

C6522293

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522293

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	8 2	90	RW
600	Proof	8 2	90	RW
607	Check Headspace	8 2	90	RW
610	Dis-assemble Gun	8 2	90	RW
612	Magnaflux Barrel Action		8/7/90	KR
	Magnaflux Bolt		8/7/90	KR
615	Rollmark Caliber		8/7/90	JS
617	Drill and Tap Sight Holes		8/10/90	WB
618	Polish Barrel RB		8/14/90	WB
620	Apply Coatings (Barrel Action)		8/24/90	TS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/27/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/27/90	RW
	C) Inspect Ejector Hole for Chamfer		8/27/90	RW
	D) Oil Firing Pin Ass'y		8/27/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/30/90	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2			8/30/90	WB
	G) Safety Off Force	3	3	3			8/30/90	WB
	H) Trigger Pull Test & Retainability						8/30/90	SC
	I) Firing Pin Indent	.022	.022	.022			8/30/90	WB
	J) Assemble Stock						8/31/90	RW
	K) Assemble Swivel Studs						9/6/90	JS
	L) Attach Front and Rear Sight Assemblies						8/31/90	RW
	M) Iron Sight Alignment						8/31/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/31/90	RW
	O) Attach Scope to Rifle						8/31/90	RW
	P) Detach & Attach Scope 20 Times						8/31/90	RW
640	Gallery Target & Test						9/4/90	KJ
	A) Time						9/4/90	KJ
	B) Malfunctions						9/4/90	KJ
	C) Pierced Primers						9/4/90	KJ
	D) Optical Clarity of Scope						9/4/90	KJ
645	Inspect for Live Ammo						9/4/90	KJ
655	Final Inspection							
	A) Headspace						9/6/90	JS
	B) Trigger Pull	2.16	2.15	2.24	2.22	2.27	9-5-90	SC
	C) Function						9/6/90	JS
660	Pack						2/20/90	NF

SWS TRIGGER PULL TEST

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

SERIAL NO. 06522293

DATE 8/30/90

TESTER J. P. K.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.24	2.20	2.25	2.16	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.25	2.39	2.33	2.15	
PULL #3	2.35	2.37	2.23	2.24	
PULL #4	2.25	2.33	2.25	2.22	
PULL #5	2.24	2.22	2.20	2.27	
TOTAL	11.33	11.51	11.26	11.04	
AVG.	2.266	2.302	2.252	2.208	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.33	3.27		
PULL #2	3.62	3.43		
PULL #3	3.35	3.40		
PULL #4	3.39	3.32		
PULL #5	3.21	3.47		
TOTAL	16.90	16.89		
AVG.	3.38	3.378		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.11	4.27		4.22
PULL #2	4.28	4.22		4.19
PULL #3	4.26	4.29		4.27
PULL #4	4.20	4.26		4.23
PULL #5	4.27	4.24		4.22
TOTAL	21.12	21.28		21.13
AVG.	4.224	4.256		4.226

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522293
5 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.705698
1 TO	2	.848374
1 TO	3	.463764
1 TO	4	.79359
1 TO	5	.69148

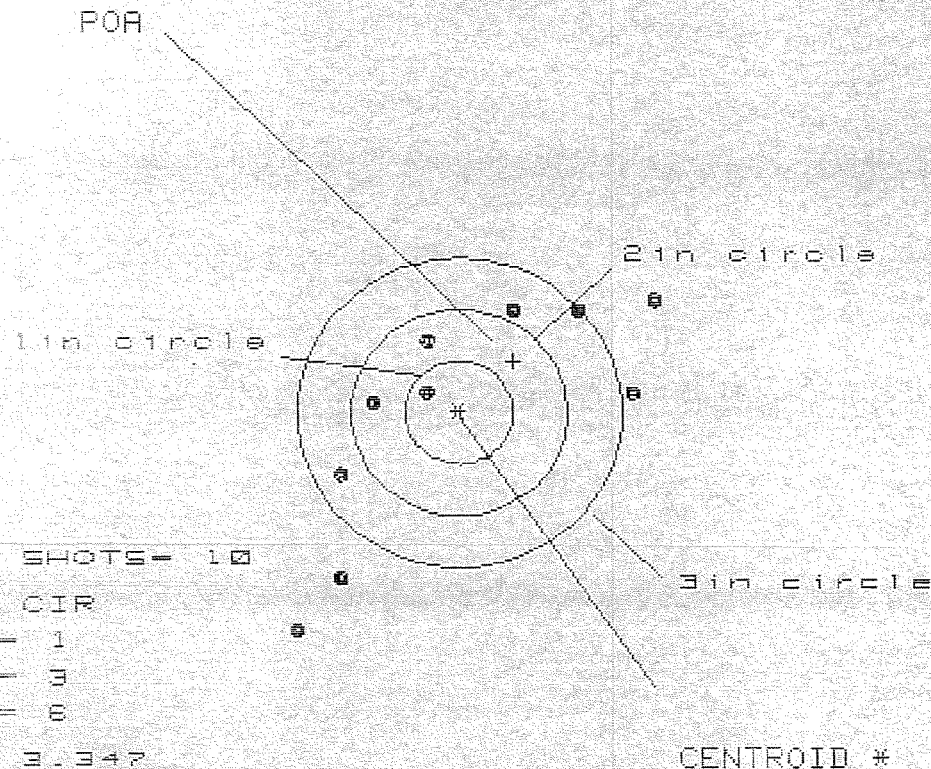
4 <----POA
34
1

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2594
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0068
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .259489
THE AMR FOR THIS RIFLE IS: .9682

5 Sep 1938

FILE:/PATTERNING/CENTERFIRE_PATT/G6522293

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 3

3 in = 6

HS= 3.347

VS= 3.106

GS= 4.566

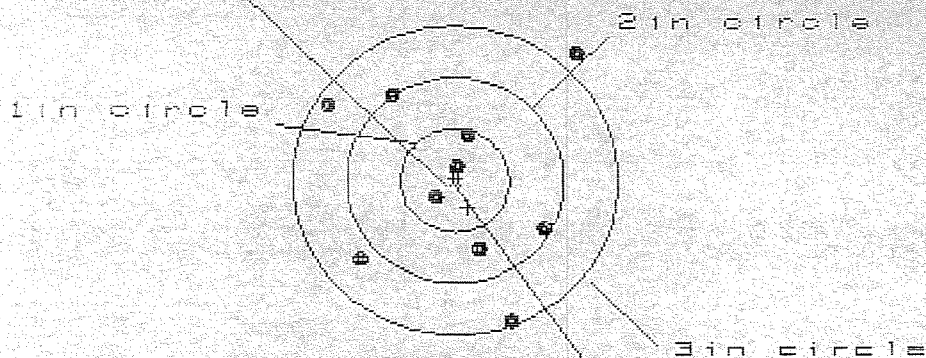
PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.824	1.655	1.619
MINIMUM X	:	-1.523	-1.293	-1.087
MAXIMUM Y	:	1.050	.822	.899
MINIMUM Y	:	-2.056	-1.792	-1.690
CENTROID X	:	-.501	-.332	-.538
CENTROID Y	:	-.497	-.269	-.371
POA TO CENTROID in.	:	.706	.427	.654
MIN RADIUS	:	.378	.463	.280
MEAN RADIUS	:	1.392	1.232	1.124
MAX RADIUS	:	2.559	2.189	1.989
HORIZONTAL SPREAD	:	3.347	2.948	2.705
VERTICAL SPREAD	:	3.106	2.614	2.589
EXTREME SPREAD	:	4.566	3.912	3.365
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		6	

5 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06522293

CENTERFIRE PATTERNS # 2

POA



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 9

HS= 2.275

VS= 2.563

GS= 2.860

CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.128	.942	1.018
MINIMUM X	:	-1.147	-1.021	-.945
MAXIMUM Y	:	1.228	.970	.821
MINIMUM Y	:	-1.335	-1.199	-.802
CENTROID X	:	-.118	-.243	-.319
CENTROID Y	:	.260	.124	.274
POA TO CENTROID in.	:	.285	.273	.420
MIN RADIUS	:	.107	.064	.209
MEAN RADIUS	:	.910	.819	.756
MAX RADIUS	:	1.668	1.365	1.210
HORIZONTAL SPREAD	:	2.275	1.963	1.963
VERTICAL SPREAD	:	2.563	2.169	1.623
EXTREME SPREAD	:	2.860	2.664	2.291
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

5 Sep 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6522293

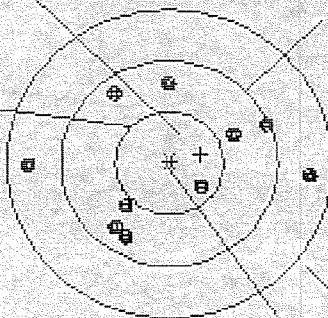
CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle



OF SHOTS = 10

IN CIR

1in = 1

2in = 8

3in = 10

HS = 2.583

VS = 1.465

GS = 2.586

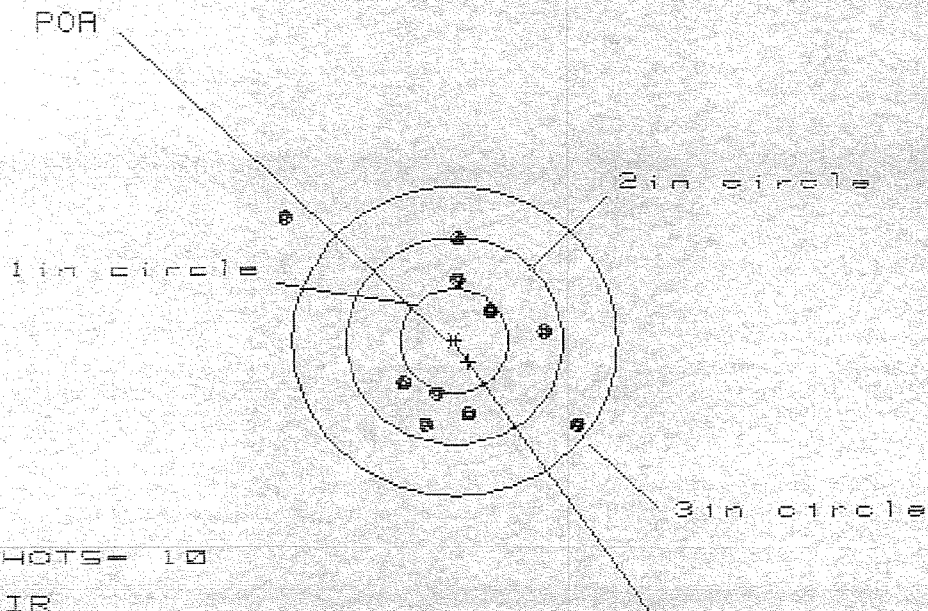
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.299	1.034	.891
MINIMUM X	:	-1.284	-1.139	-.500
MAXIMUM Y	:	.737	.723	.720
MINIMUM Y	:	-.728	-.742	-.745
CENTROID X	:	-.292	-.437	-.294
CENTROID Y	:	-.083	-.069	-.066
POA TO CENTROID in.	:	.304	.442	.302
MIN RADIUS	:	.353	.482	.365
MEAN RADIUS	:	.839	.782	.725
MAX RADIUS	:	1.306	1.140	.981
HORIZONTAL SPREAD	:	2.583	2.173	1.391
VERTICAL SPREAD	:	1.465	1.465	1.465
EXTREME SPREAD	:	2.586	2.216	1.731
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

5 Sep 1988

FILE: PATTERNING/CENTERFIRE_PATT/C6522293

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS= 2.791

VS= 2.002

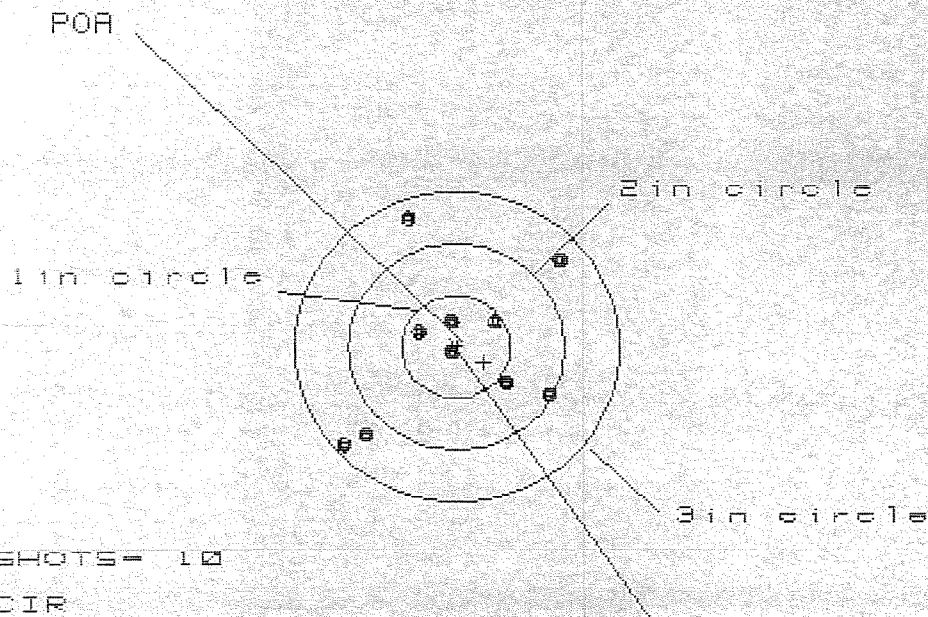
GS= 3.421

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.177	.997	.751
MINIMUM X	:	-1.614	-.656	-.531
MAXIMUM Y	:	1.218	1.154	1.076
MINIMUM Y	:	-.784	-.649	-.727
CENTROID X	:	-.129	.051	-.074
CENTROID Y	:	.204	.069	.147
POA TO CENTROID in.	:	.241	.085	.164
MIN RADIUS	:	.454	.480	.463
MEAN RADIUS	:	.910	.765	.704
MAX RADIUS	:	2.022	1.177	1.076
HORIZONTAL SPREAD	:	2.791	1.653	1.282
VERTICAL SPREAD	:	2.002	1.803	1.803
EXTREME SPREAD	:	3.421	2.097	1.843
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

5 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522293

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 4

2 in = 5

3 in = 10

HS= 2.037

VS= 2.219

GS= 2.731

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.993	.877	.811
MINIMUM X	:	-1.044	-.966	-1.032
MAXIMUM Y	:	1.233	1.124	.864
MINIMUM Y	:	-.986	-1.007	-.867
CENTROID X	:	-.257	-.141	-.075
CENTROID Y	:	.150	.259	.119
POA TO CENTROID in.	:	.297	.295	.140
MIN RADIUS	:	.046	.177	.215
MEAN RADIUS	:	.790	.713	.649
MAX RADIUS	:	1.436	1.396	1.348
HORIZONTAL SPREAD	:	2.037	1.843	1.843
VERTICAL SPREAD	:	2.219	2.131	1.731
EXTREME SPREAD	:	2.731	2.528	2.528
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

Remington
REG. U.S. PAT. & TM. OFF.

MODEL 700TM 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.

UPPONT

SERIAL NO. C6522293	ORDER NO. 5716
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