

C6522348

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington®



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

MODEL 700™ H24

**SERIAL NO.
C6522348**

ORDER NO.

5716

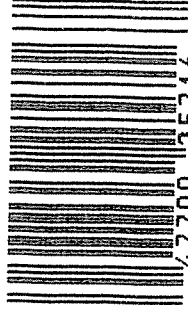
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

Ø1



5716 C6522348

UPC



0 47700 25716 7

100

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06522348
16 Aug 1990

CENTROIDAL DISTANCES

0	TO	1	.968618
1	TO	2	.75018
1	TO	3	.931271
1	TO	4	.826736
1	TO	5	.647324

1
2
3
4

<----POA

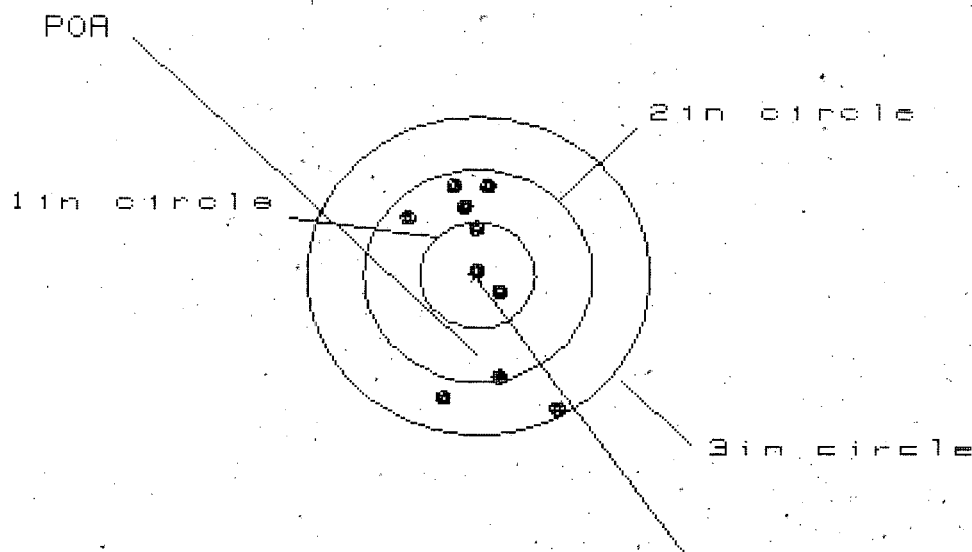
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.215
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .3342
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .397385

THE AMR FOR THIS RIFLE IS: .97

16 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522348

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 2

2in = 8

3in = 10

HS= 1.268

VS= 2.108

GS= 2.279

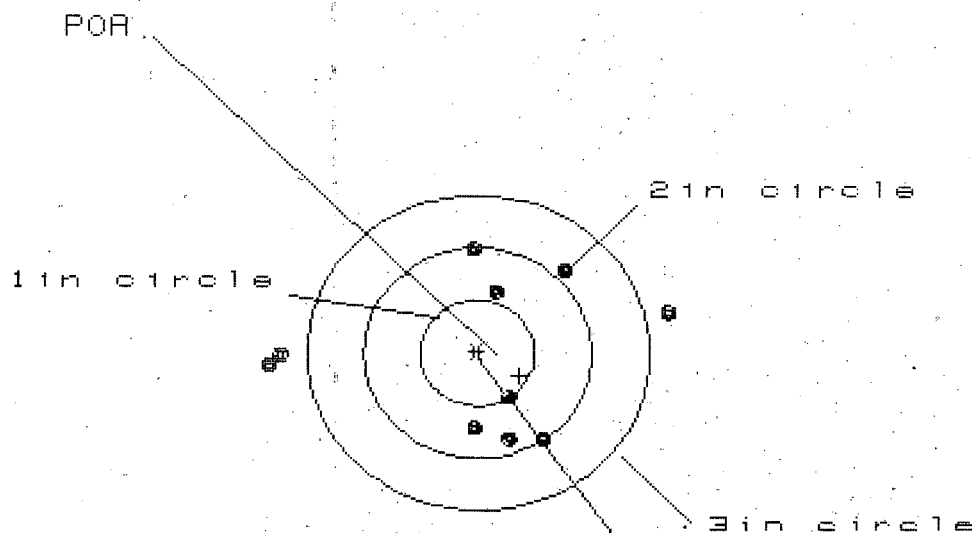
CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.647	.279	.255
MINIMUM X	-.621	-.549	-.573
MAXIMUM Y	.882	.745	.582
MINIMUM Y	-1.226	-1.305	-1.256
CENTROID X	-.189	-.261	-.237
CENTROID Y	.950	1.087	1.250
POA TO CENTROID in.	.969	1.118	1.272
MIN RADIUS	.072	.095	.216
MEAN RADIUS	.764	.669	.550
MAX RADIUS	1.387	1.319	1.276
HORIZONTAL SPREAD	1.268	.828	.828
VERTICAL SPREAD	2.108	2.050	1.838
EXTREME SPREAD	2.279	2.051	1.881
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in - 1

2in - 5

3in = 7

HS- 3.564

VS= 1.847

GS= 3.588

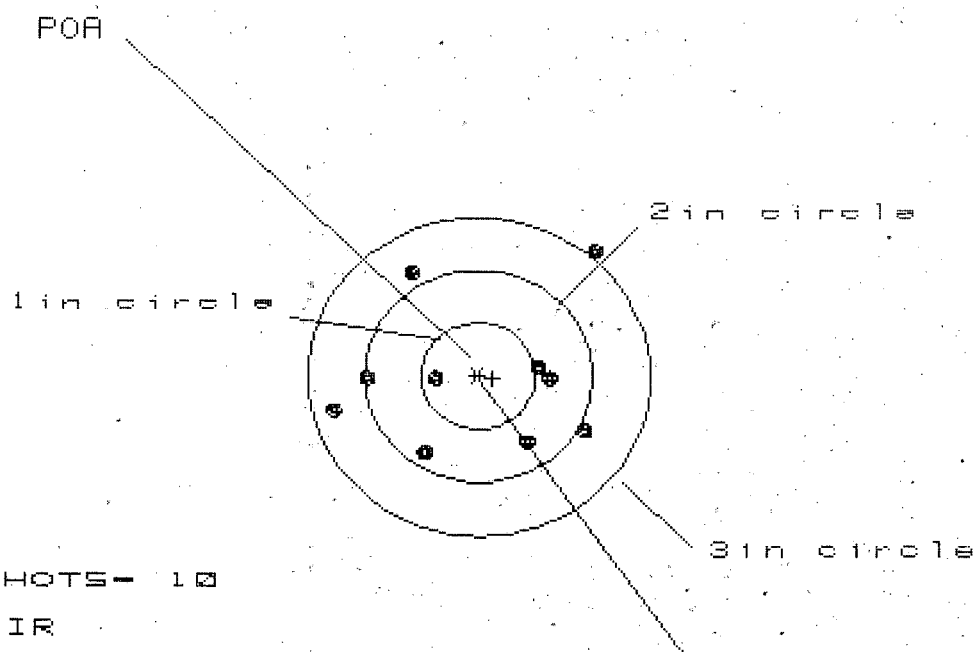
CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.691	1.483	.720
MINIMUM X	-1.873	-1.917	-1.732
MAXIMUM Y	1.009	1.002	1.045
MINIMUM Y	-.838	-.845	-.802
CENTROID X	-.366	-.158	-.343
CENTROID Y	.211	.218	.175
POA TO CENTROID in.	.422	.269	.385
MIN RADIUS	.442	.384	.399
MEAN RADIUS	1.102	.985	.920
MAX RADIUS	1.874	1.917	1.733
HORIZONTAL SPREAD	3.564	3.400	2.452
VERTICAL SPREAD	1.847	1.847	1.847
EXTREME SPREAD	3.588	3.417	2.568
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in - 1

2 in - 6

3 in - 9

HS- 2.290

VS- 1.898

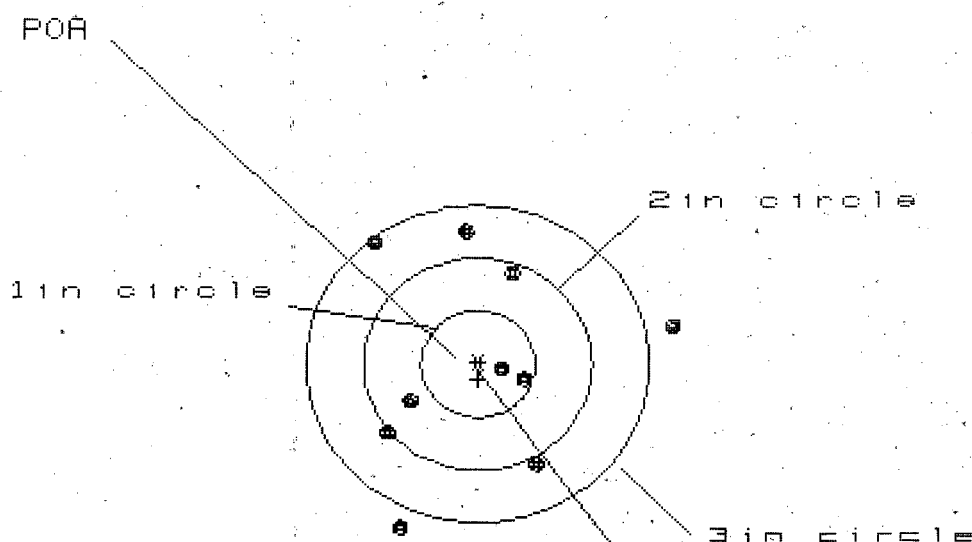
GS- 2.747

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.040	1.089	.947
MINIMUM X	:	-1.250	-1.134	-.958
MAXIMUM Y	:	1.158	1.121	1.092
MINIMUM Y	:	-.740	-.611	-.640
CENTROID X	:	-.124	-.240	-.098
CENTROID Y	:	.021	-.108	-.079
POA TO CENTROID in.	:	.126	.263	.126
MIN RADIUS	:	.346	.233	.368
MEAN RADIUS	:	.908	.819	.766
MAX RADIUS	:	1.557	1.205	1.239
HORIZONTAL SPREAD	:	2.290	2.223	1.905
VERTICAL SPREAD	:	1.898	1.732	1.732
EXTREME SPREAD	:	2.747	2.227	2.138
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	9		

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 7

HS= 2.618

VS= 2.773

GS= 3.057

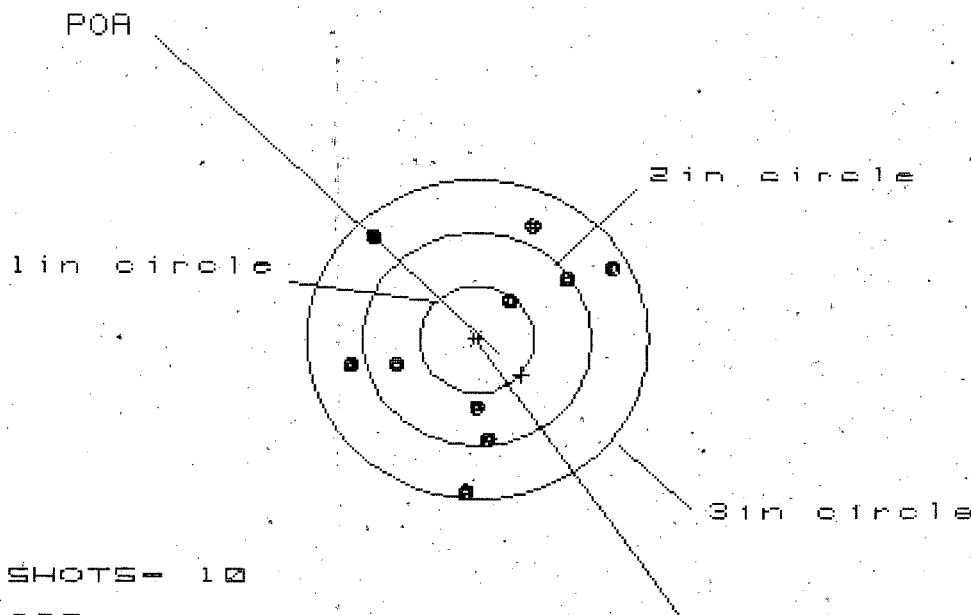
CENTROID #

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.705	.679	.612
MINIMUM X	:	-.913	-.723	-.790
MAXIMUM Y	:	1.277	1.318	1.136
MINIMUM Y	:	-1.496	-1.455	-1.087
CENTROID X	:	-.005	-.195	-.128
CENTROID Y	:	.144	.103	.285
POA TO CENTROID in.	:	.144	.220	.313
MIN RADIUS	:	.195	.373	.372
MEAN RADIUS	:	1.057	.985	.911
MAX RADIUS	:	1.743	1.550	1.321
HORIZONTAL SPREAD	:	2.618	1.402	1.402
VERTICAL SPREAD	:	2.773	2.773	2.223
EXTREME SPREAD	:	3.057	2.845	2.563
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	7		

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in - 1

2 in - 5

3 in = 10

HS- 2.300

VS= 2.424

GS= 2.541

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.212	1.202	.907
MINIMUM X	:	-1.088	-1.098	-.948
MAXIMUM Y	:	1.022	.867	.931
MINIMUM Y	:	-1.402	-1.139	-1.075
CENTROID X	:	-.391	-.381	-.531
CENTROID Y	:	.335	.490	.426
POA TO CENTROID in.	:	.514	.621	.681
MIN RADIUS	:	.460	.349	.510
MEAN RADIUS	:	1.019	.967	.921
MAX RADIUS	:	1.404	1.307	1.189
HORIZONTAL SPREAD	:	2.300	2.300	1.855
VERTICAL SPREAD	:	2.424	2.006	2.006
EXTREME SPREAD	:	2.541	2.472	2.205
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO 06522348

DATE 9-18-90

TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.32	2.31	2.40	2.21	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.12	2.32	2.28	2.11	
PULL #3	2.41	2.40	2.36	2.36	
PULL #4	2.34	2.36	2.51	2.43	
PULL #5	2.24	2.28	2.34	2.56	
TOTAL	11.43	11.67	11.89	11.61	
AVG.	2.286	2.334	2.378	2.322	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.48	3.20		
PULL #2	3.36	3.35		
PULL #3	3.39	3.27		
PULL #4	3.50	3.18		
PULL #5	3.45	3.35		
TOTAL	17.18	16.35		
AVG.	3.436	3.27		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.26	4.38		4.52
PULL #2	4.39	4.26		4.41
PULL #3	4.28	4.36		4.40
PULL #4	4.50	4.40		4.43
PULL #5	4.11	4.44		4.46
TOTAL	21.54	21.83		22.22
AVG.	4.308	4.366		4.444

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522348

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/24/90	KA
600	Proof		6/26/90	KA
607	Check Headspace		6/26/90	KA
610	Dis-assemble Gun		6/26/90	KA
612	Magnaflux Barrel Action		7/10/90	KR
	Magnaflux Bolt		7/10/90	KR
615	Rollmark Caliber		7/10/90	G.S.
617	Drill and Tap Sight Holes		7/11/90	FB
618	Polish Barrel RB		7/13/90	WB
620	Apply Coatings (Barrel Action)		7-23-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/13/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/13/90	KS
	C) Inspect Ejector Hole for Chamfer		8/13/90	KS
	D) Oil Firing Pin Ass'y		8/13/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		9-14-90	JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			8/8/90	JS
	G) Safety Off Force	2	2	2			8/8/90	JS
	H) Trigger Pull Test & Retainability						9-14-90	JS
	I) Firing Pin Indent	.0225	.0225	.0225			8/8/90	JS
	J) Assemble Stock						8/14/90	KS
	K) Assemble Swivel Studs						9/15/90	JS
	L) Attach Front and Rear Sight Assemblies						8/14/90	KS
	M) Iron Sight Alignment						8/14/90	KS
	N) Detach Front & Rear Sights & place in numbered container						8/14/90	KS
	O) Attach Scope to Rifle						8/14/90	KS
	P) Detach & Attach Scope 20 Times						8/14/90	KS
640	Gallery Target & Test						8/15/90	AF
	A) Time						8/15/90	AF
	B) Malfunctions						8/15/90	AF
	C) Pierced Primers						8/15/90	AF
	D) Optical Clarity of Scope						8/15/90	AF
645	Inspect for Live Ammo						8/15/90	AF
655	Final Inspection							
	A) Headspace						9/15/90	JS
	B) Trigger Pull	2.21	2.11	2.36	2.43	2.60	9-14-90	JS
	C) Function						9/15/90	JS
660	Pack						9/20/90	AF