

C6523347

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington
 MODEL 700™ H24

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

RES. U.S. PAT. & TM. OFF.

SERIAL NO.
 C6523347

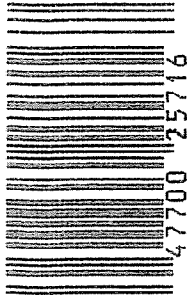
ORDER NO.
 5716

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



5716 C6523347

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523347

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 25	90	RW
600	Proof	9 25	90	RW
607	Check Headspace	8 25	90	RW
610	Dis-assemble Gun	8	90	RW
612	Magnaflux Barrel Action		9-26-90	KR
	Magnaflux Bolt		9-26-90	KR
615	Rollmark Caliber		9-26-90	JS.
617	Drill and Tap Sight Holes		9/28/90	FB
618	Polish Barrel RWB		10/1/90	WB
620	Apply Coatings (Barrel Action)		10-5-90	TH.
	Apply Coating (Bolt)		10	
625	Final Assembly A) Clean inside of Bolt Assembly		10/9/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/9/90	RW
	C) Inspect Ejector Hole for Chamfer		10/9/90	RW
	D) Oil Firing Pin Ass'y		10/9/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/9/90	921

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/4	4 1/4	4 1/4			10/24/90	WB
	G) Safety Off Force	7 1/2	7 1/2	7 1/2			10/24/90	WB
	H) Trigger Pull Test & Retainability						10/19/90	JS
	I) Firing Pin Indent	.0205	.0205	.0205			10/24/90	WB
	J) Assemble Stock						10/29/90	RW
	K) Assemble Swivel Studs						3/28/90	JS
	L) Attach Front and Rear Sight Assemblies						10/29/90	RW
	M) Iron Sight Alignment						10/29/90	RW
	N) Detach Front & Rear Sights & place in numbered container						10/29/90	RW
	O) Attach Scope to Rifle						10/29/90	RW
	P) Detach & Attach Scope 20 Times						10/29/90	RW
640	Gallery Target & Test						10-30-90	AC
	A) Time						10-30-90	AC
	B) Malfunctions						10-30-90	AC
	C) Pierced Primers						10-30-90	AC
	D) Optical Clarity of Scope						10-30-90	AC
645	Inspect for Live Ammo						10-30-90	AC
655	Final Inspection							
	A) Headspace						3/28/90	JS
	B) Trigger Pull	225	215	210	217	207	3/28/90	JS
	C) Function						3/28/90	JS
660	Pack						12-17-90	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO 06523347

DATE 10/19/98

TESTER JM.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.31	2.32	2.28	225	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.46	2.40	2.41	215	
PULL #3	2.29	2.50	2.22	210	
PULL #4	2.44	2.50	2.22	217	
PULL #5	2.39	2.23	2.23	207	
TOTAL	11.89	11.95	11.36		
AVG.	2.378	2.39	2.272		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.30	3.28		
PULL #2	3.26	3.48		
PULL #3	3.35	3.26		
PULL #4	3.30	3.44		
PULL #5	3.44	3.20		
TOTAL	16.65	16.66		
AVG.	3.33	3.332		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.30	4.26		4.33
PULL #2	4.33	4.22		4.24
PULL #3	4.20	4.24		4.39
PULL #4	4.25	4.41		4.36
PULL #5	4.27	4.30		4.25
TOTAL	21.35	21.43		21.57
AVG.	4.27	4.286		4.314

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06523347
30 Oct 1990

CENTROIDAL DISTANCES

0 TO 1	.215288
1 TO 2	.0460109
1 TO 3	.35101
1 TO 4	.12516
1 TO 5	.205197

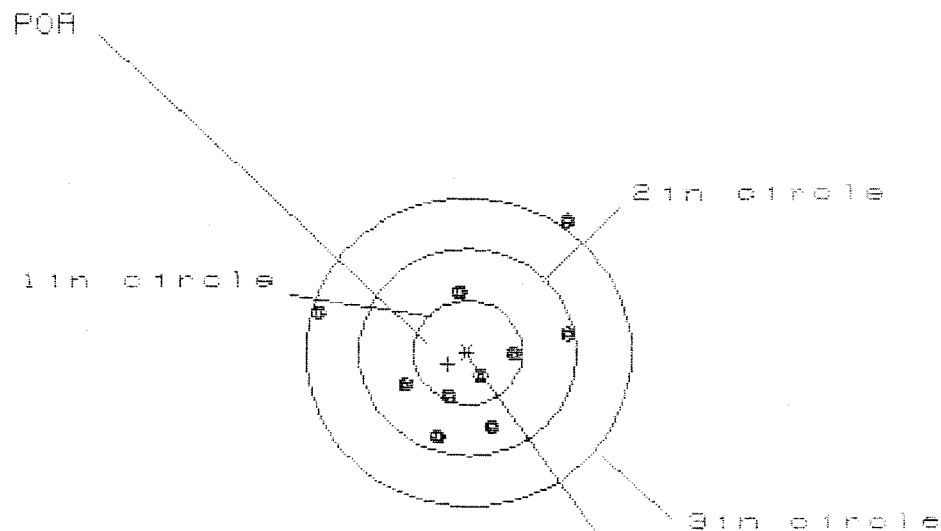
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THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1102
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0072
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .110435
THE AMR FOR THIS RIFLE IS: .8214

30 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08523347

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 3

2in = 8

3in = 9

HS= 2.250

VS= 2.045

GS= 2.412

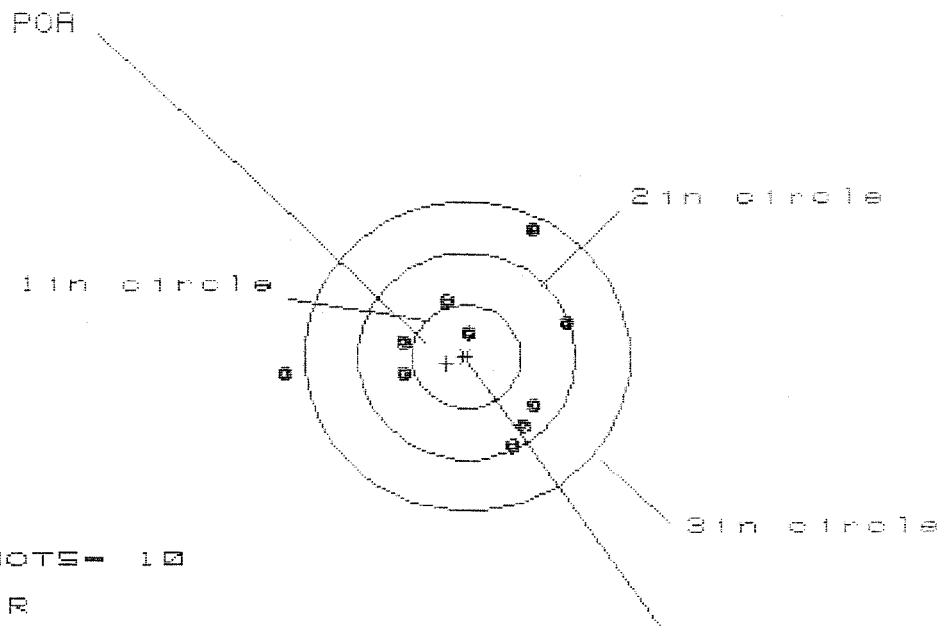
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.918	.978	.824
MINIMUM X	:	-1.332	-1.230	-.643
MAXIMUM Y	:	1.278	.716	.784
MINIMUM Y	:	-.767	-.625	-.556
CENTROID X	:	.182	.080	.234
CENTROID Y	:	.115	-.027	-.095
POA TO CENTROID in.	:	.216	.084	.253
MIN RADIUS	:	.280	.265	.097
MEAN RADIUS	:	.789	.675	.559
MAX RADIUS	:	1.573	1.348	.934
HORIZONTAL SPREAD	:	2.250	2.208	1.467
VERTICAL SPREAD	:	2.045	1.341	1.341
EXTREME SPREAD	:	2.412	2.215	1.575
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

30 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8523347

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in - 1

2in - 7

3in - 9

HS- 2.500

VS- 2.122

GS- 2.746

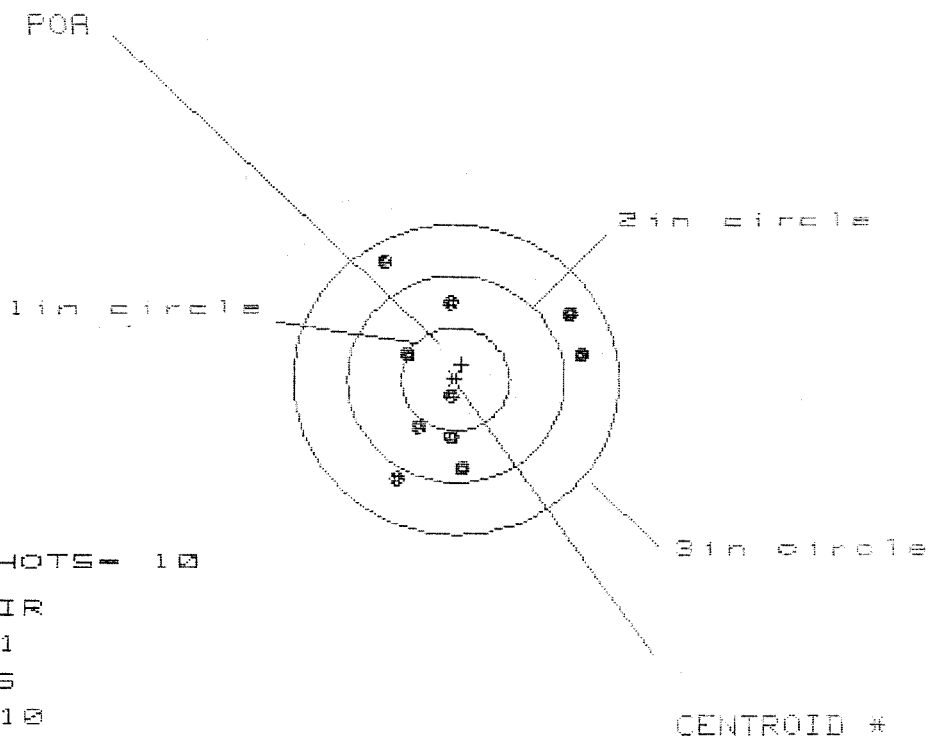
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.871	.681	.738
MINIMUM X	:	-1.709	-.819	-.762
MAXIMUM Y	:	1.209	1.186	.673
MINIMUM Y	:	-.913	-.936	-.788
CENTROID X	:	.183	.373	.316
CENTROID Y	:	.069	.092	-.056
POA TO CENTROID in.	:	.195	.384	.321
MIN RADIUS	:	.196	.205	.318
MEAN RADIUS	:	.858	.754	.683
MAX RADIUS	:	1.722	1.269	.849
HORIZONTAL SPREAD	:	2.500	1.500	1.500
VERTICAL SPREAD	:	2.122	2.122	1.461
EXTREME SPREAD	:	2.746	2.135	1.591
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

30 Oct 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6523347

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 1.790

VS= 2.121

GS= 2.217

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.137	1.064	1.181
MINIMUM X	:	-.653	-.659	-.542
MAXIMUM Y	:	1.176	.908	.999
MINIMUM Y	:	-.945	-.814	-.723
CENTROID X	:	-.056	.017	-.100
CENTROID Y	:	-.143	-.274	-.365
POA TO CENTROID in.	:	.154	.275	.379
MIN RADIUS	:	.119	.126	.114
MEAN RADIUS	:	.829	.759	.669
MAX RADIUS	:	1.346	1.185	1.273
HORIZONTAL SPREAD	:	1.790	1.723	1.723
VERTICAL SPREAD	:	2.121	1.722	1.722
EXTREME SPREAD	:	2.217	2.217	2.098
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

30 Oct 1990

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CENTERFIRE PATTERNS

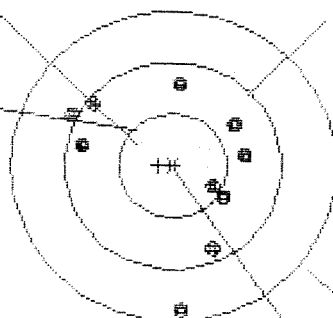
4

POA

1 in circle

2 in circle

3 in circle



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 10

HS= 1.587

VS= 2.242

GS= 2.242

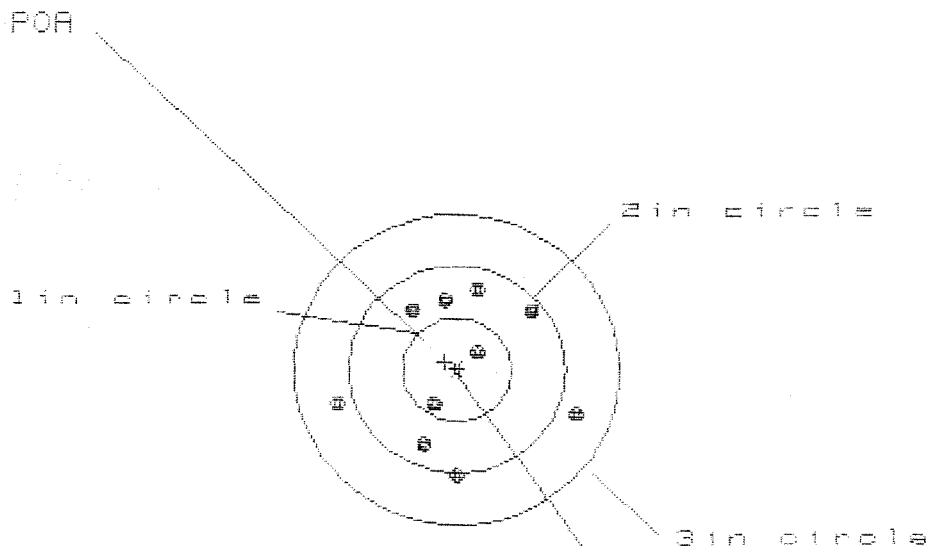
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.662	.671	.556
MINIMUM X	:	-.925	-.916	-.949
MAXIMUM Y	:	.846	.691	.739
MINIMUM Y	:	-1.396	-.923	-.875
CENTROID X	:	.135	.126	.241
CENTROID Y	:	-.001	.154	.106
POA TO CENTROID in.	:	.135	.199	.263
MIN RADIUS	:	.380	.485	.375
MEAN RADIUS	:	.839	.770	.715
MAX RADIUS	:	1.398	.994	1.041
HORIZONTAL SPREAD	:	1.587	1.587	1.505
VERTICAL SPREAD	:	2.242	1.614	1.614
EXTREME SPREAD	:	2.242	1.832	1.820
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			10	

30 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08529347

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 2.226

VS= 1.863

GS= 2.228

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.071	.943	.665
MINIMUM X	:	-1.155	-.517	-.399
MAXIMUM Y	:	.823	.788	.733
MINIMUM Y	:	-1.040	-1.075	-1.130
CENTROID X	:	.107	.235	.117
CENTROID Y	:	-.076	-.041	.014
POA TO CENTROID in.	:	.131	.239	.118
MIN RADIUS	:	.282	.172	.224
MEAN RADIUS	:	.792	.737	.685
MAX RADIUS	:	1.197	1.084	1.131
HORIZONTAL SPREAD	:	2.226	1.460	1.065
VERTICAL SPREAD	:	1.863	1.863	1.863
EXTREME SPREAD	:	2.228	1.871	1.871
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	