

C6522186

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Remington[®]

MODEL 700TM H24

UPPONT
REGISTERED PATENT OFF

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

SERIAL NO.
C6522186

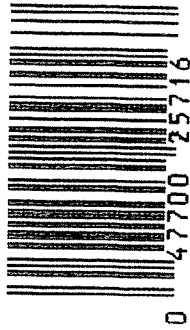
ORDER NO.
5716

Ø1

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



UPC



CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522186
30 Aug 1990

CENTROIDAL DISTANCES

Ø TO	1	1.11488
1 TO	2	.189336
1 TO	3	.356041
1 TO	4	.828409
1 TO	5	.63694

+ ^{4 5}
321 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .8238
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0886
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .828551
THE AMP FOR THIS RIFLE IS: 1.022

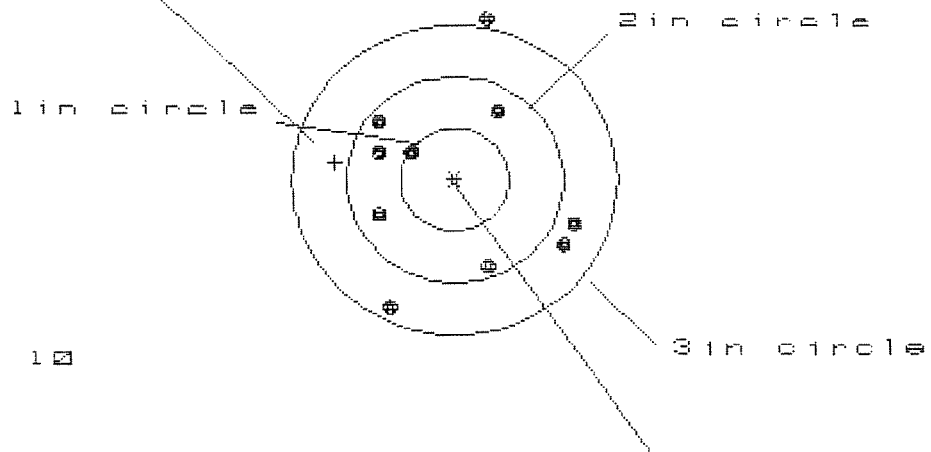
30 Aug 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C85221B8

CENTERFIRE PATTERNS

1

POA



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 6

3 in = 9

HS = 1.834

VS = 2.879

CS = 3.019

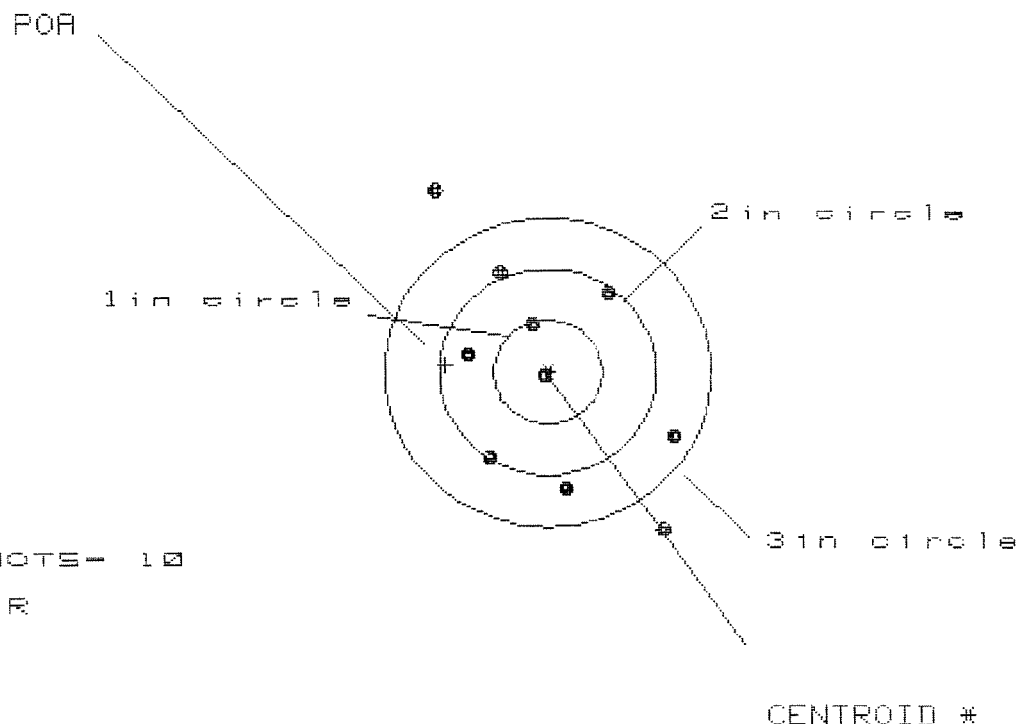
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.123	1.155	1.081
MINIMUM X	-.711	-.679	-.753
MAXIMUM Y	1.610	.852	.715
MINIMUM Y	-1.269	-1.090	-.740
CENTROID X	1.102	1.070	1.144
CENTROID Y	-.169	-.348	-.211
POA TO CENTROID in.	1.114	1.125	1.163
MIN RADIUS	.465	.567	.524
MEAN RADIUS	.985	.906	.856
MAX RADIUS	1.635	1.240	1.136
HORIZONTAL SPREAD	1.834	1.834	1.834
VERTICAL SPREAD	2.879	1.942	1.455
EXTREME SPREAD	3.019	2.206	2.032
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 2.265

VS= 3.273

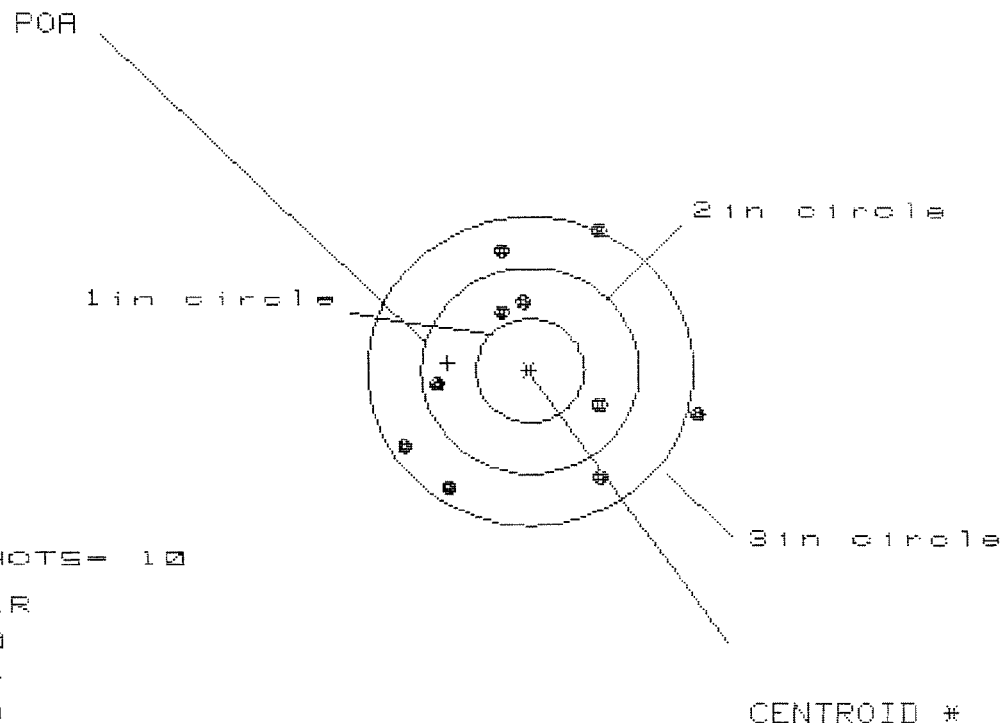
CS= 3.918

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.197	1.078	1.199
MINIMUM X	:	-1.068	-.820	-.699
MAXIMUM Y	:	1.789	1.140	.979
MINIMUM Y	:	-1.484	-1.285	-1.060
CENTROID X	:	.940	1.059	.938
CENTROID Y	:	-.071	-.270	-.109
FOR TO CENTROID in.	:	.943	1.092	.944
MIN RADIUS	:	.069	.215	.042
MEAN RADIUS	:	1.061	.968	.836
MAX RADIUS	:	2.084	1.608	1.328
HORIZONTAL SPREAD	:	2.265	1.898	1.898
VERTICAL SPREAD	:	3.273	2.425	2.039
EXTREME SPREAD	:	3.918	2.872	2.264
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 4

3 in = 9

HS = 2.742

VS = 2.440

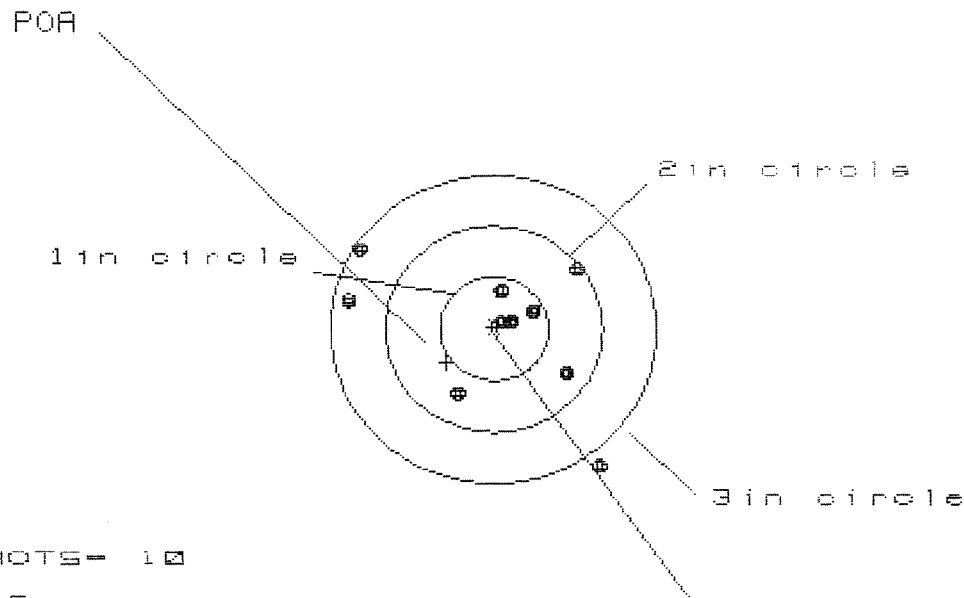
GS = 2.802

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.577	.791	.887
MINIMUM X	:	-1.165	-.989	-.891
MAXIMUM Y	:	1.338	1.289	1.327
MINIMUM Y	:	-1.102	-1.151	-.990
CENTROID X	:	.760	.584	.485
CENTROID Y	:	-.070	-.021	-.182
POA TO CENTROID in.	:	.763	.585	.519
MIN RADIUS	:	.644	.545	.592
MEAN RADIUS	:	1.118	1.040	.978
MAX RADIUS	:	1.638	1.512	1.327
HORIZONTAL SPREAD	:	2.742	1.780	1.778
VERTICAL SPREAD	:	2.440	2.440	2.317
EXTREME SPREAD	:	2.802	2.802	2.413
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1in = 4

2in = 7

3in = 9

HS = 2.303

VS = 2.172

CS = 3.053

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.940	.848	.710
MINIMUM X	:	-1.363	-1.258	-1.396
MAXIMUM Y	:	.815	.665	.533
MINIMUM Y	:	-1.357	-.819	-.736
CENTROID X	:	.437	.332	.470
CENTROID Y	:	.325	.475	.392
POA TO CENTROID (in.)	:	.544	.580	.612
MIN RADIUS	:	.035	.169	.040
MEAN RADIUS	:	.796	.717	.589
MAX RADIUS	:	1.651	1.286	1.419
HORIZONTAL SPREAD	:	2.303	2.106	2.106
VERTICAL SPREAD	:	2.172	1.484	1.269
EXTREME SPREAD	:	3.053	2.212	2.124
NUMBER IN ONE INCH CIRCLE =	:		4	
NUMBER IN TWO INCH CIRCLE =	:		7	
NUMBER IN THREE INCH CIRCLE =	:		9	

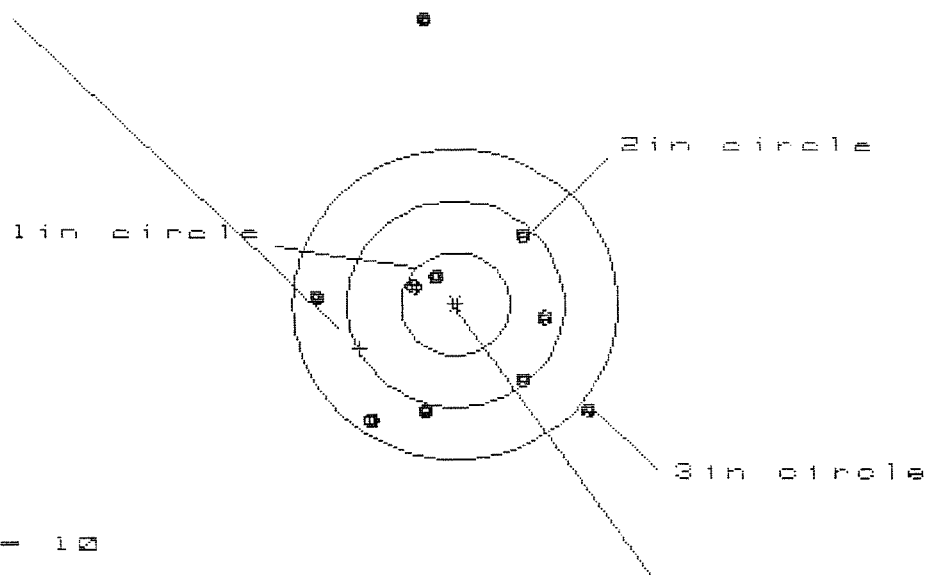
30 Aug 1998

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CENTERFIRE PATTERNS

5

POA



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS = 2.491

VS = 3.882

ES = 4.069

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.174	1.145	.946
MINIMUM X	:	-1.317	-1.346	-1.202
MAXIMUM Y	:	2.802	.951	.865
MINIMUM Y	:	-1.080	-1.769	-1.856
CENTROID X	:	.880	.909	.765
CENTROID Y	:	.428	.117	.203
POA TO CENTROID in.	:	.978	.916	.792
MIN RADIUS	:	.327	.627	.478
MEAN RADIUS	:	1.149	.947	.882
MAX RADIUS	:	2.814	1.390	1.230
HORIZONTAL SPREAD	:	2.491	2.491	2.148
VERTICAL SPREAD	:	3.882	1.720	1.720
EXTREME SPREAD	:	4.069	2.701	2.230
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

SWS TRIGGER PULL TEST

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

SERIAL NO. C6522186

DATE 8/27/90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.36	2.43	2.45	2.05	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.43	2.38	2.40	2.10	
PULL #3	2.41	2.43	2.36	2.10	
PULL #4	2.46	2.38	2.43	2.05	
PULL #5	2.43	2.41	2.41	2.05	
TOTAL	12.09	12.03	12.05	10.35	
AVG.	2.418	2.406	2.41	2.07	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.23	3.14		
PULL #2	3.19	3.15		
PULL #3	3.25	3.13		
PULL #4	3.19	3.17		
PULL #5	3.18	3.10		
TOTAL	16.04	15.69		
AVG.	3.208	3.138		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.48	4.34		4.42
PULL #2	4.36	4.43		4.47
PULL #3	4.38	4.41		4.45
PULL #4	4.35	4.43		4.43
PULL #5	4.44	4.44		4.50
TOTAL	22.01	22.05		22.28
AVG.	4.402	4.41		4.456

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522186

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	8 2	90	RW
600	Proof	8 2	90	RW
607	Check Headspace	8 2	90	RW
610	Dis-assemble Gun	8 2	90	RW
612	Magnaflux Barrel Action		8/7/90	KR
	Magnaflux Bolt		8/7/90	KR
615	Rollmark Caliber		8/7/90	JS
617	Drill and Tap Sight Holes		8/10/90	FB
618	Polish Barrel <i>FB</i>		8/14/90	WB
620	Apply Coatings (Barrel Action)		8-22-90	JS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/24/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/24/90	RW
	C) Inspect Ejector Hole for Chamfer		8/24/90	RW
	D) Oil Firing Pin Ass'y		8/24/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/27/90	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			8/27/90	RW
	G) Safety Off Force	3	3	3			8/27/90	RW
	H) Trigger Pull Test & Retainability						8/27/90	YH
	I) Firing Pin Indent	.024	.023	.023			8/27/90	RW
	J) Assemble Stock						8/27/90	RW
	K) Assemble Swivel Studs						9/5/90	YH
	L) Attach Front and Rear Sight Assemblies						8/27/90	RW
	M) Iron Sight Alignment						8/27/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/27/90	RW
	O) Attach Scope to Rifle						8/27/90	RW
	P) Detach & Attach Scope 20 Times						8/27/90	RW
640	Gallery Target & Test						8-30-90	DH
	A) Time						8-30-90	DH
	B) Malfunctions						8-30-90	DH
	C) Pierced Primers						8-30-90	DH
	D) Optical Clarity of Scope						8-30-90	DH
645	Inspect for Live Ammo						8-30-90	DH
655	Final Inspection							
	A) Headspace						9/5/90	YH
	B) Trigger Pull	2.05	2.10	2.10	2.05	2.05	9/11/90	YH
	C) Function						9/5/90	YH
660	Pack						9-18-90	YH