

C6649280

MODEL 700™ M24

Model **SWS**

Action _____™

Barrel Length _____

Capacity _____

Order No. **5715**

*Includes 1 in chamber.

Remington®

Remington®
REG. U.S. PAT. & TM. OFF.

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

MODEL 700™ H24

SERIAL NO.
C6649280

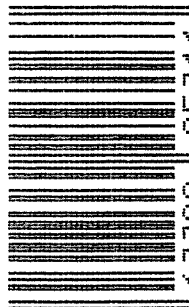
ORDER NO.
5716

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



5716 C6649280

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649280

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 27 9 1		dw
600	Proof	6 27 9 1		dw
607	Check Headspace	6 27 9 1		dw
610	Dis-assemble Gun	6 27 9 1		dw
612	Magnaflux Barrel Action	JUL	2 1991	KR
	Magnaflux Bolt	JUL	2 1991	KR
615	Rollmark Caliber	JUL	2 1991	LS.
617	Drill and Tap Sight Holes	JUL	2 1991	LB
618	Polish Barrel	JUL	1 7 1991	WB
620	Apply Coatings (Barrel Action)		7-22-91	TS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/23/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/23/91	RW
	C) Inspect Ejector Hole for Chamfer		7/23/91	RW
	D) Oil Firing Pin Ass'y		7/23/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		7-29-91	JH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			7/29/91	QU
	G) Safety Off Force	4	4	4			7/29/91	QU
	H) Trigger Pull Test & Retainability						7-29-91	QU
	I) Firing Pin Indent	.0205	.0205	.0205			7-29-91	QU
	J) Assemble Stock						7/30/91	RW
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies						7/30/91	RW
	M) Iron Sight Alignment						7/30/91	RW
	N) Detach Front & Rear Sights & place in numbered container						7/30/91	RW
	O) Attach Scope to Rifle						7/30/91	RW
	P) Detach & Attach Scope 20 Times						7/30/91	RW
640	Gallery Target & Test						7-30-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						7-30-91	AF
655	Final Inspection							
	A) Headspace						8-5-91	AF
	B) Trigger Pull	2.36	2.42	2.42	2.44	2.43	8-5-91	QU
	C) Function						8-5-91	AF
660	Pack						9-18-91	AF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6649280

DATE 7-29-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.29	2.17	2.46	2.36	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.19	2.57	2.44	2.42	
PULL #3	2.25	2.46	2.40	2.42	
PULL #4	2.18	2.44	2.52	2.44	
PULL #5	2.34	2.56	2.48	2.43	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.39		
PULL #2	3.32	3.37		
PULL #3	3.34	3.43		
PULL #4	3.40	3.41		
PULL #5	3.33	3.39		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.57	4.35		4.61
PULL #2	4.60	4.36		4.42
PULL #3	4.46	4.48		4.40
PULL #4	4.63	4.63		4.46
PULL #5	4.60	4.36		4.52
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649280
30 Jul 1991

CENTROIDAL DISTANCES

0 TO	1	.244761
1 TO	2	.129248
1 TO	3	.232002
1 TO	4	.248268
1 TO	5	.0753923

<----POA

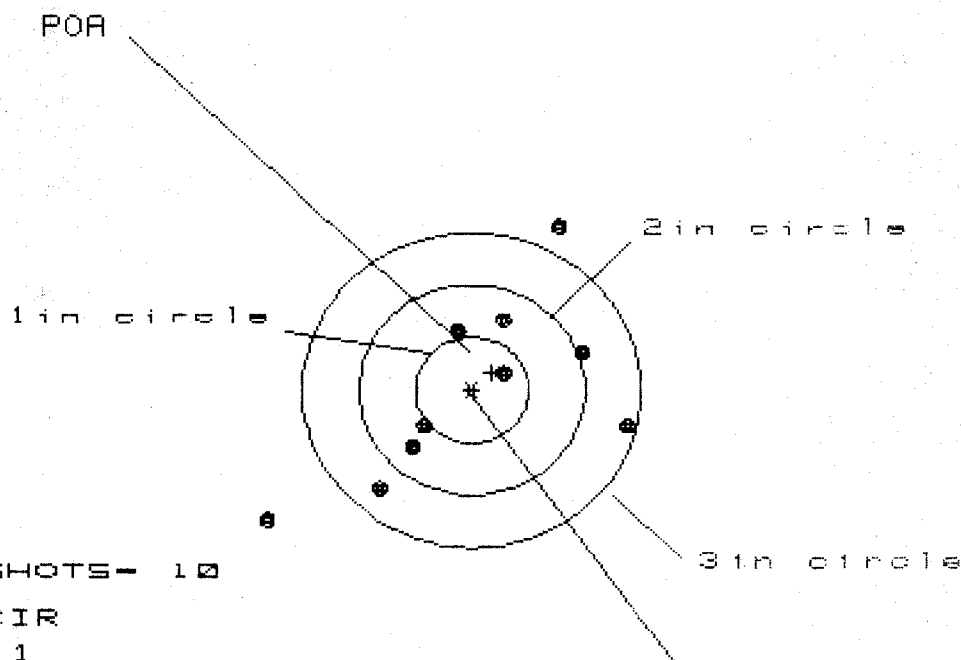
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.086
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0822
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .118966

THE AMR FOR THIS RIFLE IS: .8868

30 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/066492B0

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 3.255

VS= 2.857

GS= 3.846

CENTROID *

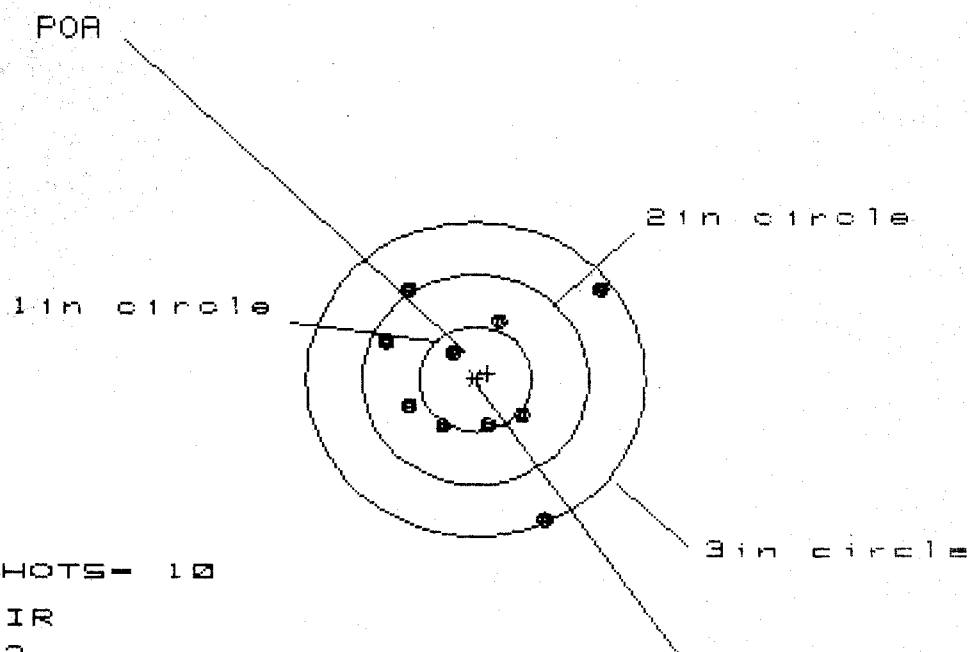
PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.422	1.218	1.284
MINIMUM X	:	-1.843	-1.003	-.937
MAXIMUM Y	:	1.590	1.449	.746
MINIMUM Y	:	-1.267	-1.045	-.864
CENTROID X	:	-.178	.026	-.040
CENTROID Y	:	-.163	-.022	-.203
POA TO CENTROID in.	:	.242	.034	.207
MIN RADIUS	:	.349	.101	.279
MEAN RADIUS	:	1.070	.902	.838
MAX RADIUS	:	2.236	1.542	1.323
HORIZONTAL SPREAD	:	3.265	2.221	2.221
VERTICAL SPREAD	:	2.857	2.494	1.610
EXTREME SPREAD	:	3.846	2.926	2.286
NUMBER IN ONE INCH CIRCLE =	:	1		
NUMBER IN TWO INCH CIRCLE =	:	5		
NUMBER IN THREE INCH CIRCLE =	:	8		

30 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66492B0

CENTERFIRE PATTERNS

2



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 1.848

VS= 2.192

GS= 2.457

CENTROID *

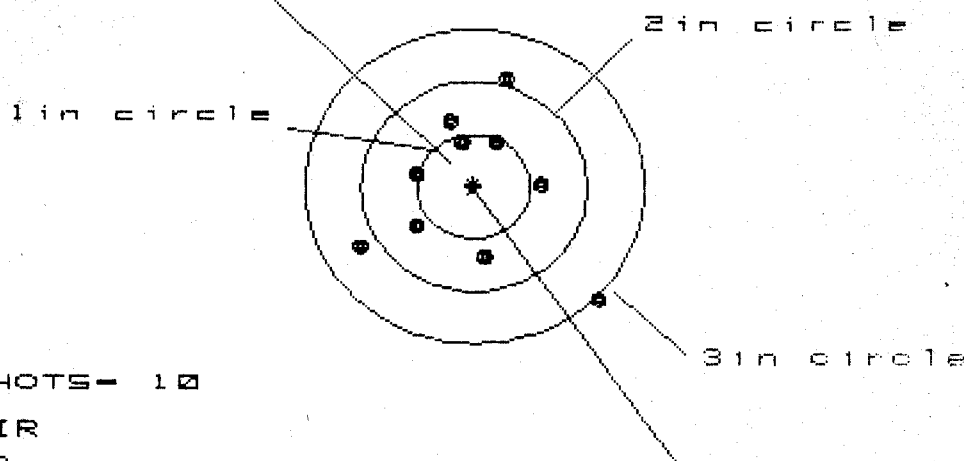
PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.069	1.134	.646
MINIMUM X	:	-.779	-.714	-.573
MAXIMUM Y	:	.870	.724	.796
MINIMUM Y	:	-1.322	-.616	-.526
CENTROID X	:	-.107	-.172	-.313
CENTROID Y	:	-.060	.086	-.004
POA TO CENTROID in.	:	.123	.192	.313
MIN RADIUS	:	.339	.197	.190
MEAN RADIUS	:	.781	.697	.590
MAX RADIUS	:	1.442	1.345	.874
HORIZONTAL SPREAD	:	1.848	1.848	1.219
VERTICAL SPREAD	:	2.192	1.340	1.322
EXTREME SPREAD	:	2.457	1.982	1.575
NUMBER IN ONE INCH CIRCLE =	:	2		
NUMBER IN TWO INCH CIRCLE =	:	7		
NUMBER IN THREE INCH CIRCLE =	:	10		

30 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66492B0

CENTERFIRE PATTERNS # 3

POR



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 2.081

VS= 2.042

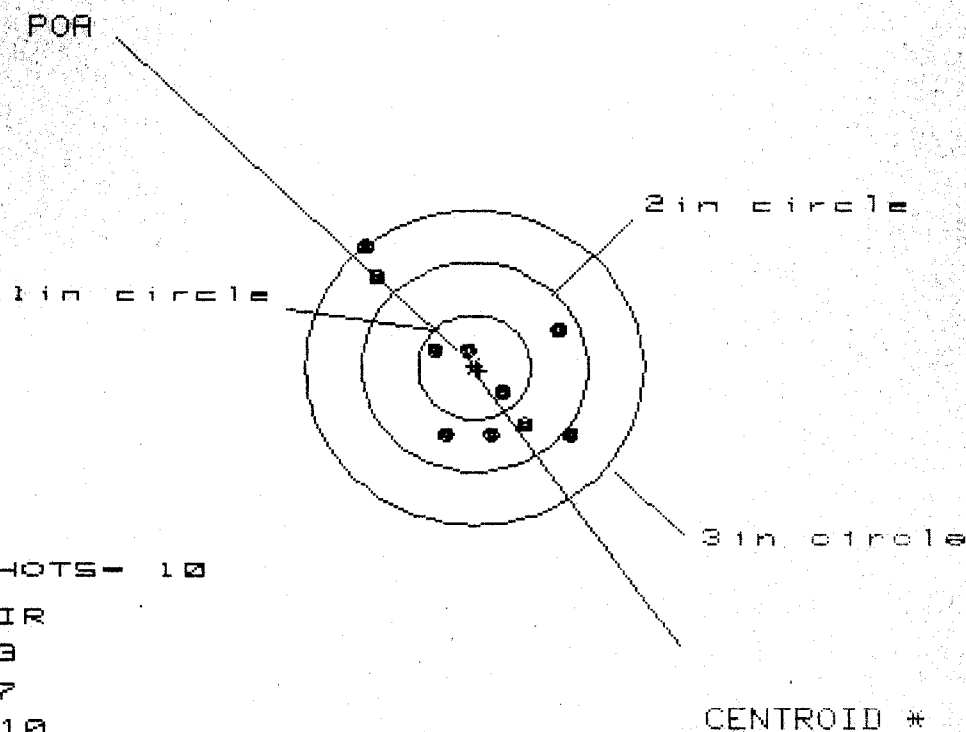
GS= 2.188

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.070	.665	.553
MINIMUM X	:	-1.011	-.892	-.502
MAXIMUM Y	:	.987	.870	.786
MINIMUM Y	:	-1.055	-.770	-.854
CENTROID X	:	.007	-.112	.000
CENTROID Y	:	-.028	.089	.173
POR TO CENTROID in.	:	.029	.143	.173
MIN RADIUS	:	.419	.286	.228
MEAN RADIUS	:	.757	.644	.564
MAX RADIUS	:	1.502	1.119	.866
HORIZONTAL SPREAD	:	2.081	1.557	1.055
VERTICAL SPREAD	:	2.042	1.640	1.640
EXTREME SPREAD	:	2.188	2.016	1.647
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	9		

30 Jul 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

HS= 1.750

VS= 1.736

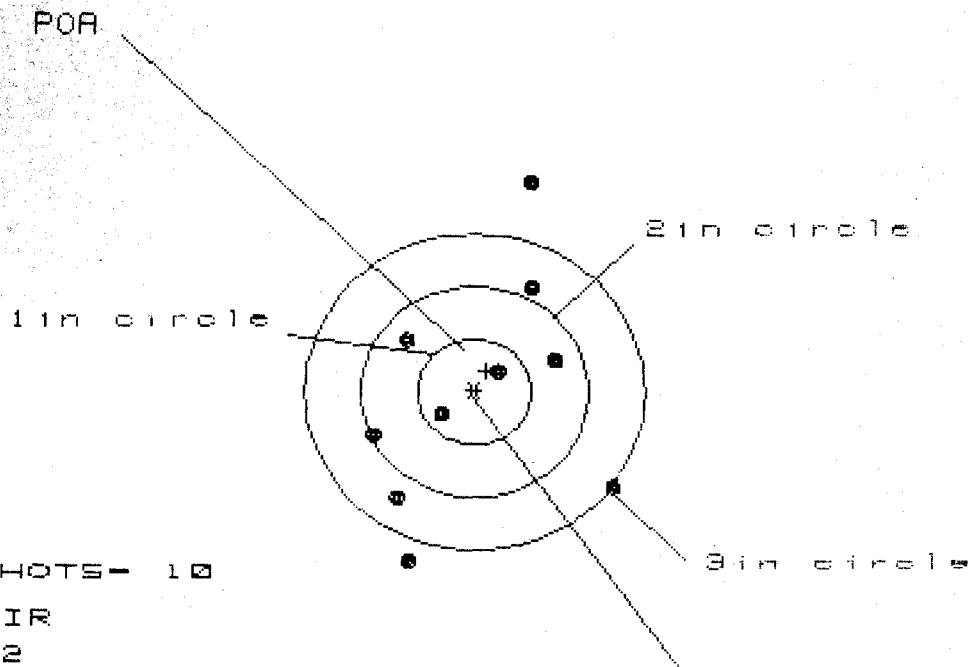
GS= 2.464

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.808	.703	.587
MINIMUM X	:	-.942	-.933	-.548
MAXIMUM Y	:	1.117	1.024	.617
MINIMUM Y	:	-.619	-.495	-.367
CENTROID X	:	-.044	.061	.177
CENTROID Y	:	.041	-.084	-.212
POA TO CENTROID in.	:	.060	.103	.276
MIN RADIUS	:	.159	.162	.035
MEAN RADIUS	:	.737	.630	.503
MAX RADIUS	:	1.461	1.385	.812
HORIZONTAL SPREAD	:	1.750	1.636	1.135
VERTICAL SPREAD	:	1.736	1.519	.984
EXTREME SPREAD	:	2.464	2.232	1.381
NUMBER IN ONE INCH CIRCLE =		3		
NUMBER IN TWO INCH CIRCLE =		7		
NUMBER IN THREE INCH CIRCLE =		10		

30 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649260

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 7

HS= 2.107

VS= 3.530

GS= 3.691

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.186	1.240	1.173
MINIMUM X	:	-.921	-.867	-.934
MAXIMUM Y	:	1.975	1.264	1.097
MINIMUM Y	:	-1.555	-1.335	-.903
CENTROID X	:	-.108	-.162	-.095
CENTROID Y	:	-.196	-.416	-.249
POA TO CENTROID in.	:	.224	.446	.266
MIN RADIUS	:	.289	.252	.322
MEAN RADIUS	:	1.089	.979	.903
MAX RADIUS	:	2.035	1.438	1.472
HORIZONTAL SPREAD	:	2.107	2.107	2.107
VERTICAL SPREAD	:	3.530	2.599	2.000
EXTREME SPREAD	:	3.691	2.826	2.363
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	