

C6587599

MODEL 700TH M24

Model **SWS** TH

Action

Barrel Length

Capacity

Order No. **5716**

* Includes 1 in chamber.

Remington

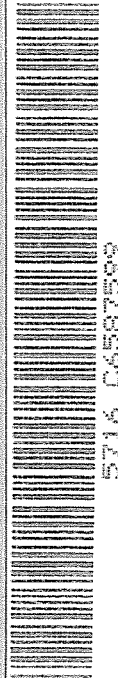
Remington[®] **DUPONT**
REG. U.S. PAT. & TM. OFF.

MODEL 700TM H24

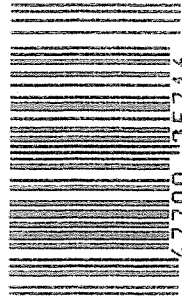
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

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

SERIAL NO. C6587599	ORDER NO. 5716
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UPC



CONTRACT # DAAA21-87-C-0086

NEW BBLGUN SERIAL # C 6587599

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/24/90	Kd
600	Proof		10/24/90	Kd
607	Check Headspace		10/24/90	Kd
610	Dis-assemble Gun		10/24/90	Kd
612	Magnaflux Barrel Action		10/30/90	KR
	Magnaflux Bolt		10/30/90	KR
615	Rollmark Caliber		10/30/90	GL
617	Drill and Tap Sight Holes		11/6/90	LB
618	Polish Barrel RB		11/7/90	WB
620	Apply Coatings (Barrel Action)		11-26-90	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/30/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/30/90	KS
	C) Inspect Ejector Hole for Chamfer		11/30/90	K
	D) Oil Firing Pin Ass'y		11/30/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		12/3/90	TH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/2	5 1/2	5 1/2			12/4/90	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			12/4/90	WB
	H) Trigger Pull Test & Retainability						12-3-90	JL
	I) Firing Pin Indent	.023	.023	.023			12/4/90	WB
	J) Assemble Stock						12/8/90	KS
	K) Assemble Swivel Studs						12-12-90	JS
	L) Attach Front and Rear Sight Assemblies						12/8/90	KS
	M) Iron Sight Alignment						12/8/90	KS
	N) Detach Front & Rear Sights & place in numbered container						12/8/90	KS
	O) Attach Scope to Rifle						12/8/90	KS
	P) Detach & Attach Scope 20 Times						12/8/90	KS
640	Gallery Target & Test						12/10/90	KJ
	A) Time						"	KJ
	B) Malfunctions						"	KJ
	C) Pierced Primers						"	KJ
	D) Optical Clarity of Scope						"	KJ
645	Inspect for Live Ammo						12/10/90	JS
655	Final Inspection							
	A) Headspace						12-12-90	JS
	B) Trigger Pull	273	277	282	275	278	12-12-90	JS
	C) Function						12-12-90	JS
660	Pack						12/14/90	AF

SWS TRIGGER PULL TEST

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

SERIAL NO. 66587599

DATE 12-3-90

TESTER JPL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.37	2.34	2.73	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.38	2.49	2.40	2.77	
PULL #3	2.37	2.41	2.36	2.82	
PULL #4	2.35	2.36	2.42	2.75	
PULL #5	2.39	2.37	2.42	2.78	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.50	3.25		
PULL #2	3.25	3.27		
PULL #3	3.24	3.32		
PULL #4	3.23	3.29		
PULL #5	3.10	3.29		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.48	4.44		4.45
PULL #2	4.27	4.21		4.47
PULL #3	4.46	4.36		4.42
PULL #4	4.43	4.39		4.46
PULL #5	4.46	4.42		4.25
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587599
11 Dec 1990

CENTROIDAL DISTANCES

0 TO	1	.116709
1 TO	2	.0728972
1 TO	3	.195164
1 TO	4	.127577
1 TO	5	.11673

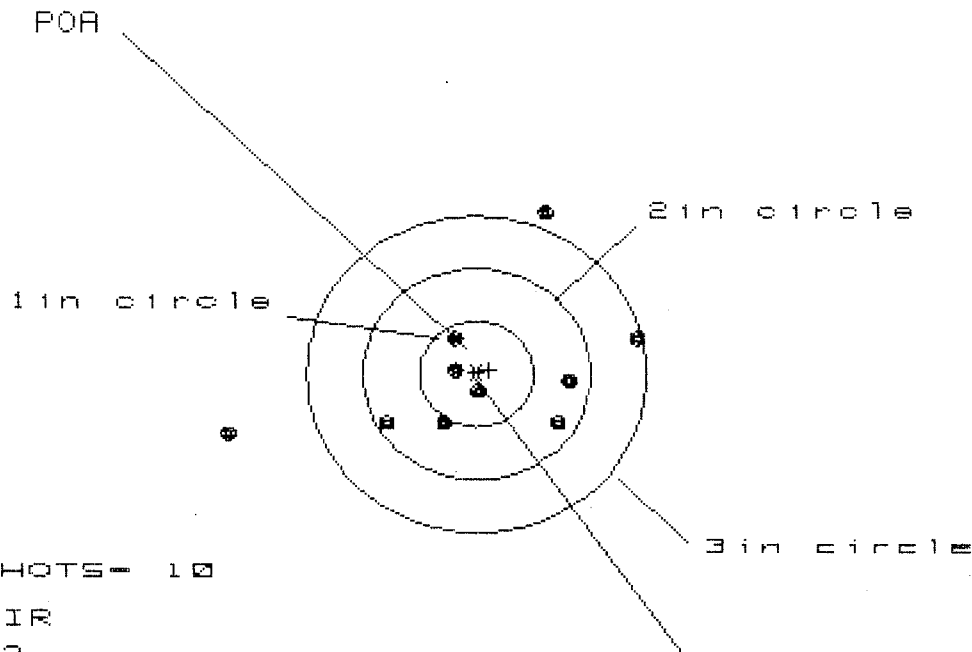
⚡ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0736
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.038
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0828309
THE AMR FOR THIS RIFLE IS: 1.126

11 Dec 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6507593

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 8

HS= 3.536

VS= 2.096

GS= 3.640

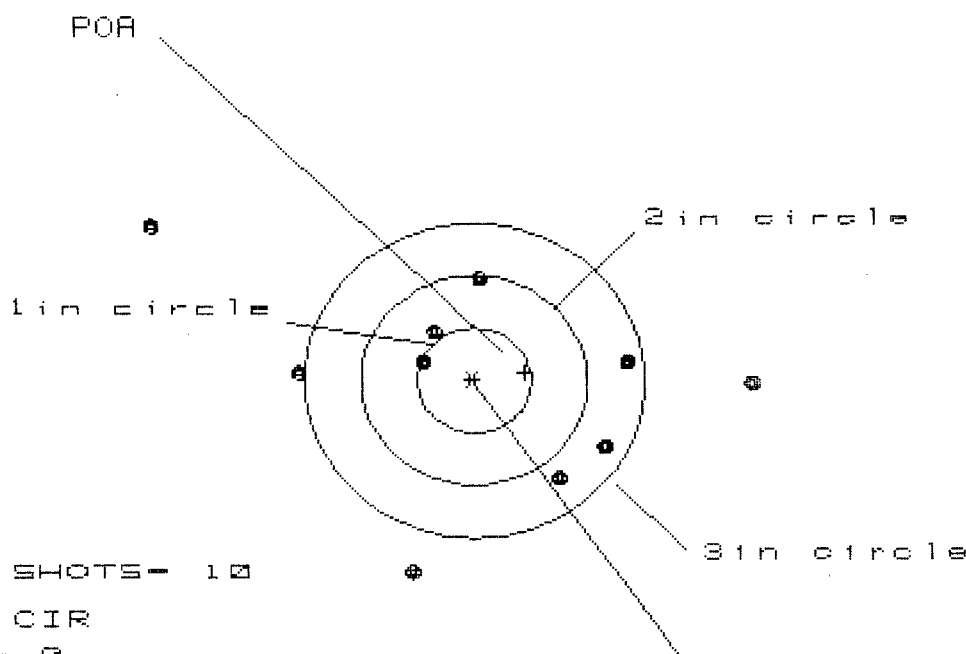
CENTROID *

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.390	1.152	1.195
MINIMUM X	:	-2.146	-1.014	-.971
MAXIMUM Y	:	1.524	1.460	.463
MINIMUM Y	:	-.572	-.547	-.365
CENTROID X	:	-.110	.128	.085
CENTROID Y	:	-.039	.025	-.158
POA TO CENTROID in.	:	.117	.131	.179
MIN RADIUS	:	.180	.305	.158
MEAN RADIUS	:	.914	.787	.660
MAX RADIUS	:	2.221	1.500	1.263
HORIZONTAL SPREAD	:	3.536	2.166	2.166
VERTICAL SPREAD	:	2.096	2.007	.827
EXTREME SPREAD	:	3.640	2.396	2.289
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

11 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06587599

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 0

2in = 2

3in = 6

HS= 5.276

VS= 3.229

GS= 5.470

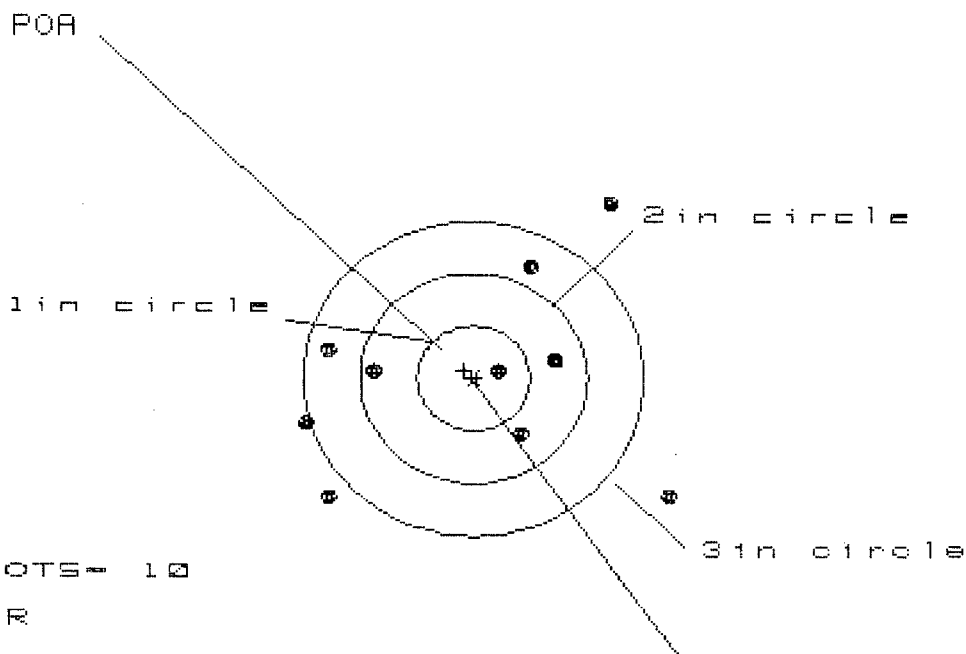
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.420	2.103	1.332
MINIMUM X	:	-2.856	-1.841	-1.578
MAXIMUM Y	:	1.423	1.176	1.193
MINIMUM Y	:	-1.806	-1.648	-1.631
CENTROID X	:	-.450	-.133	-.396
CENTROID Y	:	-.072	-.230	-.247
POA TO CENTROID in.	:	.456	.266	.467
MIN RADIUS	:	.525	.872	.659
MEAN RADIUS	:	1.510	1.314	1.198
MAX RADIUS	:	3.190	2.107	1.743
HORIZONTAL SPREAD	:	5.276	3.944	2.910
VERTICAL SPREAD	:	3.229	2.824	2.824
EXTREME SPREAD	:	5.470	3.946	2.910
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		6	

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FILE:/PATTERNING/CENTERFIRE_PATT/C6587599

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 6

HS= 3.213

VS= 2.828

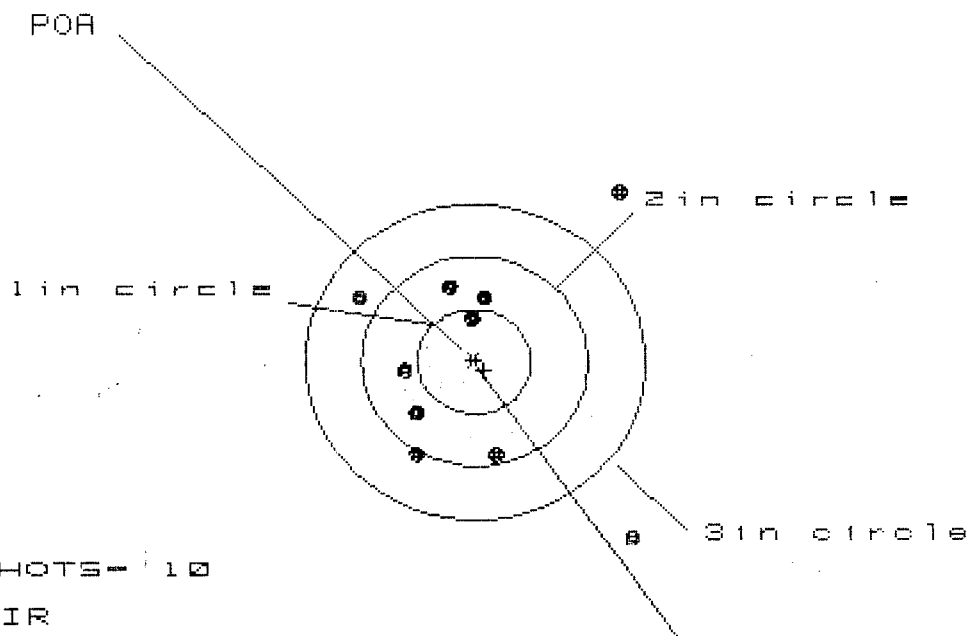
GS= 3.749

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.734	1.418	1.057
MINIMUM X	:	-1.479	-1.287	-1.109
MAXIMUM Y	:	1.668	1.539	1.144
MINIMUM Y	:	-1.160	-1.276	-1.084
CENTROID X	:	.082	-.110	-.288
CENTROID Y	:	-.074	.055	-.137
POA TO CENTROID in.	:	.110	.123	.319
MIN RADIUS	:	.242	.430	.500
MEAN RADIUS	:	1.240	1.148	1.015
MAX RADIUS	:	2.086	2.093	1.453
HORIZONTAL SPREAD	:	3.213	2.705	2.166
VERTICAL SPREAD	:	2.828	2.815	2.228
EXTREME SPREAD	:	3.749	3.749	2.849
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	6		

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 8

HS= 2.319

VS= 3.264

GS= 3.287

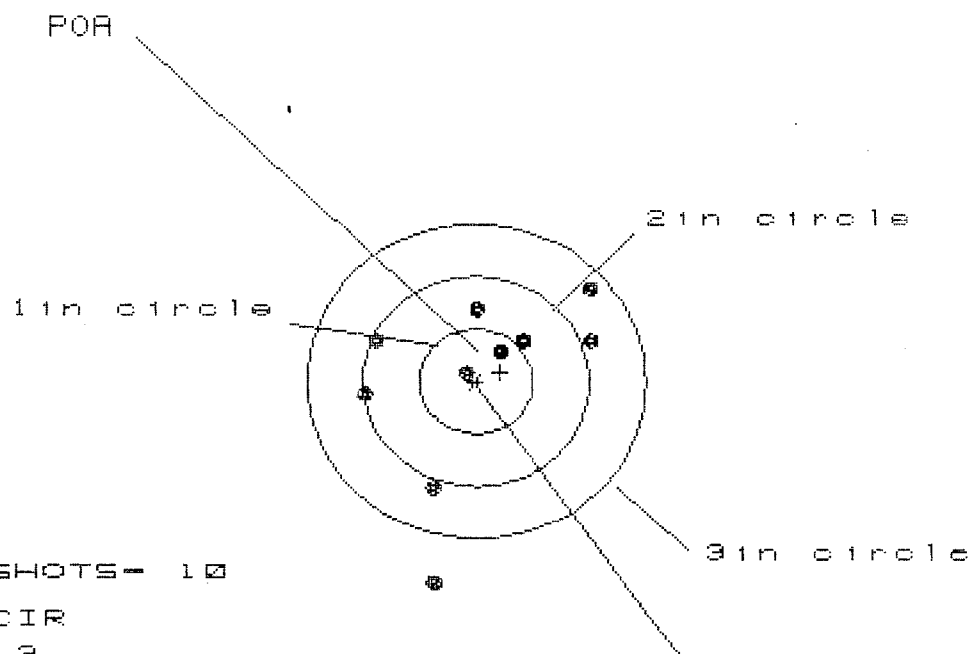
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.340	1.438	.546
MINIMUM X	:	-.979	-.830	-.651
MAXIMUM Y	:	1.584	1.397	.676
MINIMUM Y	:	-1.680	-1.062	-.887
CENTROID X	:	-.080	-.229	-.408
CENTROID Y	:	.085	.272	.097
POA TO CENTROID in.	:	.117	.355	.420
MIN RADIUS	:	.416	.279	.331
MEAN RADIUS	:	1.044	.869	.708
MAX RADIUS	:	2.149	2.005	1.042
HORIZONTAL SPREAD	:	2.319	2.268	1.197
VERTICAL SPREAD	:	3.264	2.459	1.563
EXTREME SPREAD	:	3.287	3.053	1.938
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.020

VS= 2.859

GS= 3.204

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.036
MINIMUM X	-.984
MAXIMUM Y	.911
MINIMUM Y	-1.948
CENTROID X	-.215
CENTROID Y	-.090
POA TO CENTROID in.	.233
MIN RADIUS	.123
MEAN RADIUS	.923
MAX RADIUS	1.991
HORIZONTAL SPREAD	2.020
VERTICAL SPREAD	2.859
EXTREME SPREAD	3.204
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	9