

C6522270

MODEL 700TM M24

Model **SWS** TM

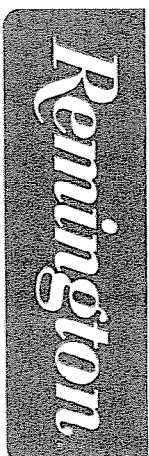
Action

Barrel Length

Capacity

Order No. **5716**

* Includes 1 in chamber.



CAD 70C

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6522270

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		8-21-90	DB
600	Proof		8-21-90	DB
607	Check Headspace		8-21-90	DB
610	Dis-assemble Gun		8-21-90	DB
612	Magnaflux Barrel Action		8/22/90	KCD
	Magnaflux Bolt		8/22/90	KCD
615	Rollmark Caliber		8/22/90	CR
617	Drill and Tap Sight Holes		8/23/90	LB
618	Polish Barrel RB		8/23/90	WB
620	Apply Coatings (Barrel Action)		8/23/90	LB
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake		9/13/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 nt.	F) Safety On Force	5	5	5			9/13/90	WB
	G) Safety Off Force	2	2	2			9/13/90	WB
	H) Trigger Pull Test & Retainability						9/13/90	WB
	I) Firing Pin Indent	.0235	.024	.0235			9/13/90	WB
	J) Assemble Stock						9/13/90	KS
	K) Assemble Swivel Studs						9/15/90	JS
	L) Attach Front and Rear Sight Assemblies						9/13/90	KS
	M) Iron Sight Alignment						9/13/90	KS
	N) Detach Front & Rear Sights & place in numbered container						9/13/90	KS
	O) Attach Scope to Rifle						9/13/90	KS
	P) Detach & Attach Scope 20 Times						9/13/90	KS
640	Gallery Target & Test						9-14-90	AC
	A) Time						9-14-90	AC
	B) Malfunctions						9-14-90	AC
	C) Pierced Primers						9-14-90	AC
	D) Optical Clarity of Scope						9-14-90	AC
645	Inspect for Live Ammo						9-14-90	AC
655	Final Inspection						9/15/90	JS
	A) Headspace						9/15/90	JS
	B) Trigger Pull	2.53	2.43	2.42	2.33	2.36	9-15-90	JS
	C) Function						9/15/90	JS
660	Pack						9/19/90	IF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6522270
DATE 9/13/90
TESTER W.B.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.48	2.45	2.50	2.53	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.45	2.27	2.40	2.43	
PULL #3	2.46	2.42	2.60	2.42	
PULL #4	2.51	2.40	2.55	2.33	
PULL #5	2.60	2.18	2.30	2.36	
TOTAL	12.50	11.72	12.35	12.07	
AVG.	2.50	2.34	2.47	2.414	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.01	3.17		TROUBLE SETTLING DOWN TRIGGER RE-DEEMED NOISE FIXED SAVING
PULL #2	3.03	3.27		
PULL #3	3.11	3.00		
PULL #4	2.95	3.02		
PULL #5	3.17	3.14		
TOTAL	15.27	15.60		
AVG.	3.05	3.12		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.10	4.25		4.06
PULL #2	4.20	4.30		4.17
PULL #3	4.11	4.40		4.20
PULL #4	4.18	4.24		4.06
PULL #5	4.18	4.10		4.22
TOTAL	20.77	21.29		20.71
AVG.	4.15	4.26		4.14

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522270
14 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.237076
1 TO	2	.256312
1 TO	3	.25787
1 TO	4	.415018
1 TO	5	.386

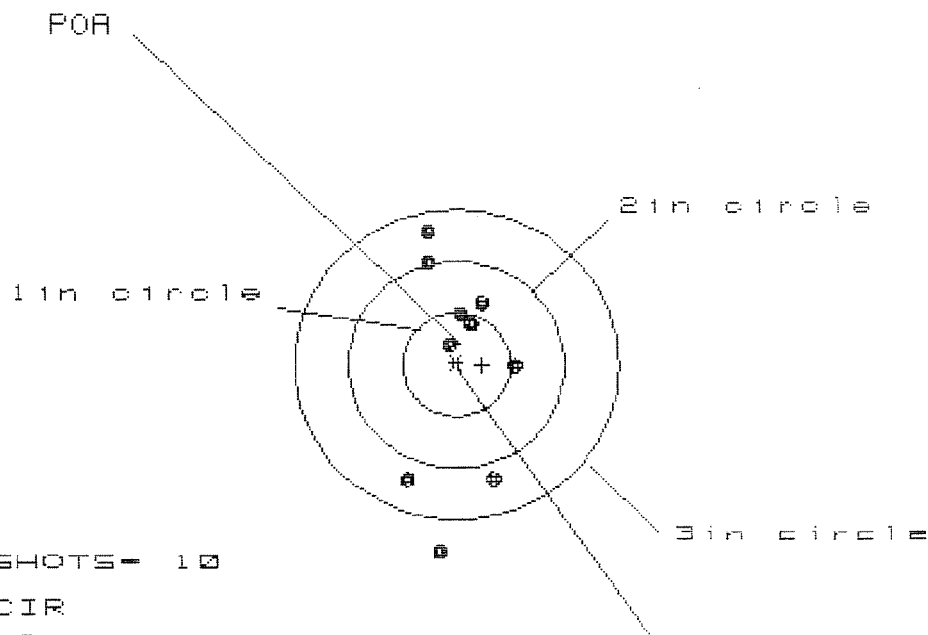
$\frac{5}{32}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1444
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .03
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .147483
THE AMR FOR THIS RIFLE IS: .9374

14 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8522270

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 1.014

VS= 3.101

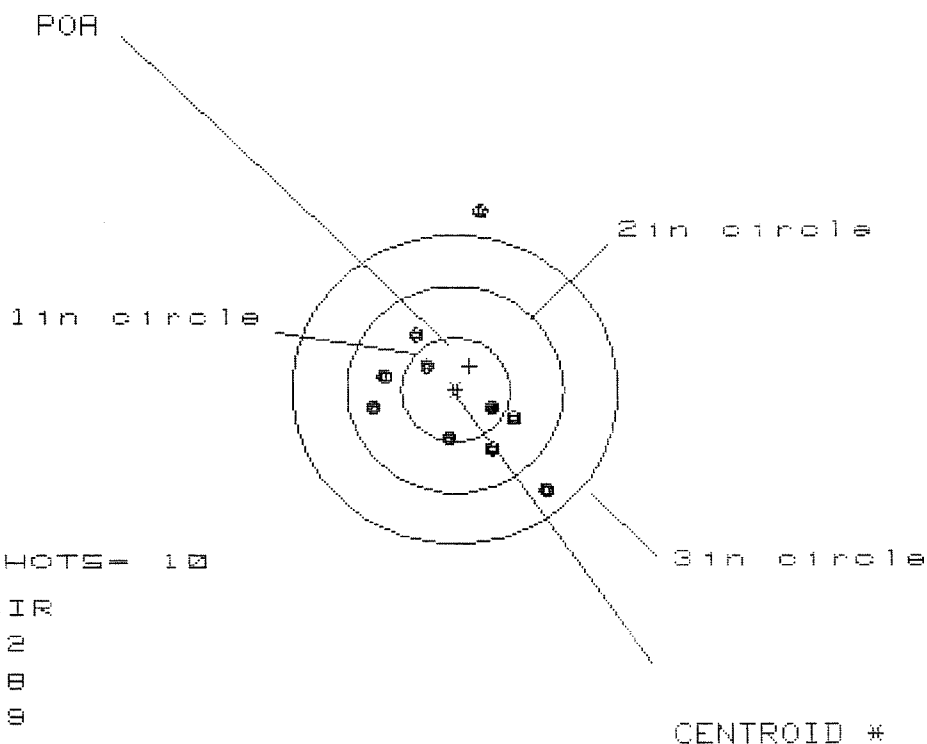
GS= 3.102

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.513	.496	.465
MINIMUM X	:	-.501	-.518	-.549
MAXIMUM Y	:	1.339	1.143	.948
MINIMUM Y	:	-1.762	-1.316	-1.173
CENTROID X	:	-.237	-.220	-.189
CENTROID Y	:	.006	.202	.059
POA TO CENTROID in.	:	.237	.299	.198
MIN RADIUS	:	.170	.065	.143
MEAN RADIUS	:	.874	.701	.678
MAX RADIUS	:	1.769	1.414	1.295
HORIZONTAL SPREAD	:	1.014	1.014	1.014
VERTICAL SPREAD	:	3.101	2.459	2.121
EXTREME SPREAD	:	3.102	2.502	2.183
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 2

2in = 8

3in = 9

HS= 1.611

VS= 2.648

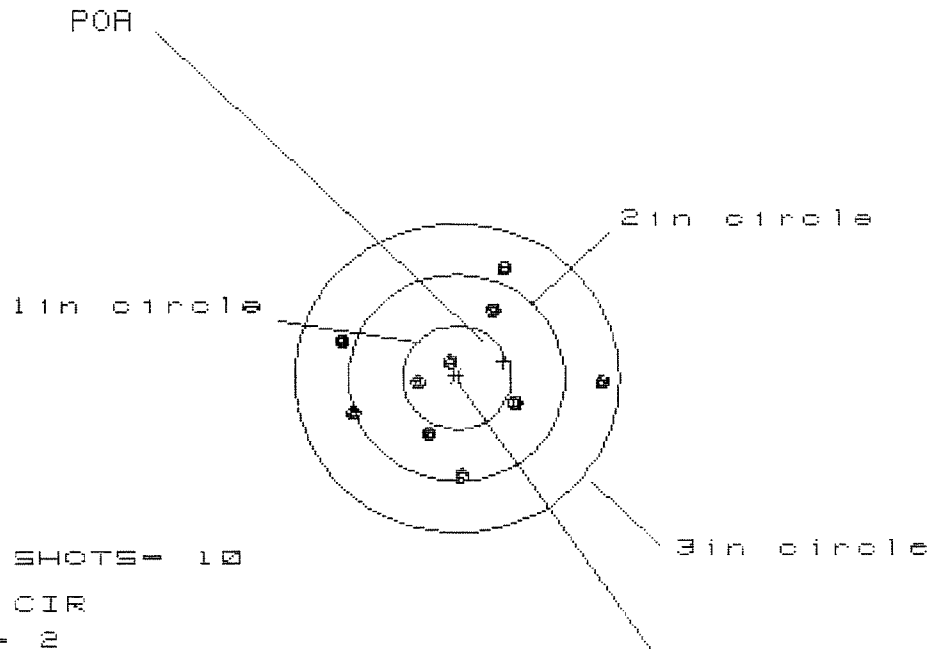
GS= 2.711

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.800	.824	.689
MINIMUM X	:	-.811	-.787	-.684
MAXIMUM Y	:	1.713	.754	.661
MINIMUM Y	:	-.935	-.745	-.484
CENTROID X	:	-.137	-.161	-.264
CENTROID Y	:	-.230	-.420	-.327
POA TO CENTROID in.	:	.268	.450	.421
MIN RADIUS	:	.344	.311	.363
MEAN RADIUS	:	.768	.637	.573
MAX RADIUS	:	1.727	1.111	.714
HORIZONTAL SPREAD	:	1.611	1.611	1.373
VERTICAL SPREAD	:	2.648	1.499	1.145
EXTREME SPREAD	:	2.711	1.914	1.377
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 6

3 in = 10

HS= 2.429

VS= 1.964

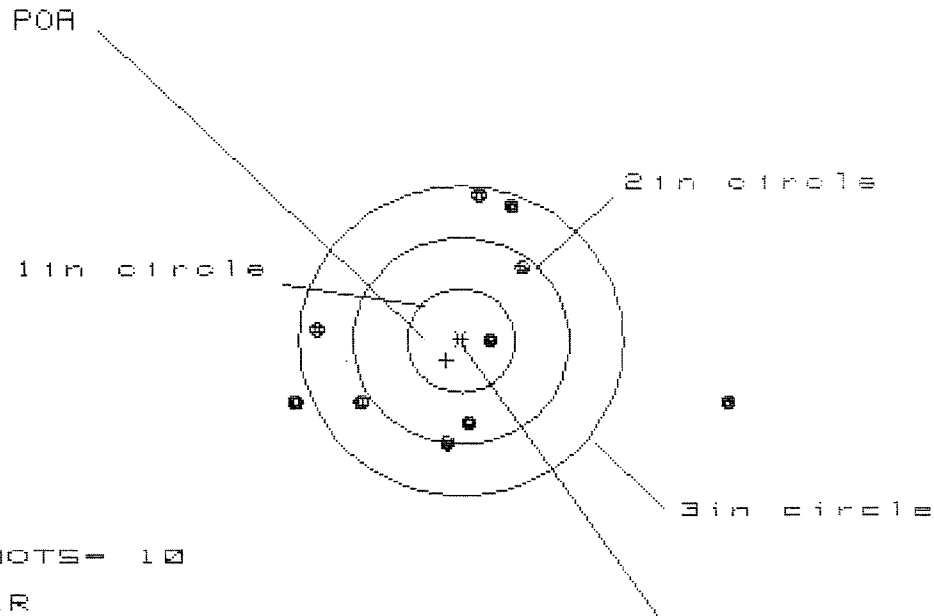
GS= 2.462

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.373	.681	.754
MINIMUM X	-1.056	-.903	-.830
MAXIMUM Y	1.039	1.035	.775
MINIMUM Y	-.925	-.929	-.799
CENTROID X	-.436	-.588	-.661
CENTROID Y	-.158	-.154	-.284
POA TO CENTROID in.	.463	.608	.719
MIN RADIUS	.126	.150	.164
MEAN RADIUS	.800	.721	.651
MAX RADIUS	1.374	1.187	.967
HORIZONTAL SPREAD	2.429	1.584	1.584
VERTICAL SPREAD	1.964	1.964	1.574
EXTREME SPREAD	2.462	1.997	1.712
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 8

HS= 4.024

VS= 2.378

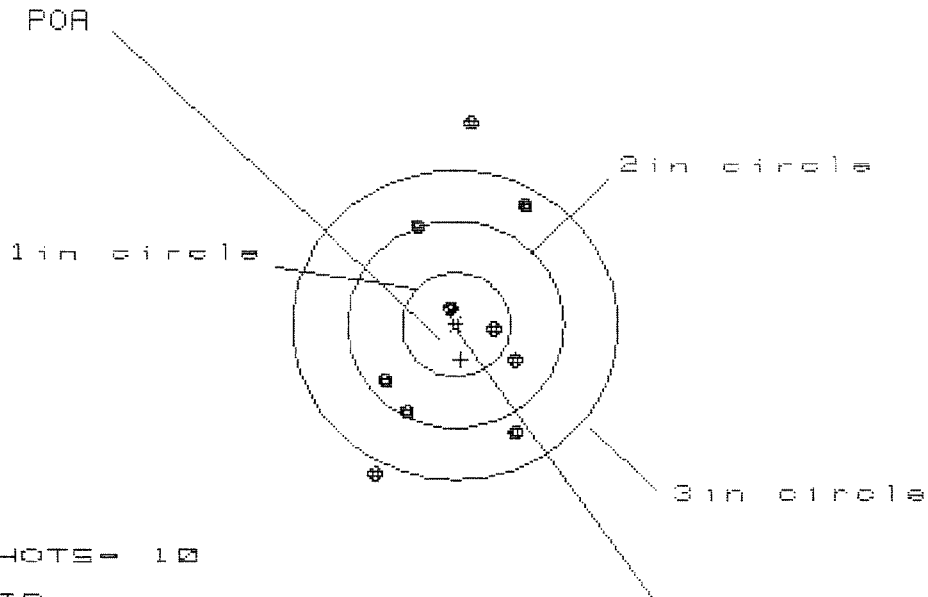
GS= 4.024

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.443	.796	.632
MINIMUM X	:	-1.581	-1.309	-1.251
MAXIMUM Y	:	1.407	1.339	1.254
MINIMUM Y	:	-.972	-1.039	-1.125
CENTROID X	:	.135	-.137	.027
CENTROID Y	:	.190	.258	.343
POA TO CENTROID in.	:	.233	.292	.345
MIN RADIUS	:	.311	.590	.458
MEAN RADIUS	:	1.243	1.101	1.037
MAX RADIUS	:	2.517	1.494	1.338
HORIZONTAL SPREAD	:	4.024	2.105	1.883
VERTICAL SPREAD	:	2.378	2.378	2.378
EXTREME SPREAD	:	4.024	2.867	2.407
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS= 1.471

VS= 3.335

GS= 3.457

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.680	.694	.597
MINIMUM X	:	-.791	-.777	-.740
MAXIMUM Y	:	1.918	1.398	1.247
MINIMUM Y	:	-1.417	-1.204	-1.024
CENTROID X	:	-.047	-.061	.037
CENTROID Y	:	.342	.129	.280
POA TO CENTROID in.	:	.346	.143	.282
MIN RADIUS	:	.152	.362	.240
MEAN RADIUS	:	1.002	.891	.802
MAX RADIUS	:	1.921	1.560	1.382
HORIZONTAL SPREAD	:	1.471	1.471	1.337
VERTICAL SPREAD	:	3.335	2.602	2.271
EXTREME SPREAD	:	3.457	2.989	2.303
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			8	

Remington®



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

MODEL 700™ H24

SERIAL NO.

C6522270

ORDER NO.

5716

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