

C6611610

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

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

MODEL 700™ H24

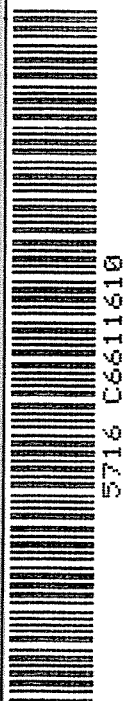
VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.

SERIAL NO. C6611610

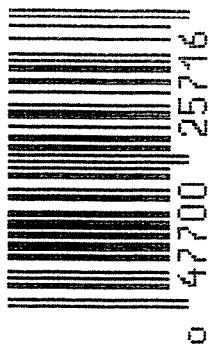
ORDER NO. 5716

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

20



UPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C 6611610**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/19/91	K.S.
600	Proof		3/19/91	K.S.
607	Check Headspace		3/19/91	K.S.
610	Dis-assemble Gun		3/19/91	K.S.
612	Magnaflux Barrel Action		3/28/91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	GS.
617	Drill and Tap Sight Holes	APR	3 1991	KLB
618	Polish Barrel	APR	3 1991	WEB
620	Apply Coatings (Barrel Action)		4-19-91	JS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/29/91	K.S.
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/29/91	K.S.
	C) Inspect Ejector Hole for Chamfer		4/29/91	K.S.
	D) Oil Firing Pin Ass'y		4/29/91	K.S.
	E) Adjust Trigger Pull to Min Setting and Stake		5/7/91	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5/7/91	JS
	G) Safety Off Force	4	4	4			5/7/91	JS
	H) Trigger Pull Test & Retainability						5/7/91	JS
	I) Firing Pin Indent	.022	.023	.023			5/7/91	JS
	J) Assemble Stock						5/7/91	KS
	K) Assemble Swivel Studs						5-11-91	D/H
	L) Attach Front and Rear Sight Assemblies						5/7/91	KS
	M) Iron Sight Alignment						5/7/91	KS
	N) Detach Front & Rear Sights & place in numbered container						5/7/91	KS
	O) Attach Scope to Rifle						5/7/91	KS
	P) Detach & Attach Scope 20 Times						5/7/91	KS
640	Gallery Target & Test						5-8-91	Kf
	A) Time						5-8-91	KJ
	B) Malfunctions						5-8-91	KJ
	C) Pierced Primers						5-8-91	KJ
	D) Optical Clarity of Scope						5-8-91	KJ
645	Inspect for Live Ammo						5-8-91	KJ
655	Final Inspection							
	A) Headspace						5-11-91	D/H
	B) Trigger Pull	2.24	2.18	2.32	2.21	2.21	5/12/91	JS
	C) Function						5-11-91	D/H
660	Pack						6-17-91	JS

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. C6611610

DATE 5/6/98

TESTER DEI

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.56	2.53	2.27	2.18	MIN. SETTING,
PULL #2	2.54	2.26	2.24	2.32	NO AVG. OF 5
PULL #3	2.47	2.54	2.33	2.21	READINGS ACCEPT-
PULL #4	2.54	2.36	2.23	2.21	ABLE LESS THAN 2#
PULL #5	2.49	2.26	2.29	2.24	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.37		
PULL #2	3.26	3.22		
PULL #3	3.37	3.29		
PULL #4	3.34	3.38		
PULL #5	3.34	3.34		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.33	4.31		4.35
PULL #2	4.41	4.32		4.35
PULL #3	4.34	4.32		4.33
PULL #4	4.27	4.32		4.27
PULL #5	4.34	4.21		4.38
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611610
9 May 1991

CENTROIDAL DISTANCES

0 TO	1	.0447214
1 TO	2	.135366
1 TO	3	.382126
1 TO	4	.272018
1 TO	5	.210794

4
3 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0128
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.122
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .12267
THE AMR FOR THIS RIFLE IS: .8744

9 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66116LV

CENTERFIRE PATTERNS

#

POR

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 4

2 in = 6

3 in = 8

HS= 3.196

VS= 2.278

GS= 3.336

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.149	.922	.824
MINIMUM X	:	-2.047	-.785	-.557
MAXIMUM Y	:	.688	.640	.435
MINIMUM Y	:	-1.590	-1.638	-.409
CENTROID X	:	.044	.271	.369
CENTROID Y	:	-.008	.040	.245
POR TO CENTROID in.	:	.045	.274	.443
MIN RADIUS	:	.132	.330	.304
MEAN RADIUS	:	.866	.720	.558
MAX RADIUS	:	2.092	1.817	.867
HORIZONTAL SPREAD	:	3.196	1.707	1.381
VERTICAL SPREAD	:	2.278	2.278	.844
EXTREME SPREAD	:	3.336	2.717	1.539
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

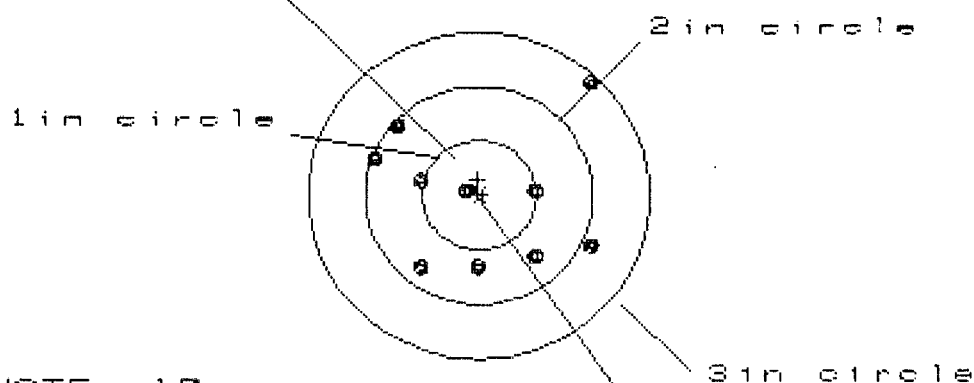
9 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611610

CENTERFIRE PATTERNS

2

POA



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS= 1.908

VS= 1.624

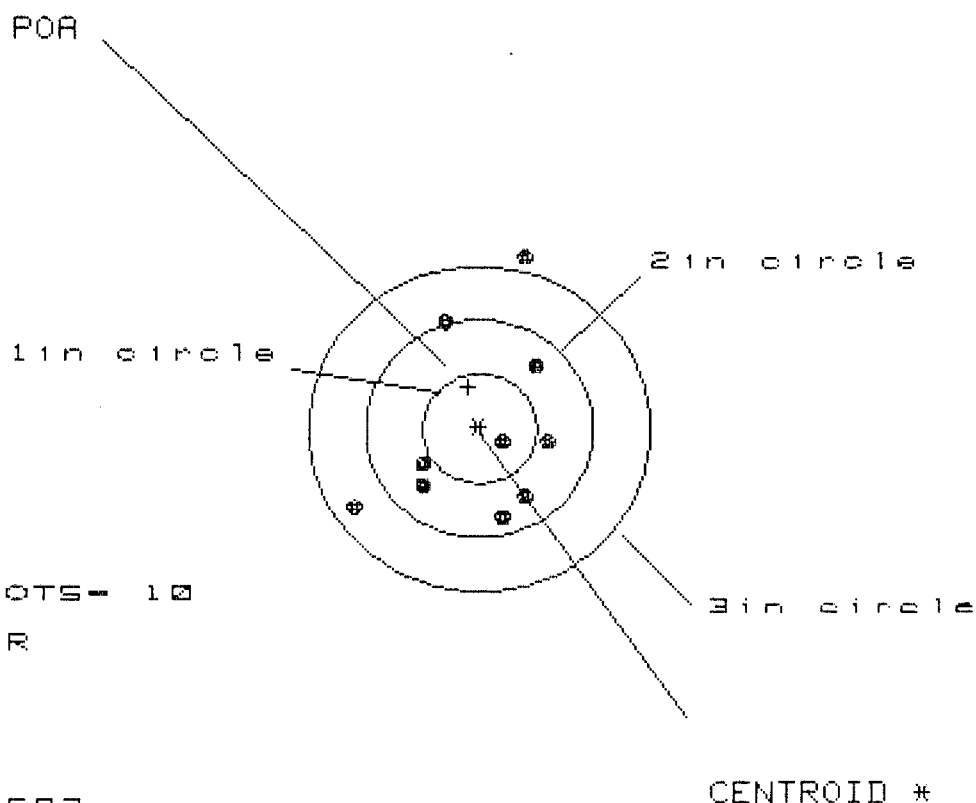
GS= 2.211

PATTERN #	:	12	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.974	1.067	.716
MINIMUM X	:	-.934	-.826	-.693
MAXIMUM Y	:	.991	.797	.756
MINIMUM Y	:	-.633	-.523	-.564
CENTROID X	:	.014	-.094	-.228
CENTROID Y	:	-.140	-.250	-.209
POA TO CENTROID in.	:	.141	.267	.309
MIN RADIUS	:	.100	.168	.202
MEAN RADIUS	:	.778	.698	.638
MAX RADIUS	:	1.390	1.117	.896
HORIZONTAL SPREAD	:	1.908	1.893	1.408
VERTICAL SPREAD	:	1.624	1.320	1.320
EXTREME SPREAD	:	2.211	2.057	1.754
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

9 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611610

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 9

HS= 1.687

VS= 2.484

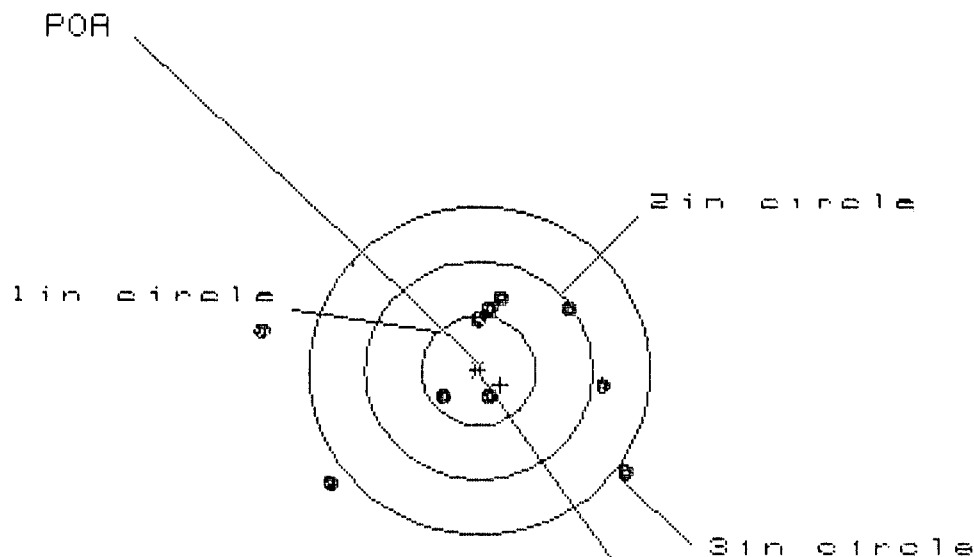
GS= 2.768

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.629	.672	.545
MINIMUM X	:	-1.058	-1.015	-.626
MAXIMUM Y	:	1.632	1.185	1.117
MINIMUM Y	:	-.852	-.671	-.739
CENTROID X	:	.100	.057	.184
CENTROID Y	:	-.386	-.567	-.499
POA TO CENTROID in.	:	.399	.570	.531
MIN RADIUS	:	.239	.297	.154
MEAN RADIUS	:	.853	.735	.664
MAX RADIUS	:	1.677	1.207	1.172
HORIZONTAL SPREAD	:	1.687	1.687	1.171
VERTICAL SPREAD	:	2.484	1.856	1.856
EXTREME SPREAD	:	2.768	1.995	1.927
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

9 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611610

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 7

HS= 3.227

VS= 1.714

GS= 3.475

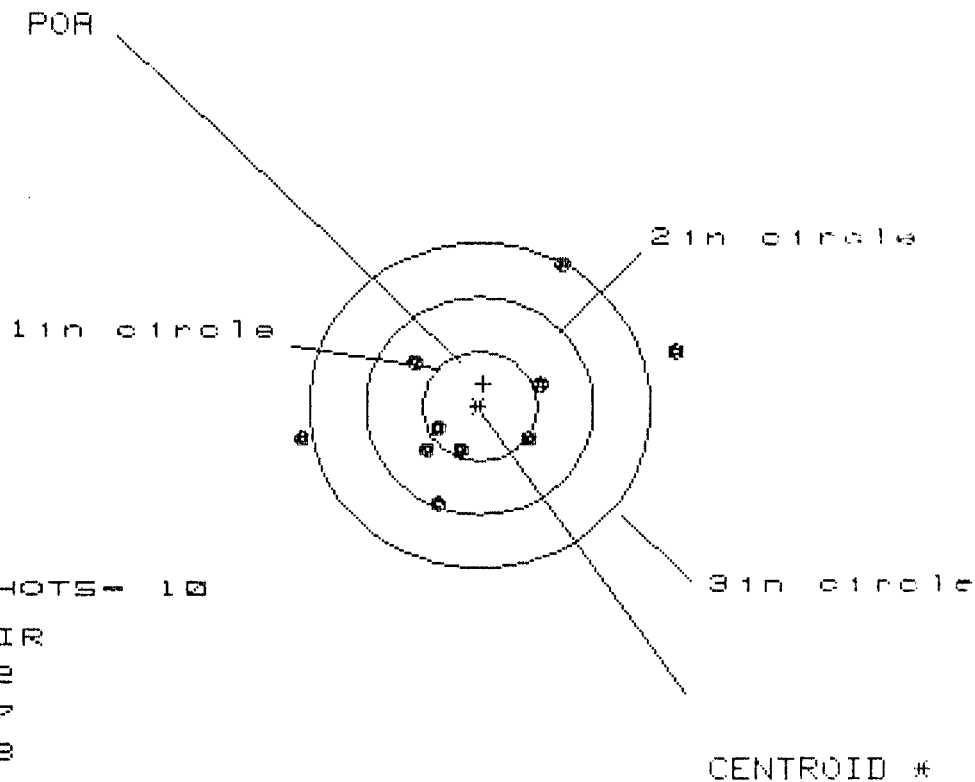
CENTROID #

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.301	1.087	.890
MINIMUM X	:	-1.926	-1.569	-.686
MAXIMUM Y	:	.687	.723	.599
MINIMUM Y	:	-1.027	-.991	-1.053
CENTROID X	:	-.191	.023	.220
CENTROID Y	:	.129	.093	.217
POR TO CENTROID in.	:	.230	.096	.309
MIN RADIUS	:	.288	.251	.462
MEAN RADIUS	:	.974	.852	.714
MAX RADIUS	:	1.953	1.856	1.379
HORIZONTAL SPREAD	:	3.227	2.656	1.576
VERTICAL SPREAD	:	1.714	1.714	1.652
EXTREME SPREAD	:	3.475	2.663	2.009
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	7		

9 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611610

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 8

HS= 3.318

VS= 2.161

GS= 3.424

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.763	.932	.762
MINIMUM X	:	-1.555	-1.359	-.508
MAXIMUM Y	:	1.288	1.347	1.315
MINIMUM Y	:	-.873	-.814	-.846
CENTROID X	:	-.031	-.227	-.057
CENTROID Y	:	-.205	-.264	-.232
POA TO CENTROID in.	:	.208	.348	.239
MIN RADIUS	:	.388	.197	.352
MEAN RADIUS	:	.901	.755	.690
MAX RADIUS	:	1.841	1.638	1.520
HORIZONTAL SPREAD	:	3.318	2.291	1.270
VERTICAL SPREAD	:	2.161	2.161	2.161
EXTREME SPREAD	:	3.424	2.798	2.422
NUMBER IN ONE INCH CIRCLE =	:	2		
NUMBER IN TWO INCH CIRCLE =	:	7		
NUMBER IN THREE INCH CIRCLE =	:	8		