

C6611519

MODEL 780™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



Remington REG. U.S. PAT. & TM. OFF.		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700TM H24		SERIAL NO. C6611519
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.		ORDER NO. 5716



5716 C6611519

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611519

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/12/91	K.S.
600	Proof		3/12/91	K.S.
607	Check Headspace		3/12/91	K.S.
610	Dis-assemble Gun		3/12/91	K.S.
612	Magnaflux Barrel Action		3/27/91	KR
	Magnaflux Bolt		11	KR
615	Rollmark Caliber		3/27/91	GB
617	Drill and Tap Sight Holes	APR	3 1991	LB
618	Polish Barrel	APR	3 1991	WB
620	Apply Coatings (Barrel Action)		4/12/91	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		5/2/91	JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5-2-91	D/H
	G) Safety Off Force	2	2	3			5-2-91	D/H
	H) Trigger Pull Test & Retainability						5/2/91	JH
	I) Firing Pin Indent	1021	1022	1022			5-2-91	D/H
	J) Assemble Stock						5/3/91	K-S
	K) Assemble Swivel Studs						5-10-91	AC
	L) Attach Front and Rear Sight Assemblies						5/3/91	K-S
	M) Iron Sight Alignment						5/3/91	K-S
	N) Detach Front & Rear Sights & place in numbered container						5/3/91	K-S
	O) Attach Scope to Rifle						5/3/91	K-S
	P) Detach & Attach Scope 20 Times						5/3/91	K-S
640	Gallery Target & Test						5/3/91	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						5/3/91	K-T
655	Final Inspection							
	A) Headspace						5-10-91	AC
	B) Trigger Pull	2.62	2.69	2.20	2.21	2.20	5/91/CP	JH
	C) Function						5-10-91	AC
660	Pack						6-17-91	NE

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6611519
DATE 5/2/91
TESTER [Signature]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST 8012 TO RESET 2.50#		COMMENTS
PULL #1	2.22	2.20	2.50	2.62	MIN. SETTING,
PULL #2	2.23	2.21	2.45	2.69	NO AVG. OF 5
PULL #3	2.25	2.44	2.41	2.20	READINGS ACCEPT-
PULL #4	2.23	2.60	2.52	2.21	ABLE LESS THAN 2#
PULL #5	2.24	2.60	2.51	2.20	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.38	3.35		
PULL #2	3.43	3.18		
PULL #3	3.39	3.45		
PULL #4	3.38	3.45		
PULL #5	3.36	3.45		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.26	4.44		4.53
PULL #2	4.45	4.43		4.27
PULL #3	4.43	4.45		4.56
PULL #4	4.42	4.52		4.57
PULL #5	4.49	4.48		4.52
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611519
3 May 1991

CENTROIDAL DISTANCES

0 TO	1	.230846
1 TO	2	.346699
1 TO	3	.338415
1 TO	4	.285955
1 TO	5	.380384

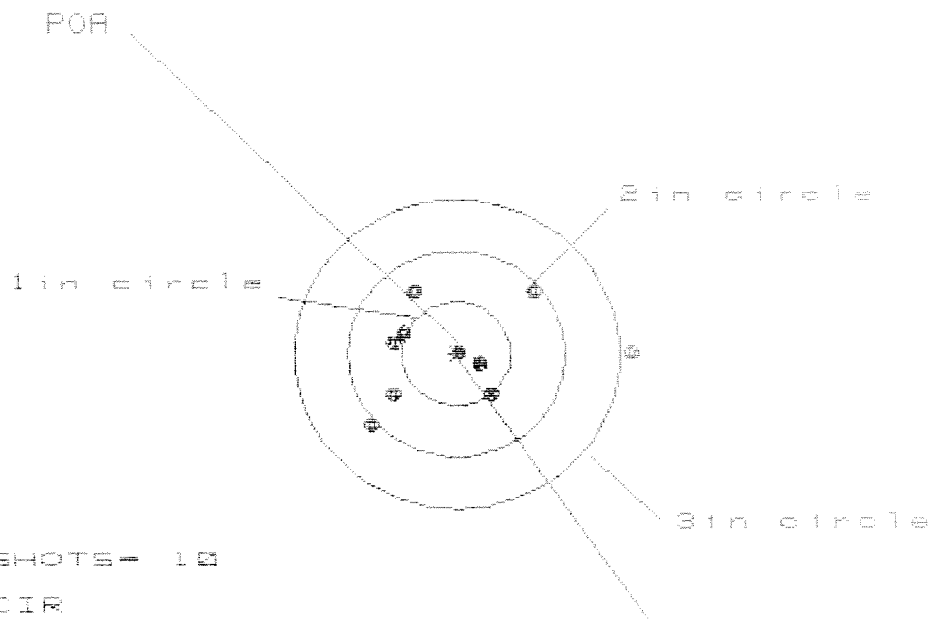
1.0 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0016
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0446
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0445
THE AMP FOR THIS RIFLE IS: .7826

3 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611519

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS= 2.362

VS= 1.243

GS= 2.473

CENTROID X

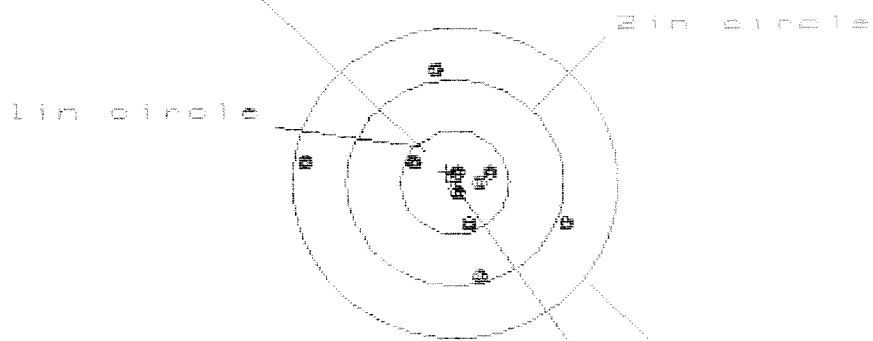
PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.583	.846	.770
MINIMUM X	:	-.779	-.603	-.489
MAXIMUM Y	:	.565	.571	.487
MINIMUM Y	:	-.678	-.672	-.440
CENTROID X	:	-.213	-.389	-.313
CENTROID Y	:	.089	.083	.167
POA TO CENTROID in.	:	.231	.397	.355
MIN RADIUS	:	.059	.235	.178
MEAN RADIUS	:	.677	.569	.521
MAX RADIUS	:	1.584	1.020	.911
HORIZONTAL SPREAD	:	2.362	1.449	1.259
VERTICAL SPREAD	:	1.243	1.243	.917
EXTREME SPREAD	:	2.473	1.909	1.547
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 2

POB



OF SHOTS - 10

IN CIR

1in = 6

2in = 7

3in = 10

HE = 3.333

VE = 1.998

GS = 2.456

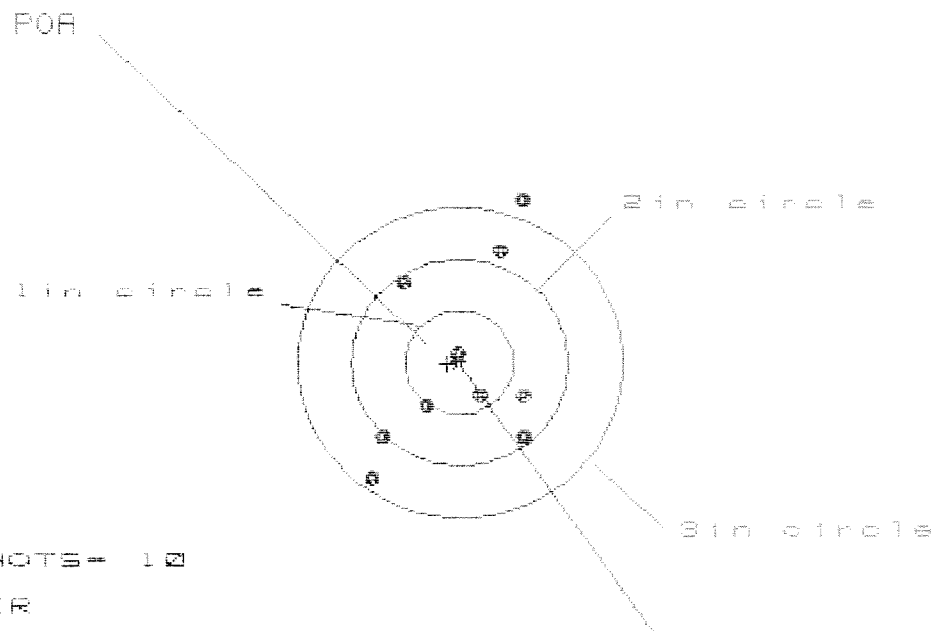
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.000	.846	.805
MINIMUM X	:	-1.389	-.511	-.552
MAXIMUM Y	:	1.121	1.145	.388
MINIMUM Y	:	-.877	-.853	-.710
CENTROID X	:	.077	.231	.272
CENTROID Y	:	-.101	-.125	-.268
POB TO CENTROID in.	:	.127	.263	.382
MIN RADIUS	:	.088	.044	.147
MEAN RADIUS	:	.609	.501	.422
MAX RADIUS	:	1.405	1.191	.827
HORIZONTAL SPREAD	:	2.389	1.357	1.357
VERTICAL SPREAD	:	1.998	1.998	1.098
EXTREME SPREAD	:	2.456	2.038	1.475
NUMBER IN ONE INCH CIRCLE	=		6	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 1.469

VS= 2.724

CS= 3.093

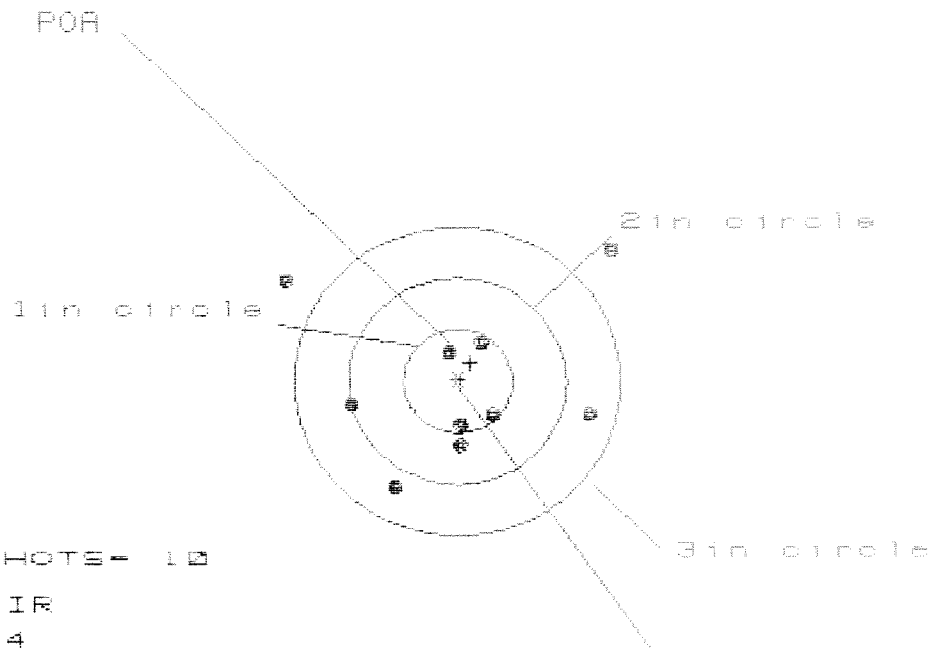
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.614	.681	.583
MINIMUM X	:	-.855	-.788	-.764
MAXIMUM Y	:	1.568	1.277	1.154
MINIMUM Y	:	-1.156	-.982	-.634
CENTROID X	:	.117	.050	.148
CENTROID Y	:	.014	-.160	-.037
POA TO CENTROID in.	:	.118	.167	.153
MIN RADIUS	:	.083	.269	.136
MEAN RADIUS	:	.881	.773	.705
MAX RADIUS	:	1.682	1.364	1.216
HORIZONTAL SPREAD	:	1.469	1.469	1.347
VERTICAL SPREAD	:	2.724	2.259	1.788
EXTREME SPREAD	:	3.093	2.591	2.109
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 4

2in = 0

3in = 0

IS= 2.0000

VS= 2.293

GS= 3.095

CENTROID #

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.377	1.350	1.167
MINIMUM X	:	-1.612	-1.459	-1.000
MAXIMUM Y	:	1.300	1.084	.688
MINIMUM Y	:	-.985	-.839	-.704
CENTROID X	:	-.116	-.269	-.086
CENTROID Y	:	-.180	-.326	-.461
POR TO CENTROID in.	:	.214	.422	.469
MIN RADIUS	:	.284	.299	.097
MEAN RADIUS	:	.939	.821	.642
MAX RADIUS	:	1.899	1.818	1.170
HORIZONTAL SPREAD	:	2.989	2.809	2.167
VERTICAL SPREAD	:	2.293	1.923	1.392
EXTREME SPREAD	:	3.095	3.095	2.169
NUMBER IN ONE INCH CIRCLE	=	4		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	8		

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 1.584

VS= 2.400

GS= 2.541

CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.924	.536	.463
MINIMUM X	-.660	-.557	-.490
MAXIMUM Y	1.449	.954	.855
MINIMUM Y	-.951	-.790	-.740
CENTROID X	.143	.040	-.027
CENTROID Y	-.045	-.266	-.107
POA TO CENTROID in.	.150	.209	.113
MIN RADIUS	.174	.266	.263
MEAN RADIUS	.807	.668	.638
MAX RADIUS	1.718	1.074	.955
HORIZONTAL SPREAD	1.584	1.093	.953
VERTICAL SPREAD	2.400	1.744	1.595
EXTREME SPREAD	2.541	2.029	1.751
NUMBER IN ONE INCH CIRCLE	= 2		
NUMBER IN TWO INCH CIRCLE	= 7		
NUMBER IN THREE INCH CIRCLE	= 9		