

C6611437

MODEL 700™ M24

Model SWS™

Action

Barrel Length

Capacity

Order No. 5715

* Includes 1 in chamber.

Remington

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C6611437

DATE 7/19/96

TESTER SF

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.68	2.55		2.81	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.78	2.78		2.87	
PULL #3	2.70	2.61		2.79	
PULL #4	2.68	2.49		2.94	
PULL #5	2.70	2.72		3.00	
TOTAL	13.54	13.15		14.41	
AVG.	2.708	2.63		2.88	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.26	3.45		
PULL #2	3.47	3.36		
PULL #3	3.32	3.47		
PULL #4	3.22	3.29		
PULL #5	3.28	3.47		
TOTAL	16.55	17.04		
AVG.	3.31	3.408		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.58	4.42		4.62
PULL #2	4.61	4.45		4.46
PULL #3	4.54	4.58		4.55
PULL #4	4.47	4.40		4.54
PULL #5	4.45	4.45		4.52
TOTAL	22.65	22.3		22.69
AVG.	4.53	4.46		4.538

op. #	OP. NAME	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	4.5	4.5	5	8/2	SF		
	G) Safety Off Force	4.5	4	4.25	8/2	SF		
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent	.022	.0215	.0215	8/2	SF		
	J) Assemble Stock							
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies							
	M) Iron Sight Alignment							
	N) Detach Front & Rear Sights & place in numbered container							
	O) Attach Scope to Rifle							
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test							
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection							
	A) Headspace							
	B) Trigger Pull	244	249	253	250	248	8/2	SF
	C) Function							
660	Pack							

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock			
600	Proof			
607	Check Headspace			
610	Dis-assemble Gun			
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake			

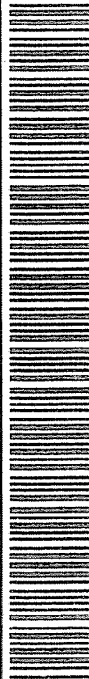
Remington[®] **DUPONT**
REG. U.S. PAT. & TM. OFF.

MODEL 700TM H24

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

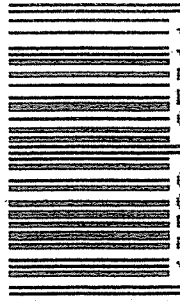
VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.

SERIAL NO. C6611437	ORDER NO. 5716
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5716 C6611437

UPC



0 47700 25716 7

Redo

Trigger Pull

OK

word test
OK

5-20-91

D/H

GUN SERIAL # **C6611437**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/18/91	K.S.
600	Proof		3/18/91	K.S.
607	Check Headspace		3/18/91	K.S.
610	Dis-assemble Gun		3/18/91	K.S.
612	Magnaflux Barrel Action		3/28/91	KR
	Magnaflux Bolt		11	KR
615	Rollmark Caliber		11	GB
617	Drill and Tap Sight Holes		APR 3 1991	WB
618	Polish Barrel		APR 3 1991	WB
620	Apply Coatings (Barrel Action)		4-19-91	AK
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/24/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/24/91	KS
	C) Inspect Ejector Hole for Chamfer		4/24/91	KS
	D) Oil Firing Pin Ass'y		4/24/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		4/25/91	AK

op. #	OP. NAME	READINGS			DATE	INIT
625 cont.	F) Safety On Force	5	5	5	4/29/90	JM
	G) Safety Off Force	3	3	3	4/29/90	AP
	H) Trigger Pull Test & Retainability				4/25/91	90
	I) Firing Pin Indent	.023	.023	.0225	4/29/91	90
	J) Assemble Stock				4/29/91	KS
	K) Assemble Swivel Studs				5-20-91	A
	L) Attach Front and Rear Sight Assemblies				4/29/91	KS
	M) Iron Sight Alignment				4/29/91	KS
	N) Detach Front & Rear Sights & place in numbered container				4/29/91	KS
	O) Attach Scope to Rifle				4/29/91	KS
	P) Detach & Attach Scope 20 Times				4/29/91	KS
640	Gallery Target & Test				4-29-91	NF
	A) Time				"	NF
	B) Malfunctions				"	NF
	C) Pierced Primers				"	NF
	D) Optical Clarity of Scope				"	NF
645	Inspect for Live Ammo				4-29-91	NF
655	Final Inspection					
	A) Headspace				5-20-91	A
	B) Trigger Pull	2.37	2.31	2.24	5/10/91	90
	C) Function	2.43	2.40	2.20	5/20/91	90
660	Pack				6-17-91	NF

bad Creep in trigger
Replaced fire control with
good fire control that was
sent back

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO C-66114-37

DATE 5/20/91

TESTER JM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.37	2.41	2.36	2.43	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.25	2.41	2.28	2.40	
PULL #3	2.42	2.21	2.25	2.20	
PULL #4	2.47	2.35	2.26	2.20	
PULL #5	2.41	2.47	2.23	2.23	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.18	3.11		
PULL #2	3.22	3.16		
PULL #3	3.20	3.34		
PULL #4	3.28	3.37		
PULL #5	3.24	3.38		
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	4.15		4.41
PULL #2	4.49	4.13		4.46
PULL #3	4.46	4.30		4.45
PULL #4	4.48	4.38		4.43
PULL #5	4.50	4.33		4.38
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611437
29 Apr 1991

CENTROIDAL DISTANCES

0 TO 1	.163248
1 TO 2	.306888
1 TO 3	.133304
1 TO 4	.272611
1 TO 5	.170003

513
27 <----PDR

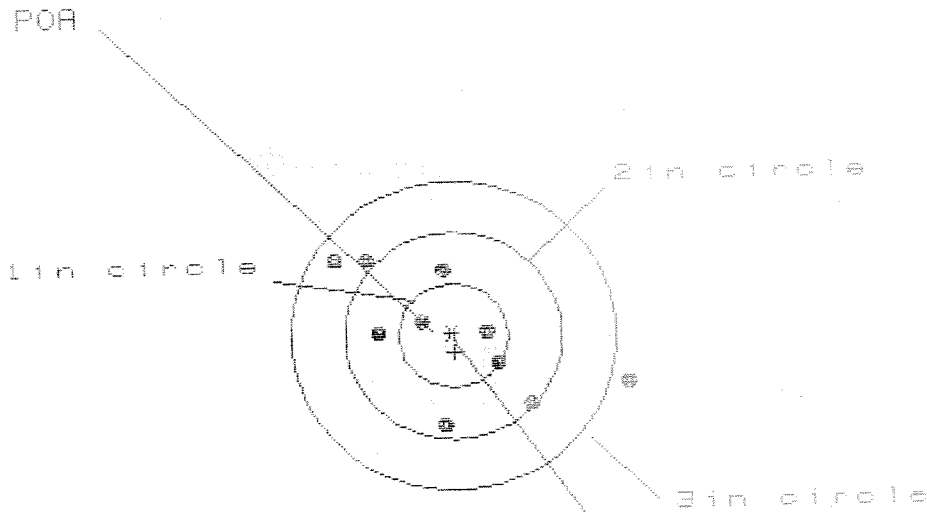
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0178
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0526
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0555302
THE AMP FOR THIS RIFLE IS: .7456

29 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B11437

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 2.665

VS= 1.616

GS= 2.907

CENTROID *

PATTERN #

I

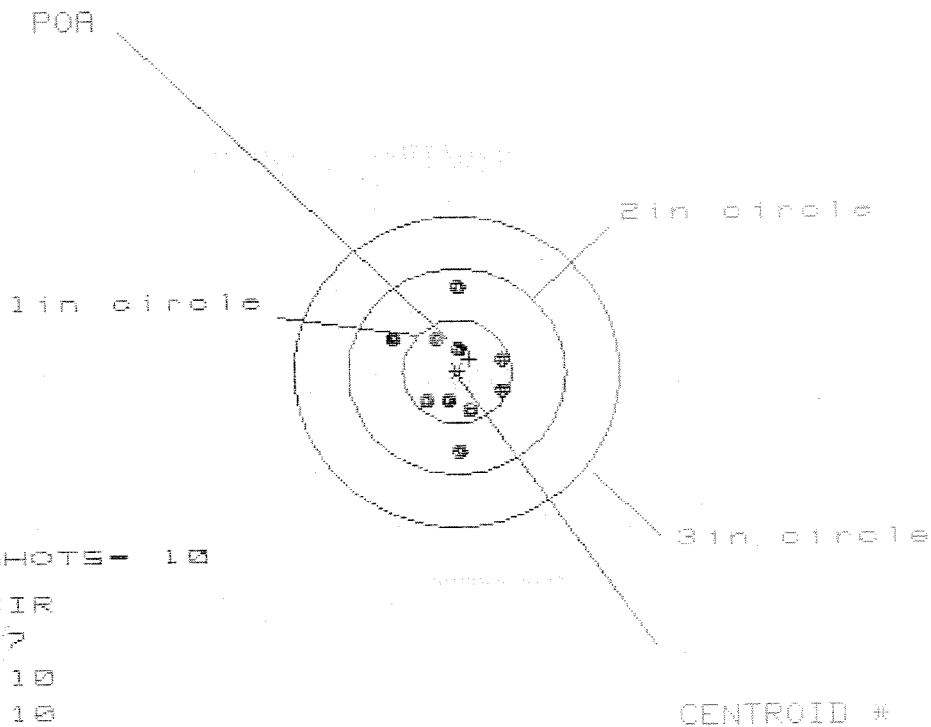
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.588	.855	.743
MINIMUM X	-1.077	-.901	-.767
MAXIMUM Y	.758	.711	.797
MINIMUM Y	-.858	-.905	-.819
CENTROID X	-.009	-.185	-.073
CENTROID Y	.163	.210	.124
POA TO CENTROID in.	.163	.280	.143
MIN RADIUS	.303	.124	.265
MEAN RADIUS	.842	.734	.684
MAX RADIUS	1.643	1.141	1.107
HORIZONTAL SPREAD	2.665	1.756	1.510
VERTICAL SPREAD	1.616	1.616	1.616
EXTREME SPREAD	2.907	2.275	2.105
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

29 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611437

CENTERFIRE PATTERNS

2



OF SHOTS- 10

IN CIR

1in = 7

2in = 10

3in = 10

HS= .981

VS= 1.637

GS= 1.637

PATTERN #

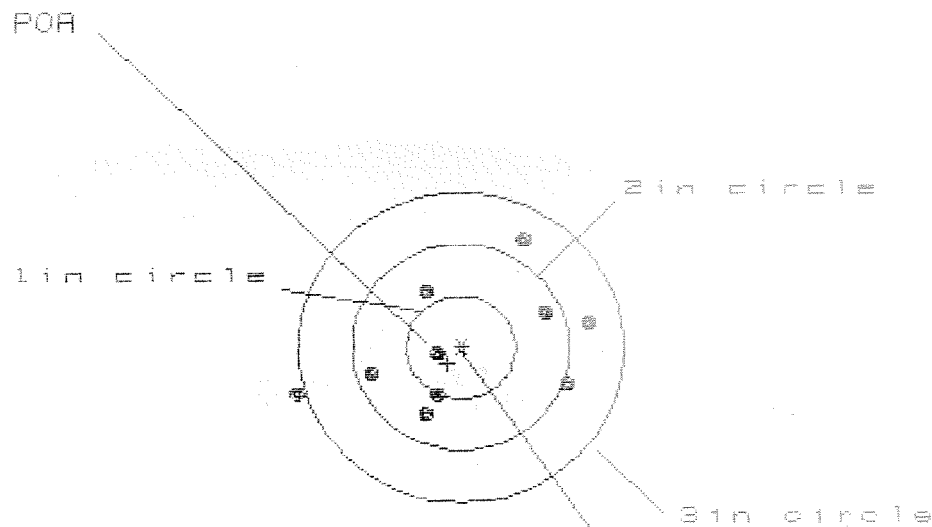
2

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.435	.437	.442
MINIMUM X	-.546	-.544	-.539
MAXIMUM Y	.822	.455	.365
MINIMUM Y	-.815	-.724	-.333
CENTROID X	-.115	-.117	-.122
CENTROID Y	-.125	-.216	-.126
POA TO CENTROID in.	.170	.246	.176
MIN RADIUS	.242	.211	.245
MEAN RADIUS	.493	.448	.412
MAX RADIUS	.822	.725	.639
HORIZONTAL SPREAD	.981	.981	.981
VERTICAL SPREAD	1.637	1.179	.698
EXTREME SPREAD	1.637	1.297	1.100
NUMBER IN ONE INCH CIRCLE =		7	
NUMBER IN TWO INCH CIRCLE =		10	
NUMBER IN THREE INCH CIRCLE =		10	

29 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611437

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 3

HS= 2.671

VS= 1.695

GS= 2.775

CENTROID #

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.177	1.011	.918
MINIMUM X	-1.494	-1.032	-.906
MAXIMUM Y	1.017	.961	.986
MINIMUM Y	-.678	-.734	-.709
CENTROID X	.124	.290	.164
CENTROID Y	.154	.210	.185
POA TO CENTROID in.	.198	.358	.247
MIN RADIUS	.185	.358	.229
MEAN RADIUS	.881	.814	.762
MAX RADIUS	1.575	1.064	1.185
HORIZONTAL SPREAD	2.671	2.043	1.824
VERTICAL SPREAD	1.695	1.695	1.695
EXTREME SPREAD	2.775	2.093	1.985
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

29 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611437

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.572

VS= 2.250

GS= 2.292

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.915

.898

.823

MINIMUM X

-.657

-.674

-.749

MAXIMUM Y

1.290

.610

.508

MINIMUM Y

-.960

-.817

-.911

CENTROID X

.090

.107

.182

CENTROID Y

-.091

-.234

-.132

POA TO CENTROID in.

.128

.257

.225

MIN RADIUS

.206

.330

.205

MEAN RADIUS

.743

.692

.627

MAX RADIUS

1.299

1.017

.911

HORIZONTAL SPREAD

1.572

1.572

1.572

VERTICAL SPREAD

2.250

1.427

1.419

EXTREME SPREAD

2.292

1.896

1.746

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

8

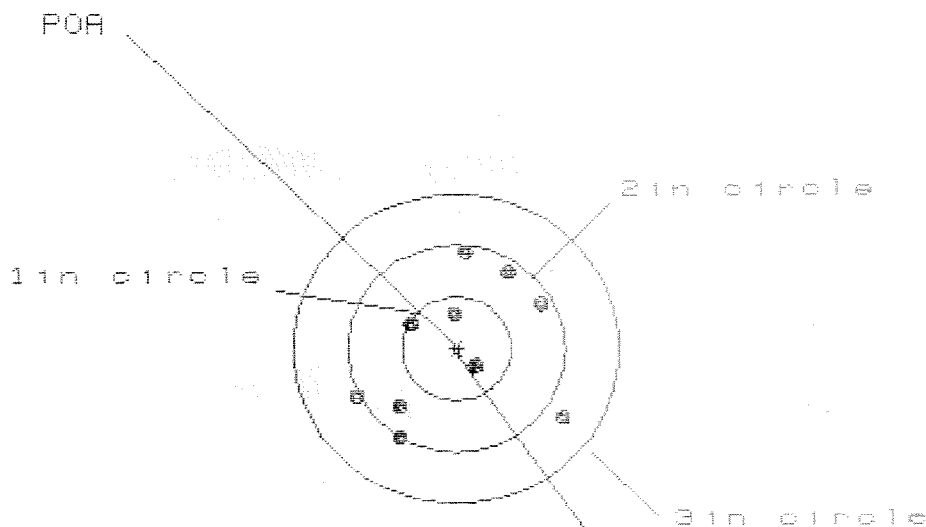
NUMBER IN THREE INCH CIRCLE =

10

29 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611437

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 1.893

VS= 1.769

GS= 1.901

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.976	.839	.738
MINIMUM X	-.917	-.808	-.558
MAXIMUM Y	.940	.867	.797
MINIMUM Y	-.829	-.902	-.972
CENTROID X	-.179	-.288	-.186
CENTROID Y	.162	.235	.305
POA TO CENTROID in.	.241	.372	.358
MIN RADIUS	.261	.238	.163
MEAN RADIUS	.769	.711	.661
MAX RADIUS	1.179	1.012	1.121
HORIZONTAL SPREAD	1.893	1.647	1.296
VERTICAL SPREAD	1.769	1.769	1.769
EXTREME SPREAD	1.901	1.895	1.895
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		