

C6522173

MODEL 700™ H24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Smead®

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522173

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 12	90	RW
600	Proof	7 12	90	RW
607	Check Headspace	7 12	90	RW
610	Dis-assemble Gun	7 12	90	RW
612	Magnaflux Barrel Action		7-17-90	HR
	Magnaflux Bolt		7-17-90	HR
615	Rollmark Caliber		7-17-90	GB
617	Drill and Tap Sight Holes		7/23/90	LB
618	Polish Barrel <i>LB</i>		7/24/90	LB
620	Apply Coatings (Barrel Action)		7-16-90	LB
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/8/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/8/90	RW
	C) Inspect Ejector Hole for Chamfer		8/8/90	RW
	D) Oil Firing Pin Ass'y		8/8/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/17/90	RL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			8/16/90	SL
	G) Safety Off Force	3	3	3			8/16/90	SL
	H) Trigger Pull Test & Retainability						8/17/90	SL
	I) Firing Pin Indent	.0215	.021	.021			8/16/90	SL
	J) Assemble Stock						8/20/90	RW
	K) Assemble Swivel Studs						8/20/90	SL
	L) Attach Front and Rear Sight Assemblies						8/20/90	RW
	M) Iron Sight Alignment						8/20/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/20/90	RW
	O) Attach Scope to Rifle						8/20/90	RW
	P) Detach & Attach Scope 20 Times						8/20/90	RW
640	Gallery Target & Test						8/20/90	VF
	A) Time						8/20/90	VF
	B) Malfunctions						8/20/90	VF
	C) Pierced Primers						8/20/90	VF
	D) Optical Clarity of Scope						8/20/90	VF
645	Inspect for Live Ammo						8/20/90	VF
655	Final Inspection							
	A) Headspace						8/22/90	SL
	B) Trigger Pull	2.46	2.40	2.48	2.38	2.50	8/22/90	SL
	C) Function						8/24/90	SL
660	Pack						9/20/90	VF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6522173

DATE 8/17/92

TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.48	2.25	2.50	2.46	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.29	2.31	2.51	2.40	
PULL #3	2.32	2.30	2.50	2.48	
PULL #4	2.26	2.25	2.50	2.38	
PULL #5	2.31	2.28	2.35	2.50	
TOTAL	11.66	11.39	12.36	12.22	
AVG.	2.332	2.278	2.472	2.444	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.41	3.29		
PULL #2	3.32	3.30		
PULL #3	3.42	3.28		
PULL #4	3.40	3.30		
PULL #5	3.43	3.47		
TOTAL	16.98	16.64		
AVG.	3.396	3.328		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.35	4.27		4.38
PULL #2	4.20	4.28		4.50
PULL #3	4.33	4.31		4.31
PULL #4	4.27	4.27		4.33
PULL #5	4.34	4.32		4.40
TOTAL	21.49	21.45		21.92
AVG.	4.298	4.29		4.384

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522173
21 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.399566
1 TO	2	.474482
1 TO	3	.775542
1 TO	4	.1386
1 TO	5	.653723

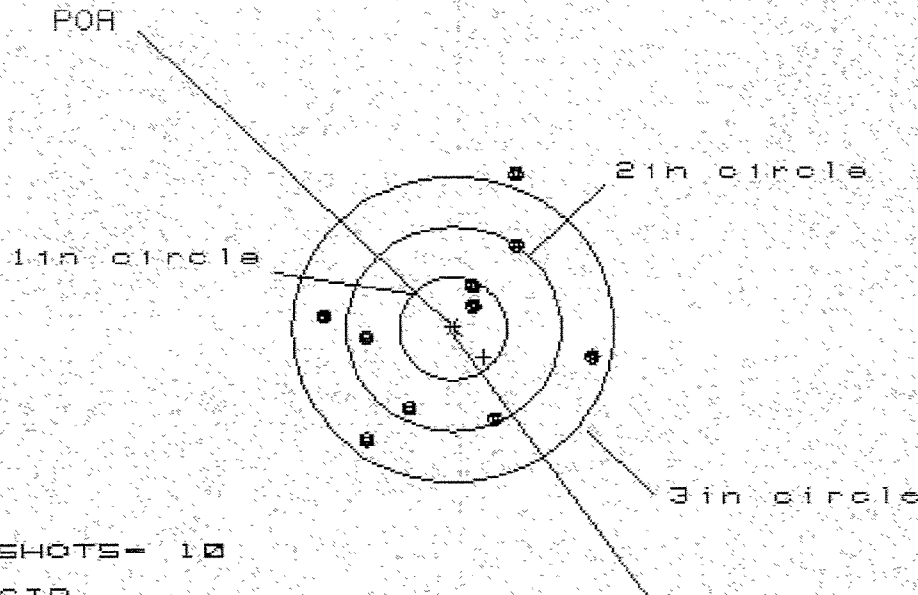
σ_{15} <----POA
3

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0382
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0388
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0544489
THE AMR FOR THIS RIFLE IS: .9976

28 Aug 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6522173

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.500

VS= 2.545

GS= 2.908

CENTROID *

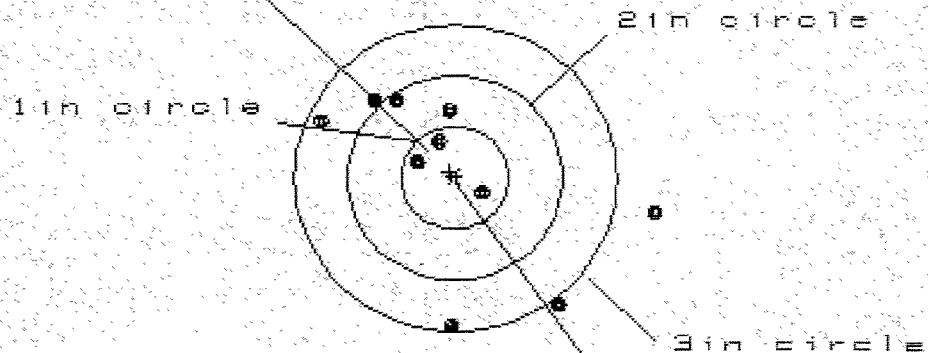
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.317	1.379	1.280
MINIMUM X	-1.183	-1.121	-1.220
MAXIMUM Y	1.473	.984	.870
MINIMUM Y	-1.072	-.908	-.800
CENTROID X	-.287	-.349	-.250
CENTROID Y	.278	.114	.228
POA TO CENTROID in.	.400	.367	.338
MIN RADIUS	.258	.429	.282
MEAN RADIUS	.982	.916	.862
MAX RADIUS	1.573	1.387	1.307
HORIZONTAL SPREAD	2.500	2.500	2.500
VERTICAL SPREAD	2.545	1.892	1.670
EXTREME SPREAD	2.908	2.536	2.536
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

28 Aug 1998

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CENTERFIRE PATTERNS # 2

POA



OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 8

HS= 3.035

VS= 2.270

GS= 3.178

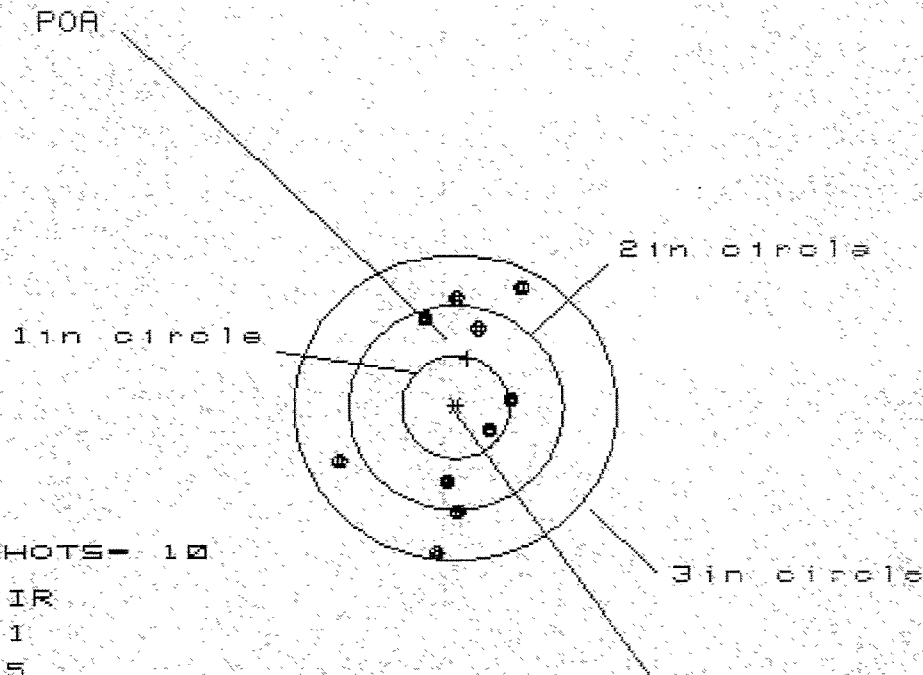
CENTROID #

PATTERN #	2
SHOTS (BEST OF)	10
MAXIMUM X	1.821
MINIMUM X	-1.214
MAXIMUM Y	.781
MINIMUM Y	-1.489
CENTROID X	.046
CENTROID Y	-.060
POA TO CENTROID in.	.075
MIN RADIUS	.302
MEAN RADIUS	.998
MAX RADIUS	1.862
HORIZONTAL SPREAD	3.035
VERTICAL SPREAD	2.270
EXTREME SPREAD	3.178
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	8

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 1.760

VS= 2.525

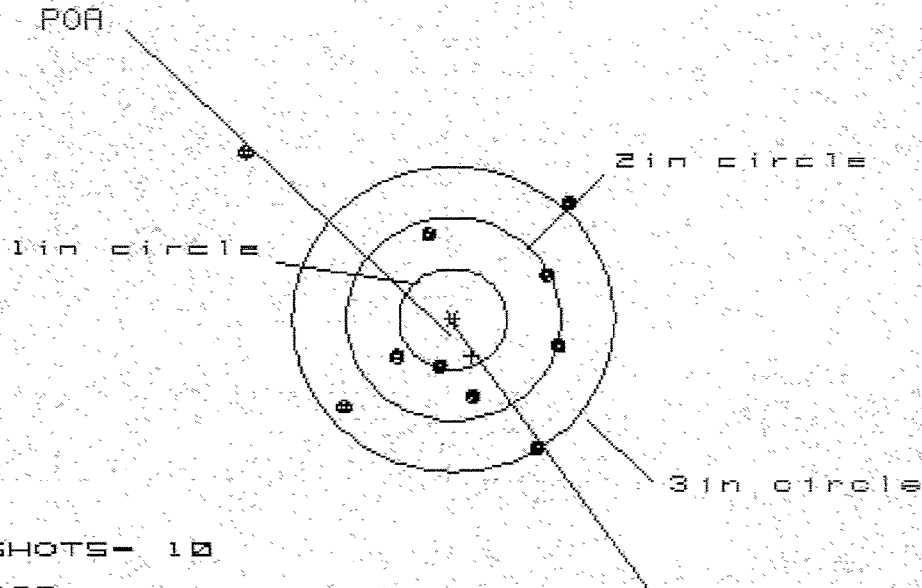
GS= 2.643

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.636	.620	.590
MINIMUM X	:	-1.124	-1.140	-1.062
MAXIMUM Y	:	1.133	.979	1.075
MINIMUM Y	:	-1.392	-1.179	-1.057
CENTROID X	:	-.114	-.098	-.176
CENTROID Y	:	-.478	-.324	-.446
POA TO CENTROID in.	:	.492	.338	.479
MIN RADIUS	:	.381	.474	.451
MEAN RADIUS	:	.951	.889	.858
MAX RADIUS	:	1.399	1.350	1.221
HORIZONTAL SPREAD	:	1.760	1.760	1.652
VERTICAL SPREAD	:	2.525	2.158	2.132
EXTREME SPREAD	:	2.643	2.448	2.132
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in - 0

2 in - 5

3 in - 8

HS= 2.978

VS= 2.923

GS= 3.942

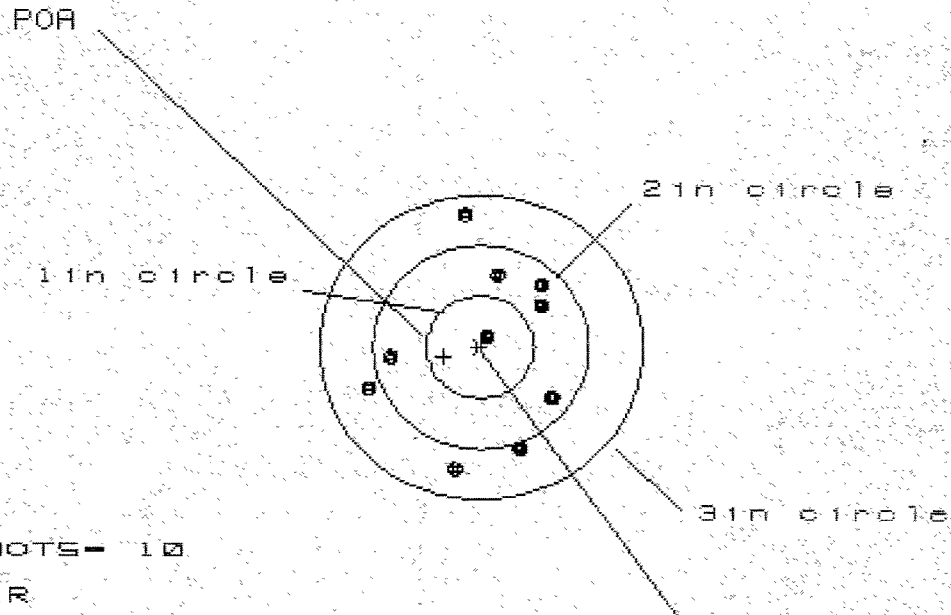
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.070	.858	.867
MINIMUM X	:	-1.908	-1.225	-1.118
MAXIMUM Y	:	1.624	1.289	1.171
MINIMUM Y	:	-1.299	-1.118	-.957
CENTROID X	:	-.176	.036	-.071
CENTROID Y	:	.361	.180	.019
POA TO CENTROID in.	:	.401	.184	.074
MIN RADIUS	:	.518	.491	.312
MEAN RADIUS	:	1.174	.987	.880
MAX RADIUS	:	2.506	1.548	1.250
HORIZONTAL SPREAD	:	2.978	2.083	1.985
VERTICAL SPREAD	:	2.923	2.407	2.128
EXTREME SPREAD	:	3.942	2.894	2.345
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 1.720

VS= 2.555

GS= 2.562

CENTROID #

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.641	.631	.594
MINIMUM X	-1.079	-1.089	-1.126
MAXIMUM Y	1.356	.840	.709
MINIMUM Y	-1.199	-1.049	-1.002
CENTROID X	.340	.350	.387
CENTROID Y	.093	-.057	.074
POA TO CENTROID in.	.352	.355	.394
MIN RADIUS	.141	.285	.151
MEAN RADIUS	.083	.039	.777
MAX RADIUS	1.359	1.109	1.176
HORIZONTAL SPREAD	1.720	1.720	1.720
VERTICAL SPREAD	2.555	1.889	1.711
EXTREME SPREAD	2.562	2.031	1.930
NUMBER IN ONE INCH CIRCLE	=	1	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	10	

Remington®
REG. U.S. PAT. & TM. OFF.

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

MODEL 700™ H24

SERIAL NO.
C6522173

ORDER NO.
5716

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5716 C6522173

UPC

