

C5611480

MODEL 700™ M24

Model **SWS**

Action _____™

Barrel Length _____

Capacity _____

Order No. **5715**

*Includes 1 in chamber.

Remington

Sinclair®




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

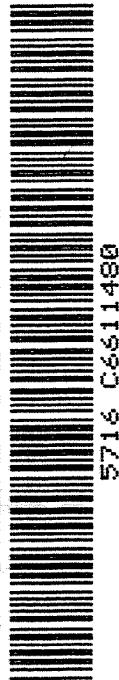
MODEL 700TM H24

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

SERIAL NO.
C6611480

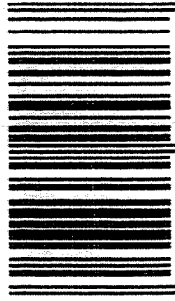
ORDER NO.
5716

46



5716 C6611480

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6611480**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/12/91	K.S.
600	Proof		3/12/91	K.S.
607	Check Headspace		3/12/91	K.S.
610	Dis-assemble Gun		3/12/91	K.S.
612	Magnaflux Barrel Action		3/27/91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		3/27/91	SL
617	Drill and Tap Sight Holes		APR 3 1991	FB
618	Polish Barrel		APR 3 1991	WB
620	Apply Coatings (Barrel Action)		3-12-91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/12/91	K.S.
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/18/91	K.S.
	C) Inspect Ejector Hole for Chamfer		4/18/91	K.S.
	D) Oil Firing Pin Ass'y		4/18/91	K.S.
	E) Adjust Trigger Pull to Min Setting and Stake		4/22/91	SL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			4-22-91	DH
	G) Safety Off Force	2 1/4	2 1/2	3			4-22-91	DH
	H) Trigger Pull Test & Retainability						4/22/91	M
	I) Firing Pin Indent	.020	.021	.020			4-22-91	DH
	J) Assemble Stock						4/22/91	KS
	K) Assemble Swivel Studs						4-30-91	DH
	L) Attach Front and Rear Sight Assemblies						4/22/91	KS
	M) Iron Sight Alignment						4/22/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/22/91	KS
	O) Attach Scope to Rifle						4/22/91	KS
	P) Detach & Attach Scope 20 Times						4/22/91	KS
640	Gallery Target & Test						4-23-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						4-23-91	NF
655	Final Inspection							
	A) Headspace						4-30-91	DH
	B) Trigger Pull	2.60	2.63	2.65	2.61	2.58	4/26/91	RC
	C) Function						4-30-91	DH
660	Pack						6-18-91	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-6611480

DATE 4/22/91

TESTER J. J. J.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.47	2.43	2.60	MIN. SETTING,
PULL #2	2.35	2.41	2.48	2.63	NO AVG. OF 5
PULL #3	2.33	2.42	2.49	2.65	READINGS ACCEPT-
PULL #4	2.38	2.43	2.36	2.66	ABLE LESS THAN 2#
PULL #5	2.38	2.48	2.43	2.58	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES			COMMENTS
PULL #1	3.39	3.45			
PULL #2	3.25	3.28			
PULL #3	3.22	3.32			
PULL #4	3.33	3.29			
PULL #5	3.32	3.35			
TOTAL					
AVG.					

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.55	4.29		4.27
PULL #2	4.48	4.27		4.40
PULL #3	4.56	4.32		4.34
PULL #4	4.25	4.28		4.35
PULL #5	4.29	4.30		4.42
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611480
23 Apr 1991

CENTROIDAL DISTANCES

Ø TO	1	.522946
1 TO	2	.428085
1 TO	3	.426728
1 TO	4	.766984
1 TO	5	.656303

1.000000 <----POR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0532
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.054
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS:

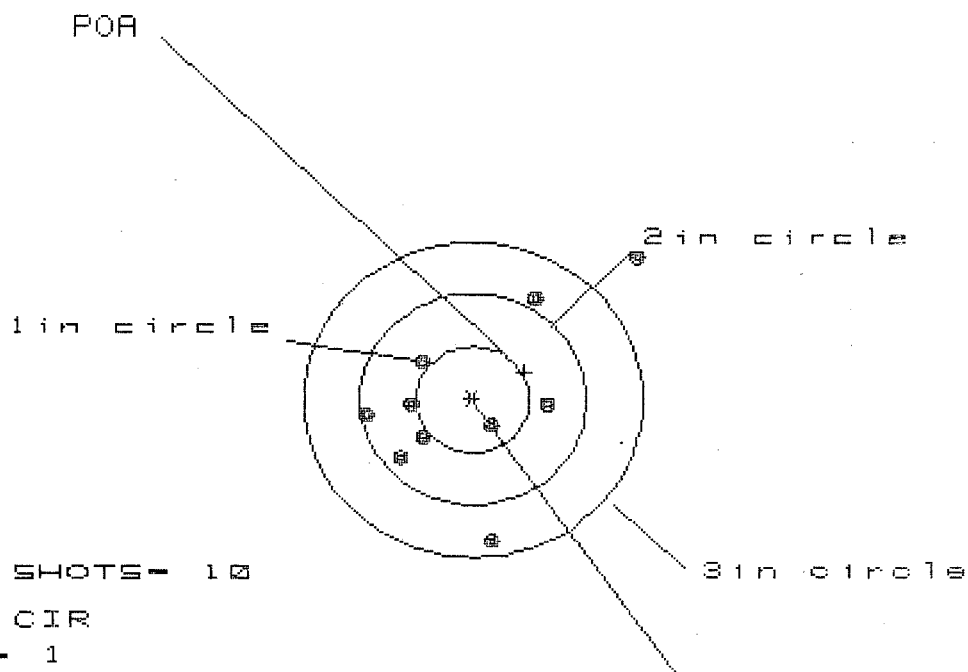
THE AMR FOR THIS RIFLE IS: .9324

23 Apr 1991

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CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS= 2.354

VS= 2.723

GS= 3.021

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.435	.859	.695
MINIMUM X	-.919	-.760	-.724
MAXIMUM Y	1.361	1.129	.943
MINIMUM Y	-1.362	-1.211	-.518
CENTROID X	-.456	-.615	-.651
CENTROID Y	-.256	-.407	-.272
POA TO CENTROID in.	.523	.738	.770
MIN RADIUS	.290	.311	.372
MEAN RADIUS	.893	.723	.655
MAX RADIUS	1.978	1.354	1.253
HORIZONTAL SPREAD	2.354	1.619	1.619
VERTICAL SPREAD	2.723	2.340	1.516
EXTREME SPREAD	3.021	2.385	1.964
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

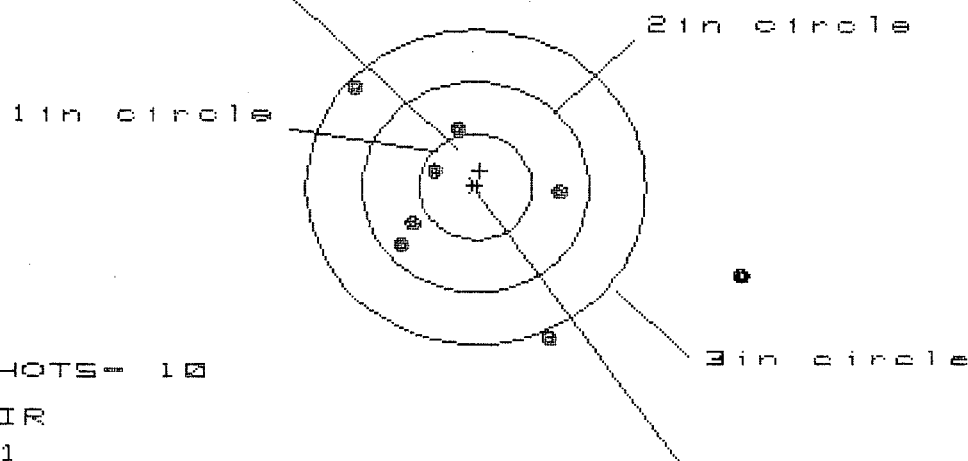
23 Apr 1991

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CENTERFIRE PATTERNS

2

POA



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 7

HS= 3.358

VS= 3.348

GS= 3.795

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.310	.947	.944
MINIMUM X	:	-1.048	-.791	-.794
MAXIMUM Y	:	1.906	1.813	1.060
MINIMUM Y	:	-1.442	-1.535	-1.309
CENTROID X	:	-.040	-.297	-.294
CENTROID Y	:	-.155	-.062	-.288
POA TO CENTROID in.	:	.160	.303	.412
MIN RADIUS	:	.348	.075	.258
MEAN RADIUS	:	1.118	.900	.771
MAX RADIUS	:	2.459	1.813	1.559
HORIZONTAL SPREAD	:	3.358	1.738	1.738
VERTICAL SPREAD	:	3.348	3.348	2.369
EXTREME SPREAD	:	3.795	3.459	2.882
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

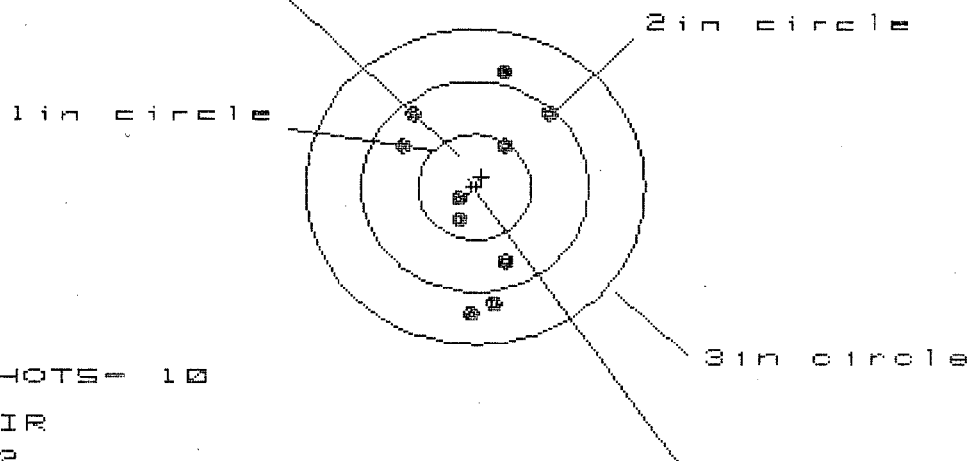
23 Apr 1991

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CENTERFIRE PATTERNS

3

POA



OF SHOTS- 10

IN CIR

1in - 2

2in - 7

3in - 10

HS= 1.244

VS= 2.302

GS= 2.324

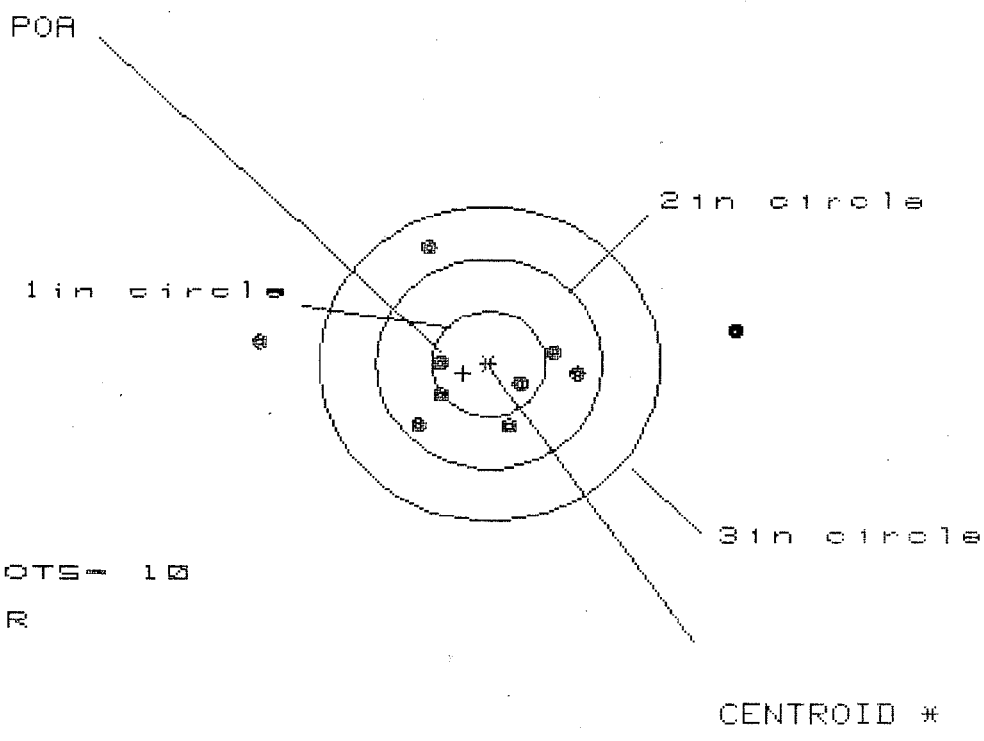
CENTROID #

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.649	.677	.671
MINIMUM X	:	-.595	-.567	-.573
MAXIMUM Y	:	1.143	.817	.688
MINIMUM Y	:	-1.159	-1.032	-1.105
CENTROID X	:	-.060	-.088	-.082
CENTROID Y	:	-.097	-.224	-.095
POA TO CENTROID in.	:	.114	.240	.125
MIN RADIUS	:	.150	.113	.133
MEAN RADIUS	:	.767	.708	.664
MAX RADIUS	:	1.169	1.049	1.114
HORIZONTAL SPREAD	:	1.244	1.244	1.244
VERTICAL SPREAD	:	2.302	1.849	1.793
EXTREME SPREAD	:	2.324	1.971	1.903
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	10		

23 Apr 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 8

HS= 4.185

VS= 1.700

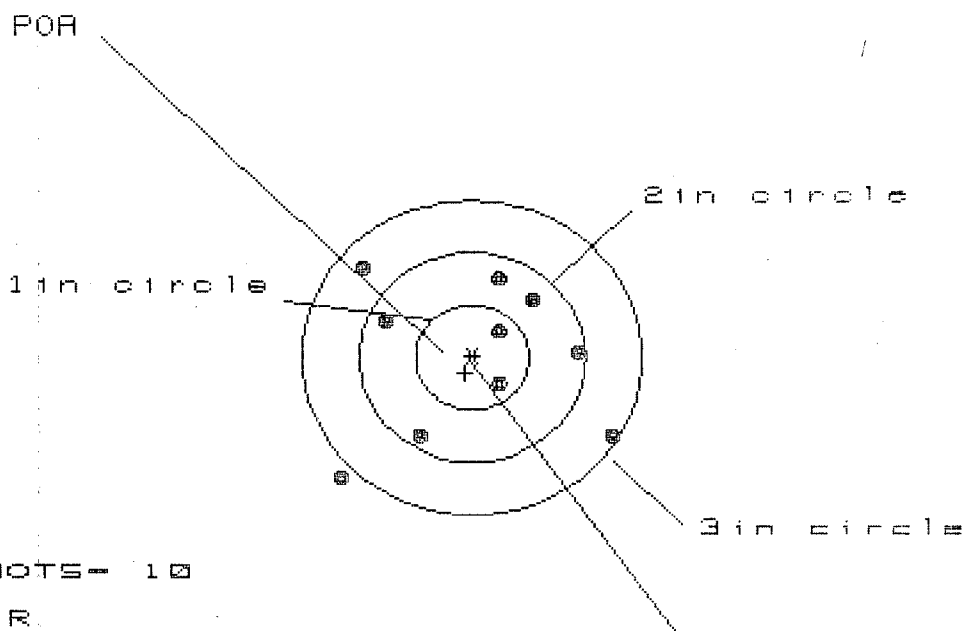
GS= 4.189

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.199	1.006	.788
MINIMUM X	:	-1.986	-1.742	-.591
MAXIMUM Y	:	1.132	1.169	1.194
MINIMUM Y	:	-.568	-.531	-.506
CENTROID X	:	.228	-.016	.202
CENTROID Y	:	.091	.054	.029
POA TO CENTROID in.	:	.246	.056	.204
MIN RADIUS	:	.355	.164	.341
MEAN RADIUS	:	.956	.796	.656
MAX RADIUS	:	2.224	1.753	1.287
HORIZONTAL SPREAD	:	4.185	2.748	1.379
VERTICAL SPREAD	:	1.700	1.700	1.700
EXTREME SPREAD	:	4.189	2.757	1.817
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

23 Apr 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 2.391

VS= 1.980

GS= 2.711

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.196	1.063	.934
MINIMUM X	:	-1.195	-1.142	-1.009
MAXIMUM Y	:	.866	.742	.637
MINIMUM Y	:	-1.114	-.904	-1.004
CENTROID X	:	.062	.195	.062
CENTROID Y	:	.147	.271	.376
POA TO CENTROID in.	:	.160	.334	.381
MIN RADIUS	:	.354	.181	.253
MEAN RADIUS	:	.928	.811	.748
MAX RADIUS	:	1.634	1.362	1.193
HORIZONTAL SPREAD	:	2.391	2.205	1.943
VERTICAL SPREAD	:	1.980	1.646	1.646
EXTREME SPREAD	:	2.711	2.711	2.111
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	