

C6522259

MODEL 700TM N24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Cliff

MOD. 24 GA. CAL. 36 S GUN # 2259

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st	5th Rd. Tight in May.	KS
	2nd	adjusted mag B&A	KS
	3rd		
	4th		
		FUNCTION	

RD 6654

Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522259

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		8/13/90	KS
600	Proof		8/13/90	KS
607	Check Headspace		8/13/90	KS
610	Dis-assemble Gun		8/13/90	KS
612	Magnaflux Barrel Action		8/14	KCR
	Magnaflux Bolt		8/14	KCR
615	Rollmark Caliber		8/14	GL
617	Drill and Tap Sight Holes		8/23/90	FB
618	Polish Barrel RB		8/23/90	WB
620	Apply Coatings (Barrel Action)		8/31/90	TSA
	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		9/14/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/2	5 1/2	5 1/2			9/14/90	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			9/14/90	WB
	H) Trigger Pull Test & Retainability						9/14/90	WB
	I) Firing Pin Indent	.0225	.022	.022			9/14/90	WB
	J) Assemble Stock						9/14/90	KA
	K) Assemble Swivel Studs						9/16/90	JB
	L) Attach Front and Rear Sight Assemblies						9/14/90	KA
	M) Iron Sight Alignment						9/14/90	KA
	N) Detach Front & Rear Sights & place in numbered container						9/14/90	KA
	O) Attach Scope to Rifle						9/14/90	KA
	P) Detach & Attach Scope 20 Times						9/14/90	KA
640	Gallery Target & Test						9/15/90	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						9/15/90	NF
655	Final Inspection							
	A) Headspace						9/16/90	JB
	B) Trigger Pull	2.43	2.47	2.51	2.44	2.37	9-16-90	KA
	C) Function						9/16/90	JB
660	Pack						9-19-90	DA

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6527259

DATE 9/14/90

TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.45	2.34	2.43	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.34	2.39	2.42	2.47	
PULL #3	2.32	2.49	2.35	2.51	
PULL #4	2.36	2.52	2.49	2.44	
PULL #5	2.44	2.36	2.40	2.37	
TOTAL	11.87	12.21	12.00	12.22	
AVG.	2.37	2.44	2.40	2.444	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.21	3.22		
PULL #2	3.13	3.05		
PULL #3	3.27	3.14		
PULL #4	3.31	3.15		
PULL #5	3.26	3.17		
TOTAL	16.18	15.73		
AVG.	3.23	3.14		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.00	3.90		4.08
PULL #2	3.97	3.85		4.04
PULL #3	3.97	3.90		4.03
PULL #4	4.00	3.85		4.11
PULL #5	3.97	3.87		4.14
TOTAL	19.97	19.37		20.40
AVG.	3.98	3.90		4.08

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06522259
15 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.195931
1 TO	2	.284754
1 TO	3	.11868
1 TO	4	.191086
1 TO	5	.310498

48 <----POA

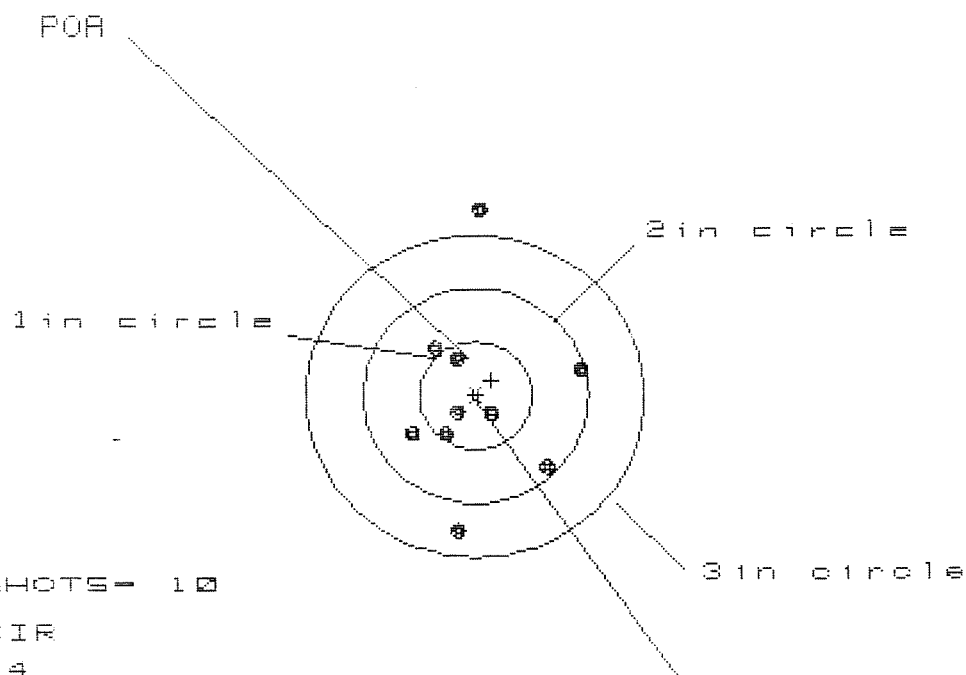
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.063
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0194
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0659193
THE AMR FOR THIS RIFLE IS: .8924

15 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8522259

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 8

3 in = 9

HS= 1.501

VS= 3.038

GS= 3.050

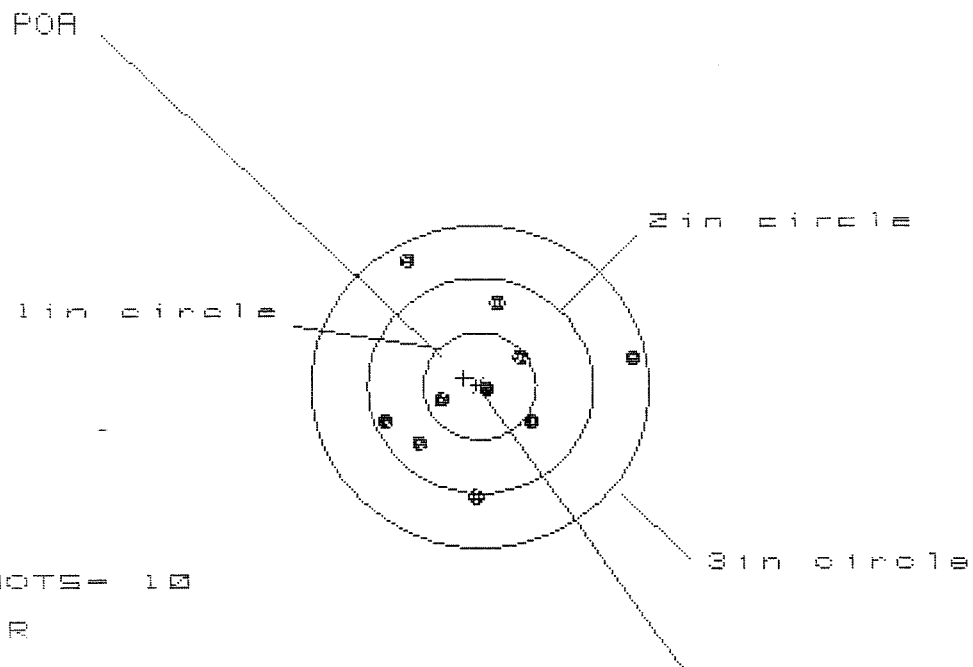
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.927	.934	.909
MINIMUM X	-.574	-.567	-.592
MAXIMUM Y	1.783	.678	.546
MINIMUM Y	-1.255	-1.057	-.615
CENTROID X	-.135	-.142	-.117
CENTROID Y	-.142	-.340	-.208
POA TO CENTROID in.	.196	.369	.239
MIN RADIUS	.182	.112	.118
MEAN RADIUS	.745	.601	.541
MAX RADIUS	1.784	1.076	.976
HORIZONTAL SPREAD	1.501	1.501	1.501
VERTICAL SPREAD	3.038	1.735	1.161
EXTREME SPREAD	3.050	1.916	1.630
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	9		

15 Sep 1990

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

HS= 2.240

VS= 2.170

GS= 2.344

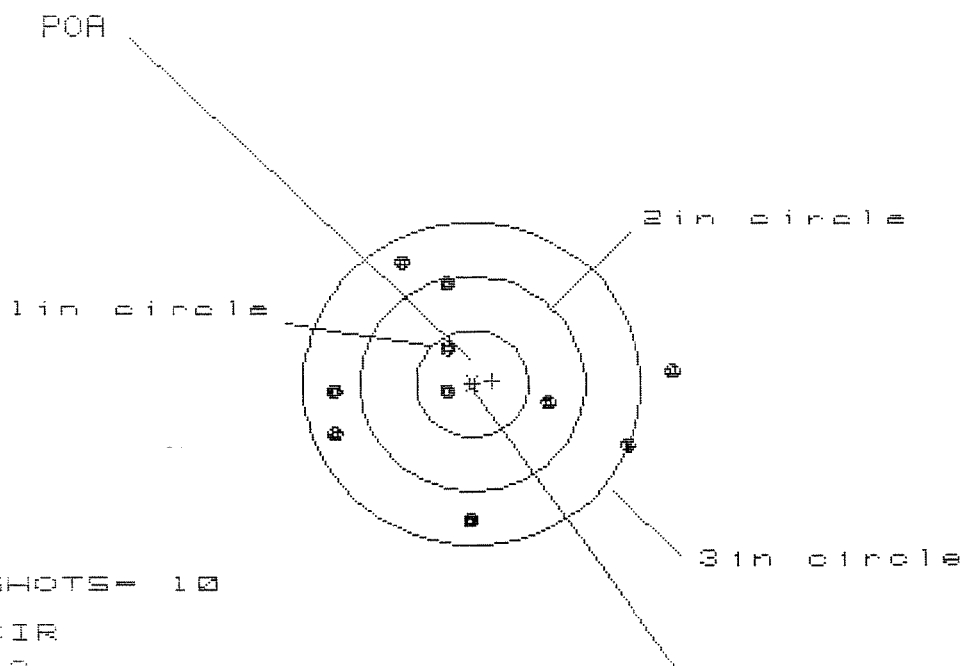
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.391	.584	.520
MINIMUM X	:	-.857	-.703	-.767
MAXIMUM Y	:	1.136	1.170	.909
MINIMUM Y	:	-1.034	-1.000	-.854
CENTROID X	:	.142	-.012	.052
CENTROID Y	:	-.076	-.110	-.256
POA TO CENTROID in.	:	.161	.110	.261
MIN RADIUS	:	.053	.210	.226
MEAN RADIUS	:	.760	.686	.596
MAX RADIUS	:	1.423	1.279	.956
HORIZONTAL SPREAD	:	2.248	1.287	1.287
VERTICAL SPREAD	:	2.170	2.170	1.763
EXTREME SPREAD	:	2.344	2.258	1.781
NUMBER IN ONE INCH CIRCLE	=		3	
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 = 4

3in = 8

HS= 2.978

VS= 2.415

GS= 3.014

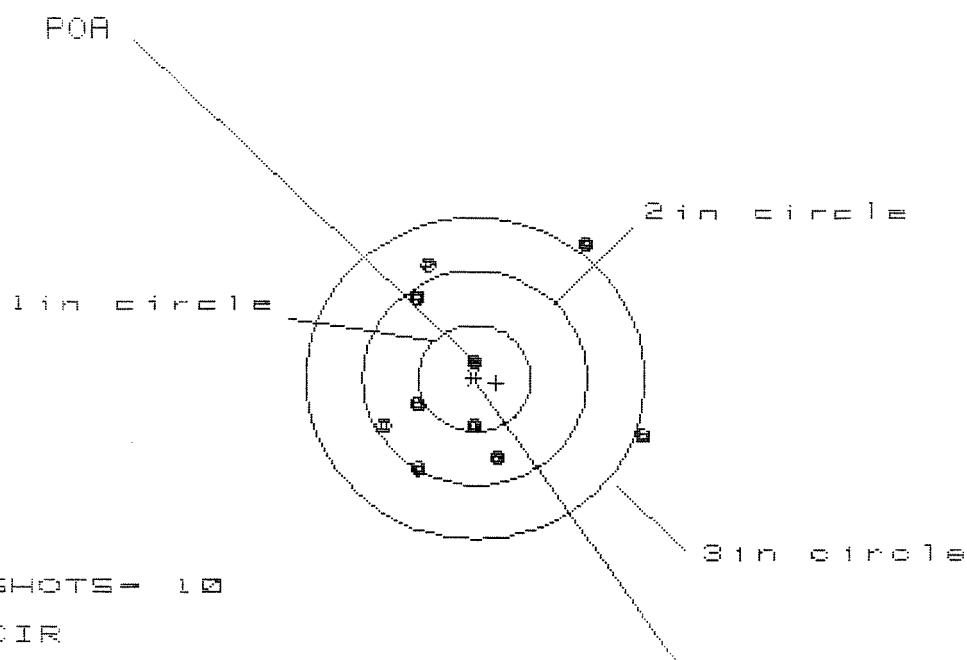
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.768	1.541	1.061
MINIMUM X	:	-1.212	-1.015	-.822
MAXIMUM Y	:	1.170	1.182	1.118
MINIMUM Y	:	-1.245	-1.233	-1.297
CENTROID X	:	-.177	-.374	-.567
CENTROID Y	:	-.031	-.043	.021
POA TO CENTROID in.	:	.188	.376	.567
MIN RADIUS	:	.210	.042	.213
MEAN RADIUS	:	1.059	.942	.850
MAX RADIUS	:	1.771	1.623	1.353
HORIZONTAL SPREAD	:	2.979	2.556	1.883
VERTICAL SPREAD	:	2.415	2.415	2.415
EXTREME SPREAD	:	3.014	2.619	2.500
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 8

HS= 2.209

VS= 2.114

GS= 2.554

CENTROID #

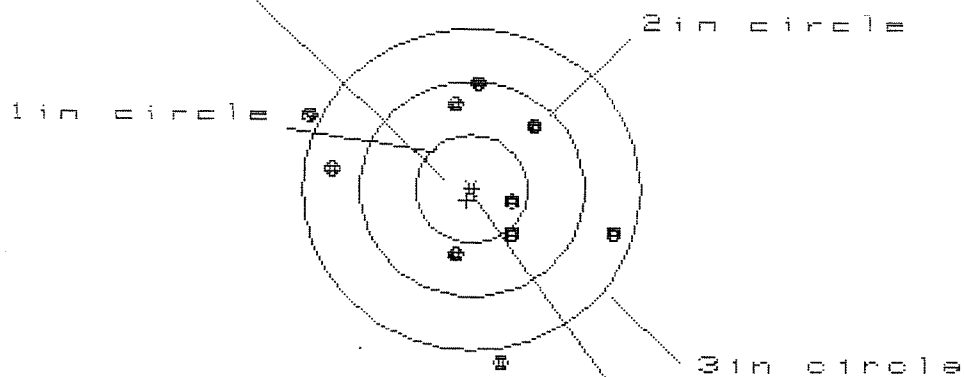
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.447	1.555	.484
MINIMUM X	:	-.762	-.654	-.459
MAXIMUM Y	:	1.232	1.212	1.167
MINIMUM Y	:	-.882	-.745	-.789
CENTROID X	:	-.190	-.298	-.492
CENTROID Y	:	.041	-.096	-.051
POA TO CENTROID in.	:	.194	.313	.495
MIN RADIUS	:	.168	.327	.238
MEAN RADIUS	:	.895	.787	.666
MAX RADIUS	:	1.571	1.595	1.169
HORIZONTAL SPREAD	:	2.209	2.209	.944
VERTICAL SPREAD	:	2.114	1.957	1.957
EXTREME SPREAD	:	2.554	2.399	1.959
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5

FOR



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS = 2.642

VS = 2.590

GS = 2.853

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.220	1.251	1.077
MINIMUM X	-1.422	-1.391	-1.432
MAXIMUM Y	.989	.811	.873
MINIMUM Y	-1.601	-.834	-.772
CENTROID X	.045	.014	.188
CENTROID Y	.111	.289	.227
POA TO CENTROID in.	.120	.289	.295
MIN RADIUS	.417	.530	.358
MEAN RADIUS	1.003	.928	.825
MAX RADIUS	1.625	1.477	1.437
HORIZONTAL SPREAD	2.642	2.642	2.509
VERTICAL SPREAD	2.590	1.645	1.645
EXTREME SPREAD	2.853	2.853	2.589
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

Remington®

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.

REG. U.S. PAT. & T.M. OFF.

SERIAL NO.
C6522259

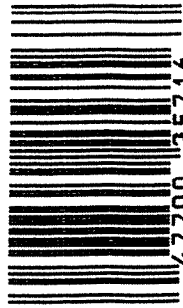
ORDER NO.
5716

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