

C6522280

MODEL 700™ M241

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522280

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 29	90	RW
600	Proof	6 29	90	RW
607	Check Headspace	6 29	90	RW
610	Dis-assemble Gun	6 29	90	RW
612	Magnaflux Barrel Action		7-12-90	KR
	Magnaflux Bolt		7-12-90	KR
615	Rollmark Caliber		7-12-90	LS.
617	Drill and Tap Sight Holes		7/13/90	FB
618	Polish Barrel RB		7/16/90	WB
620	Apply Coatings (Barrel Action)		7-23-90	TH
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		7/25/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/25/90	RW
	C) Inspect Ejector Hole for Chamfer		7/25/90	RW
	D) Oil Firing Pin Ass'y		7/25/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/25/90	RM

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			8/2/90	RL
	G) Safety Off Force	3	3	3			8/2/90	RL
	H) Trigger Pull Test & Retainability						8/25/90	RL
	I) Firing Pin Indent	.023	.023	.022			8/2/91	RL
	J) Assemble Stock						8/7/90	RW
	K) Assemble Swivel Studs						8/30/90	RS
	L) Attach Front and Rear Sight Assemblies						8/7/90	RW
	M) Iron Sight Alignment						8/7/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/7/90	RW
	O) Attach Scope to Rifle						8/7/90	RW
	P) Detach & Attach Scope 20 Times						8/7/90	RW
640	Gallery Target & Test						8/5/90	NT
	A) Time						8/7/90	NT
	B) Malfunctions						8/7/90	NT
	C) Pierced Primers						8/7/90	NT
	D) Optical Clarity of Scope						8/7/90	NT
645	Inspect for Live Ammo						8/7/90	NT
655	Final Inspection							
	A) Headspace						8/30/90	RS
	B) Trigger Pull	2.34	2.31	2.36	2.41	2.42	8/25/90	RL
	C) Function						8/30/90	RS
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. C6522280

DATE 8/25/90

TESTER 88

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.37	2.28	2.34	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.37	2.32	2.29	2.31	
PULL #3	2.33	2.35	2.30	2.36	
PULL #4	2.34	2.33	2.32	2.41	
PULL #5	2.35	2.37	2.30	2.42	
TOTAL	11.85	11.74	11.49	11.84	
AVG.	2.37	2.348	2.298	2.368	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.10	3.31		
PULL #2	3.30	3.23		
PULL #3	3.16	3.29		
PULL #4	3.22	3.30		
PULL #5	3.28	3.27		
TOTAL	16.06	16.40		
AVG.	3.212	3.28		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.49	4.30		4.05
PULL #2	4.17	4.25		4.13
PULL #3	4.25	4.12		4.11
PULL #4	4.27	4.11		4.10
PULL #5	4.17	4.08		4.22
TOTAL	21.35	20.86		20.61
AVG.	4.27	4.172		4.122

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522280
7 Aug 1990

CENTROIDAL DISTANCES

0	TO	1	.339285
1	TO	2	.842719
1	TO	3	.372776
1	TO	4	.655131
1	TO	5	1.17426

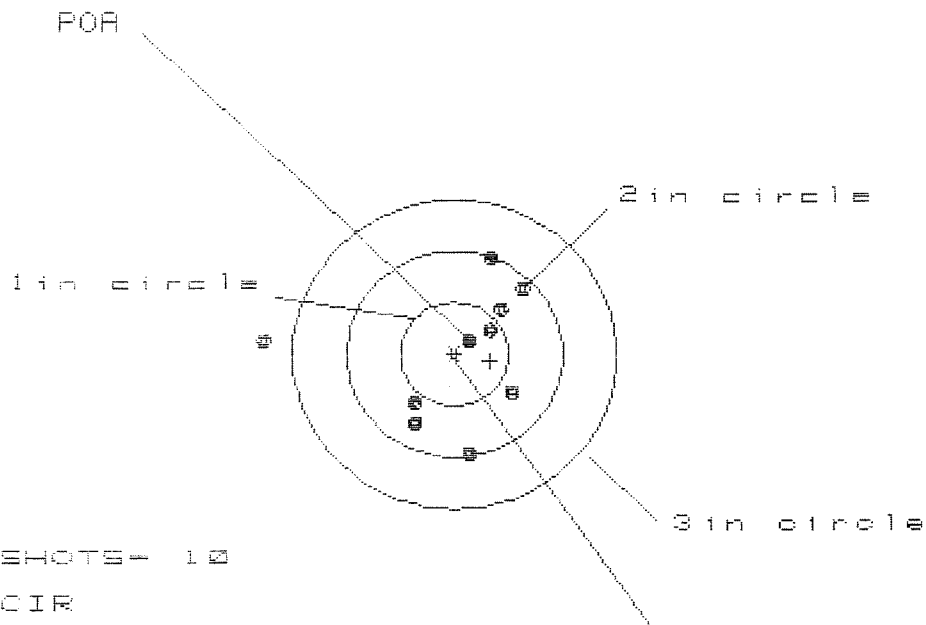
2 4
17 5 (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1124
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .3746
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .3911
THE AMR FOR THIS RIFLE IS: .7598

7 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522280

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 9

3in = 9

HS= 2.370

VS= 1.812

GS= 2.428

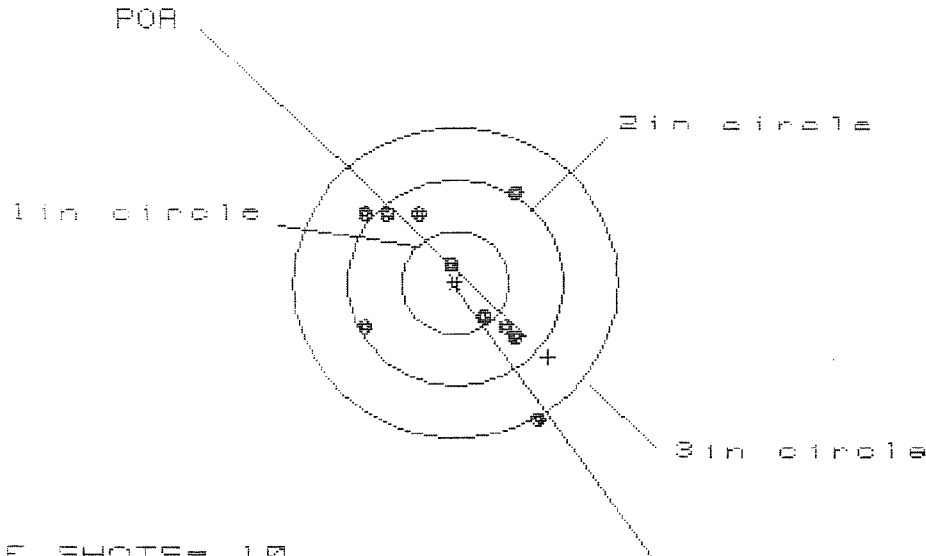
CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.595	.397	.414
MINIMUM X	:	-1.776	-.530	-.513
MAXIMUM Y	:	.885	.898	.759
MINIMUM Y	:	-.927	-.914	-.802
CENTROID X	:	-.333	-.135	-.152
CENTROID Y	:	.065	.052	-.060
POA TO CENTROID in.	:	.339	.145	.163
MIN RADIUS	:	.165	.142	.241
MEAN RADIUS	:	.772	.623	.596
MAX RADIUS	:	1.779	.920	.864
HORIZONTAL SPREAD	:	2.370	.927	.927
VERTICAL SPREAD	:	1.812	1.812	1.561
EXTREME SPREAD	:	2.428	1.827	1.640
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	9		
NUMBER IN THREE INCH CIRCLE	=	9		

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS= 1.606

VS= 2.160

GS= 2.581

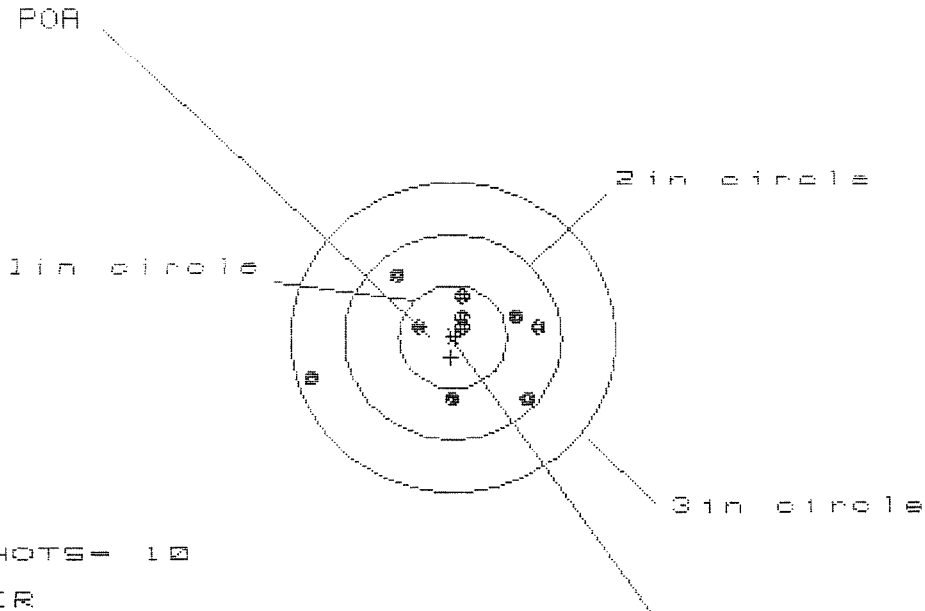
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.788	.659	.567
MINIMUM X	:	-.818	-.730	-.811
MAXIMUM Y	:	.830	.682	.749
MINIMUM Y	:	-1.330	-.668	-.601
CENTROID X	:	-.857	-.945	-.853
CENTROID Y	:	.725	.873	.805
POR TO CENTROID in.	:	1.123	1.286	1.173
MIN RADIUS	:	.170	.056	.095
MEAN RADIUS	:	.826	.728	.699
MAX RADIUS	:	1.546	.948	.969
HORIZONTAL SPREAD	:	1.606	1.389	1.378
VERTICAL SPREAD	:	2.160	1.350	1.350
EXTREME SPREAD	:	2.581	1.881	1.881
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 4

2in = 9

3in = 10

HS= 2.069

VS= 1.182

GS= 2.109

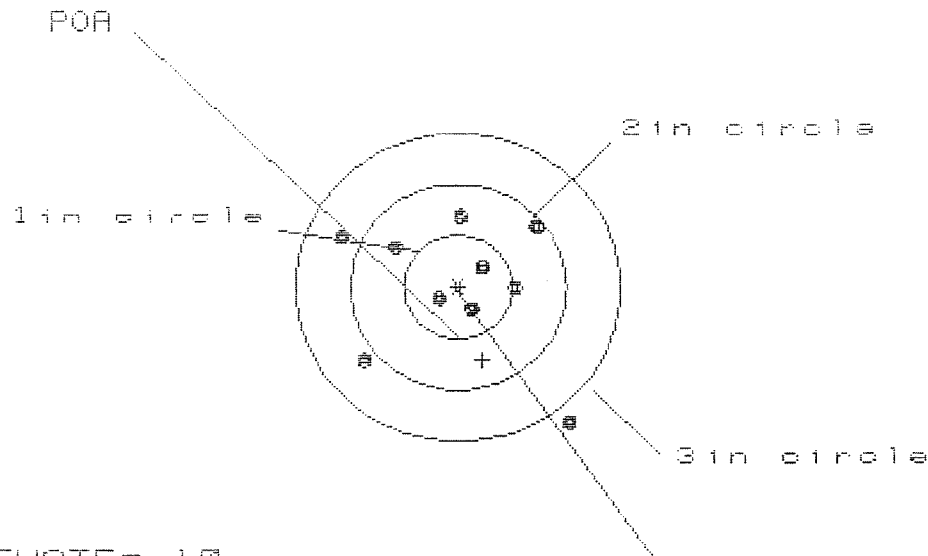
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.783	.640	.783
MINIMUM X	:	-1.286	-.698	-.635
MAXIMUM Y	:	.553	.515	.432
MINIMUM Y	:	-.628	-.667	-.673
CENTROID X	:	.016	.159	.096
CENTROID Y	:	.196	.235	.318
POA TO CENTROID in.	:	.197	.284	.333
MIN RADIUS	:	.085	.079	.070
MEAN RADIUS	:	.596	.498	.432
MAX RADIUS	:	1.332	.867	.768
HORIZONTAL SPREAD	:	2.069	1.338	1.338
VERTICAL SPREAD	:	1.182	1.182	1.105
EXTREME SPREAD	:	2.109	1.687	1.426
NUMBER IN ONE INCH CIRCLE =			4	
NUMBER IN TWO INCH CIRCLE =			9	
NUMBER IN THREE INCH CIRCLE =			10	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 2.108

VS= 1.990

GS= 2.754

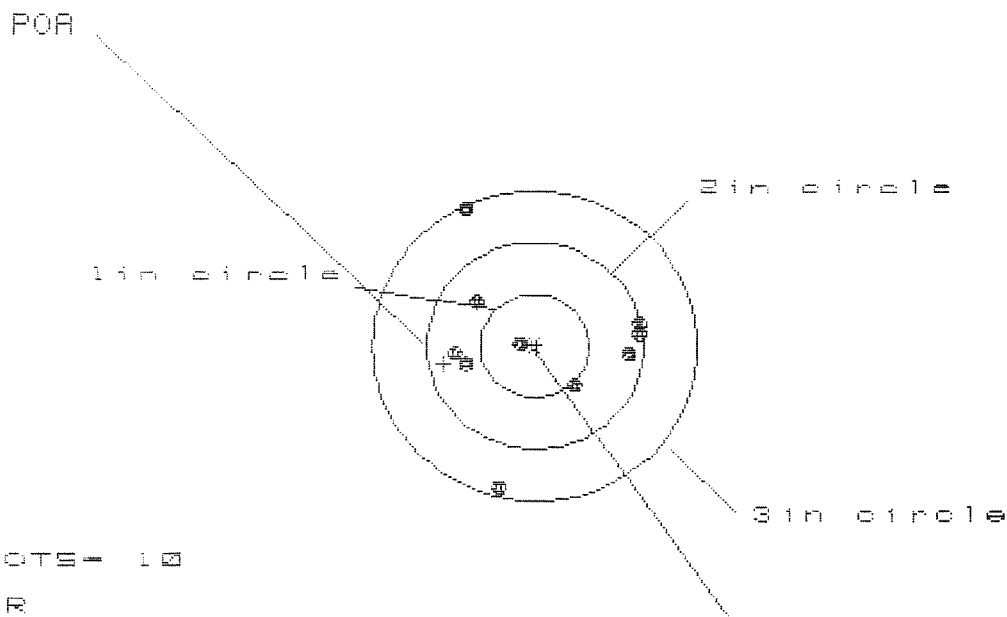
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.984	.846	.719
MINIMUM X	:	-1.124	-1.014	-.920
MAXIMUM Y	:	.691	.547	.588
MINIMUM Y	:	-1.299	-.843	-.802
CENTROID X	:	-.224	-.334	-.207
CENTROID Y	:	.711	.855	.814
POA TO CENTROID in.	:	.745	.918	.840
MIN RADIUS	:	.198	.273	.228
MEAN RADIUS	:	.756	.663	.584
MAX RADIUS	:	1.630	1.158	1.221
HORIZONTAL SPREAD	:	2.108	1.860	1.639
VERTICAL SPREAD	:	1.990	1.390	1.390
EXTREME SPREAD	:	2.754	2.067	2.067
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 8

3in = 10

HS= 1.698

VS= 2.739

GS= 2.760

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.931	.860	.814
MINIMUM X	:	-.767	-.838	-.884
MAXIMUM Y	:	1.326	.530	.371
MINIMUM Y	:	-1.413	-1.265	-.401
CENTROID X	:	.836	.907	.953
CENTROID Y	:	.176	.028	.187
POR TO CENTROID in.	:	.855	.908	.971
MIN RADIUS	:	.126	.246	.242
MEAN RADIUS	:	.849	.778	.702
MAX RADIUS	:	1.471	1.317	.885
HORIZONTAL SPREAD	:	1.698	1.698	1.698
VERTICAL SPREAD	:	2.739	1.795	.772
EXTREME SPREAD	:	2.760	2.068	1.723
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

Remington® REG. U.S. PAT. & TM. OFF.

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.

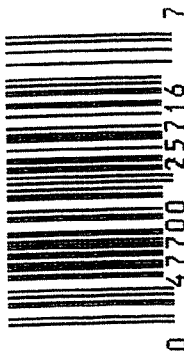
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