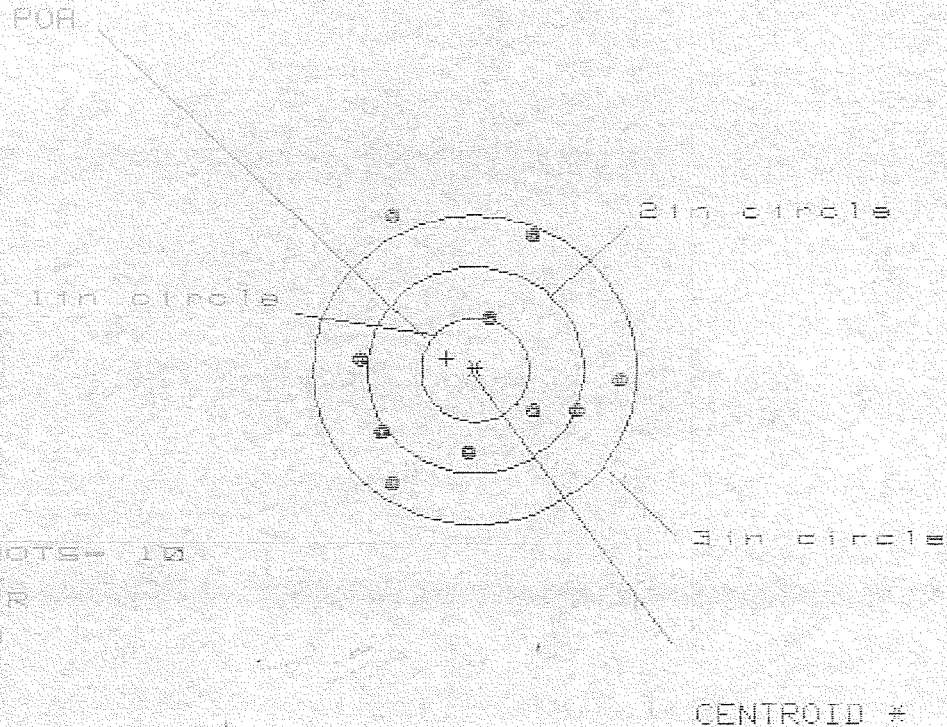
9

INTERCHANGEABILITY

18 Sep 1989

FILE: PATTERNING/CENTERFIRE_PATT/C834B879.1

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 4

3 in = 9

HS= 2.406

VS= 2.562

GS= 2.682

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.367	1.281	1.340
MINIMUM X	-1.039	-1.125	-1.066
MAXIMUM Y	1.468	1.423	.831
MINIMUM Y	-1.094	-.931	-.753
CENTROID X	.264	.350	.291
CENTROID Y	-.108	-.271	-.449
POA TO CENTROID in.	.285	.443	.536
MIN RADIUS	.506	.500	.424
MEAN RADIUS	1.075	.985	.899
MAX RADIUS	1.662	1.500	1.358
HORIZONTAL SPREAD	2.406	2.406	2.406
VERTICAL SPREAD	2.562	2.354	1.584
EXTREME SPREAD	2.682	2.682	2.421
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		9	

INTERCHANGEABILITY

19 Sep 1989

FILE: PATTERNING CENTERFIRE_PATT/C634B079.1

CENTERFIRE PATTERNS

3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 3

3 in = 10

HS = 2.450

VS = 1.551

GS = 2.585

CENTROID #

PATTERN #

3

	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.172	1.030	1.148
MINIMUM X	-1.278	-1.257	-1.139
MAXIMUM Y	.834	.864	.770
MINIMUM Y	-.717	-.687	-.614
CENTROID X	.204	.346	.228
CENTROID Y	-.052	-.082	.004
POA TO CENTROID IN.	.211	.356	.228
MIN RADIUS	.405	.261	.404
MEAN RADIUS	1.024	.973	.951
MAX RADIUS	1.306	1.263	1.219
HORIZONTAL SPREAD	2.450	2.287	2.287
VERTICAL SPREAD	1.551	1.551	1.392
EXTREME SPREAD	2.585	2.296	2.296
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	10		

INTERCHANGEABILITY

19 Sep 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C8348879.1

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 0

2in = 7

3in = 10

HS= 1.562

VS= 2.160

GS= 2.263

CENTROID #

PATTERN #

4

	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.911	.992	.970
MINIMUM X	-.651	-.570	-.592
MAXIMUM Y	1.121	1.223	.883
MINIMUM Y	-1.039	-.937	-.784
CENTROID X	-.005	-.086	-.064
CENTROID Y	-.011	-.113	-.265
POA TO CENTROID in.	.012	.142	.274
MIN RADIUS	.581	.492	.537
MEAN RADIUS	.919	.876	.819
MAX RADIUS	1.171	1.235	1.044
HORIZONTAL SPREAD	1.562	1.562	1.562
VERTICAL SPREAD	2.160	2.160	1.667
EXTREME SPREAD	2.263	2.166	1.777
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

INTERCHANGEABILITY

19 Sep 1989

FILE:/PATTERNING/CENTERFIRE PATT/C6348879.1

CENTERFIRE PATTERNS # 5

FOR

1 in circle

2 in circle

3 in circle

CENTROID *

* OF SHOTS - 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS = 3.053

VS = 1.818

GS = 3.082

PATTERN #

5

	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.088	.870	.864
MINIMUM X	-1.965	-.887	-.779
MAXIMUM Y	1.110	1.142	1.236
MINIMUM Y	-.708	-.676	-.582
CENTROID X	.434	.652	.544
CENTROID Y	-.233	-.265	-.359
POR TO CENTROID in.	.493	.704	.651
MIN RADIUS	.209	.035	.161
MEAN RADIUS	.889	.741	.685
MAX RADIUS	1.996	1.146	1.236
HORIZONTAL SPREAD	3.053	1.757	1.643
VERTICAL SPREAD	1.818	1.818	1.818
EXTREME SPREAD	3.082	2.193	1.892
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

COMMENTS

SAUPER N-24

1. *Introduction*

R

HARD CASE

UPS

DATE _____

M2400039350

