

C6636254

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington®

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

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

MODEL 700™ H24

SERIAL NO.
C6636254

ORDER NO.
5716

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

06



5716 C6636254

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636254

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 30 91		RW
600	Proof	4 30 91		RW
607	Check Headspace	4 30 91		RW
610	Dis-assemble Gun	4 30 91		RW
612	Magnaflux Barrel Action	5 6 91		KCR
	Magnaflux Bolt	5 6 91		KCR
615	Rollmark Caliber	5 6 91		GS
617	Drill and Tap Sight Holes	5 10 91		FB
618	Polish Barrel	5 10 91		WB
620	Apply Coatings (Barrel Action)		5-30-91	TH
	Apply Coating (Bolt)		5-30-91	TH
625	Final Assembly A) Clean inside of Bolt Assembly		5/30/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/91	RW
	C) Inspect Ejector Hole for Chamfer		5/30/91	RW
	D) Oil Firing Pin Ass'y		5/30/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		6-5-91	JH

Op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	8	8	8			6-5-91	RM
	G) Safety Off Force	4	4	4			6-5-91	RM
	H) Trigger Pull Test & Retainability						6-5-91	RM
	I) Firing Pin Indent	10215	10215	10215			6-5-91	RM
	J) Assemble Stock						6/5/91	RM
	K) Assemble Swivel Studs						6-14-91	RM
	L) Attach Front and Rear Sight Assemblies						6/5/91	RM
	M) Iron Sight Alignment						6/5/91	RM
	N) Detach Front & Rear Sights & place in numbered container						6/5/91	RM
	O) Attach Scope to Rifle						6/5/91	RM
	P) Detach & Attach Scope 20 Times						6/5/91	RM
640	Gallery Target & Test						6-6-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						6-6-91	NF
655	Final Inspection							
	A) Headspace						6-14-91	RM
	B) Trigger Pull	2.63	2.55	2.54	2.58	2.58	6-13-91	RM
	C) Function						6-14-91	RM
660	Pack						6-14-91	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6636254

DATE 6-5-91

TESTER JH.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.33	2.38	2.40	2.63	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.23	2.23	2.33	2.55	
PULL #3	2.19	2.40	2.35	2.59	
PULL #4	2.39	2.42	2.38	2.58	
PULL #5	2.31	2.39	2.40	2.58	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.41	3.34		
PULL #2	3.25	3.18		
PULL #3	3.29	3.41		
PULL #4	3.15	3.31		
PULL #5	3.45	3.42		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.35	4.33		4.38
PULL #2	4.32	4.25		4.41
PULL #3	4.39	4.41		4.33
PULL #4	4.37	4.40		4.45
PULL #5	4.39	4.41		4.33
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636254
6 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.391429
1 TO	2	.209764
1 TO	3	.567088
1 TO	4	.484004
1 TO	5	.528394

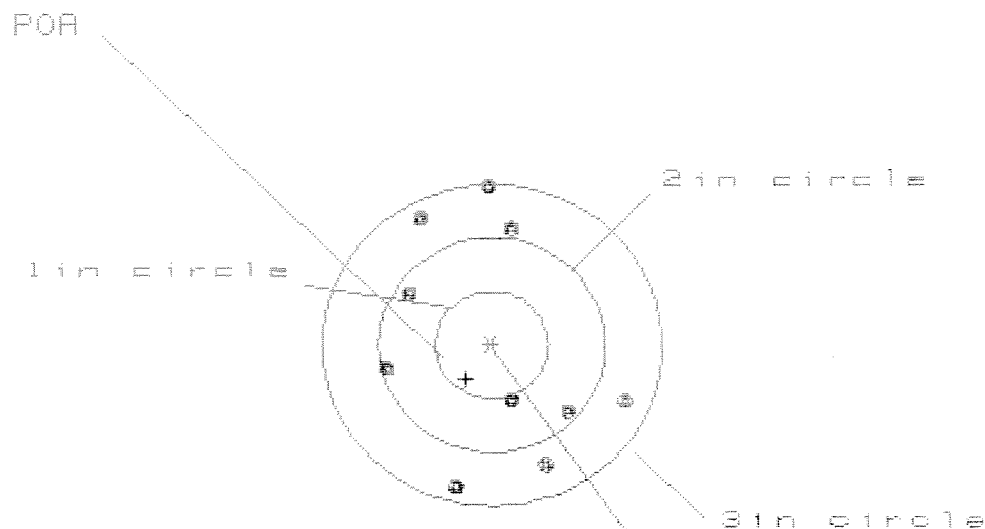
$\frac{4.2}{9.3}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0798
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0328
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0862779
THE AMR FOR THIS RIFLE IS: .9574

6 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08636254

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 4

3 in = 9

HS= 2.006

VS= 2.821

GS= 2.832

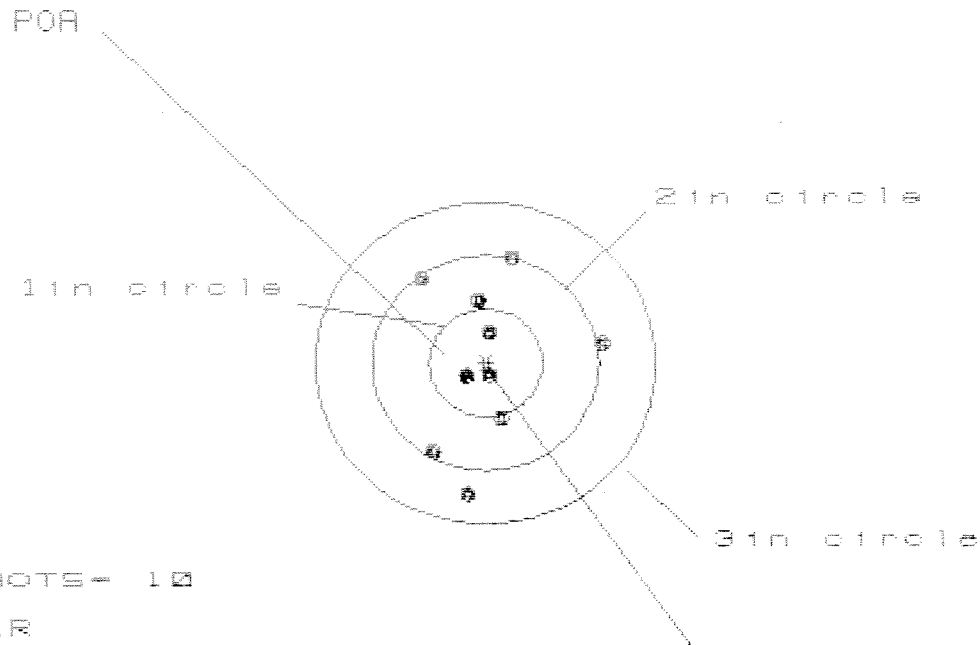
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.124	1.117	1.036
MINIMUM X	-.882	-.889	-.970
MAXIMUM Y	1.520	1.362	1.470
MINIMUM Y	-1.301	-1.132	-.962
CENTROID X	.231	.238	.319
CENTROID Y	.316	.147	-.023
POA TO CENTROID in.	.391	.280	.320
MIN RADIUS	.556	.394	.206
MEAN RADIUS	1.110	1.036	.932
MAX RADIUS	1.521	1.509	1.474
HORIZONTAL SPREAD	2.006	2.006	2.006
VERTICAL SPREAD	2.821	2.494	2.432
EXTREME SPREAD	2.832	2.570	2.487
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	9		

6 Jun 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 1.546

VS= 2.255

GS= 2.295

CENTROID #

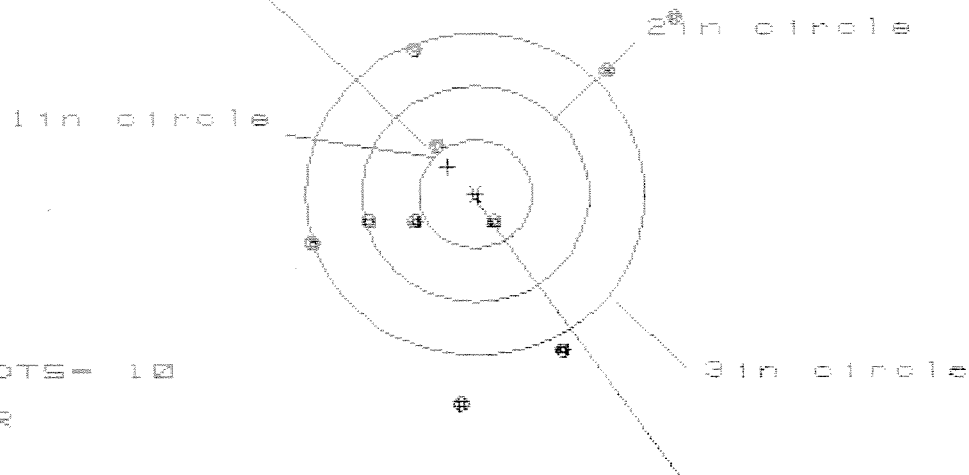
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.004	.985	1.014
MINIMUM X	:	-.542	-.561	-.532
MAXIMUM Y	:	1.034	.898	.735
MINIMUM Y	:	-1.221	-.982	-.870
CENTROID X	:	.171	.190	.161
CENTROID Y	:	.115	.251	.139
POA TO CENTROID in.	:	.206	.315	.213
MIN RADIUS	:	.102	.156	.126
MEAN RADIUS	:	.701	.639	.590
MAX RADIUS	:	1.234	1.115	1.020
HORIZONTAL SPREAD	:	1.546	1.546	1.546
VERTICAL SPREAD	:	2.255	1.880	1.605
EXTREME SPREAD	:	2.295	2.028	1.804
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			10	

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CENTERFIRE PATTERNS # 3

POA



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 6

HS= 3.126

VS= 3.669

GS= 4.099

CENTROID x

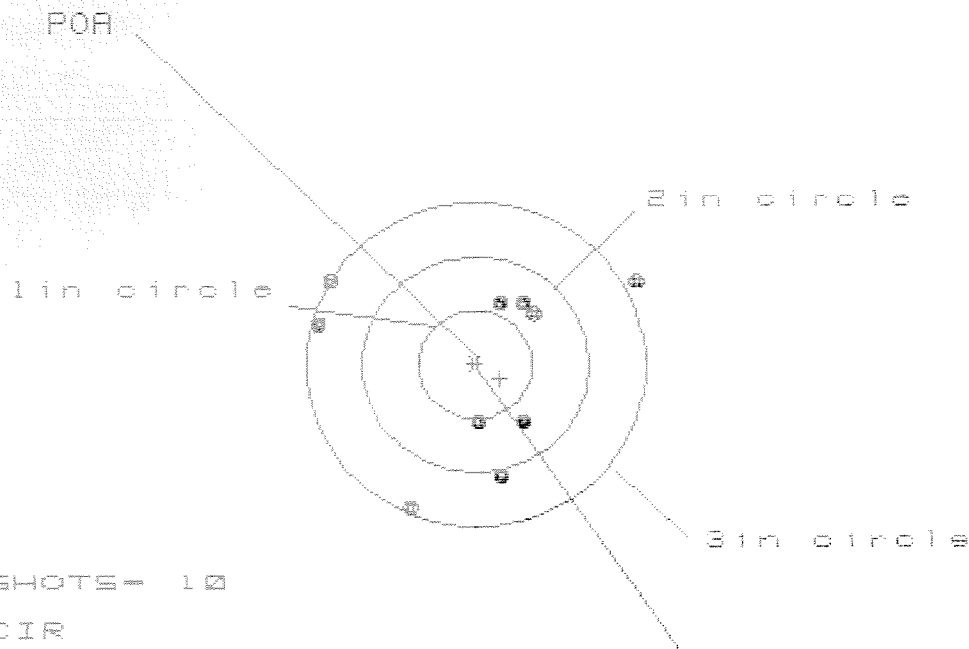
PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.709	1.371	1.380
MINIMUM X	:	-1.417	-1.227	-1.218
MAXIMUM Y	:	1.693	1.531	1.307
MINIMUM Y	:	-1.976	-1.788	-1.471
CENTROID X	:	.241	.051	.042
CENTROID Y	:	-.251	-.439	-.215
POA TO CENTROID in.	:	.348	.442	.219
MIN RADIUS	:	.281	.308	.391
MEAN RADIUS	:	1.291	1.122	1.027
MAX RADIUS	:	2.405	1.914	1.772
HORIZONTAL SPREAD	:	3.126	2.598	2.598
VERTICAL SPREAD	:	3.669	3.319	2.778
EXTREME SPREAD	:	4.099	3.383	3.067
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 = 0

2in = 5

3in = 7

HS= 2.787

VS= 2.184

GS= 2.841

CENTROID #

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.401	.673	.532
MINIMUM X	-1.386	-1.231	-1.372
MAXIMUM Y	.807	.892	.791
MINIMUM Y	-1.377	-1.292	-1.181
CENTROID X	-.215	-.370	-.229
CENTROID Y	.128	.043	-.069
POA TO CENTROID in.	.250	.373	.239
MIN RADIUS	.555	.504	.361
MEAN RADIUS	1.049	1.000	.906
MAX RADIUS	1.595	1.441	1.475
HORIZONTAL SPREAD	2.787	1.904	1.904
VERTICAL SPREAD	2.184	2.184	1.972
EXTREME SPREAD	2.941	2.432	2.204
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		7	

6 Jun 1991

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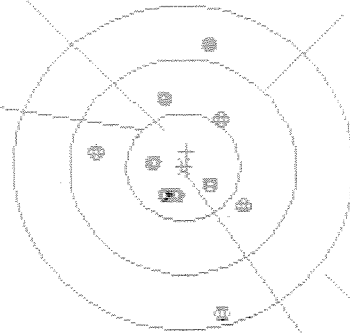
CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle



OF SHOTS- 10

IN CIR

1in = 4

2in = 8

3in = 10

HS= 1.272

VS= 2.443

GS= 2.445

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.514	.547	.577
MINIMUM X	-.758	-.725	-.696
MAXIMUM Y	1.121	.975	.669
MINIMUM Y	-1.321	-.503	-.382
CENTROID X	-.029	-.062	-.091
CENTROID Y	-.144	.002	-.119
POA TO CENTROID in.	.147	.062	.151
MIN RADIUS	.275	.301	.250
MEAN RADIUS	.636	.564	.482
MAX RADIUS	1.355	1.003	.701
HORIZONTAL SPREAD	1.272	1.272	1.272
VERTICAL SPREAD	2.443	1.478	1.050
EXTREME SPREAD	2.445	1.510	1.357
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		