

C65221B2

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522182

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		7/10/90	KL
600	Proof		7/10/90	KL
607	Check Headspace		7/10/90	KL
610	Dis-assemble Gun		7/10/90	KL
612	Magnaflux Barrel Action		7-17-90	KR
	Magnaflux Bolt		7-17-90	KR
615	Rollmark Caliber		7-17-90	GL
617	Drill and Tap Sight Holes		7/23/90	EB
618	Polish Barrel RB		7/24/90	WB
620	Apply Coatings (Barrel Action)		7-26-90	SA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/13/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/13/90	KS
	C) Inspect Ejector Hole for Chamfer		8/13/90	KS
	D) Oil Firing Pin Ass'y		8/13/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		9-12-90	JH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			8/13/90	QJ
	G) Safety Off Force	3	3	3			8/13/90	QJ
	H) Trigger Pull Test & Retainability						9-12-90	QJ
	I) Firing Pin Indent	.0235	.0235	.0235			8/13/90	QJ
	J) Assemble Stock						8/14/90	KS
	K) Assemble Swivel Studs						8/13/90	QJ
	L) Attach Front and Rear Sight Assemblies						8/14/90	KS
	M) Iron Sight Alignment						8/14/90	KS
	N) Detach Front & Rear Sights & place in numbered container						8/14/90	KS
	O) Attach Scope to Rifle						8/14/90	KS
	P) Detach & Attach Scope 20 Times						8/14/90	KS
640	Gallery Target & Test						8/15/90	A
	A) Time						8/15/90	A
	B) Malfunctions						8/15/90	A
	C) Pierced Primers						8/15/90	A
	D) Optical Clarity of Scope						8/15/90	A
645	Inspect for Live Ammo						8/15/90	A
655	Final Inspection						9/13/90	QJ
	A) Headspace							
	B) Trigger Pull	2.25	2.33	2.25	2.29	2.29	9-12-90	QJ
	C) Function						9/13/90	QJ
660	Pack						9-18-90	QJ

SWS TRIGGER PULL TEST

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

SERIAL NO. C6522182

DATE 9-12-90

TESTER J.P.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.36	2.38	2.25	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.50	2.37	2.35	2.33	
PULL #3	2.27	2.36	2.37	2.25	
PULL #4	2.30	2.36	2.34	2.29	
PULL #5	2.33	2.37	2.37	2.29	
TOTAL	11.84	11.82	11.81	11.41	
AVG.	2.368	2.364	2.362	2.282	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.22	3.28		
PULL #2	3.27	3.28		
PULL #3	3.26	3.26		
PULL #4	3.27	3.33		
PULL #5	3.29	3.34		
TOTAL	16.31	16.49		
AVG.	3.262	3.298		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.30	4.36		4.38
PULL #2	4.33	4.33		4.35
PULL #3	4.33	4.36		4.39
PULL #4	4.28	4.39		4.34
PULL #5	4.35	4.37		4.40
TOTAL	21.59	21.81		21.86
AVG.	4.318	4.362		4.372

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522182
16 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.158152
1 TO	2	.408476
1 TO	3	.267002
1 TO	4	.138224
1 TO	5	.0751798

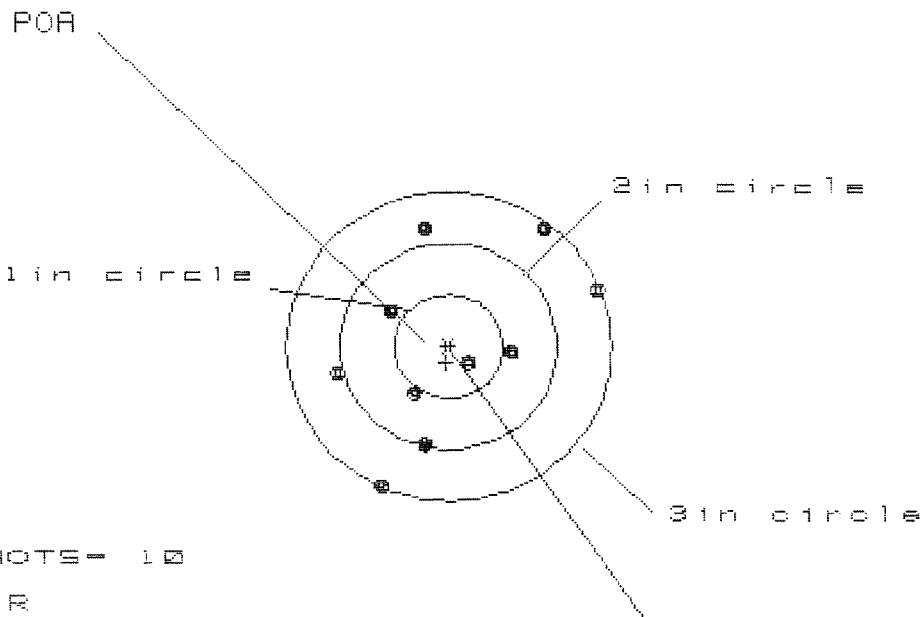
$\frac{3.6}{2}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0544
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0474
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0721534
THE ANR FOR THIS RIFLE IS: .9894

15 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522182

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS= 2.365

VS= 2.575

GS= 2.915

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.383	1.315	.980
MINIMUM X	:	-.982	-1.050	-.886
MAXIMUM Y	:	1.191	1.038	1.001
MINIMUM Y	:	-1.384	-1.104	-1.061
CENTROID X	:	.026	.094	-.070
CENTROID Y	:	.156	.309	.266
POA TO CENTROID in.	:	.158	.323	.275
MIN RADIUS	:	.179	.273	.324
MEAN RADIUS	:	.953	.901	.825
MAX RADIUS	:	1.514	1.360	1.405
HORIZONTAL SPREAD	:	2.365	2.365	1.866
VERTICAL SPREAD	:	2.575	2.142	2.142
EXTREME SPREAD	:	2.915	2.487	2.354
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

16 Aug 1998

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CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 8

3in = 10

HS= 1.679

VS= 2.290

GS= 2.376

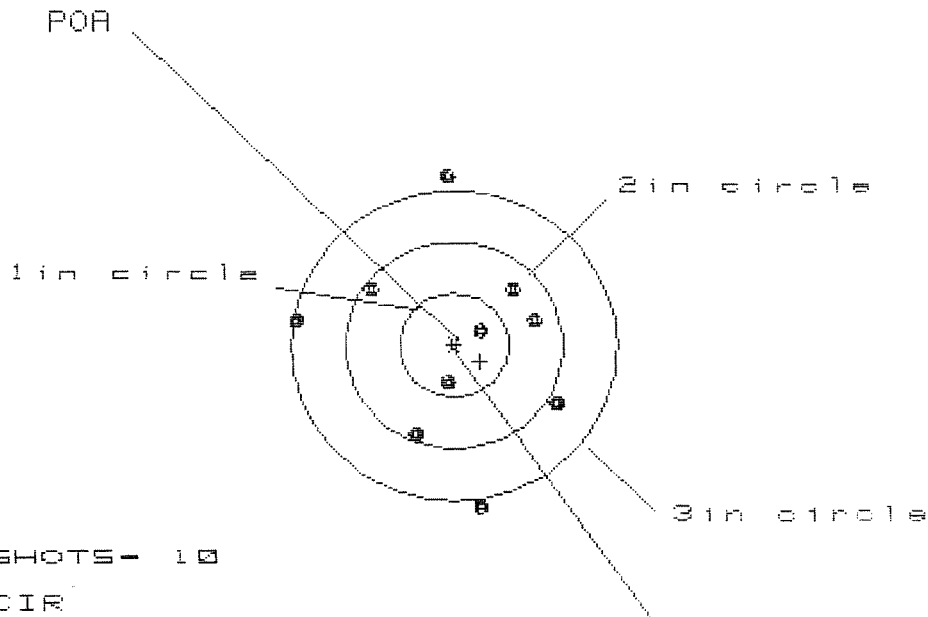
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.857	.812	.704
MINIMUM X	:	-.822	-.867	-.724
MAXIMUM Y	:	.967	.820	.718
MINIMUM Y	:	-1.323	-.812	-.863
CENTROID X	:	-.116	-.071	.037
CENTROID Y	:	-.227	-.080	.022
POA TO CENTROID in.	:	.255	.107	.043
MIN RADIUS	:	.225	.319	.177
MEAN RADIUS	:	.787	.704	.619
MAX RADIUS	:	1.384	1.188	.943
HORIZONTAL SPREAD	:	1.679	1.679	1.427
VERTICAL SPREAD	:	2.290	1.632	1.581
EXTREME SPREAD	:	2.376	1.967	1.645
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			10	

16 Aug 1998

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS= 2.409

VS= 3.163

GS= 3.172

CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.990	.987	1.014
MINIMUM X	:	-1.419	-1.422	-1.395
MAXIMUM Y	:	1.646	.756	.590
MINIMUM Y	:	-1.517	-1.335	-.874
CENTROID X	:	-.241	-.238	-.265
CENTROID Y	:	.157	-.025	.141
POA TO CENTROID in.	:	.288	.239	.300
MIN RADIUS	:	.232	.224	.260
MEAN RADIUS	:	.978	.893	.829
MAX RADIUS	:	1.646	1.482	1.417
HORIZONTAL SPREAD	:	2.409	2.409	2.409
VERTICAL SPREAD	:	3.163	2.091	1.464
EXTREME SPREAD	:	3.172	2.528	2.528
NUMBER IN ONE INCH CIRCLE =	:		2	
NUMBER IN TWO INCH CIRCLE =	:		6	
NUMBER IN THREE INCH CIRCLE =	:		8	

16 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C65221B2

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 3.632

VS= 2.691

GS= 3.450

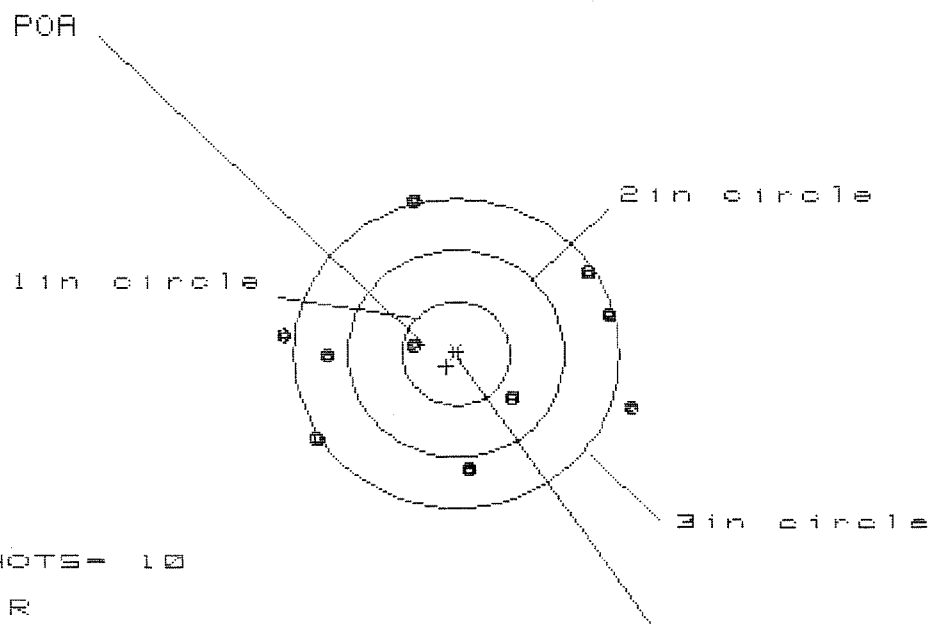
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.448	1.369	.915
MINIMUM X	:	-1.184	-1.263	-1.092
MAXIMUM Y	:	.928	.732	.702
MINIMUM Y	:	-1.763	-.979	-.887
CENTROID X	:	-.033	.046	-.125
CENTROID Y	:	.031	.227	.136
POA TO CENTROID in.	:	.045	.232	.185
MIN RADIUS	:	.139	.321	.156
MEAN RADIUS	:	.975	.963	.759
MAX RADIUS	:	1.901	1.553	1.153
HORIZONTAL SPREAD	:	2.632	2.632	2.007
VERTICAL SPREAD	:	2.691	1.711	1.589
EXTREME SPREAD	:	3.450	2.751	2.118
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

16 Aug 1998

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 2

3in = 6

HS= 3.208

VS= 2.555

GS= 3.305

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.638	1.581	1.406
MINIMUM X	:	-1.578	-1.396	-1.319
MAXIMUM Y	:	1.458	1.395	1.415
MINIMUM Y	:	-1.097	-1.160	-1.139
CENTROID X	:	.092	-.090	.085
CENTROID Y	:	.120	.183	.163
POA TO CENTROID in.	:	.151	.204	.183
MIN RADIUS	:	.397	.206	.381
MEAN RADIUS	:	1.254	1.179	1.153
MAX RADIUS	:	1.726	1.617	1.559
HORIZONTAL SPREAD	:	3.208	2.977	2.725
VERTICAL SPREAD	:	2.555	2.555	2.555
EXTREME SPREAD	:	3.305	2.982	2.975
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		6	



MODEL 700™ H24

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



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

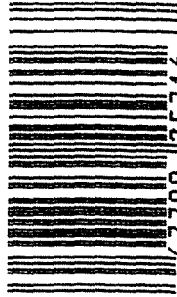
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

SERIAL NO.	C6522182
ORDER NO.	5716



5716 C6522182

UPC



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