

C6611442

MODEL 700™ M24

Model **SWS**™

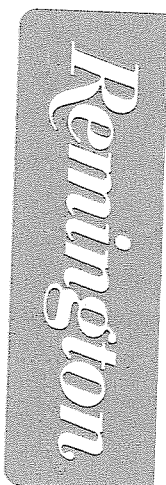
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Remington ®		DUPONT REG. U.S. PAT. & TM. OFF.	VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700™ M24		SERIAL NO. C6611442	ORDER NO. 5716
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.			



5716 C6611442



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611442

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		"	KR
615	Rollmark Caliber		"	Y.B.
617	Drill and Tap Sight Holes	APR	4 1001	LB
618	Polish Barrel	APR	3 1991	LB
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	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			4/29/91	SH
	G) Safety Off Force	3	3	3			4/29/91	SH
	H) Trigger Pull Test & Retainability						4/25/91	SH
	I) Firing Pin Indent	0235	0235	0235			4/29/91	SH
	J) Assemble Stock						4/29/91	1-S
	K) Assemble Swivel Studs						5-11-91	D/H
	L) Attach Front and Rear Sight Assemblies						4/29/91	1-S
	M) Iron Sight Alignment						4/29/91	1-S
	N) Detach Front & Rear Sights & place in numbered container						4/29/91	1-S
	O) Attach Scope to Rifle						4/29/91	1-S
	P) Detach & Attach Scope 20 Times						4/29/91	1-S
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						5-11-91	D/H
	B) Trigger Pull	256	251	256	252	257	5/11/91	SH
	C) Function						5-11-91	D/H
660	Pack						6-11-91	NF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6611472

DATE 4/25/94

TESTER JEP 11 (H)

VIII 081159H

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.55	2.56	2.40	2.56	MIN. SETTING,
PULL #2	2.21	2.49	2.38	2.57	INO. AVG. OF 5
PULL #3	2.21	2.51	2.54	2.56	READINGS ACCEPT-
PULL #4	2.41	2.48	2.50	2.52	ABLE LESS THAN 2#
PULL #5	2.36	2.57	2.50	2.57	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.48	3.35		
PULL #2	3.59	3.66		
PULL #3	3.60	3.57		
PULL #4	3.54	3.60		
PULL #5	3.54	3.43		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.17	4.30		4.33
PULL #2	4.25	4.18		4.33
PULL #3	4.22	4.30		4.28
PULL #4	4.24	4.29		4.35
PULL #5	4.15	4.30		4.23
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611442
29 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.300533
1 TO	2	.22642
1 TO	3	.199484
1 TO	4	.171747
1 TO	5	.307313

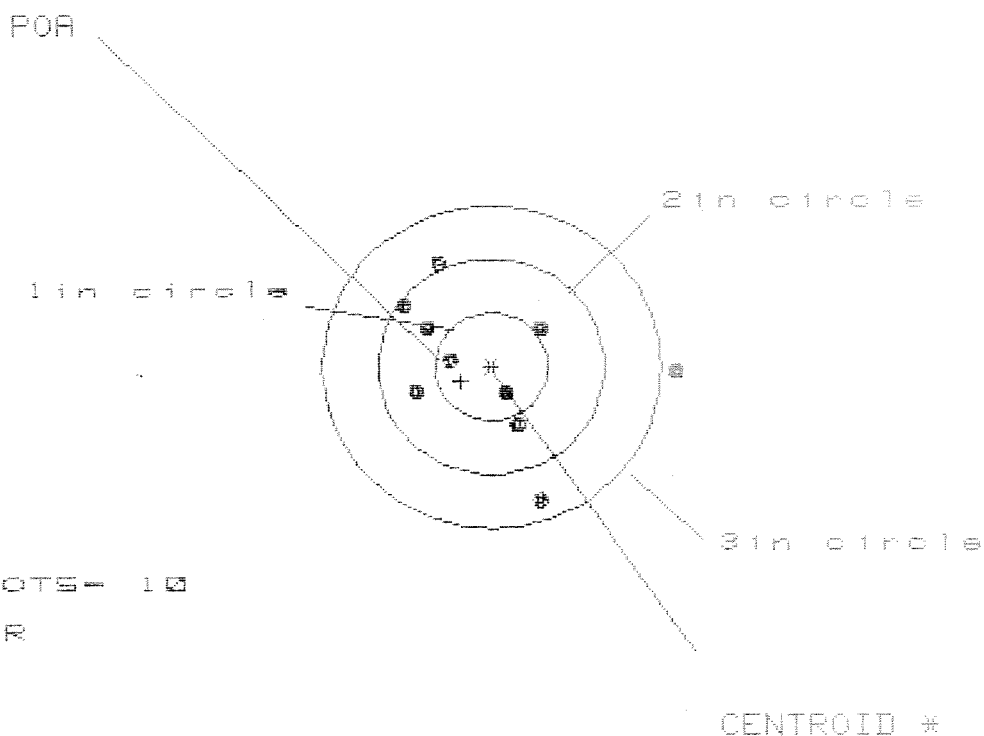
50 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1026
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0986
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .142298
THE AMR FOR THIS RIFLE IS: .8488

29 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B11442

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 9

HS = 2.468

VS = 2.174

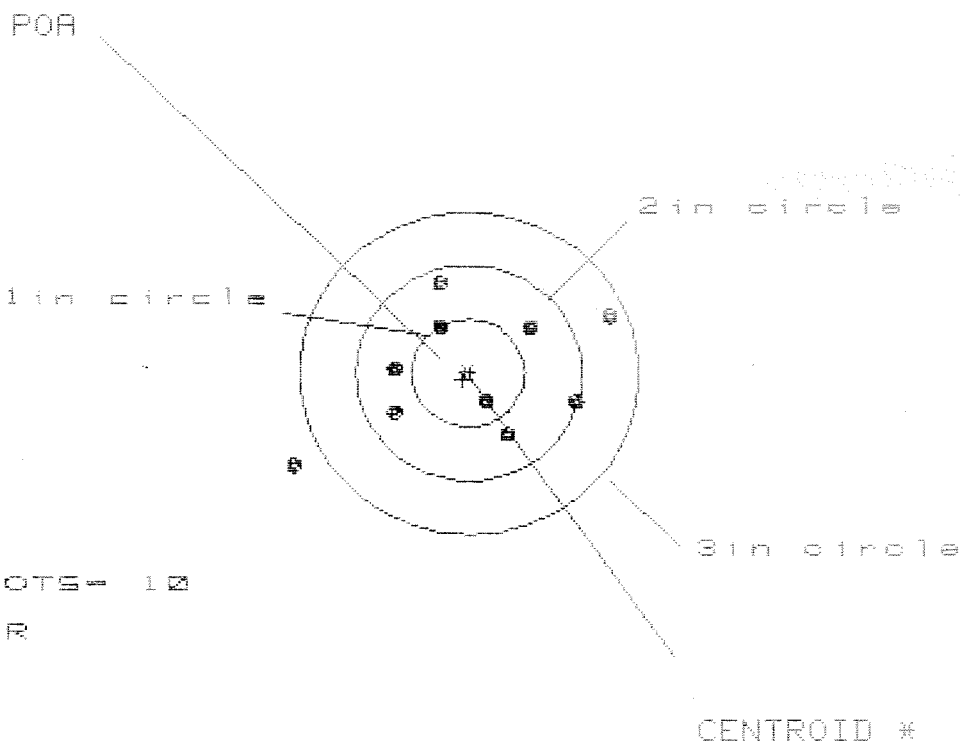
GS = 2.523

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.663	.640	.668
MINIMUM X	:	-.804	-.620	-.540
MAXIMUM Y	:	.980	.981	.832
MINIMUM Y	:	-1.194	-1.193	-.726
CENTROID X	:	.268	.084	.084
CENTROID Y	:	.136	.135	.284
POA TO CENTROID in.	:	.301	.159	.284
MIN RADIUS	:	.214	.172	.156
MEAN RADIUS	:	.805	.679	.579
MAX RADIUS	:	1.664	1.354	.868
HORIZONTAL SPREAD	:	2.468	1.260	1.208
VERTICAL SPREAD	:	2.174	2.174	1.558
EXTREME SPREAD	:	2.523	2.369	1.706
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 1

2in = 8

3in = 9

HS = 2.802

VS = 1.657

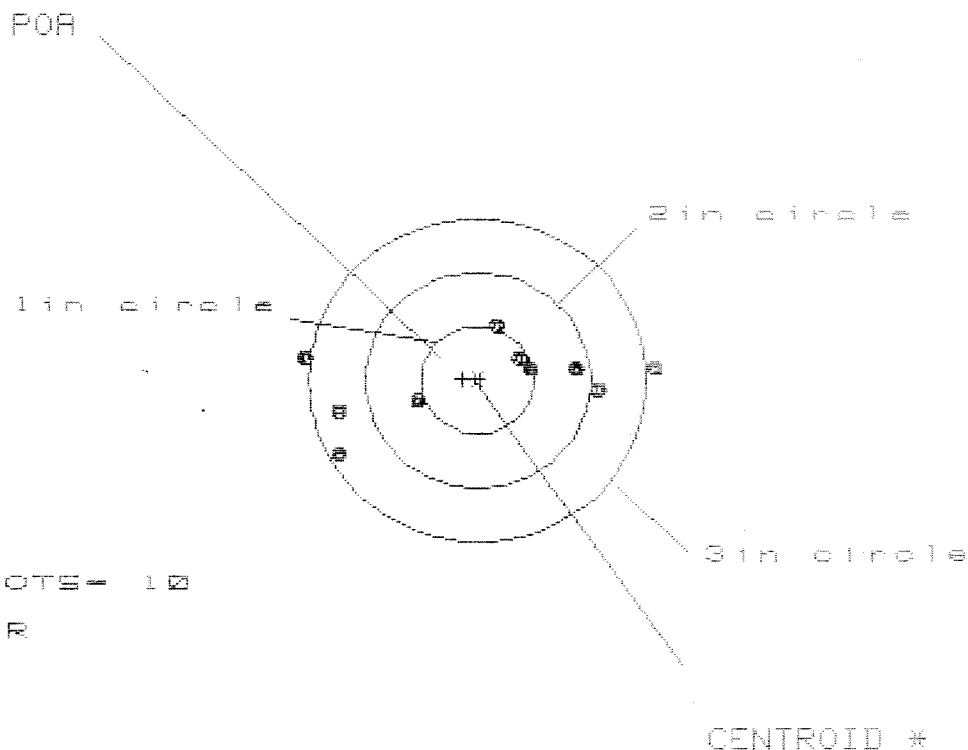
GS = 3.139

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.291	1.123	.937
MINIMUM X	:	-1.511	-.862	-.722
MAXIMUM Y	:	.816	.722	.783
MINIMUM Y	:	-.841	-.705	-.644
CENTROID X	:	.053	.221	.081
CENTROID Y	:	.065	.159	.098
POA TO CENTROID in.	:	.084	.272	.127
MIN RADIUS	:	.310	.366	.328
MEAN RADIUS	:	.861	.758	.684
MAX RADIUS	:	1.730	1.222	.975
HORIZONTAL SPREAD	:	2.802	1.985	1.659
VERTICAL SPREAD	:	1.657	1.427	1.427
EXTREME SPREAD	:	3.139	2.106	1.678
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS = 3.183

VS = 1.239

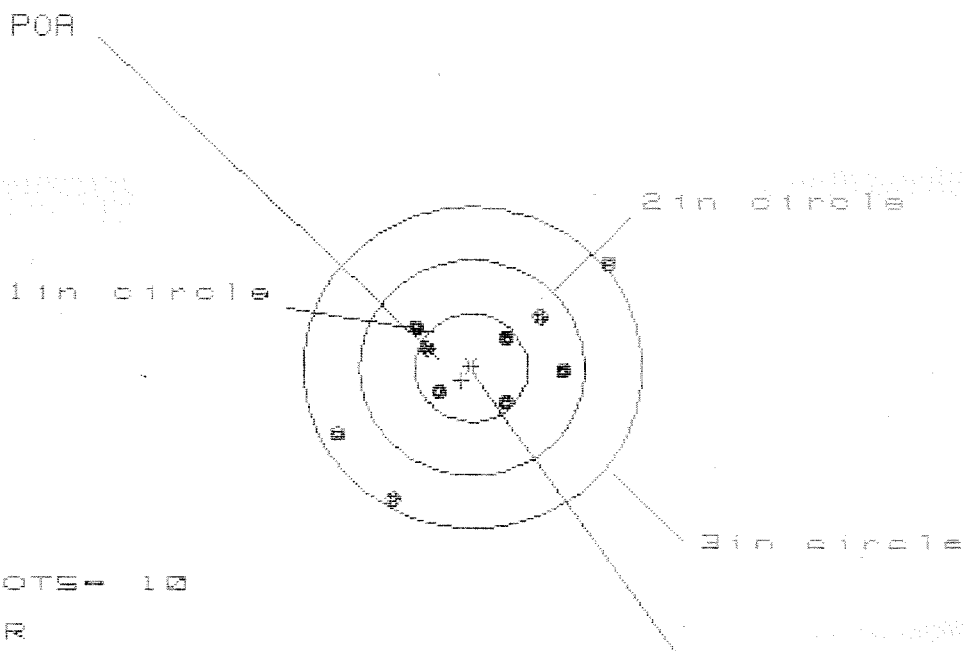
GS = 3.183

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.611	1.261	1.087
MINIMUM X	:	-1.572	-1.393	-1.229
MAXIMUM Y	:	.513	.531	.559
MINIMUM Y	:	-.726	-.708	-.680
CENTROID X	:	.131	-.048	.126
CENTROID Y	:	-.009	-.026	-.054
POA TO CENTROID in.	:	.131	.054	.137
MIN RADIUS	:	.448	.411	.467
MEAN RADIUS	:	.987	.930	.839
MAX RADIUS	:	1.618	1.411	1.378
HORIZONTAL SPREAD	:	3.183	2.654	2.316
VERTICAL SPREAD	:	1.239	1.239	1.239
EXTREME SPREAD	:	3.183	2.673	2.366
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 4

2in = 7

3in = 9

HS = 2.336

VS = 2.167

GS = 2.875

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.179	.906	.833
MINIMUM X	:	-1.157	-1.025	-1.098
MAXIMUM Y	:	.975	.628	.492
MINIMUM Y	:	-1.192	-1.083	-.668
CENTROID X	:	.097	-.035	.038
CENTROID Y	:	.120	.011	.147
POA TO CENTROID in.	:	.154	.036	.151
MIN RADIUS	:	.360	.235	.372
MEAN RADIUS	:	.810	.726	.646
MAX RADIUS	:	1.531	1.228	1.285
HORIZONTAL SPREAD	:	2.336	1.931	1.931
VERTICAL SPREAD	:	2.167	1.711	1.160
EXTREME SPREAD	:	2.875	2.177	2.136
NUMBER IN ONE INCH CIRCLE =			4	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			9	

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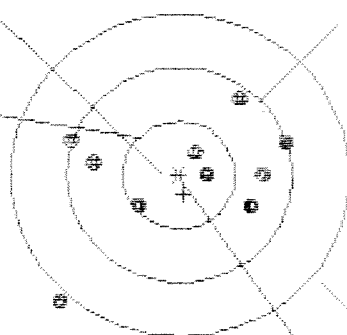
CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 8

3 in = 9

HS= 1.992

VS= 1.915

GS= 2.516

CENTROID #

PATTERN #

5

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.933	.815	.676
MINIMUM X	:	-1.059	-1.115	-1.063
MAXIMUM Y	:	.722	.589	.618
MINIMUM Y	:	-1.194	-.450	-.421
CENTROID X	:	-.036	.082	.221
CENTROID Y	:	.181	.313	.284
POA TO CENTROID in.	:	.184	.324	.360
MIN RADIUS	:	.268	.098	.126
MEAN RADIUS	:	.781	.654	.564
MAX RADIUS	:	1.596	1.138	1.063
HORIZONTAL SPREAD	:	1.992	1.930	1.739
VERTICAL SPREAD	:	1.915	1.039	1.039
EXTREME SPREAD	:	2.516	1.930	1.757
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	