

C6611490

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington

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

MODEL 700™ 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.
 C6611490

ORDER NO.
 5716

20



5716 C6611490

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6611490

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		"	GL
617	Drill and Tap Sight Holes	APR	3 ...	LB
618	Polish Barrel	APR	3 1991	WB
620	Apply Coatings (Barrel Action)		4-19-91	LA
	Apply Coating (Bolt)			LA
625	Final Assembly A) Clean inside of Bolt Assembly		5/1/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/1/91	KS
	C) Inspect Ejector Hole for Chamfer		5/1/91	KS
	D) Oil Firing Pin Ass'y		5/1/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		5-10-91	PH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7	6	6			5-10-91	AC
	G) Safety Off Force	4	4	3			5-10-91	AC
	H) Trigger Pull Test & Retainability						5-10-91	DH
	I) Firing Pin Indent	.022	.022	.021			5-10-91	AC
	J) Assemble Stock						5-10-91	K-S
	K) Assemble Swivel Studs						5-20-91	AC
	L) Attach Front and Rear Sight Assemblies						5-10-91	K-S
	M) Iron Sight Alignment						5-10-91	K-S
	N) Detach Front & Rear Sights & place in numbered container						5-10-91	K-S
	O) Attach Scope to Rifle						5-10-91	K-S
	P) Detach & Attach Scope 20 Times						5-10-91	K-S
640	Gallery Target & Test						5/15/91	K-T
	A) Time						"	K-T
	B) Malfunctions						"	K-T
	C) Pierced Primers						"	K-T
	D) Optical Clarity of Scope						"	K-T
645	Inspect for Live Ammo						5/15/91	K-T
655	Final Inspection							
	A) Headspace						5-20-91	AC
	B) Trigger Pull	2.54	2.54	2.54	2.55	2.57	5/20/91	JH
	C) Function						5-20-91	AC
660	Pack						6-17-91	AC

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6611490

DATE 5-10-91

TESTER R. J. Smith

(Signature)

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.45	2.26	2.63	MIN. SETTING,
PULL #2	2.45	2.30	2.62	NO AVG. OF 5
PULL #3	2.34	2.31	2.34	READINGS ACCEPT-
PULL #4	2.39	2.30	2.64	ABLE LESS THAN 2#
PULL #5	2.42	2.32	2.58	
TOTAL				
AVG.				

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.07	3.00	
PULL #2	3.00	3.11	
PULL #3	2.99	3.15	
PULL #4	3.21	3.19	
PULL #5	3.17	3.21	
TOTAL			
AVG.			

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.19	3.99		4.06
PULL #2	4.24	4.20		4.22
PULL #3	4.27	4.23		4.22
PULL #4	4.22	4.23		4.11
PULL #5	4.16	4.24		4.22
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611490
15 May 1991

CENTROIDAL DISTANCES

0 TO	1	.274235
1 TO	2	.132019
1 TO	3	.193259
1 TO	4	.25794
1 TO	5	.338095

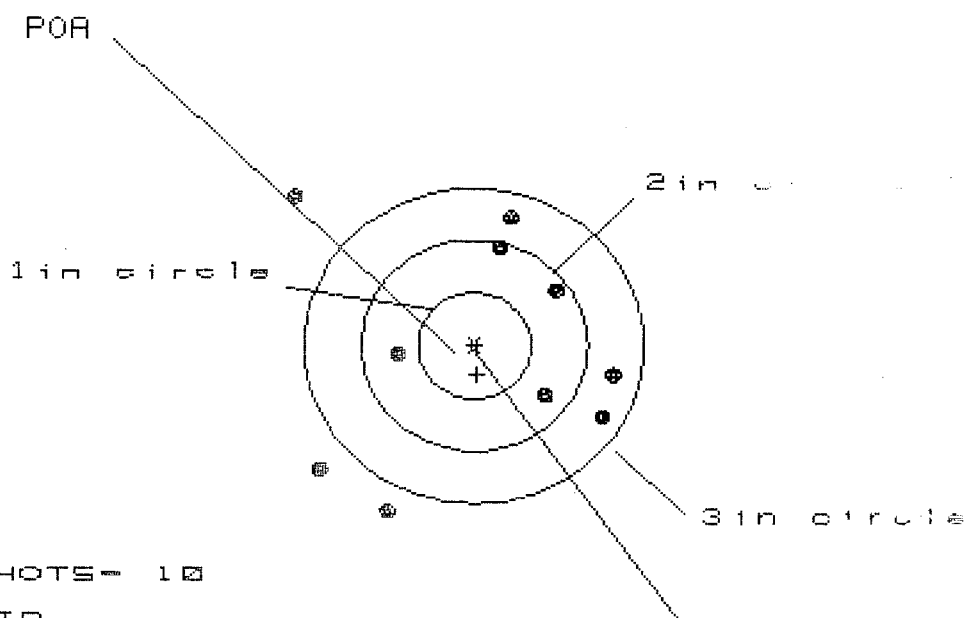
449
51 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0698
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .179
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .192128
THE AMR FOR THIS RIFLE IS: .9214

15 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611490

CENTERFIRE PATTERNS



OF SHOTS - 10

IN CIR

1 in = 0

2 in = 4

3 in = 7

HS = 2.753

VS = 3.009

GS = 3.438

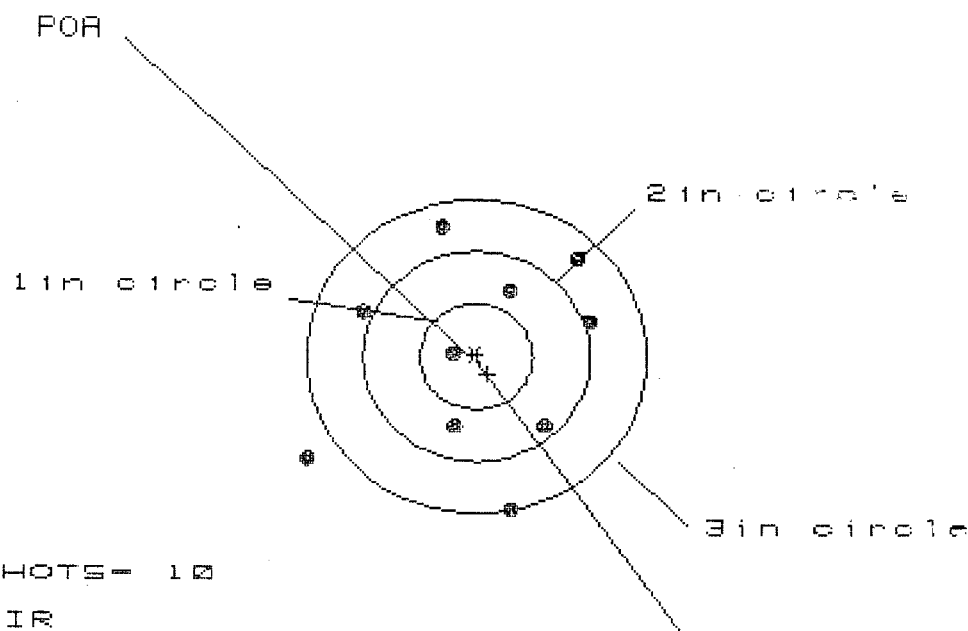
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.221	1.051	.864
MINIMUM X	:	-1.532	-1.495	-1.122
MAXIMUM Y	:	1.458	1.364	1.242
MINIMUM Y	:	-1.551	-1.389	-1.511
CENTROID X	:	-.026	.144	.331
CENTROID Y	:	.273	.111	.233
POA TO CENTROID in.	:	.274	.182	.405
MIN RADIUS	:	.660	.557	.515
MEAN RADIUS	:	1.270	1.151	1.025
MAX RADIUS	:	2.115	1.786	1.882
HORIZONTAL SPREAD	:	2.753	2.546	1.986
VERTICAL SPREAD	:	3.009	2.753	2.753
EXTREME SPREAD	:	3.438	2.955	2.955
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

15 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611490

CENTERFIRE PATTERNS



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS= 2.463

VS= 2.667

GS= 3.034

CENTROID #

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.002	.839	.850
MINIMUM X	-1.462	-1.136	-1.125
MAXIMUM Y	1.188	1.083	.885
MINIMUM Y	-1.479	-1.584	-.952
CENTROID X	-.099	.063	.052
CENTROID Y	.163	.268	.466
POA TO CENTROID in.	.191	.275	.469
MIN RADIUS	.187	.347	.384
MEAN RADIUS	1.040	.953	.854
MAX RADIUS	1.738	1.586	1.140
HORIZONTAL SPREAD	2.463	1.975	1.975
VERTICAL SPREAD	2.667	2.667	1.837
EXTREME SPREAD	3.034	2.722	2.031
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

15 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611490

CENTERFIRE PATTERNS

3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 4

2 in = 8

3 in = 10

HS= 1.687

VS= 1.922

GS= 2.432

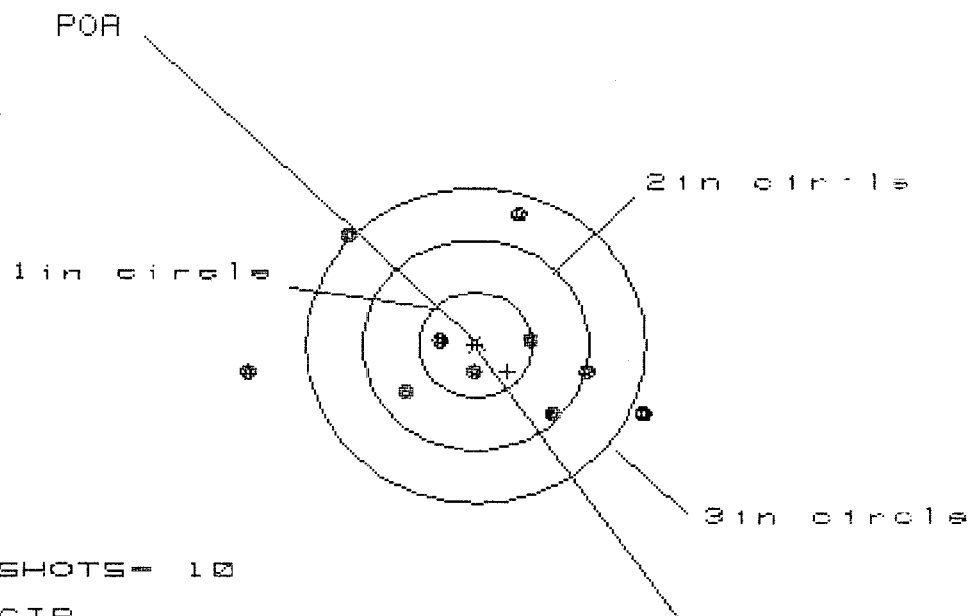
CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.046	.762	.721
MINIMUM X	-.641	-.525	-.566
MAXIMUM Y	.959	.704	.597
MINIMUM Y	-.963	-.857	-.633
CENTROID X	.167	.051	.092
CENTROID Y	.263	.157	.264
POA TO CENTROID in.	.312	.165	.279
MIN RADIUS	.348	.226	.338
MEAN RADIUS	.679	.571	.527
MAX RADIUS	1.419	.917	.745
HORIZONTAL SPREAD	1.687	1.287	1.287
VERTICAL SPREAD	1.922	1.561	1.230
EXTREME SPREAD	2.432	1.655	1.291
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	

15 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611490

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 5

3 in = 8

HS = 3.561

VS = 1.953

GS = 3.585

CENTROID *

PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	1.504
MINIMUM X	-2.057
MAXIMUM Y	1.267
MINIMUM Y	-1.686
CENTROID X	-1.283
CENTROID Y	.251
POA TO CENTROID in.	.379
MIN RADIUS	.212
MEAN RADIUS	1.018
MAX RADIUS	2.067
HORIZONTAL SPREAD	3.561
VERTICAL SPREAD	1.953
EXTREME SPREAD	3.585
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	8

15 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611490

CENTERFIRE PATTERNS

#

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 5

2in = 8

3in = 10

HS= 1.692

VS= 1.967

GS= 2.212

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.829	.881	.820
MINIMUM X	-.863	-.811	-.872
MAXIMUM Y	.905	.787	.435
MINIMUM Y	-1.062	-.553	-.455
CENTROID X	.108	-.160	-.099
CENTROID Y	-.055	.063	-.035
POA TO CENTROID in.	.122	.172	.105
MIN RADIUS	.170	.141	.149
MEAN RADIUS	.600	.526	.468
MAX RADIUS	1.160	.955	.962
HORIZONTAL SPREAD	1.692	1.692	1.692
VERTICAL SPREAD	1.967	1.340	.890
EXTREME SPREAD	2.212	1.808	1.808
NUMBER IN ONE INCH CIRCLE =	5		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		