

C6225145

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



M2400050032

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

Remington®



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

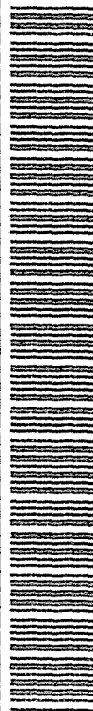
MODEL 700™ H24

SERIAL NO.
C6225145

ORDER NO.
5716

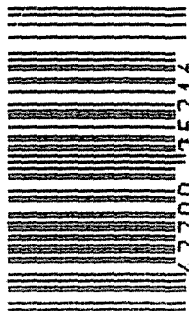
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



5716 C6225145

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225145

OP.#	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and stock	8	9/88	FB
600	Proof	9	7/88	RW
607	Check Headspace	9	7/88	RW
610	Dis-assemble gun	9	7/88	RW
612	Magnaflux Barrel Action		9-14-88	PJL.
	Magnaflux Bolt		9-14-88	PJL.
615	Rollmark Caliber		9-15-88	GS.
617	Drill & Tap Sight Holes		10/24	FB
618	Polish Barrel		10/24	WST
620	Apply Coatings (Barrel Action)		10-31-88	TJA
	Apply Coatings (Bolt)		10-31-88	TJA
625	Final Assembly A) Clean inside of Bolt Assembly		1/11/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/11/89	RW
	C) Inspect Ejector Hole for Chamfer		1/11/89	RW

OVER

OP.#		READINGS	DATE	INITIAL
625	D) Oil Firing Pin Ass'y		1/11/89	RW
cont.	E) Adjust Trigger Pull to Min. Setting and Stake		9 Jan 89	JS
	F) Safety on Force	5 : 5 : 5	11 Jan 89	JS
	G) Safety off Force	3 : 3 : 3	11 Jan 89	JS
	H) Trigger Pull Test & Retainability		9 Jan 89	JS
	I) Firing Pin Indent	.022 : .022 : .022	11 Jan 89	JS
	J) Assemble Stock		1/11/89	RW
	K) Attach Front & Rear Sight Assemblies		1/11/89	RW
	L) Iron Sight Alignment		1/11/89	RW
	M) Detach Front & Rear Sights & place in numbered container		1/11/89	RW
	N) Attach Scope to Rifle		16 Jan 89	JS
	O) Detach & Attach Scope 20 times		16 Jan 89	JS
640	Gallery Target & Test	70 L 80 L	1-19-89	AC
	A) Optical Clarity of Scope	OK	1-19-89	AC
645	Inspect for Live Ammo	NONE	1-19-89	AC
655	Final Inspection			
	A) Headspace		27 Jan 89	JS
	B) Trigger Pull	2.50 : 2.28 : 2.32	2.32 : 2.32	JS
	C) Function		27 Jan 89	JS
	D) Assemble Swivel Studs		27 Jan 89	JS
660	Pack		23 Jan 89	JS

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6225195DATE 4/4/90TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.32	2.12	2.57		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.34	2.11	2.56		
PULL #3	2.29	2.16	2.58		
PULL #4	2.32	2.16	2.47		
PULL #5	2.30	2.20	2.50		
TOTAL	11.57	10.75	12.68		
AVG.	2.31	2.15	2.53		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.37	3.35		
PULL #2	3.39	3.38		
PULL #3	3.37	3.38		
PULL #4	3.41	3.40		
PULL #5	3.41	3.37		
TOTAL	16.95	16.88		
AVG.	3.39	3.37		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.36	4.37		
PULL #2	4.30	4.15		
PULL #3	4.33	4.41		
PULL #4	4.38	4.41		
PULL #5	4.39	4.39		
TOTAL	21.76	21.73		
AVG.	4.35	4.34		

Jan 20, 1989

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06225145

CENTROIDAL DISTANCES

0 TO 1	.359089
1 TO 2	.233805
1 TO 3	.277651
1 TO 4	.721011
1 TO 5	.406203

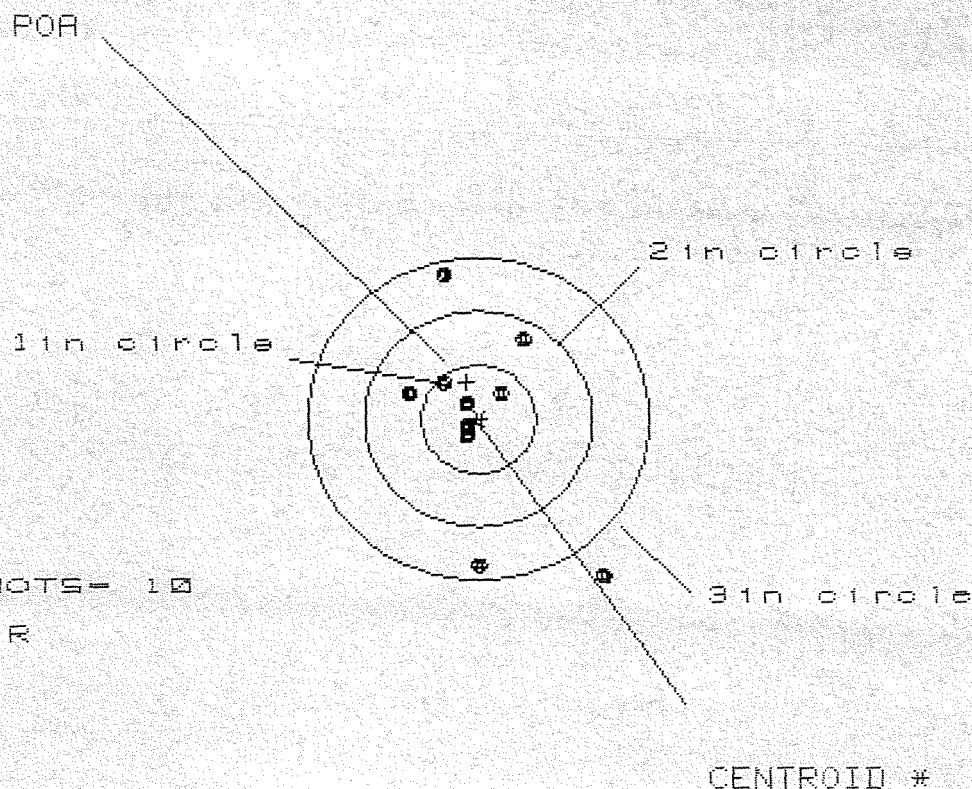
$\bar{x}_1$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .05
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0596
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0777956
THE AMR FOR THIS RIFLE IS: 1.026

20 Jan 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6225145

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 5

2in = 7

3in = 9

HS= 1.645

VS= 2.740

GS= 3.055

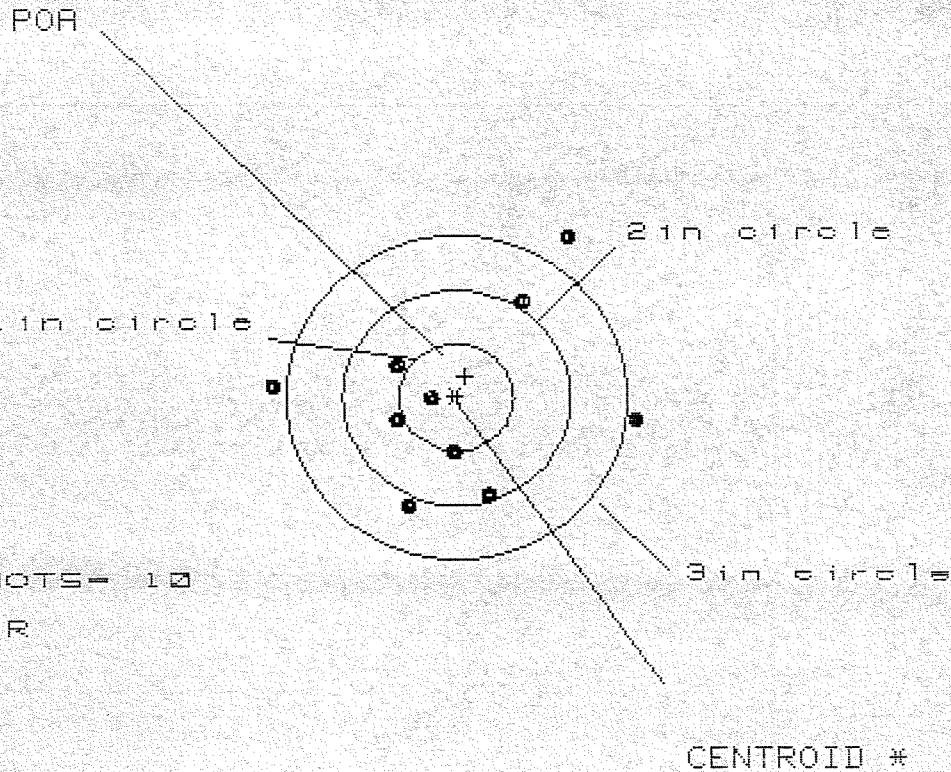
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.070	.495	.475
MINIMUM X	:	-.575	-.456	-.476
MAXIMUM Y	:	1.297	1.136	.702
MINIMUM Y	:	-1.443	-1.485	-1.343
CENTROID X	:	.103	-.016	.004
CENTROID Y	:	-.344	-.183	-.325
POA TO CENTROID in.	:	.359	.184	.326
MIN RADIUS	:	.140	.019	.089
MEAN RADIUS	:	.717	.553	.480
MAX RADIUS	:	1.797	1.486	1.343
HORIZONTAL SPREAD	:	1.645	.951	.951
VERTICAL SPREAD	:	2.740	2.621	2.044
EXTREME SPREAD	:	3.055	2.631	2.089
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

28 Jan 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6225145

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 7

HS= 3.135

VS= 2.470

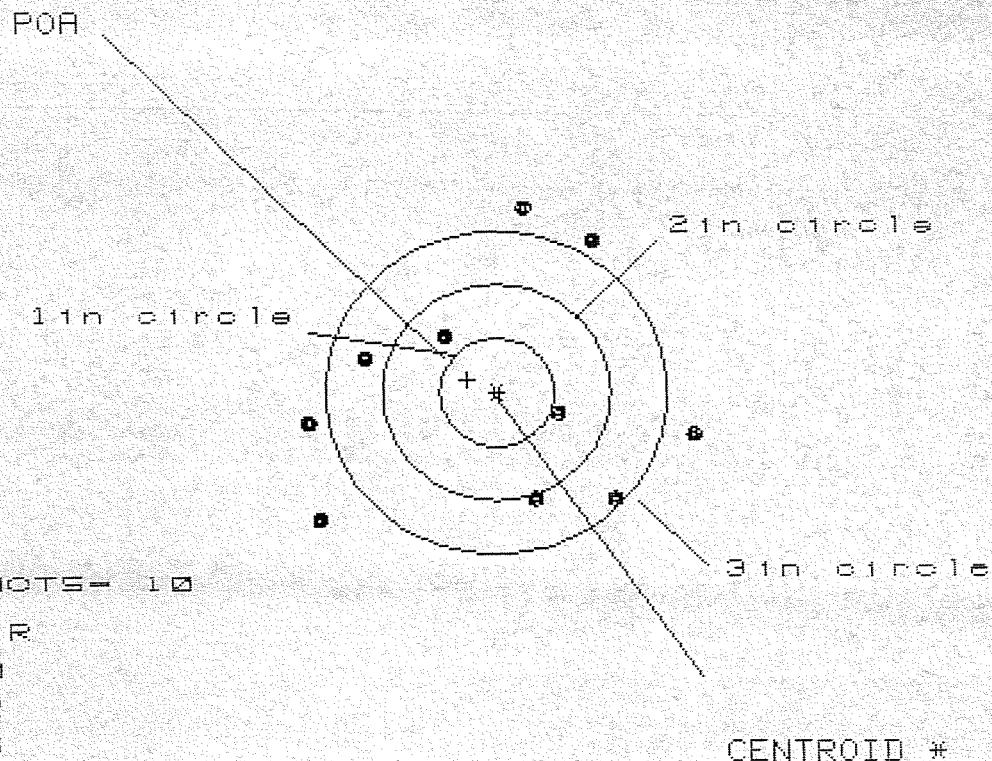
GS= 3.148

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.528	1.641	1.455
MINIMUM X	:	-1.607	-1.494	-1.640
MAXIMUM Y	:	1.486	1.035	1.071
MINIMUM Y	:	-.984	-.819	-.783
CENTROID X	:	-.078	-.191	-.005
CENTROID Y	:	-.196	-.361	-.397
POA TO CENTROID in.	:	.211	.408	.397
MIN RADIUS	:	.213	.149	.286
MEAN RADIUS	:	.991	.851	.792
MAX RADIUS	:	1.802	1.641	1.455
HORIZONTAL SPREAD	:	3.135	3.135	2.095
VERTICAL SPREAD	:	2.470	1.854	1.854
EXTREME SPREAD	:	3.148	3.148	2.152
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

28 Jan 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6225145

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 0

2in = 2

3in = 5

HS= 3.436

VS= 2.907

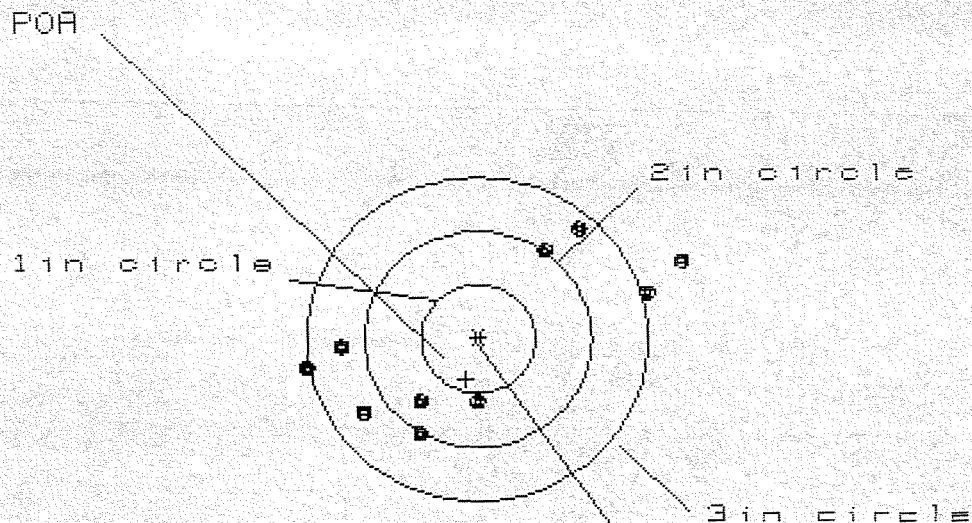
GS= 3.510

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.778	1.607	1.628
MINIMUM X	:	-1.658	-1.829	-1.628
MAXIMUM Y	:	1.734	1.603	1.537
MINIMUM Y	:	-1.173	-1.097	-1.163
CENTROID X	:	.260	.431	.230
CENTROID Y	:	-.115	.016	.082
POA TO CENTROID in.	:	.284	.431	.244
MIN RADIUS	:	.598	.523	.545
MEAN RADIUS	:	1.368	1.294	1.233
MAX RADIUS	:	1.936	1.871	1.693
HORIZONTAL SPREAD	:	3.436	3.436	2.656
VERTICAL SPREAD	:	2.907	2.700	2.700
EXTREME SPREAD	:	3.510	3.439	2.999
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		5	

28 Jan 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C8225145

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 0

2in = 2

3in = 7

HS= 3.362

VS= 1.915

GS= 3.506

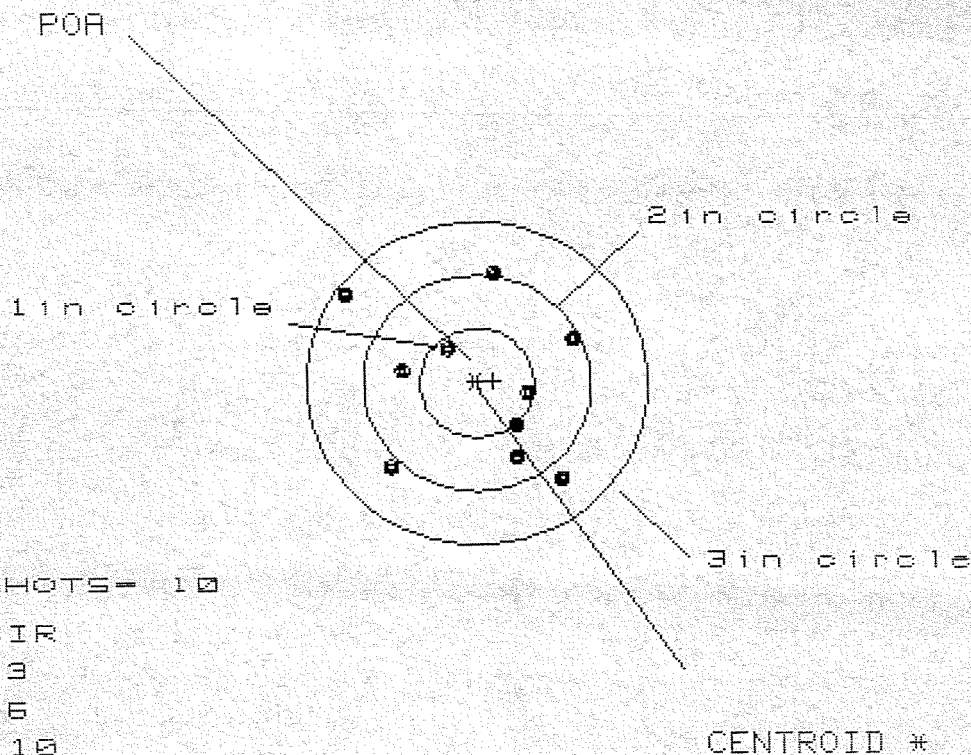
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.836	1.671	1.506
MINIMUM X	:	-1.526	-1.322	-1.141
MAXIMUM Y	:	1.055	1.133	1.106
MINIMUM Y	:	-.860	-.782	-.809
CENTROID X	:	.107	-.097	.068
CENTROID Y	:	.377	.299	.326
POA TO CENTROID in.	:	.392	.314	.333
MIN RADIUS	:	.588	.536	.536
MEAN RADIUS	:	1.220	1.090	1.073
MAX RADIUS	:	1.965	1.756	1.590
HORIZONTAL SPREAD	:	3.362	2.993	2.647
VERTICAL SPREAD	:	1.915	1.915	1.915
EXTREME SPREAD	:	3.506	3.087	2.728
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		7	

20 Jan 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6225145

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 3

2in = 6

3in = 10

HS= 1.933

VS= 1.871

GS= 2.518

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.808	.683	.760
MINIMUM X	:	-1.125	-.914	-.837
MAXIMUM Y	:	1.003	1.094	.997
MINIMUM Y	:	-.868	-.777	-.824
CENTROID X	:	-.142	-.017	-.094
CENTROID Y	:	-.020	-.111	-.014
POA TO CENTROID in.	:	.143	.113	.095
MIN RADIUS	:	.407	.320	.403
MEAN RADIUS	:	.832	.747	.719
MAX RADIUS	:	1.393	1.168	1.174
HORIZONTAL SPREAD	:	1.933	1.597	1.597
VERTICAL SPREAD	:	1.871	1.871	1.821
EXTREME SPREAD	:	2.518	2.042	2.042
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	