

C6611485

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Smead

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

MODEL 700™ H24

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

SERIAL NO.
 C6611485

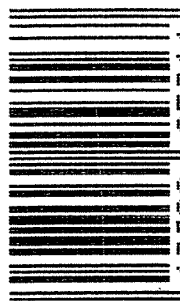
ORDER NO.
 5716

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



5716 C6611485

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611485

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		3/23/91	KR
	Magnaflux Bolt		11	KR
615	Rollmark Caliber		11	GL
617	Drill and Tap Sight Holes	APR	3 1991	LB
618	Polish Barrel	APR	3 1991	WB
620	Apply Coatings (Barrel Action)		4/19/91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/30/91	K.S.
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/30/91	K.S.
	C) Inspect Ejector Hole for Chamfer		4/30/91	K.S.
	D) Oil Firing Pin Ass'y		4/30/91	K.S.
	E) Adjust Trigger Pull to Min Setting and Stake		5/3/91	GL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5/4/91	JK
	G) Safety Off Force	4	4	4			5/4/91	JK
	H) Trigger Pull Test & Retainability						5/3/91	JK
	I) Firing Pin Indent	.0225	.022	.022			5/4/91	JK
	J) Assemble Stock						5/4/91	KS
	K) Assemble Swivel Studs						5-10-91	AC
	L) Attach Front and Rear Sight Assemblies						5/6/91	KS
	M) Iron Sight Alignment						5/6/91	KS
	N) Detach Front & Rear Sights & place in numbered container						5/4/91	KS
	O) Attach Scope to Rifle						5/4/91	KS
	P) Detach & Attach Scope 20 Times						5/6/91	KS
640	Gallery Target & Test						5-7-91	DH
	A) Time						5-7-91	DH
	B) Malfunctions						5-7-91	DH
	C) Pierced Primers						5-7-91	DH
	D) Optical Clarity of Scope						5-7-91	DH
645	Inspect for Live Ammo						5-7-91	DH
655	Final Inspection							
	A) Headspace						5-10-91	AC
	B) Trigger Pull	2.56	2.55	2.58	2.60	2.61	5/9/91	JK
	C) Function						5-10-91	AC
660	Pack						6-17-91	DH

SWS TRIGGER PULL TEST

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

SERIAL NO. C6611485

DATE 5/3/91 (P)

TESTER [Signature] (b)

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS (I)
PULL #1	2.54	2.46	2.50	2.56	MTN. SETTING,
PULL #2	2.48	2.51	2.54	2.55	NO AVG. OF 5
PULL #3	2.51	2.51	2.52	2.58	READINGS ACCEPT-
PULL #4	2.50	2.54	2.48	2.60	ABLE LESS THAN 2#
PULL #5	2.47	2.51	2.52	2.61	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES			COMMENTS
PULL #1	3.45	3.50			
PULL #2	3.50	3.53			
PULL #3	3.36	3.50			
PULL #4	3.49	3.55			
PULL #5	3.51	3.46			
TOTAL					
AVG.					

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.35		4.42
PULL #2	4.18	4.31		4.45
PULL #3	4.20	4.40		4.38
PULL #4	4.20	4.39		4.32
PULL #5	4.30	4.41		4.45
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611485
7 May 1991

CENTROIDAL DISTANCES

Ø TO	1	.153075
1 TO	2	.327794
1 TO	3	.214086
1 TO	4	.282007
1 TO	5	.505562

5
4
3
2
1 <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0702
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0984
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .120874
THE AMR FOR THIS RIFLE IS: 1.087

7 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611465

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 9

HS= 3.011

VS= 1.472

GS= 3.165

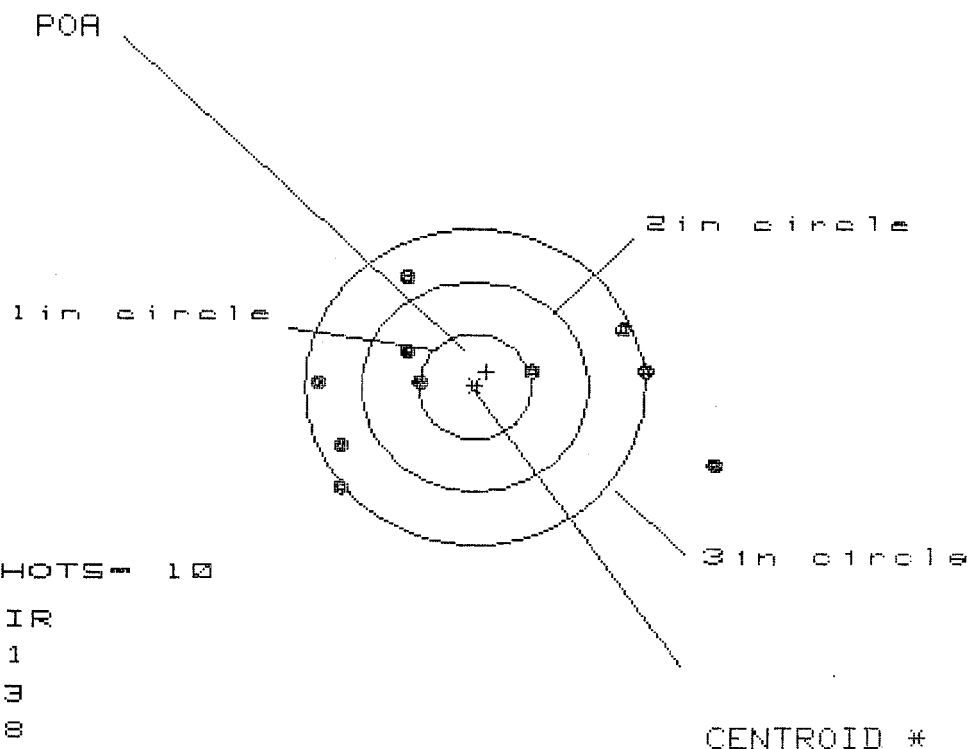
CENTROID *

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.690	.696	.555
MINIMUM X	:	-1.321	-1.134	-.835
MAXIMUM Y	:	.745	.779	.700
MINIMUM Y	:	-.727	-.693	-.772
CENTROID X	:	.137	-.050	.091
CENTROID Y	:	.074	.040	.119
POA TO CENTROID in.	:	.156	.064	.150
MIN RADIUS	:	.347	.507	.347
MEAN RADIUS	:	.869	.785	.689
MAX RADIUS	:	1.718	1.298	1.045
HORIZONTAL SPREAD	:	3.011	1.830	1.390
VERTICAL SPREAD	:	1.472	1.472	1.472
EXTREME SPREAD	:	3.165	2.086	1.869
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	9		

7 May 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in - 1

2 in - 3

3 in - 8

HS - 3.515

VS - 1.919

GS - 3.609

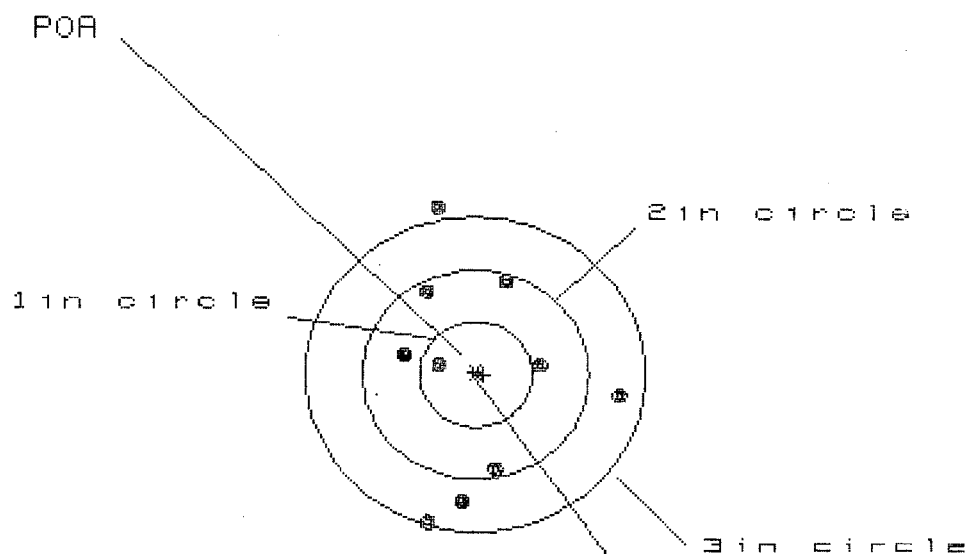
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.095	1.742	1.808
MINIMUM X	:	-1.420	-1.187	-.970
MAXIMUM Y	:	.996	.914	.919
MINIMUM Y	:	-.923	-1.005	-.999
CENTROID X	:	-.109	-.342	-.559
CENTROID Y	:	-.146	-.064	-.070
POA TO CENTROID in.	:	.182	.348	.564
MIN RADIUS	:	.496	.276	.090
MEAN RADIUS	:	1.223	1.055	.908
MAX RADIUS	:	2.221	1.742	1.873
HORIZONTAL SPREAD	:	3.515	2.929	2.778
VERTICAL SPREAD	:	1.919	1.919	1.919
EXTREME SPREAD	:	3.609	2.929	2.913
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in - 1

2in - 6

3in - 9

HS- 1.929

VS- 2.999

GS- 3.001

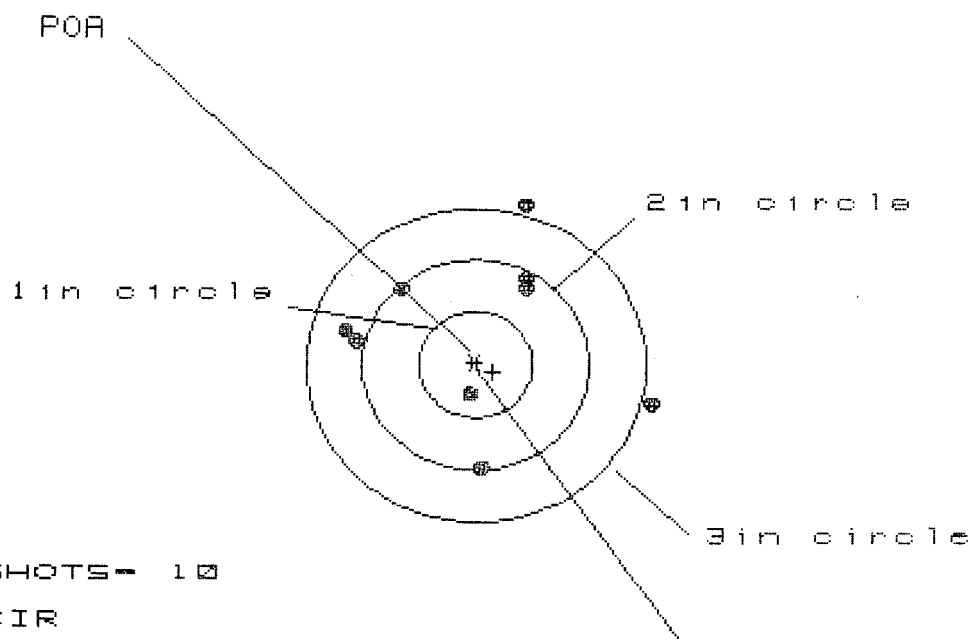
PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.271	1.237	1.181
MINIMUM X	:	-.658	-.692	-.748
MAXIMUM Y	:	1.628	1.115	.966
MINIMUM Y	:	-1.371	-1.190	-1.192
CENTROID X	:	-.069	-.035	.021
CENTROID Y	:	.006	-.175	-.026
POA TO CENTROID in.	:	.069	.178	.033
MIN RADIUS	:	.358	.483	.453
MEAN RADIUS	:	.998	.928	.866
MAX RADIUS	:	1.656	1.271	1.216
HORIZONTAL SPREAD	:	1.929	1.929	1.929
VERTICAL SPREAD	:	2.999	2.305	2.158
EXTREME SPREAD	:	3.001	2.397	2.194
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	9		

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CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1in - 1

2in - 4

3in - 7

HS- 2.650

VS= 4.219

GS= 4.255

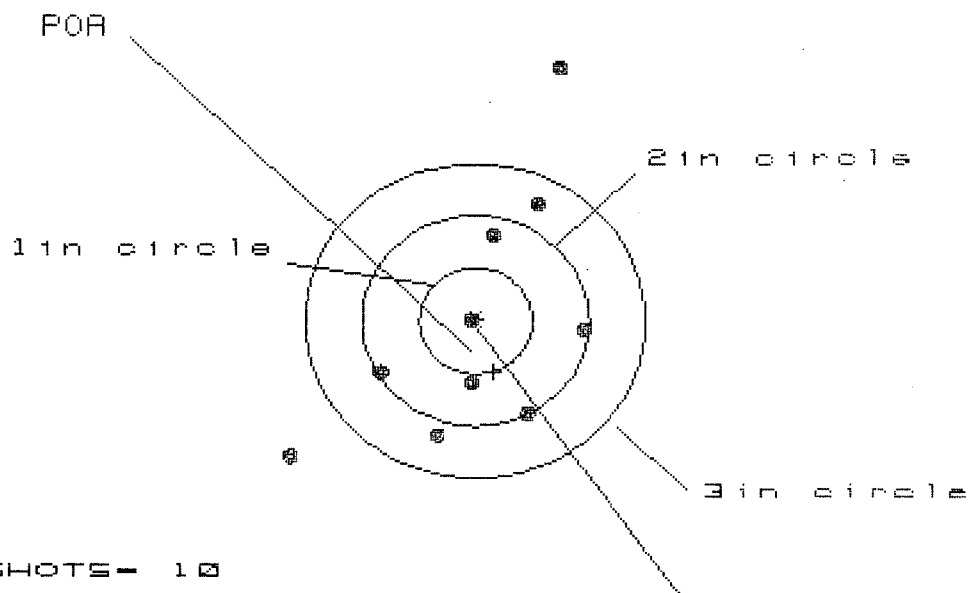
CENTROID #

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.547	1.536	.635
MINIMUM X	:	-1.103	-1.114	-.922
MAXIMUM Y	:	1.508	1.207	1.126
MINIMUM Y	:	-2.711	-1.314	-1.395
CENTROID X	:	-.148	-.137	-.329
CENTROID Y	:	.072	.373	.454
POA TO CENTROID in.	:	.164	.398	.560
MIN RADIUS	:	.272	.573	.544
MEAN RADIUS	:	1.210	1.004	.898
MAX RADIUS	:	2.713	1.665	1.409
HORIZONTAL SPREAD	:	2.650	2.650	1.558
VERTICAL SPREAD	:	4.219	2.521	2.521
EXTREME SPREAD	:	4.255	2.745	2.558
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	7		

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS = 2.541

VS = 3.700

GS = 4.389

CENTROID #

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.999	1.079	.883
MINIMUM X	:	-1.642	-1.562	-.911
MAXIMUM Y	:	2.414	1.403	1.275
MINIMUM Y	:	-1.286	-1.017	-.976
CENTROID X	:	-.159	-.239	-.043
CENTROID Y	:	.486	.217	.345
POA TO CENTROID in.	:	.511	.323	.347
MIN RADIUS	:	.072	.274	.242
MEAN RADIUS	:	1.136	.950	.835
MAX RADIUS	:	2.519	1.865	1.364
HORIZONTAL SPREAD	:	2.641	2.641	1.794
VERTICAL SPREAD	:	3.700	2.420	2.251
EXTREME SPREAD	:	4.389	3.298	2.422
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	8		