

C6522143

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington



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

MODEL 700™ H24

SERIAL NO.
C6522143

ORDER NO.
5716

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

Ø1



5716 C6522143

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # *CL522143*

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		<i>8/13/90</i>	<i>KS</i>
600	Proof		<i>8/13/90</i>	<i>KS</i>
607	Check Headspace		<i>8/13/90</i>	<i>KS</i>
610	Dis-assemble Gun		<i>8/13/90</i>	<i>KS</i>
612	Magnaflux Barrel Action		<i>8/16</i>	<i>KCR</i>
	Magnaflux Bolt		<i>8/16</i>	<i>KCR</i>
615	Rollmark Caliber		<i>8/16</i>	<i>g.s.</i>
617	Drill and Tap Sight Holes		<i>8/23/90</i>	<i>FB</i>
618	Polish Barrel <i>RB</i>		<i>8/23/90</i>	<i>WB</i>
620	Apply Coatings (Barrel Action)		<i>8/23/90</i>	<i>TS</i>
	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		<i>9/14/90</i>	<i>WB</i>

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			9/14/90	WB
	G) Safety Off Force	7 1/2	7 1/2	7 1/2			9/14/90	WB
	H) Trigger Pull Test & Retainability						9/14/90	WB
	I) Firing Pin Indent	.0245	.0245	.0245			9/14/90	WB
	J) Assemble Stock						9/14/90	KA
	K) Assemble Swivel Studs							
	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							
	B) Trigger Pull	2.59	2.49	2.60	2.37	2.49	9-16-90	KE
	C) Function							
660	Pack						9/20/90	NF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6522143
DATE 9/14/90
TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.37	2.47	2.59	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.49	2.36	2.20	2.49	
PULL #3	2.36	2.41	2.33	2.60	
PULL #4	2.32	2.44	2.17	2.37	
PULL #5	2.38	2.34	2.19	2.49	
TOTAL	11.99	11.92	11.36	12.54	
AVG.	2.40	2.38	2.27	2.508	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.07	3.11		
PULL #2	3.09	2.90		
PULL #3	2.95	3.06		
PULL #4	3.02	3.05		
PULL #5	3.14	2.95		
TOTAL	15.27	15.07		
AVG.	3.05	3.01		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.27	4.00		4.30
PULL #2	4.19	3.95		4.34
PULL #3	4.07	4.00		4.35
PULL #4	4.11	4.00		4.26
PULL #5	4.27	4.08		4.22
TOTAL	20.91	20.03		21.47
AVG.	4.18	4.01		4.29

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522143
15 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.401384
1 TO	2	.474175
1 TO	3	.531154
1 TO	4	.143684
1 TO	5	.277683

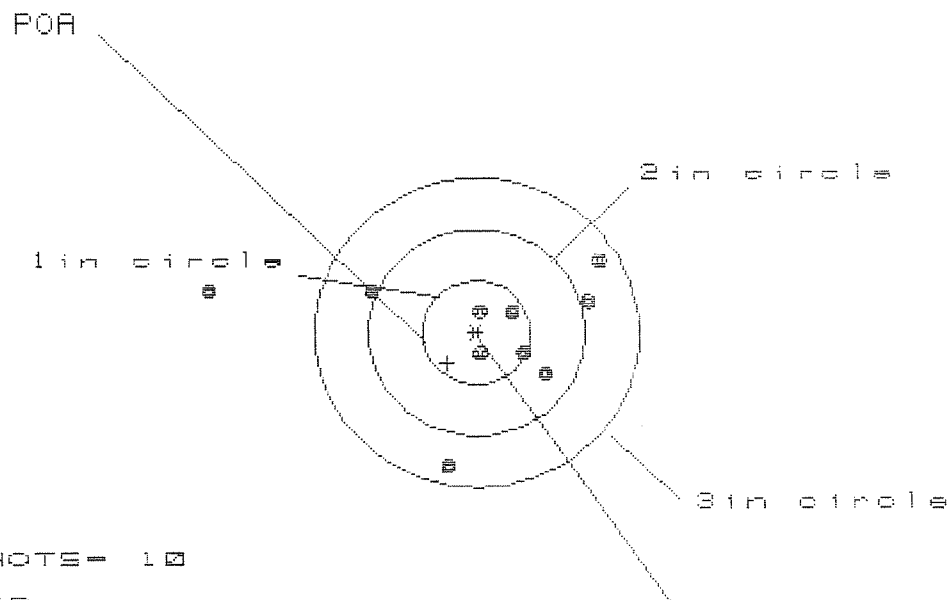
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THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .093
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0896
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .12914
THE AMR FOR THIS RIFLE IS: .9836

15 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522143

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 4

2 in = 5

3 in = 9

HS = 3.542

VS = 2.007

GS = 3.552

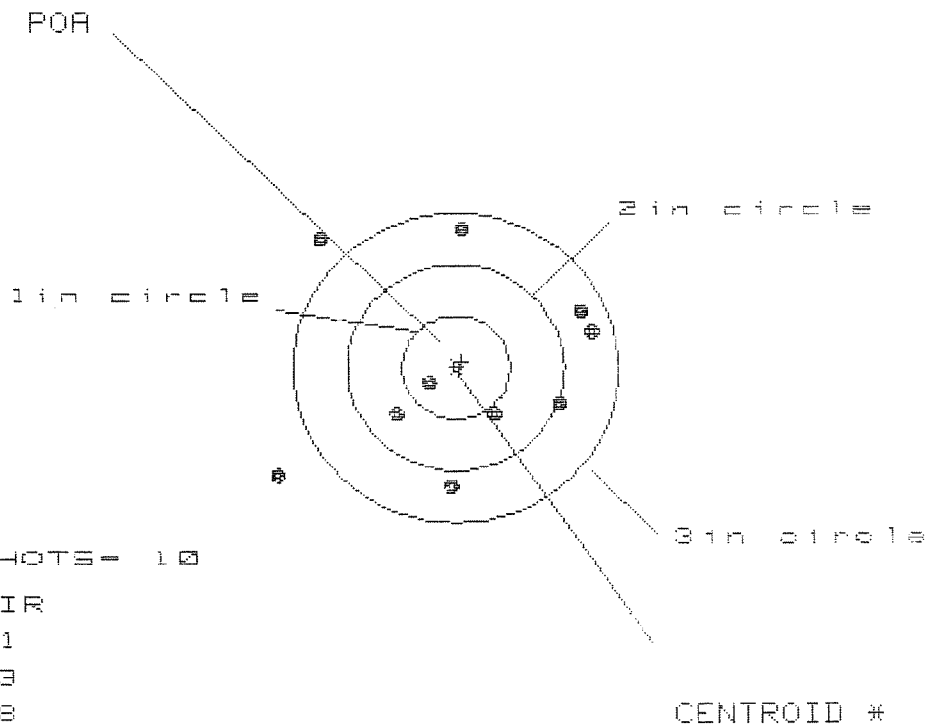
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.113	.843	.769
MINIMUM X	:	-2.429	-1.194	-1.268
MAXIMUM Y	:	.673	.719	.558
MINIMUM Y	:	-1.334	-1.288	-.478
CENTROID X	:	.270	.540	.614
CENTROID Y	:	.297	.251	.412
POA TO CENTROID in.	:	.401	.596	.739
MIN RADIUS	:	.204	.217	.048
MEAN RADIUS	:	.922	.683	.581
MAX RADIUS	:	2.464	1.415	1.300
HORIZONTAL SPREAD	:	3.542	2.037	2.037
VERTICAL SPREAD	:	2.007	2.007	1.036
EXTREME SPREAD	:	3.552	2.464	2.055
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

15 Sep 1990

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 3

3 in = 8

HS= 2.862

VS= 2.453

GS= 3.194

PATTERN #	:	2
SHOTS (BEST OF)	:	10
MAXIMUM X	:	1.228
MINIMUM X	:	-1.635
MAXIMUM Y	:	1.350
MINIMUM Y	:	-1.103
CENTROID X	:	-.051
CENTROID Y	:	-.052
POA TO CENTROID in.	:	.073
MIN RADIUS	:	.283
MEAN RADIUS	:	1.135
MAX RADIUS	:	1.941
HORIZONTAL SPREAD	:	2.862
VERTICAL SPREAD	:	2.453
EXTREME SPREAD	:	3.194
NUMBER IN ONE INCH CIRCLE	=	1
NUMBER IN TWO INCH CIRCLE	=	3
NUMBER IN THREE INCH CIRCLE	=	8

15 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8522143

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 10

HS= 2.621

VS= 2.316

GS= 2.785

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.462	1.333	.760
MINIMUM X	:	-1.159	-.605	-.438
MAXIMUM Y	:	.947	1.050	1.063
MINIMUM Y	:	-1.369	-1.263	-1.250
CENTROID X	:	.065	.194	.027
CENTROID Y	:	-.193	-.299	-.312
POA TO CENTROID in.	:	.204	.356	.314
MIN RADIUS	:	.232	.068	.207
MEAN RADIUS	:	.913	.825	.752
MAX RADIUS	:	1.497	1.382	1.310
HORIZONTAL SPREAD	:	2.621	1.938	1.198
VERTICAL SPREAD	:	2.316	2.313	2.313
EXTREME SPREAD	:	2.785	2.570	2.570
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

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FILE:/PATTERNING/CENTERFIRE_PATT/C8522143

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= .731

VS= 3.501

GS= 3.565

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.425

.453

.429

MINIMUM X

-.306

-.259

-.283

MAXIMUM Y

1.593

1.381

1.414

MINIMUM Y

-1.908

-1.439

-1.266

CENTROID X

.173

.126

.150

CENTROID Y

.191

.403

.230

POA TO CENTROID in.

.257

.422

.275

MIN RADIUS

.081

.243

.087

MEAN RADIUS

1.030

.898

.837

MAX RADIUS

1.955

1.509

1.416

HORIZONTAL SPREAD

.731

.712

.712

VERTICAL SPREAD

3.501

2.820

2.680

EXTREME SPREAD

3.565

2.894

2.727

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

5

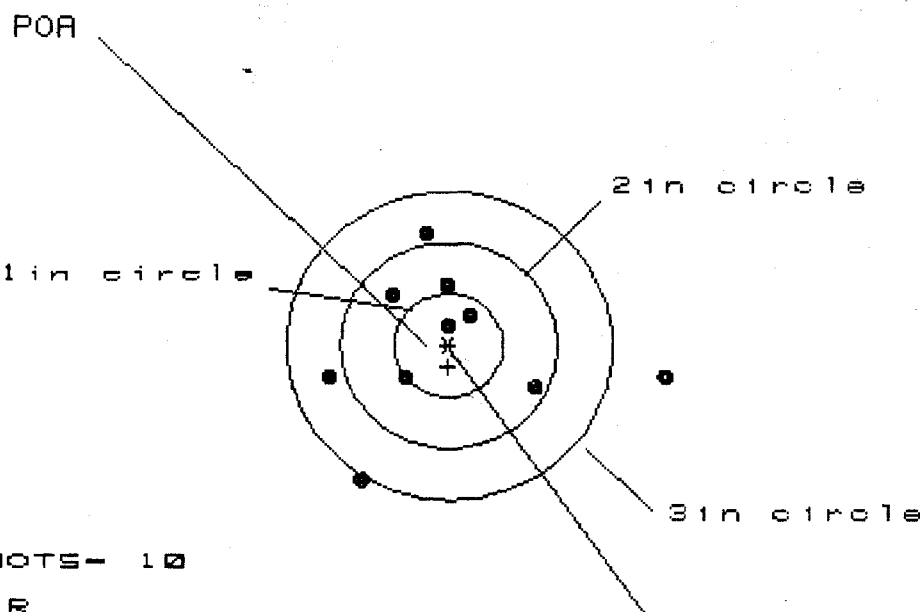
NUMBER IN THREE INCH CIRCLE =

8

15 Sep 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6522143

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 3.084

VS= 2.379

GS= 3.084

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.993	1.040	.968
MINIMUM X	:	-1.091	-.870	-.942
MAXIMUM Y	:	1.062	1.026	.857
MINIMUM Y	:	-1.317	-1.353	-.598
CENTROID X	:	.008	-.213	-.141
CENTROID Y	:	.205	.241	.410
POA TO CENTROID in.	:	.206	.322	.433
MIN RADIUS	:	.188	.267	.147
MEAN RADIUS	:	.918	.778	.647
MAX RADIUS	:	2.018	1.472	1.137
HORIZONTAL SPREAD	:	3.084	1.910	1.910
VERTICAL SPREAD	:	2.379	2.379	1.455
EXTREME SPREAD	:	3.084	2.458	1.911
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	