

C6498750

MODEL 700™ M24

Model SWS™

Action _____

Barrel Length _____

Capacity _____

Order No. 5716

*Includes 1 in chamber.

Remington



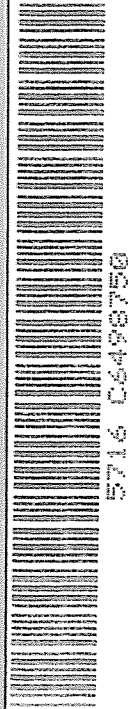

VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700™ H24

SERIAL NO.
C6498750

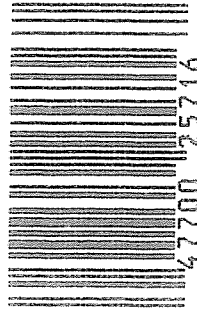
ORDER NO.
5716

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



5716 C6498750

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6498750

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	5 17	90	RW
600	Proof	5 17	90	RW
607	Check Headspace	5 17	90	RW
610	Dis-assemble Gun	5 17	90	RW
612	Magnaflux Barrel Action		5/22/90	KCR
	Magnaflux Bolt		5/22/90	KCR
615	Rollmark Caliber		5/22/90	GS
617	Drill and Tap Sight Holes		5/23/90	FOB
618	Polish Barrel RB		5/24/90	WLB
620	Apply Coatings (Barrel Action)		5-90	TH
	Apply Coating (Bolt)		6	TH
625	Final Assembly A) Clean inside of Bolt Assembly		6/12/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6/12/90	RW
	C) Inspect Ejector Hole for Chamfer		6/12/90	RW
	D) Oil Firing Pin Ass'y		6/12/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/25/90	JK

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			7/26/90	JL
	G) Safety Off Force	2	2	2			7/26/90	JL
	H) Trigger Pull Test & Retainability						8/25/90	JL
	I) Firing Pin Indent	.0235	.023	.023			7/26/90	JL
	J) Assemble Stock						7/30/90	RW
	K) Assemble Swivel Studs						8/30/90	JS
	L) Attach Front and Rear Sight Assemblies						7/30/90	RW
	M) Iron Sight Alignment						7/30/90	RW
	N) Detach Front & Rear Sights & place in numbered container						7/30/90	RW
	O) Attach Scope to Rifle						7/30/90	RW
	P) Detach & Attach Scope 20 Times						7/30/90	RW
640	Gallery Target & Test						8-7-90	DH
	A) Time						8-7-90	DH
	B) Malfunctions						8-7-90	DH
	C) Pierced Primers						8-7-90	DH
	D) Optical Clarity of Scope						8-7-90	DH
645	Inspect for Live Ammo						8-7-90	DH
655	Final Inspection							
	A) Headspace						8/30/90	JS
	B) Trigger Pull	2.34	2.27	2.39	2.31	2.38	8/25/90	JL
	C) Function						8/30/90	JS
660	Pack						9/20/90	NF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6498750

DATE 8/25/90

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.38	2.34	2.34	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.44	2.43	2.43	2.27	
PULL #3	2.40	2.34	2.33	2.39	
PULL #4	2.46	2.33	2.42	2.31	
PULL #5	2.27	2.43	2.32	2.38	
TOTAL	12.03	11.91	11.84	11.69	
AVG.	2.406	2.382	2.368	2.338	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.35	3.28		
PULL #2	3.34	3.22		
PULL #3	3.25	3.22		
PULL #4	3.22	3.21		
PULL #5	3.10	3.25		
TOTAL	16.26	16.18		
AVG.	3.252	3.236		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.28	4.36		4.28
PULL #2	4.27	4.34		4.35
PULL #3	4.32	4.24		4.29
PULL #4	4.35	4.32		4.43
PULL #5	4.33	4.36		4.34
TOTAL	21.55	21.62		21.69
AVG.	4.31	4.324		4.338

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6498750
7 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	1.01695
1 TO	2	.50531
1 TO	3	1.93838
1 TO	4	.431519
1 TO	5	1.63442

24¹
+ <----POA
3 5

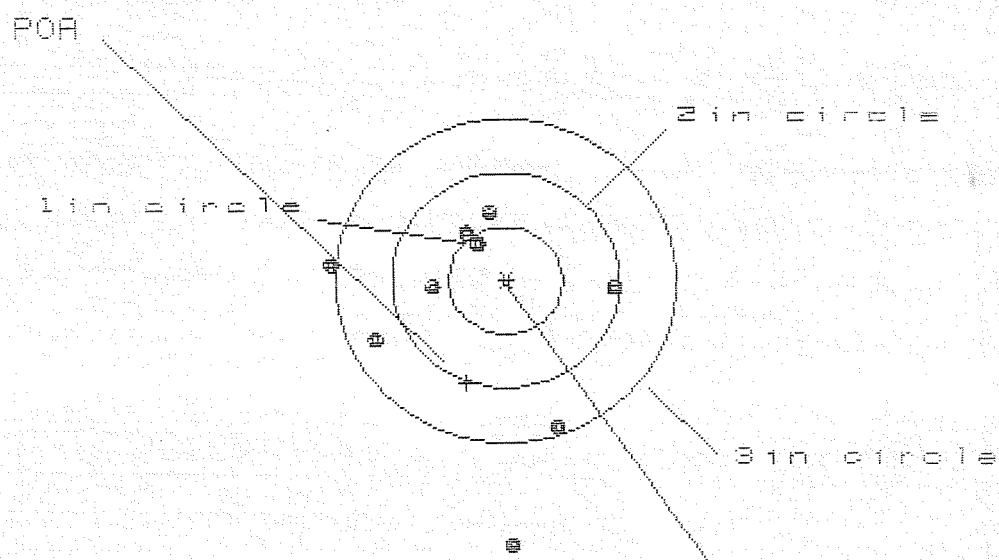
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0062
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1986
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .198697
THE AMR FOR THIS RIFLE IS: 1.066

7 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08498750

CENTERFIRE PATTERNS

1



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 7

HS = 4.107

VS = 5.539

GS = 6.098

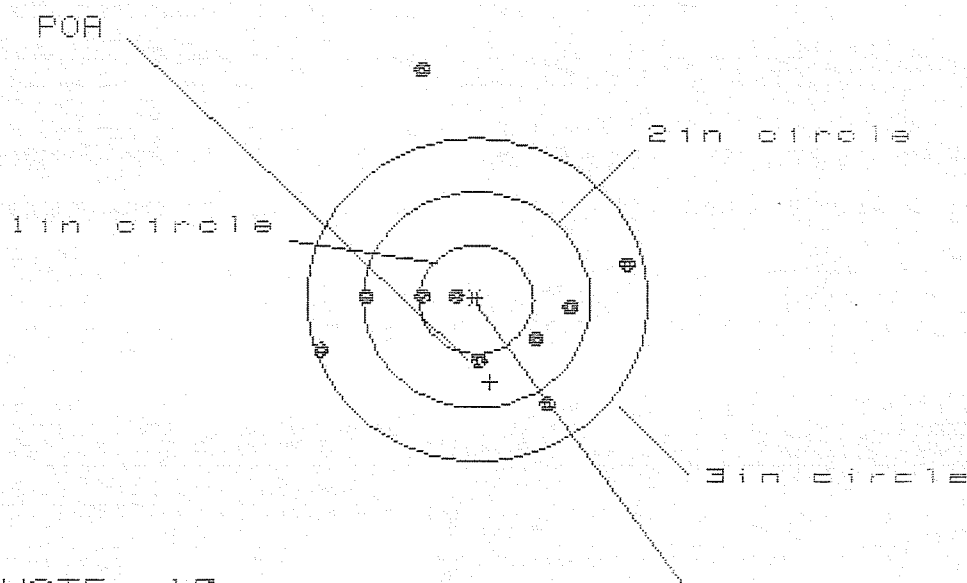
CENTROID *

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.604	1.261	1.303
MINIMUM X	-1.503	-1.213	-1.171
MAXIMUM Y	3.060	.989	.722
MINIMUM Y	-2.479	-2.139	-1.324
CENTROID X	.344	.054	.012
CENTROID Y	.957	.617	.884
POA TO CENTROID in.	1.017	.619	.884
MIN RADIUS	.424	.430	.302
MEAN RADIUS	1.401	1.086	.865
MAX RADIUS	4.018	2.166	1.525
HORIZONTAL SPREAD	4.107	2.474	2.474
VERTICAL SPREAD	5.539	3.128	2.046
EXTREME SPREAD	6.098	3.138	2.484
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

7 Aug 1990

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.730

VS= 3.091

GS= 3.270

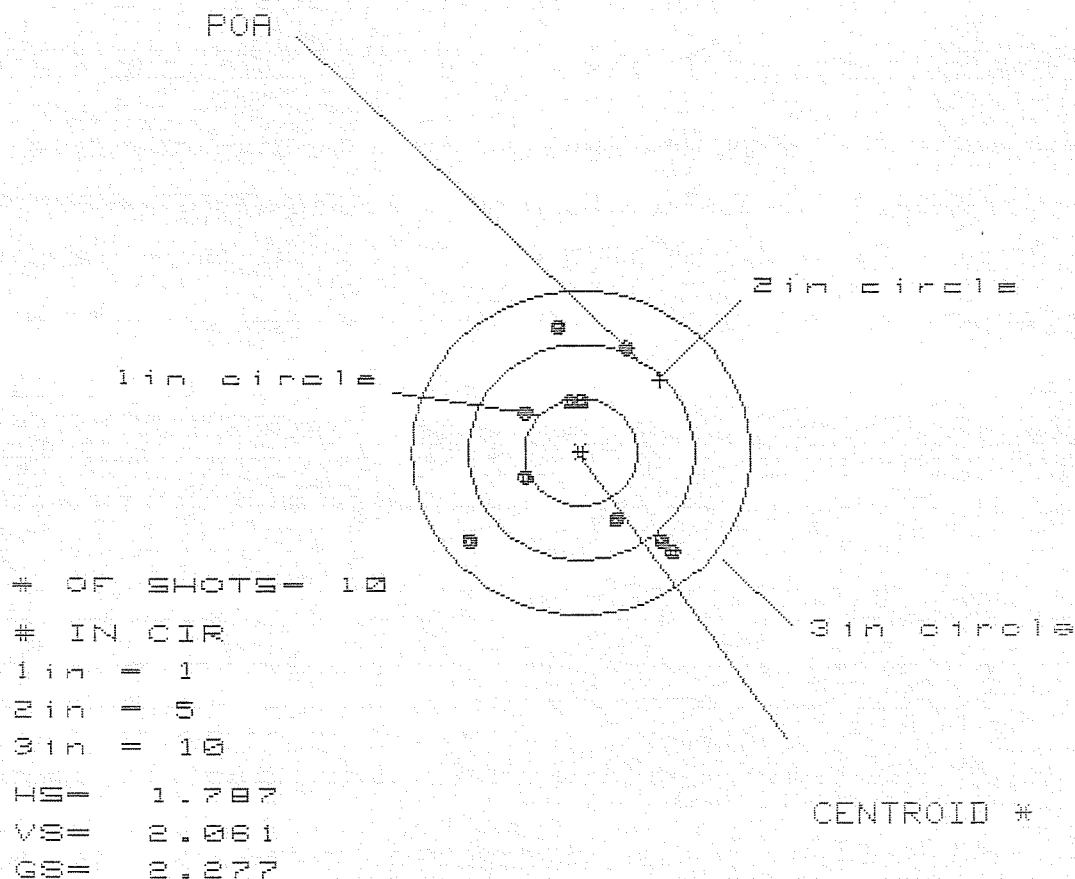
CENTROID #

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.335	1.286	1.105
MINIMUM X	:	-1.395	-1.444	-1.206
MAXIMUM Y	:	2.110	.551	.518
MINIMUM Y	:	-.981	-.746	-.779
CENTROID X	:	-.123	-.074	.106
CENTROID Y	:	.764	.529	.563
POA TO CENTROID in.	:	.774	.534	.572
MIN RADIUS	:	.142	.341	.366
MEAN RADIUS	:	.986	.829	.742
MAX RADIUS	:	2.157	1.468	1.226
HORIZONTAL SPREAD	:	2.730	2.730	2.311
VERTICAL SPREAD	:	3.091	1.297	1.297
EXTREME SPREAD	:	3.270	2.850	2.329
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	9		

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CENTERFIRE PATTERNS # 3



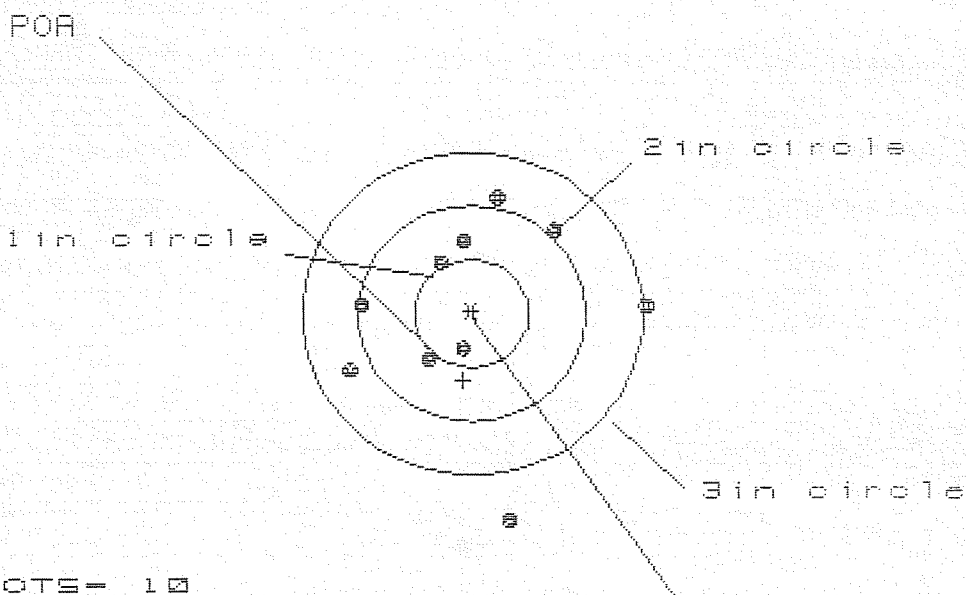
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.800	.690	.720
MINIMUM X	:	-.987	-.618	-.531
MAXIMUM Y	:	1.159	1.066	.942
MINIMUM Y	:	-.902	-.995	-1.087
CENTROID X	:	-.705	-.595	-.682
CENTROID Y	:	-.673	-.580	-.456
POA TO CENTROID in.	:	.975	.832	.820
MIN RADIUS	:	.441	.374	.229
MEAN RADIUS	:	.861	.806	.713
MAX RADIUS	:	1.291	1.211	1.304
HORIZONTAL SPREAD	:	1.787	1.308	1.251
VERTICAL SPREAD	:	2.061	2.061	2.029
EXTREME SPREAD	:	2.277	2.277	2.224
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS

4



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS= 2.622

VS= 3.047

GS= 3.048

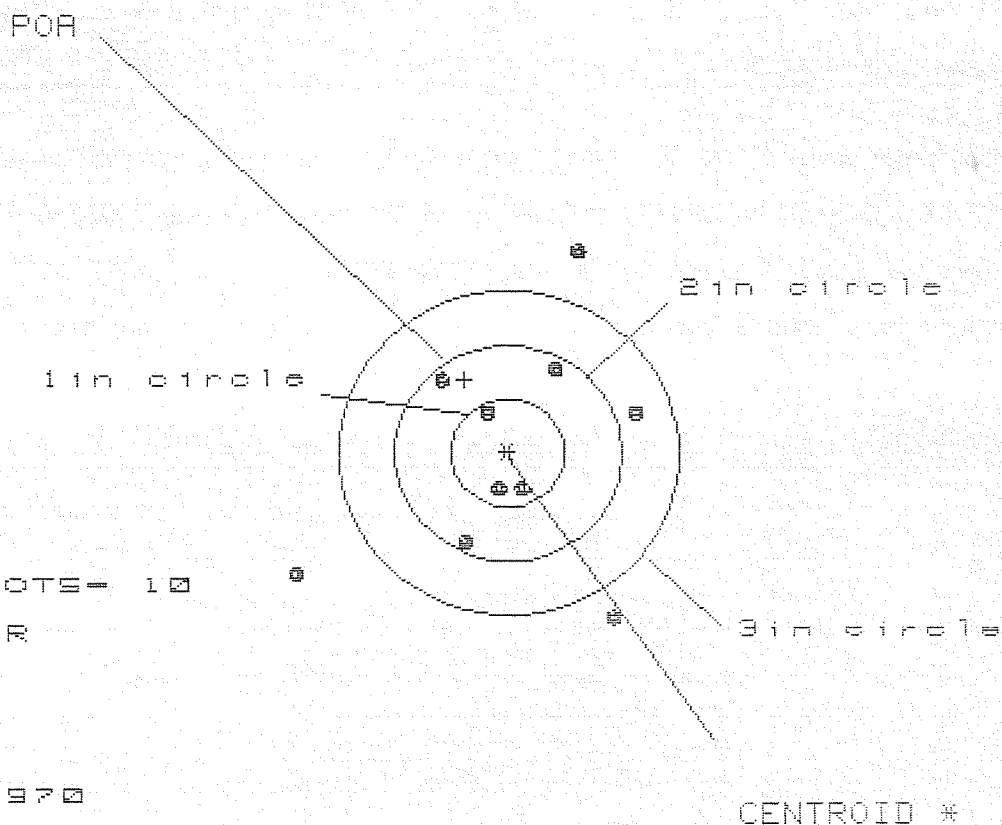
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.544	1.582	.940
MINIMUM X	:	-1.078	-1.040	-.842
MAXIMUM Y	:	1.109	.894	.876
MINIMUM Y	:	-1.938	-.688	-.706
CENTROID X	:	.072	.034	-.164
CENTROID Y	:	.622	.837	.855
POA TO CENTROID in.	:	.626	.838	.871
MIN RADIUS	:	.319	.313	.235
MEAN RADIUS	:	.995	.856	.739
MAX RADIUS	:	1.969	1.589	1.099
HORIZONTAL SPREAD	:	2.622	2.622	1.782
VERTICAL SPREAD	:	3.047	1.582	1.582
EXTREME SPREAD	:	3.048	2.678	2.151
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5



PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.101	.893	.940
MINIMUM X	:	-1.869	-.818	-.771
MAXIMUM Y	:	1.849	1.723	.913
MINIMUM Y	:	-1.560	-1.686	-1.471
CENTROID X	:	.381	.589	.542
CENTROID Y	:	-.677	-.552	-.767
POA TO CENTROID in.	:	.777	.807	.939
MIN RADIUS	:	.296	.475	.263
MEAN RADIUS	:	1.086	.975	.847
MAX RADIUS	:	2.185	1.836	1.662
HORIZONTAL SPREAD	:	2.970	1.711	1.711
VERTICAL SPREAD	:	3.409	3.409	2.384
EXTREME SPREAD	:	3.861	3.427	2.699
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			7	