

C6611481

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington

Remington® **DU PONT**
REG. U.S. PAT. & TM. OFF.

MODEL 700™ H24

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

SERIAL NO.
 C6611481

ORDER NO.
5716

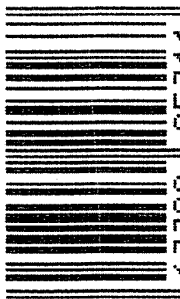
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

20



5716 C6611481

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611481

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 28	91	RW
600	Proof	3 28	91	RW
607	Check Headspace	3 28	91	RW
610	Dis-assemble Gun	3 28	91	RW
612	Magnaflux Barrel Action	APR	2 1991	KR
	Magnaflux Bolt	APR	2 1991	LI
615	Rollmark Caliber	APR	3 1991	YB
617	Drill and Tap Sight Holes	APR	5 1991	LB
618	Polish Barrel	APR	5 1991	WB
620	Apply Coatings (Barrel Action)		4-9-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/10/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/10/91	RW
	C) Inspect Ejector Hole for Chamfer		4/10/91	RW
	D) Oil Firing Pin Ass'y		4/10/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4/22/91	JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			4-22-91	DH
	G) Safety Off Force	4	4	4			4-22-91	DH
	H) Trigger Pull Test & Retainability						4/22/91	XH
	I) Firing Pin Indent	.021	.022	.022			4-22-91	DH
	J) Assemble Stock						4/30/91	RW
	K) Assemble Swivel Studs						5-1-91	DH
	L) Attach Front and Rear Sight Assemblies						4/30/91	RW
	M) Iron Sight Alignment						4/30/91	RW
	N) Detach Front & Rear Sights & place in numbered container						4/30/91	RW
	O) Attach Scope to Rifle						4/30/91	RW
	P) Detach & Attach Scope 20 Times						4/30/91	RW
640	Gallery Target & Test						4/30/91	KT
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	KT
645	Inspect for Live Ammo						4/30/91	KT
655	Final Inspection							
	A) Headspace						5-1-91	DH
	B) Trigger Pull	2.49	2.30	2.27	2.18	2.28	5/10/91	XH
	C) Function						5-1-91	DH
660	Pack						6-18-91	RE

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6611481

DATE 4/22/91

TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.28	2.50	2.30	2.49	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.38	2.38	2.37	2.30	
PULL #3	2.34	2.51	2.35	2.27	
PULL #4	2.42	2.51	2.34	2.18	
PULL #5	2.44	2.56	2.34	2.28	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.40	3.29		
PULL #2	3.36	3.42		
PULL #3	3.60	3.57		
PULL #4	3.63	3.55		
PULL #5	3.60	3.60		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.20	4.12		4.28
PULL #2	4.37	4.28		4.38
PULL #3	4.17	4.18		4.28
PULL #4	4.27	4.20		4.25
PULL #5	4.25	4.16		4.35
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611481
30 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.16483
1 TO	2	.274171
1 TO	3	.17818
1 TO	4	.216393
1 TO	5	.0989798

45 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0168
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.144
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .144977

THE AMR FOR THIS RIFLE IS: .9996

30 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611481

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 2.346

VS= 2.280

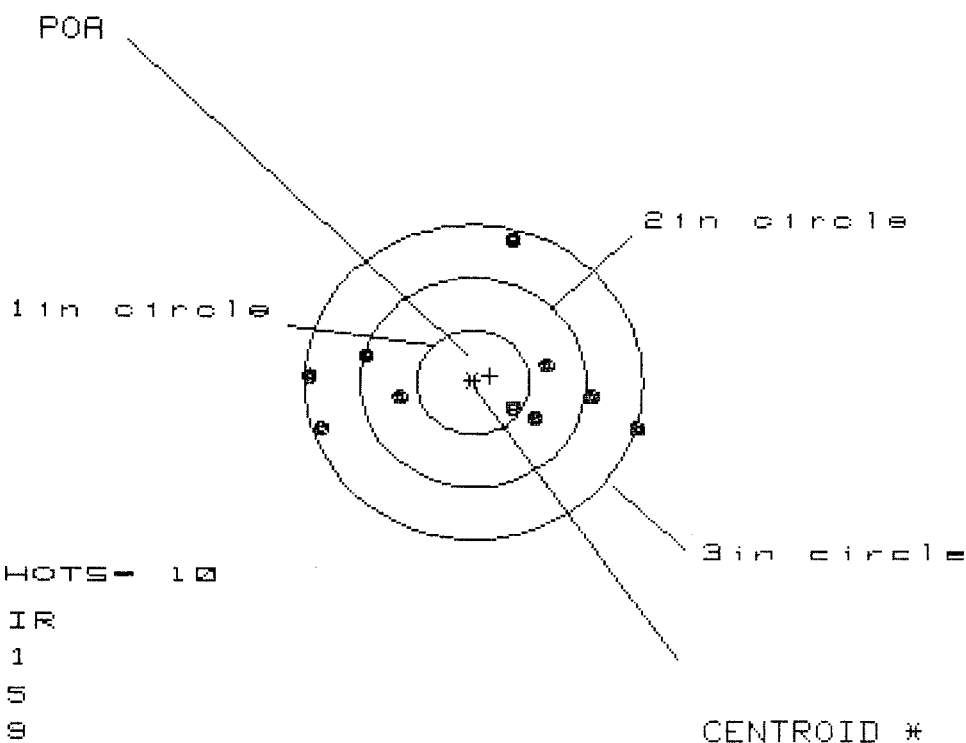
GS= 2.760

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.220	1.123	.723
MINIMUM X	:	-1.126	-1.223	-1.083
MAXIMUM Y	:	1.488	1.130	1.138
MINIMUM Y	:	-.792	-.626	-.618
CENTROID X	:	.120	.217	.076
CENTROID Y	:	-.113	-.279	-.287
POA TO CENTROID in.	:	.165	.353	.297
MIN RADIUS	:	.282	.097	.170
MEAN RADIUS	:	.916	.787	.750
MAX RADIUS	:	1.727	1.238	1.186
HORIZONTAL SPREAD	:	2.346	2.346	1.805
VERTICAL SPREAD	:	2.280	1.756	1.756
EXTREME SPREAD	:	2.760	2.361	1.936
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

30 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611481

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in - 1

2in - 5

3in = 9

HS- 2.874

VS= 1.804

GS= 2.918

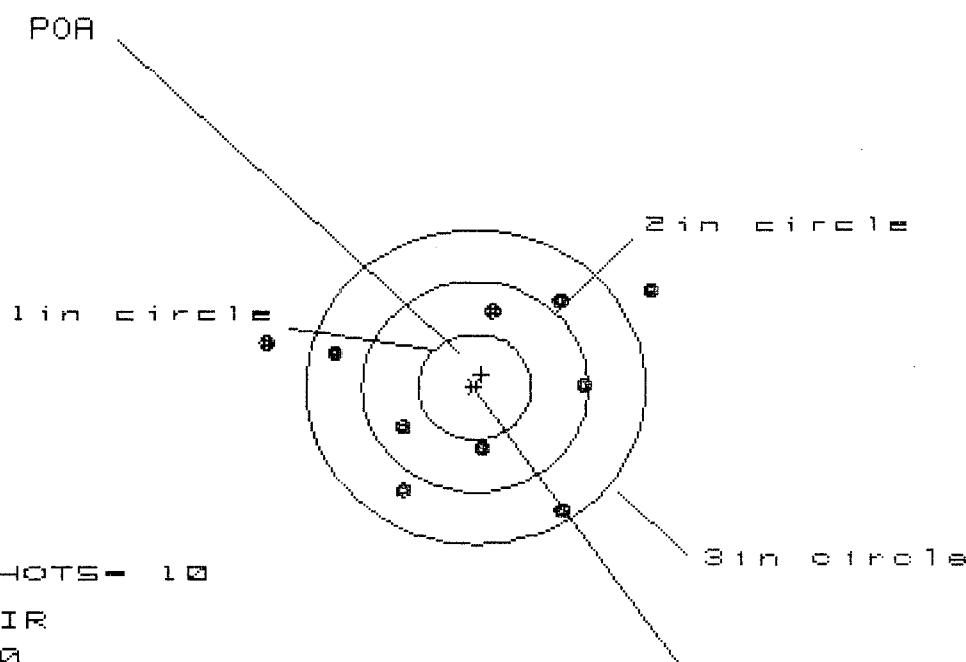
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.450	1.231	1.074
MINIMUM X	:	-1.424	-1.263	-1.313
MAXIMUM Y	:	1.328	1.275	1.272
MINIMUM Y	:	-.476	-.489	-.492
CENTROID X	:	-.149	-.310	-.153
CENTROID Y	:	-.060	-.007	-.004
POA TO CENTROID in.	:	.161	.311	.153
MIN RADIUS	:	.427	.573	.463
MEAN RADIUS	:	1.022	.970	.912
MAX RADIUS	:	1.526	1.357	1.402
HORIZONTAL SPREAD	:	2.874	2.494	2.387
VERTICAL SPREAD	:	1.804	1.764	1.764
EXTREME SPREAD	:	2.918	2.503	2.401
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

30 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611461

CENTERFIRE PATTERNS

3



OF SHOTS- 10

IN CIR

1 in - 0

2 in - 4

3 in - 8

HS- 3.411

VS= 2.129

GS= 3.457

CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.586	1.384	.945
MINIMUM X	:	-1.825	-1.436	-1.264
MAXIMUM Y	:	.957	1.000	.963
MINIMUM Y	:	-1.172	-1.129	-1.004
CENTROID X	:	-.058	.144	-.029
CENTROID Y	:	-.121	-.164	-.289
POA TO CENTROID in.	:	.134	.219	.291
MIN RADIUS	:	.605	.586	.436
MEAN RADIUS	:	1.159	1.068	.964
MAX RADIUS	:	1.867	1.707	1.342
HORIZONTAL SPREAD	:	3.411	2.820	2.208
VERTICAL SPREAD	:	2.129	2.129	1.967
EXTREME SPREAD	:	3.457	2.916	2.453
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

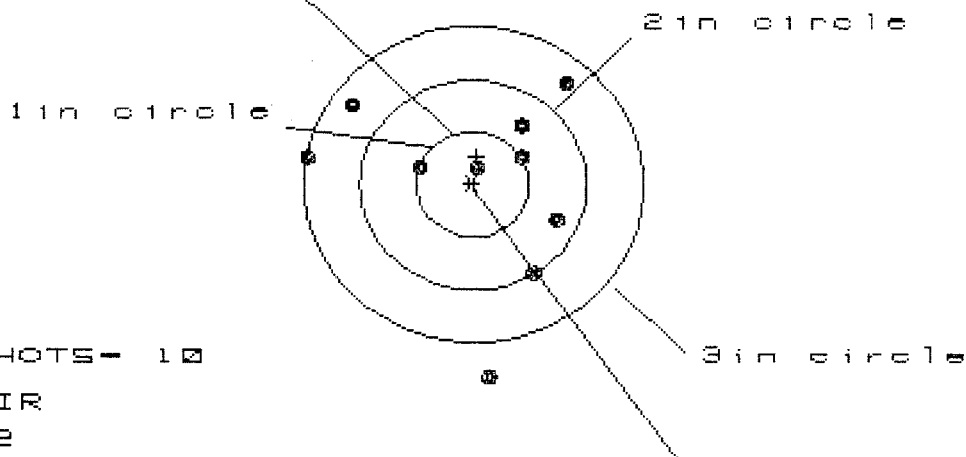
30 Apr 1991

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CENTERFIRE PATTERNS

4

POA



OF SHOTS - 10

IN CIR

1in = 2

2in = 6

3in = 8

HS = 2.352

VS = 2.786

GS = 2.882

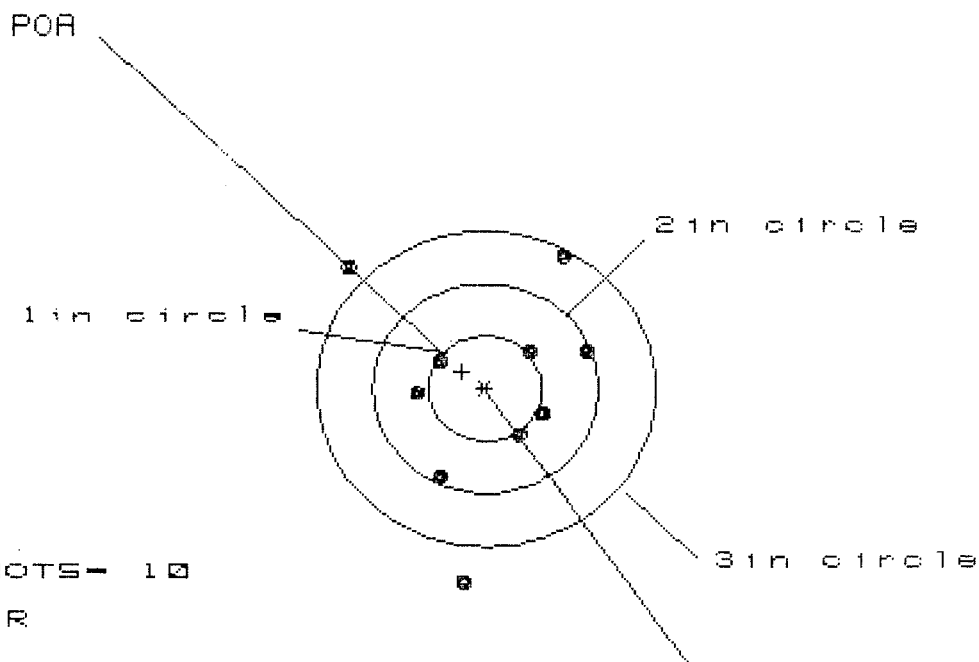
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.854	.868	.682
MINIMUM X	:	-1.498	-1.484	-1.279
MAXIMUM Y	:	.950	.746	.750
MINIMUM Y	:	-1.836	-1.075	-1.071
CENTROID X	:	-.035	-.049	.137
CENTROID Y	:	-.264	-.060	-.064
POA TO CENTROID in.	:	.267	.078	.151
MIN RADIUS	:	.199	.032	.154
MEAN RADIUS	:	.959	.821	.716
MAX RADIUS	:	1.839	1.485	1.393
HORIZONTAL SPREAD	:	2.352	2.352	1.961
VERTICAL SPREAD	:	2.786	1.821	1.821
EXTREME SPREAD	:	2.882	2.458	2.274
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

30 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611481

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 8

HS= 2.092

VS= 3.076

GS= 3.216

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.933	.906	.757
MINIMUM X	-1.159	-1.186	-.777
MAXIMUM Y	1.285	1.086	1.207
MINIMUM Y	-1.791	-.990	-.869
CENTROID X	.206	.233	.382
CENTROID Y	-.162	.037	-.084
POA TO CENTROID in.	.262	.236	.391
MIN RADIUS	.421	.382	.345
MEAN RADIUS	.942	.845	.731
MAX RADIUS	1.808	1.535	1.313
HORIZONTAL SPREAD	2.092	2.092	1.534
VERTICAL SPREAD	3.076	2.076	2.076
EXTREME SPREAD	3.216	2.338	2.338
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		