

C6611445

MODEL 700TH M24

Model **SWS** TH

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington



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

MODEL 700TM H24

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

20

SERIAL NO.
C6611445

ORDER NO.
5716



5716 C6611445

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611445

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 25	91	RW
600	Proof	3 25	91	RW
607	Check Headspace	3 25	91	RW
610	Dis-assemble Gun	3 25	91	RW
612	Magnaflux Barrel Action	3 28	91	KR
	Magnaflux Bolt	3 28	91	LS
615	Rollmark Caliber	3 28	91	ES
617	Drill and Tap Sight Holes	APR	3 1991	LB
618	Polish Barrel	APR	3 1991	WB
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		4/16/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/16/91	RW
	C) Inspect Ejector Hole for Chamfer		4/16/91	RW
	D) Oil Firing Pin Ass'y		4/16/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/8/91	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5-8-91	AC
	G) Safety Off Force	3	3	3			5-8-91	AC
	H) Trigger Pull Test & Retainability						5/8/91	YH
	I) Firing Pin Indent	.023	.023	.023			5-8-91	AC
	J) Assemble Stock						5/9/91	RW
	K) Assemble Swivel Studs						5-11-91	DH
	L) Attach Front and Rear Sight Assemblies						5/9/91	RW
	M) Iron Sight Alignment						5/9/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/9/91	RW
	O) Attach Scope to Rifle						5/9/91	RW
	P) Detach & Attach Scope 20 Times						5/9/91	RW
640	Gallery Target & Test						5/5/91	KF
	A) Time							KF
	B) Malfunctions							KF
	C) Pierced Primers							KF
	D) Optical Clarity of Scope							KF
645	Inspect for Live Ammo						5/9/91	KF
655	Final Inspection							
	A) Headspace						5-11-91	DH
	B) Trigger Pull	2.14	2.18	2.22	2.20	2.22	5/10/91	YH
	C) Function						5-11-91	DH
660	Pack						6-18-91	VF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6611445

DATE 5/8/91

TESTER JEL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.54	2.54	2.50	2.14	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.53	2.53	2.51	2.18	
PULL #3	2.48	2.31	2.55	2.22	
PULL #4	2.52	2.51	2.52	2.20	
PULL #5	2.57	2.53	2.50	2.22	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.57	3.44		
PULL #2	3.54	3.42		
PULL #3	3.38	3.21		
PULL #4	3.15	3.47		
PULL #5	3.43	3.48		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.28	4.29		4.28
PULL #2	4.30	4.26		4.28
PULL #3	4.32	4.39		4.30
PULL #4	4.31	4.28		4.30
PULL #5	4.31	4.21		4.27
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611445
9 May 1991

CENTROIDAL DISTANCES

0 TO	1	.0588218
1 TO	2	.52811
1 TO	3	.143534
1 TO	4	.109
1 TO	5	.337913

15
2 <----POA

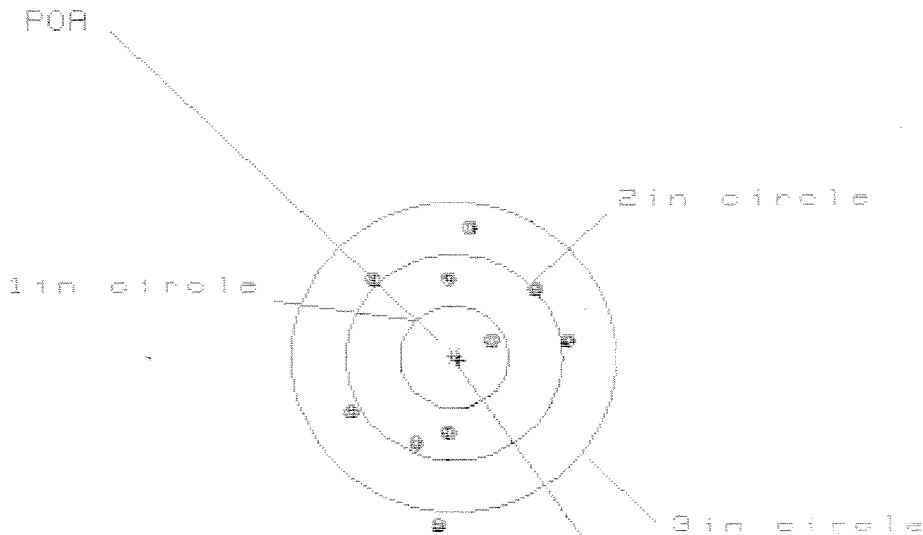
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0824
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0928
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .124103

THE AMR FOR THIS RIFLE IS: .9602

9 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8511445

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 1.965

VS= 2.935

GS= 2.946

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.046	1.029	1.040
MINIMUM X	-.919	-.936	-.925
MAXIMUM Y	1.268	1.083	.754
MINIMUM Y	-1.667	-1.050	-.915
CENTROID X	-.048	-.031	-.042
CENTROID Y	.034	.219	.084
POA TO CENTROID in.	.059	.222	.094
MIN RADIUS	.378	.350	.360
MEAN RADIUS	.993	.897	.871
MAX RADIUS	1.674	1.198	1.110
HORIZONTAL SPREAD	1.965	1.965	1.965
VERTICAL SPREAD	2.935	2.133	1.669
EXTREME SPREAD	2.946	2.171	2.104
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

9 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06B11445

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 8

3in = 10

HS= 1.878

VS= 2.064

GS= 2.083

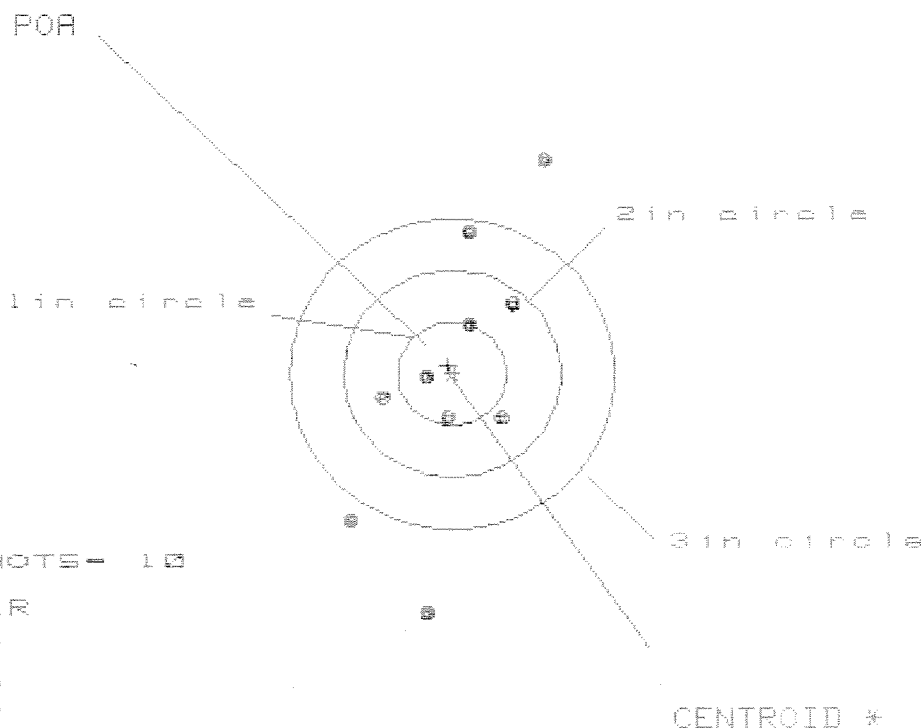
CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.740	.749	.609
MINIMUM X	-1.138	-1.129	-.710
MAXIMUM Y	1.356	.344	.375
MINIMUM Y	-.708	-.557	-.526
CENTROID X	.122	.113	.254
CENTROID Y	-.466	-.617	-.648
POA TO CENTROID in.	.482	.627	.696
MIN RADIUS	.051	.117	.052
MEAN RADIUS	.665	.573	.481
MAX RADIUS	1.358	1.156	.903
HORIZONTAL SPREAD	1.878	1.878	1.318
VERTICAL SPREAD	2.064	.901	.901
EXTREME SPREAD	2.083	1.900	1.373
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	

9 May 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 7

HS= 1.802

VS= 4.420

GS= 4.572

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.887	.856	.598
MINIMUM X	-.915	-.946	-.839
MAXIMUM Y	2.105	1.848	1.381
MINIMUM Y	-2.315	-1.663	-1.433
CENTROID X	.043	.074	-.033
CENTROID Y	-.077	.180	-.051
POA TO CENTROID in.	.088	.195	.060
MIN RADIUS	.206	.274	.140
MEAN RADIUS	1.095	.958	.786
MAX RADIUS	2.332	2.036	1.660
HORIZONTAL SPREAD	1.802	1.802	1.437
VERTICAL SPREAD	4.420	3.511	2.013
EXTREME SPREAD	4.572	3.946	3.028
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	7		

9 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6511445

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS= 3.108

VS= 2.170

GS= 3.186

PATTERN #

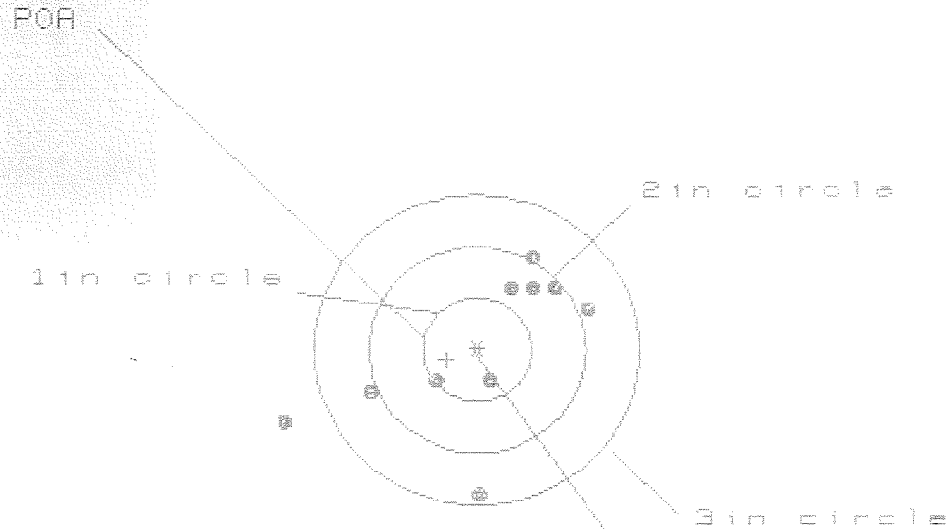
4

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.426	1.083	.893
MINIMUM X	:	-1.682	-1.524	-.952
MAXIMUM Y	:	1.014	.886	.813
MINIMUM Y	:	-1.156	-1.153	-1.226
CENTROID X	:	.012	-.146	.044
CENTROID Y	:	-.057	.071	.144
POA TO CENTROID in.	:	.059	.163	.151
MIN RADIUS	:	.333	.318	.486
MEAN RADIUS	:	1.070	.959	.878
MAX RADIUS	:	1.835	1.632	1.288
HORIZONTAL SPREAD	:	3.108	2.607	1.845
VERTICAL SPREAD	:	2.170	2.039	2.039
EXTREME SPREAD	:	3.186	2.693	2.295
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

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FILE:/PATTERNING/CENTERFIRE_PATT/08611445

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 2.749

VS= 2.309

GS= 2.982

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.984
MINIMUM X	-1.764
MAXIMUM Y	.914
MINIMUM Y	-1.395
CENTROID X	.283
CENTROID Y	.102
POA TO CENTROID in.	.300
MIN RADIUS	.346
MEAN RADIUS	.978
MAX RADIUS	1.904
HORIZONTAL SPREAD	2.749
VERTICAL SPREAD	2.309
EXTREME SPREAD	2.982
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	9