

06522151

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Smead®

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6522151

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	ES.
617	Drill and Tap Sight Holes		8/10/90	WB
618	Polish Barrel RB		8/14/90	WB
620	Apply Coatings (Barrel Action)		8/24/90	TH
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		8/27/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/27/90	RW
	C) Inspect Ejector Hole for Chamfer		8/27/90	RW
	D) Oil Firing Pin Ass'y		8/27/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/31/90	TH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			9/5/90	WB
	G) Safety Off Force	3	3	3			9/5/90	WB
	H) Trigger Pull Test & Retainability						8/5/90	SM
	I) Firing Pin Indent	.0215	.0215	.0215			9/5/90	WB
	J) Assemble Stock						9/10/90	RW
	K) Assemble Swivel Studs						9/15/90	228
	L) Attach Front and Rear Sight Assemblies						9/10/90	RW
	M) Iron Sight Alignment						9/10/90	RW
	N) Detach Front & Rear Sights & place in numbered container						9/10/90	RW
	O) Attach Scope to Rifle						9/10/90	RW
	P) Detach & Attach Scope 20 Times						9/10/90	RW
640	Gallery Target & Test						9-12-90	DA
	A) Time						9-12-90	DA
	B) Malfunctions						9-12-90	DA
	C) Pierced Primers						9-12-90	DA
	D) Optical Clarity of Scope						9-12-90	DA
645	Inspect for Live Ammo						9-12-90	DA
655	Final Inspection							
	A) Headspace						9/15/90	228
	B) Trigger Pull	2.10	2.15	2.19	2.11	2.17	9-14-90	221
	C) Function						9/15/90	228
660	Pack						9/19/90	AF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6522151

DATE 8/31/90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.16	2.39	2.51	2.10	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.15	2.50	2.39	2.15	
PULL #3	2.42	2.30	2.51	2.19	
PULL #4	2.44	2.48	2.53	2.11	
PULL #5	2.43	2.46	2.45	2.17	
TOTAL	11.60	12.13	12.39	10.72	
AVG.	2.32	2.426	2.478	2.144	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.20	3.10		
PULL #2	3.16	3.18		
PULL #3	3.14	3.25		
PULL #4	3.16	3.28		
PULL #5	3.37	3.34		
TOTAL	16.03	16.15		
AVG.	3.206	3.23		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.13	4.10		4.49
PULL #2	4.25	4.28		4.48
PULL #3	4.27	4.33		4.26
PULL #4	4.12	4.24		4.47
PULL #5	4.21	4.01		4.49
TOTAL	20.98	20.96		22.19
AVG.	4.196	4.192		4.438

Remington®  REG. U.S. PAT. & TM. OFF.

MODEL 700™ H24

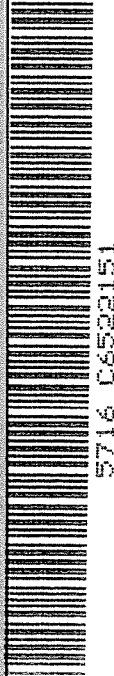
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

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

SERIAL NO.
C6522151

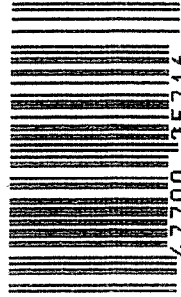
ORDER NO.
5716

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5716 C6522151

LPC



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CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522151
12 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.65307
1 TO	2	.310306
1 TO	3	.500146
1 TO	4	.054626
1 TO	5	.438912

3 4 5
<----POA

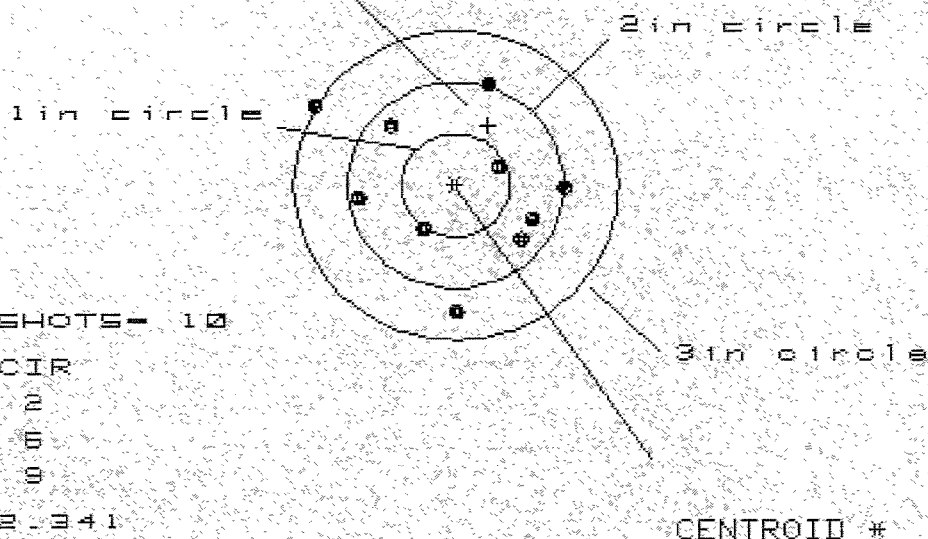
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.3952
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.4936
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .632316
THE AMR FOR THIS RIFLE IS: .8092

12 Sep 1990

FILE:/PATTERNING/CENTERFIRE_PATT/08522151

CENTERFIRE PATTERNS # 1

POA



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS= 2.341

VS= 2.179

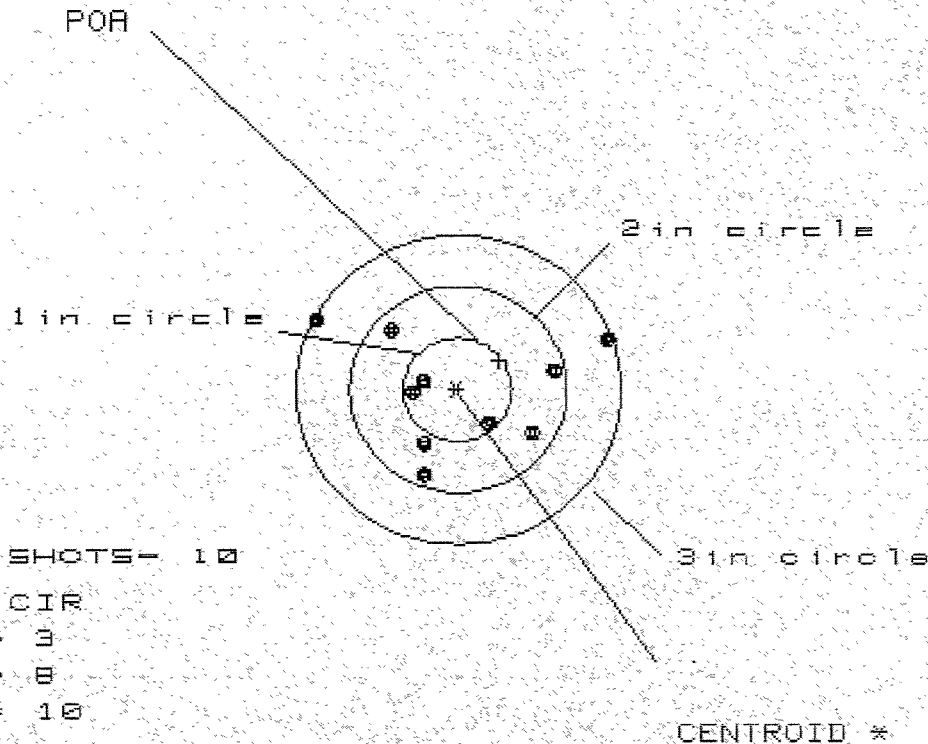
GS= 2.466

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.049	.905	.884
MINIMUM X	-1.292	-1.047	-1.068
MAXIMUM Y	.968	1.055	.914
MINIMUM Y	-1.211	-1.124	-.615
CENTROID X	-.304	-.160	-.139
CENTROID Y	-.578	-.665	-.524
POA TO CENTROID in.	.654	.684	.542
MIN RADIUS	.460	.393	.289
MEAN RADIUS	.914	.824	.776
MAX RADIUS	1.506	1.137	1.077
HORIZONTAL SPREAD	2.341	1.952	1.952
VERTICAL SPREAD	2.179	2.179	1.529
EXTREME SPREAD	2.466	2.202	1.954
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 8

3 in = 10

HS= 2.681

VS= 1.515

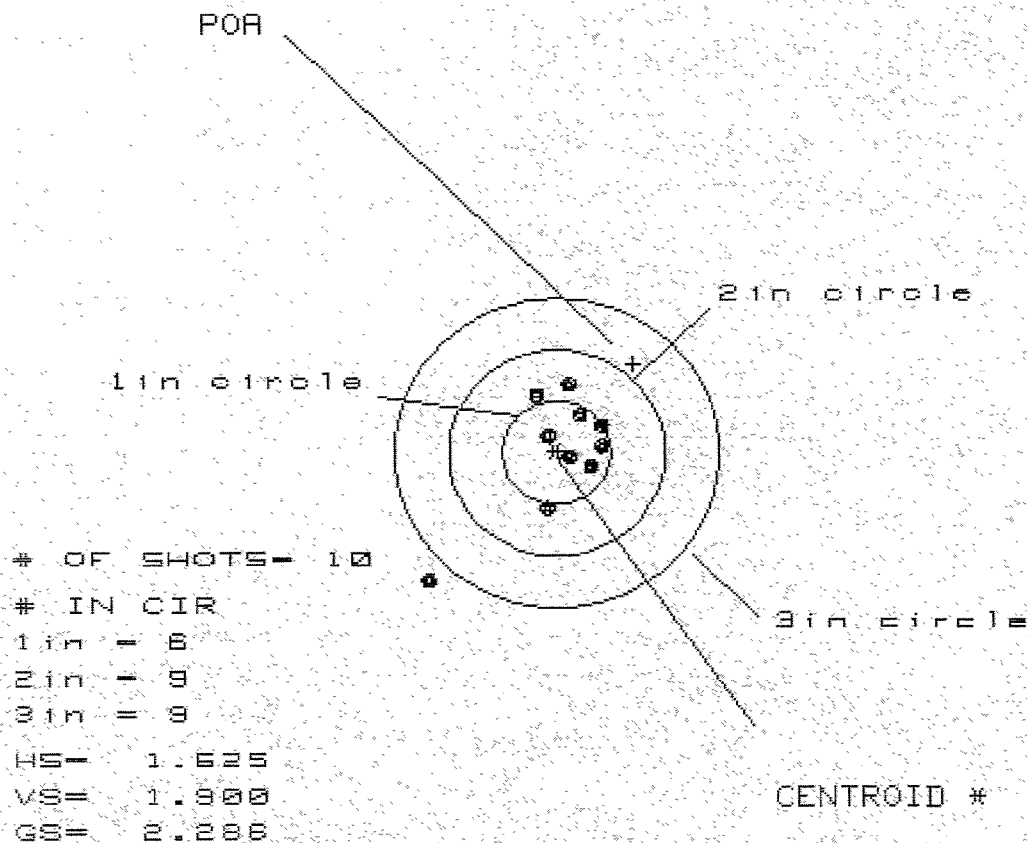
GS= 2.695

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.370	1.224	.935
MINIMUM X	-1.311	-.712	-.559
MAXIMUM Y	.720	.680	.746
MINIMUM Y	-.795	-.715	-.649
CENTROID X	-.387	-.241	-.394
CENTROID Y	-.279	-.359	-.425
POA TO CENTROID in.	.477	.433	.580
MIN RADIUS	.304	.308	.350
MEAN RADIUS	.809	.729	.622
MAX RADIUS	1.496	1.333	1.002
HORIZONTAL SPREAD	2.681	1.936	1.494
VERTICAL SPREAD	1.515	1.395	1.395
EXTREME SPREAD	2.695	2.120	1.625
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 3

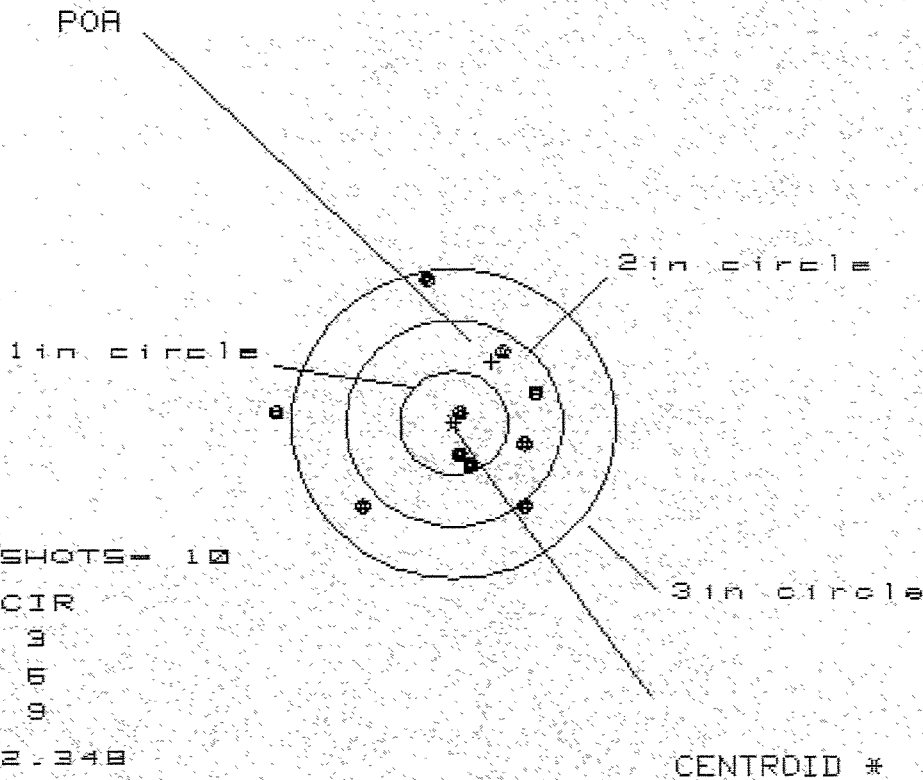


PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	-.452	.321	.318
MINIMUM X	:	-1.173	-.347	-.351
MAXIMUM Y	:	.643	.503	.441
MINIMUM Y	:	-1.257	-.696	-.633
CENTROID X	:	-.715	-.584	-.581
CENTROID Y	:	-.863	-.723	-.786
POA TO CENTROID in.	:	1.120	.930	.977
MIN RADIUS	:	.111	.220	.171
MEAN RADIUS	:	.553	.377	.359
MAX RADIUS	:	1.720	.722	.663
HORIZONTAL SPREAD	:	1.625	.668	.668
VERTICAL SPREAD	:	1.900	1.199	1.074
EXTREME SPREAD	:	2.286	1.210	1.085
NUMBER IN ONE INCH CIRCLE	=		6	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 9

HS= 2.348

VS= 2.228

GS= 2.419

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.751	.574	.518
MINIMUM X	:	-1.597	-1.042	-1.098
MAXIMUM Y	:	1.383	1.392	.836
MINIMUM Y	:	-.845	-.836	-.661
CENTROID X	:	-.354	-.177	-.121
CENTROID Y	:	-.600	-.609	-.784
POA TO CENTROID in.	:	.697	.635	.793
MIN RADIUS	:	.106	.195	.282
MEAN RADIUS	:	.834	.718	.596
MAX RADIUS	:	1.599	1.463	1.246
HORIZONTAL SPREAD	:	2.348	1.616	1.616
VERTICAL SPREAD	:	2.228	2.228	1.497
EXTREME SPREAD	:	2.419	2.407	1.929
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 10

HS= 1.651

VS= 2.248

GS= 2.499

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.737	.638	.671
MINIMUM X	-.914	-1.013	-.933
MAXIMUM Y	1.108	.988	.830
MINIMUM Y	-1.140	-1.260	-1.040
CENTROID X	-.216	-.117	-.197
CENTROID Y	-.148	-.028	.130
POA TO CENTROID in.	.262	.120	.236
MIN RADIUS	.447	.328	.168
MEAN RADIUS	.936	.862	.768
MAX RADIUS	1.401	1.413	1.042
HORIZONTAL SPREAD	1.651	1.651	1.604
VERTICAL SPREAD	2.248	2.248	1.870
EXTREME SPREAD	2.499	2.499	1.871
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		