

C6522341

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington

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

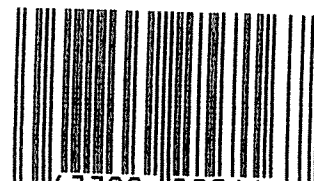
MODEL 700™ H24**SERIAL NO.**
C6522341**ORDER NO.**
5716

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

Ø1



5716 C6522341

UPC

0 47700 25716 7

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522341
16 Sep 1990

CENTROIDAL DISTANCES

Ø TO	1	.405183
1 TO	2	.129958
1 TO	3	.641346
1 TO	4	.312872
1 TO	5	.307319

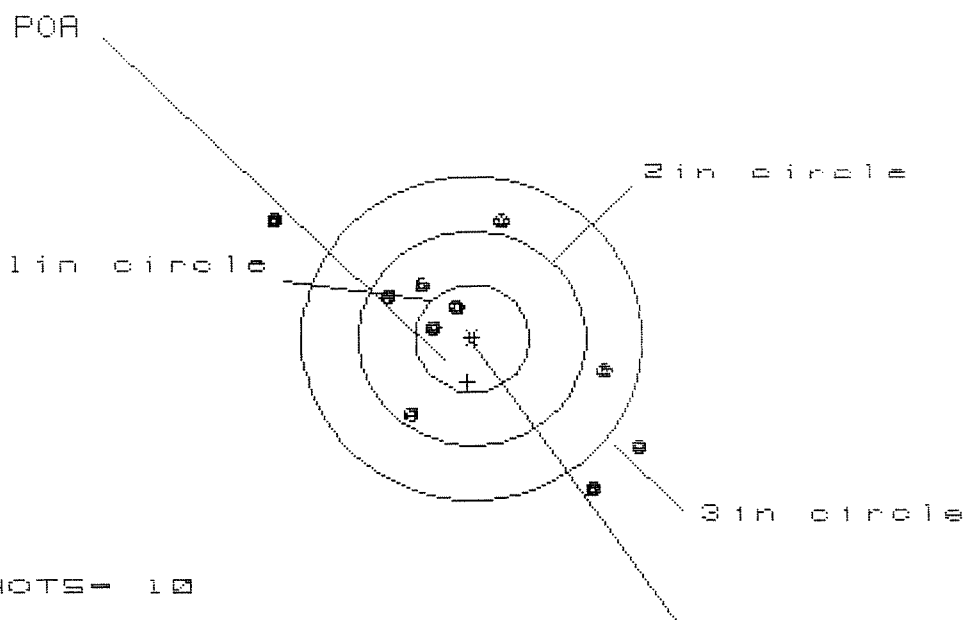
10/2/90 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0042
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1364
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .136465
THE AMR FOR THIS RIFLE IS: 1.109

16 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522341

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 7

HS= 3.237

VS= 2.544

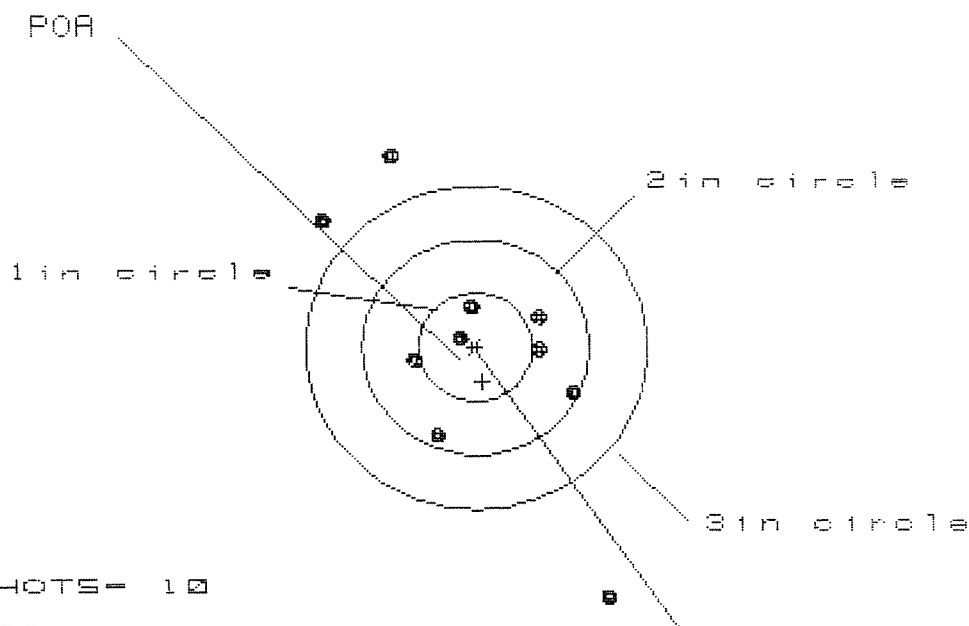
GS= 3.840

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.488	1.293	1.109
MINIMUM X	:	-1.749	-.923	-.761
MAXIMUM Y	:	1.142	1.261	1.152
MINIMUM Y	:	-1.402	-1.283	-1.392
CENTROID X	:	.042	.237	.075
CENTROID Y	:	.403	.284	.393
POA TO CENTROID in.	:	.406	.370	.400
MIN RADIUS	:	.294	.495	.316
MEAN RADIUS	:	1.097	1.031	.900
MAX RADIUS	:	2.052	1.560	1.730
HORIZONTAL SPREAD	:	3.237	2.216	1.870
VERTICAL SPREAD	:	2.544	2.544	2.544
EXTREME SPREAD	:	3.840	2.677	2.677
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	7		

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 7

3 in = 7

HS= 2.536

VS= 4.099

GS= 4.525

CENTROID #

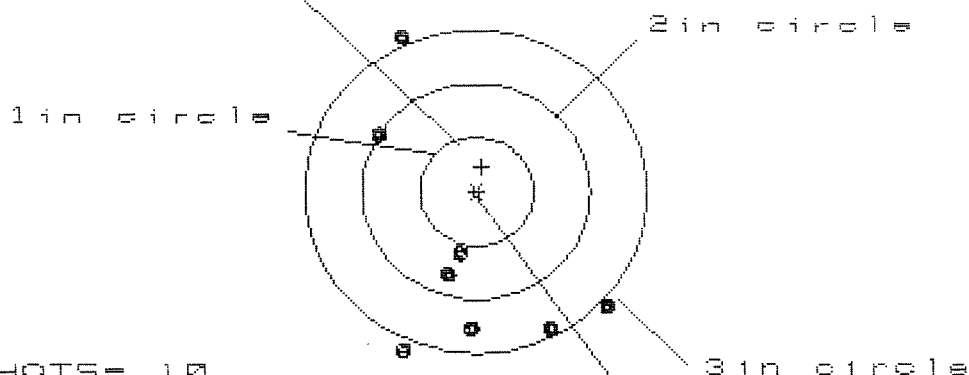
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.204	.957	.885
MINIMUM X	:	-1.332	-1.198	-1.270
MAXIMUM Y	:	1.777	1.519	1.087
MINIMUM Y	:	-2.322	-1.086	-.896
CENTROID X	:	-.058	-.192	-.119
CENTROID Y	:	.320	.578	.388
POA TO CENTROID in.	:	.325	.609	.406
MIN RADIUS	:	.194	.168	.111
MEAN RADIUS	:	1.038	.855	.725
MAX RADIUS	:	2.615	1.626	1.672
HORIZONTAL SPREAD	:	2.536	2.155	2.155
VERTICAL SPREAD	:	4.099	2.605	1.983
EXTREME SPREAD	:	4.525	2.654	2.650
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 3

POA



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 2

3 in = 5

HS= 2.039

VS= 3.703

GS= 3.841

CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.166	1.203	1.269
MINIMUM X	:	-.873	-.836	-.770
MAXIMUM Y	:	2.277	2.376	1.968
MINIMUM Y	:	-1.426	-1.173	-.876
CENTROID X	:	-.048	-.085	-.151
CENTROID Y	:	-.232	-.485	-.782
POA TO CENTROID in.	:	.237	.492	.796
MIN RADIUS	:	.582	.327	.023
MEAN RADIUS	:	1.430	1.253	.982
MAX RADIUS	:	2.300	2.435	2.055
HORIZONTAL SPREAD	:	2.039	2.039	2.039
VERTICAL SPREAD	:	3.703	3.549	2.844
EXTREME SPREAD	:	3.841	3.743	3.068
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		5	

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CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 0

2 in = 4

3 in = 6

HS= 3.135

VS= 2.440

GS= 3.253

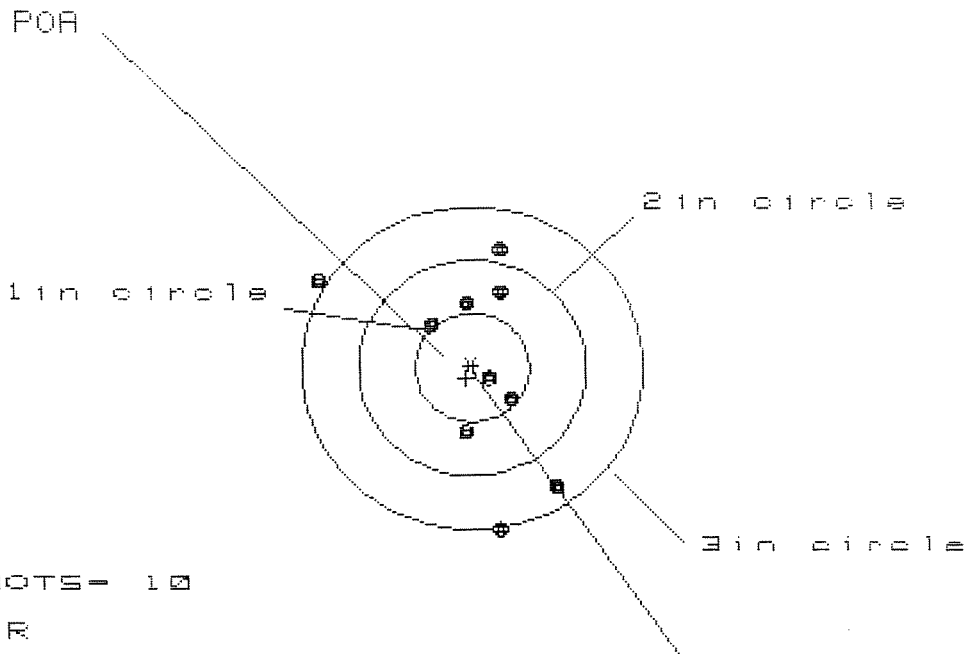
CENTROID #

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.614	1.699	1.538
MINIMUM X	:	-1.521	-1.436	-1.598
MAXIMUM Y	:	.909	.739	.754
MINIMUM Y	:	-1.531	-1.215	-1.122
CENTROID X	:	-.013	-.098	.064
CENTROID Y	:	.095	.265	.172
POA TO CENTROID in.	:	.095	.282	.184
MIN RADIUS	:	.607	.514	.502
MEAN RADIUS	:	1.131	1.053	.984
MAX RADIUS	:	1.714	1.721	1.643
HORIZONTAL SPREAD	:	3.135	3.135	3.135
VERTICAL SPREAD	:	2.440	1.954	1.876
EXTREME SPREAD	:	3.253	3.185	3.185
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	6		

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS= 2.113

VS= 2.561

GS= 2.844

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.726	.572	.577
MINIMUM X	:	-1.387	-.490	-.485
MAXIMUM Y	:	1.090	1.176	1.003
MINIMUM Y	:	-1.471	-1.385	-1.217
CENTROID X	:	.056	.210	.205
CENTROID Y	:	.096	.010	.183
POA TO CENTROID in.	:	.111	.210	.274
MIN RADIUS	:	.191	.037	.151
MEAN RADIUS	:	.848	.742	.659
MAX RADIUS	:	1.588	1.385	1.347
HORIZONTAL SPREAD	:	2.113	1.062	1.062
VERTICAL SPREAD	:	2.561	2.561	2.220
EXTREME SPREAD	:	2.844	2.561	2.276
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

SWS TRIGGER PULL TEST

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

SERIAL NO. C6522341
DATE 9/11/90
TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.58	2.59	2.33	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.50	2.49	2.63	2.32	
PULL #3	2.42	2.47	2.55	2.31	
PULL #4	2.50	2.39	2.60	2.29	
PULL #5	2.37	2.51	2.52	2.19	
TOTAL	12.22	12.44	12.89	11.44	
AVG.	2.44	2.49	2.58	2.288	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.20	3.20		
PULL #2	3.18	3.30		
PULL #3	3.07	3.25		
PULL #4	3.18	3.21		
PULL #5	3.20	3.22		
TOTAL	15.83	16.18		
AVG.	3.16	3.23		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.15	4.06		4.00
PULL #2	4.26	4.16		3.80
PULL #3	4.19	4.35		3.83
PULL #4	4.07	4.37		3.80
PULL #5	4.23	4.27		3.76
TOTAL	20.90	21.21		19.19
AVG.	4.18	4.24		3.82

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522341

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		8-21-90	DB
600	Proof		8-21-90	DB
607	Check Headspace		8-21-90	DB
610	Dis-assemble Gun		8-21-90	DB
612	Magnaflux Barrel Action		8/22/90	KCR
	Magnaflux Bolt		8/22/90	KCR
615	Rollmark Caliber		8/22/90	GS.
617	Drill and Tap Sight Holes		8/23/90	LB
618	Polish Barrel		8/23/90	WB
620	Apply Coatings (Barrel Action)		8-20-90	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/31/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/31/90	RW
	C) Inspect Ejector Hole for Chamfer		8/31/90	RW
	D) Oil Firing Pin Ass'y		8/31/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9/1/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 ont.	F) Safety On Force	5	5	5			9/4/90	WB
	G) Safety Off Force	7 1/2	7 1/2	7 1/4			9/4/90	WB
	H) Trigger Pull Test & Retainability						9/4/90	WB
	I) Firing Pin Indent	.023	.0235	.023			9/4/90	WB
	J) Assemble Stock						9/15/90	RW
	K) Assemble Swivel Studs						9/17/90	AD
	L) Attach Front and Rear Sight Assemblies						9/15/90	RW
	M) Iron Sight Alignment						9/15/90	RW
	N) Detach Front & Rear Sights & place in numbered container						9/15/90	RW
	O) Attach Scope to Rifle						9/15/90	RW
	P) Detach & Attach Scope 20 Times						9/15/90	RW
640	Gallery Target & Test						9/16/90	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						9/16/90	AF
655	Final Inspection							
	A) Headspace						9/17/90	928
	B) Trigger Pull	7-33	2-32	2-31	2-29	2-19	9-17-90	928
	C) Function						9/17/90	928
660	Pack						9-19-90	DH