

C6522298

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522298

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/27/90	KH
600	Proof		6/27/90	KH
607	Check Headspace		6/27/90	KH
610	Dis-assemble Gun		6/27/90	KH
612	Magnaflux Barrel Action		7/10/90	KR
	Magnaflux Bolt		7/10/90	KR
615	Rollmark Caliber		7/14/90	L.S.
617	Drill and Tap Sight Holes		7/11/90	FB
618	Polish Barrel RB		7/13/90	W/B
620	Apply Coatings (Barrel Action)		7/23/90	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/30/90	KH
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/30/90	KH
	C) Inspect Ejector Hole for Chamfer		7/30/90	KH
	D) Oil Firing Pin Ass'y		7/30/90	KH
	E) Adjust Trigger Pull to Min Setting and Stake		8/21/90	JP

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			7/31/90	JK
	G) Safety Off Force	3	3	3			7/31/90	JK
	H) Trigger Pull Test & Retainability						8/21/90	JK
	I) Firing Pin Indent	0235	023	023			7/31/90	JK
	J) Assemble Stock						7/31/90	JK
	K) Assemble Swivel Studs						7/24/90	JK
	L) Attach Front and Rear Sight Assemblies						7/31/90	JK
	M) Iron Sight Alignment						7/31/90	JK
	N) Detach Front & Rear Sights & place in numbered container						7/31/90	JK
	O) Attach Scope to Rifle						7/31/90	JK
	P) Detach & Attach Scope 20 Times						7/31/90	JK
640	Gallery Target & Test						8-1-90	DH
	A) Time						8-1-90	DH
	B) Malfunctions						8-1-90	DH
	C) Pierced Primers						8-1-90	DH
	D) Optical Clarity of Scope						8-1-90	DH
645	Inspect for Live Ammo						8-1-90	DH
655	Final Inspection							
	A) Headspace						2/29/90	JD
	B) Trigger Pull	2.43	2.48	2.41	2.34	2.45	8/21/90	JK
	C) Function						8/24/90	JK
660	Pack						9/20/90	NE

SWS TRIGGER PULL TEST

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

SERIAL NO. C6522298
DATE 8/20/90
TESTER JP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.45	2.38	2.35	2.43	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.36	2.33	2.32	2.48	
PULL #3	2.39	2.37	2.44	2.41	
PULL #4	2.38	2.31	2.45	2.34	
PULL #5	2.53	2.51	2.45	2.45	
TOTAL	11.91	11.90	12.01	12.11	
AVG.	2.382	2.38	2.402	2.422	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.26	3.31		
PULL #2	3.32	3.18		
PULL #3	3.27	3.03		
PULL #4	3.19	3.20		
PULL #5	3.21	3.35		
TOTAL	16.25	16.07		
AVG.	3.25	3.214		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.12	4.14		4.19
PULL #2	4.16	4.24		4.23
PULL #3	4.35	4.16		4.20
PULL #4	4.16	4.25		4.16
PULL #5	4.26	4.17		4.20
TOTAL	21.05	20.96		20.98
AVG.	4.21	4.192		4.196

Remington[®]

REG. U.S. PAT. & TM. OFF.

MODEL 700TM 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.

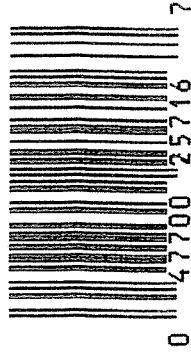
SERIAL NO.
C6522298

ORDER NO.
5716

Q1



UPC



CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06522298
1 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.173511
1 TO	2	.0841487
1 TO	3	.0868332
1 TO	4	.125539
1 TO	5	.419935

POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0848
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0164
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0863713
THE AMR FOR THIS RIFLE IS: .8296

1 Aug 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6522298

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 4

2in = 9

3in = 10

HS= 1.842

VS= 1.156

GS= 1.920

CENTROID #

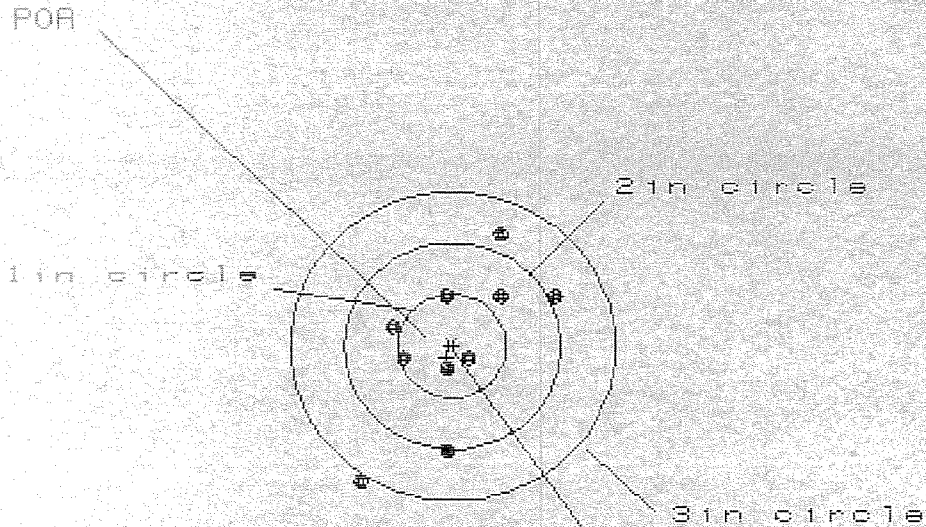
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.790	.674	.496
MINIMUM X	-1.052	-1.007	-.923
MAXIMUM Y	.510	.506	.483
MINIMUM Y	-.646	-.650	-.587
CENTROID X	.135	.251	.167
CENTROID Y	.109	.113	.050
POA TO CENTROID in.	.173	.276	.174
MIN RADIUS	.360	.281	.294
MEAN RADIUS	.650	.579	.550
MAX RADIUS	1.052	1.050	.991
HORIZONTAL SPREAD	1.842	1.681	1.419
VERTICAL SPREAD	1.156	1.156	1.069
EXTREME SPREAD	1.920	1.694	1.435
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	9		
NUMBER IN THREE INCH CIRCLE =	10		

1 Aug 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6522298

CENTERFIRE PATTERNS

2



OF SHOTS= 10

IN CIR

1in = 4

2in = 7

3in = 9

HS= 1.753

VS= 2.372

CS= 2.691

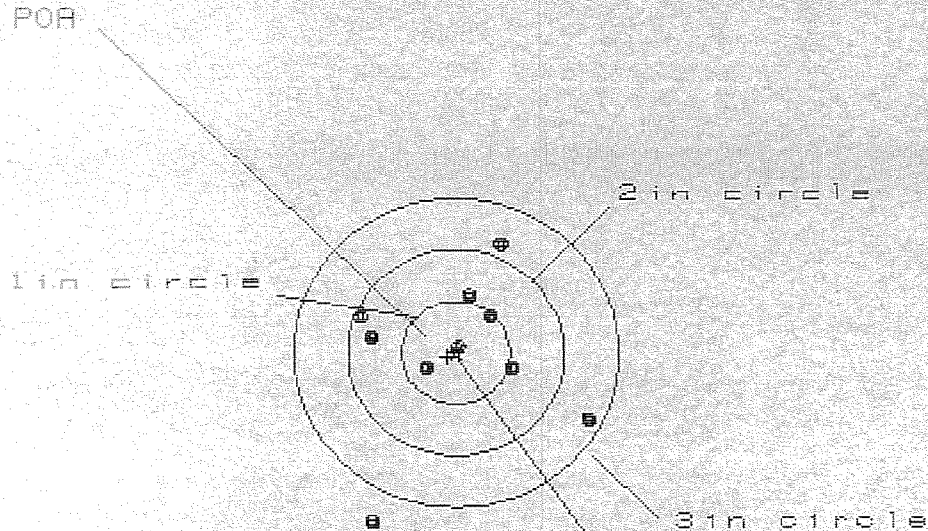
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.941	.849	.894
MINIMUM X	:	-.823	-.661	-.616
MAXIMUM Y	:	1.072	.928	.465
MINIMUM Y	:	-1.300	-1.122	-1.006
CENTROID X	:	.051	.143	.098
CENTROID Y	:	.114	.258	.142
POA TO CENTROID in.	:	.125	.295	.173
MIN RADIUS	:	.191	.240	.167
MEAN RADIUS	:	.731	.637	.578
MAX RADIUS	:	1.538	1.128	1.009
HORIZONTAL SPREAD	:	1.763	1.510	1.510
VERTICAL SPREAD	:	2.372	2.050	1.471
EXTREME SPREAD	:	2.691	2.103	1.739
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

1 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08522298

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 2.147

VS= 2.765

GS= 3.011

CENTROID #

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.230	1.148	.579
MINIMUM X	-.917	-.999	-.855
MAXIMUM Y	1.081	.894	.795
MINIMUM Y	-1.684	-.792	-.468
CENTROID X	.081	.163	.019
CENTROID Y	.041	.228	.327
POA TO CENTROID in.	.091	.280	.328
MIN RADIUS	.081	.123	.227
MEAN RADIUS	.815	.676	.591
MAX RADIUS	1.838	1.395	.949
HORIZONTAL SPREAD	2.147	2.147	1.434
VERTICAL SPREAD	2.765	1.686	1.263
EXTREME SPREAD	3.011	2.370	1.569
NUMBER IN ONE INCH CIRCLE	=	3	
NUMBER IN TWO INCH CIRCLE	=	7	
NUMBER IN THREE INCH CIRCLE	=	9	

1 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522298

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 9

HS= 2.894

VS= 1.931

GS= 2.940

CENTROID #

PATTERN #

4

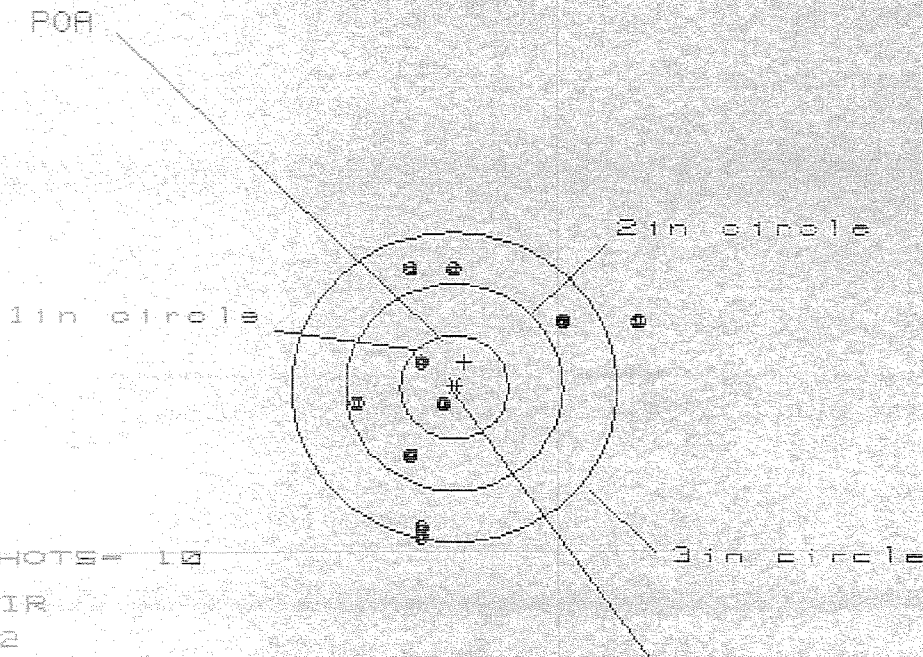
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.328	1.154	.900
MINIMUM X	-1.566	-.882	-.737
MAXIMUM Y	1.091	1.119	1.089
MINIMUM Y	-.841	-.812	-.842
CENTROID X	.251	.425	.280
CENTROID Y	.061	.033	.063
POA TO CENTROID in.	.258	.426	.287
MIN RADIUS	.326	.351	.317
MEAN RADIUS	.907	.828	.767
MAX RADIUS	1.586	1.178	1.101
HORIZONTAL SPREAD	2.894	2.036	1.637
VERTICAL SPREAD	1.931	1.931	1.931
EXTREME SPREAD	2.940	2.054	2.002
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

1 Aug 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6522290

CENTERFIRE PATTERNS

5



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 4

3 in = 9

HS= 2.577

VS= 2.587

GS= 2.886

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.673	1.193	1.173
MINIMUM X	:	-.904	-.718	-.738
MAXIMUM Y	:	1.133	1.200	1.027
MINIMUM Y	:	-1.455	-1.387	-1.432
CENTROID X	:	-.094	-.280	-.260
CENTROID Y	:	-.243	-.310	-.137
POA TO CENTROID in.	:	.260	.418	.294
MIN RADIUS	:	.219	.162	.208
MEAN RADIUS	:	1.045	.928	.864
MAX RADIUS	:	1.781	1.400	1.441
HORIZONTAL SPREAD	:	2.577	1.911	1.911
VERTICAL SPREAD	:	2.587	2.587	2.459
EXTREME SPREAD	:	2.886	2.587	2.459
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	