

C6498854

MODEL 700TM M24

Model SWS TM

Action

Barrel Length

Capacity

Order No. 5715

*Includes 1 in chamber.

Remington

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CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6498864

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	FB
618	Polish Barrel RB		5/24/90	WB
620	Apply Coatings (Barrel Action)		6-4-90	JA
	Apply Coating (Bolt)			
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		8/24/90	JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			7/24/90	JK
	G) Safety Off Force	3	3	3			7/24/90	JK
	H) Trigger Pull Test & Retainability						8/24/90	JK
	I) Firing Pin Indent	.024	.0235	.0235			7/24/90	JK
	J) Assemble Stock						8/1/90	RW
	K) Assemble Swivel Studs						8/29/90	JS
	L) Attach Front and Rear Sight Assemblies						8/1/90	RW
	M) Iron Sight Alignment						8/1/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/1/90	RW
	O) Attach Scope to Rifle						8/1/90	RW
	P) Detach & Attach Scope 20 Times						8/1/90	RW
640	Gallery Target & Test						8-2-90	AC
	A) Time						8-2-90	AC
	B) Malfunctions						8-2-90	AC
	C) Pierced Primers						8-2-90	AC
	D) Optical Clarity of Scope						8-2-90	AC
645	Inspect for Live Ammo						8-2-90	AC
655	Final Inspection							
	A) Headspace						8/29/90	JS
	B) Trigger Pull	2.33	2.30	2.24	2.42	2.37	8/24/90	JK
	C) Function							
660	Pack						9/19/90	VF

SWS TRIGGER PULL TEST

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

SERIAL NO 26498864
DATE 8/24/90
TESTER gk

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.35	2.33	2.31	2.33	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.37	2.41	2.28	2.30	
PULL #3	2.30	2.32	2.34	2.24	
PULL #4	2.23	2.33	2.30	2.42	
PULL #5	2.25	2.29	2.35	2.37	
TOTAL	11.50	11.68	11.58	11.66	
AVG.	2.3	2.336	2.316	2.332	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.41	3.42		
PULL #2	3.38	3.46		
PULL #3	3.35	3.31		
PULL #4	3.40	3.39		
PULL #5	3.42	3.42		
TOTAL	16.96	17.00		
AVG.	3.392	3.4		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.41	4.26		4.26
PULL #2	4.29	4.30		4.38
PULL #3	4.22	4.30		4.29
PULL #4	4.31	4.31		4.27
PULL #5	4.31	4.33		4.29
TOTAL	21.54	21.50		21.49
AVG.	4.308	4.3		4.298

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6498864
2 Aug 1990

CENTROIDAL DISTANCES

0 TO 1	.187553
1 TO 2	.227502
1 TO 3	1.00887
1 TO 4	.396793
1 TO 5	.17746

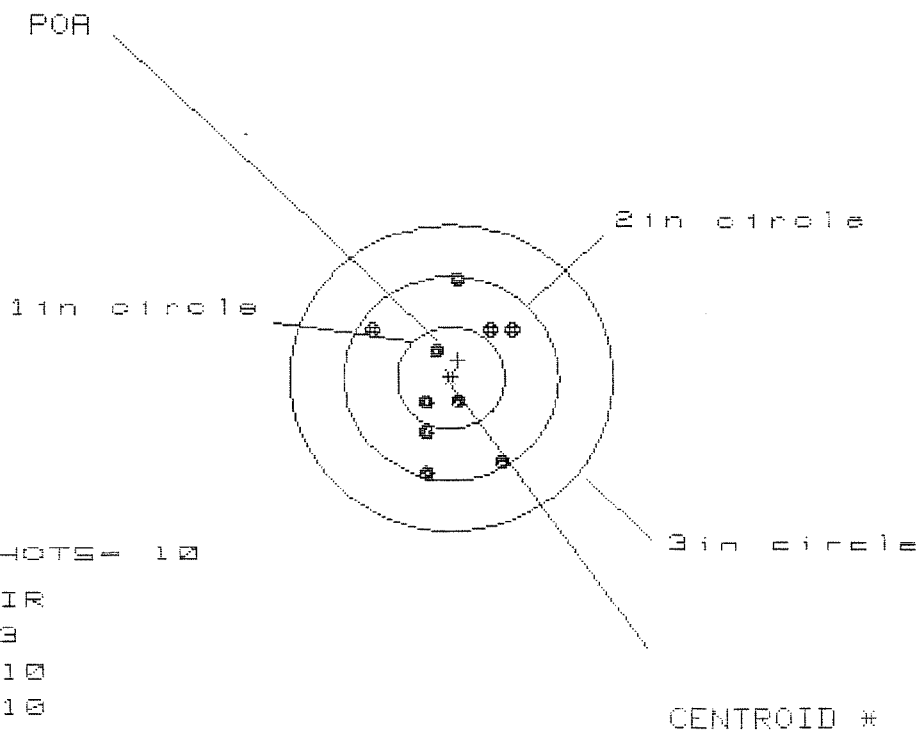
3
2 1/2 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0826
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.085
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .118523
THE AMR FOR THIS RIFLE IS: .756

2 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6498864

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 3

2in = 10

3in = 10

HS= 1.235

VS= 1.913

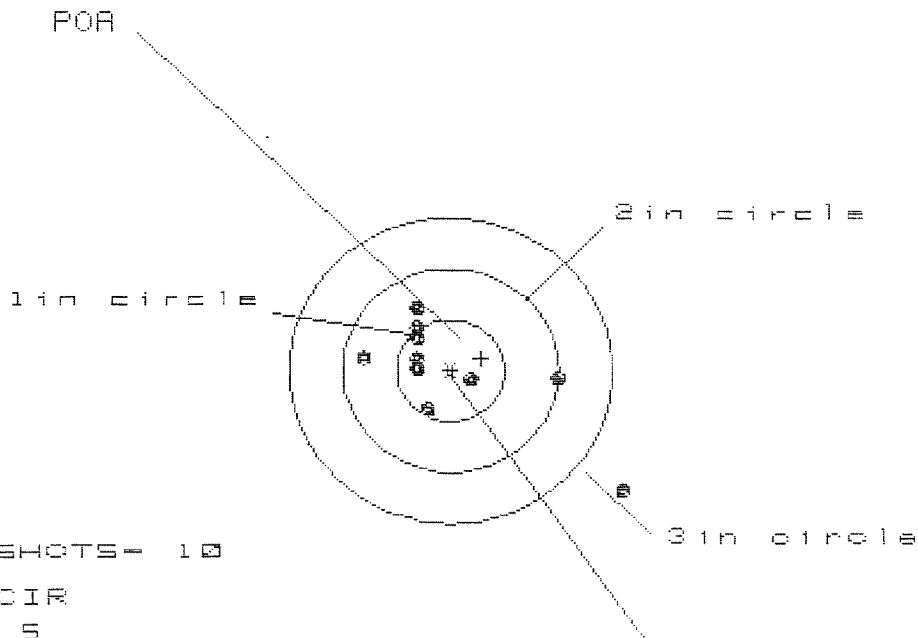
GS= 1.947

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.527	.538	.508
MINIMUM X	:	-.708	-.697	-.728
MAXIMUM Y	:	.990	.614	.512
MINIMUM Y	:	-.923	-.813	-.798
CENTROID X	:	-.070	-.081	-.050
CENTROID Y	:	-.174	-.284	-.182
POA TO CENTROID in.	:	.188	.296	.189
MIN RADIUS	:	.230	.136	.217
MEAN RADIUS	:	.648	.594	.566
MAX RADIUS	:	.995	.878	.940
HORIZONTAL SPREAD	:	1.235	1.235	1.235
VERTICAL SPREAD	:	1.913	1.427	1.311
EXTREME SPREAD	:	1.947	1.736	1.736
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		10	
NUMBER IN THREE INCH CIRCLE	=		10	

2 Aug 1998

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 5

2in = 9

3in = 9

HS= 2.382

VS= 1.818

GS= 2.715

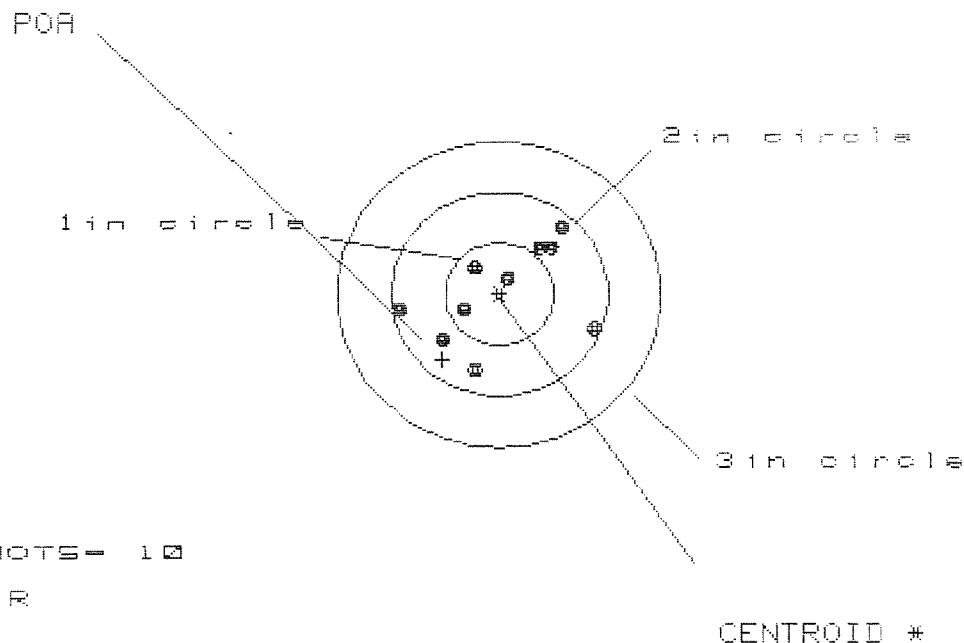
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.545	1.137	.478
MINIMUM X	:	-.837	-.666	-.523
MAXIMUM Y	:	.646	.515	.492
MINIMUM Y	:	-1.172	-.556	-.579
CENTROID X	:	-.291	-.462	-.605
CENTROID Y	:	-.120	.011	.034
POA TO CENTROID in.	:	.314	.463	.606
MIN RADIUS	:	.182	.173	.036
MEAN RADIUS	:	.684	.473	.343
MAX RADIUS	:	1.939	1.152	.596
HORIZONTAL SPREAD	:	2.382	1.803	1.001
VERTICAL SPREAD	:	1.818	1.071	1.071
EXTREME SPREAD	:	2.715	1.813	1.081
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 3

2in = 10

3in = 10

HS= 1.715

VS= 1.435

GS= 1.726

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.831	.626	.527
MINIMUM X	:	-.884	-.792	-.571
MAXIMUM Y	:	.664	.624	.596
MINIMUM Y	:	-.770	-.811	-.839
CENTROID X	:	.526	.434	.533
CENTROID Y	:	.640	.681	.709
POA TO CENTROID in.	:	.829	.808	.886
MIN RADIUS	:	.179	.223	.125
MEAN RADIUS	:	.630	.588	.549
MAX RADIUS	:	.909	.884	.865
HORIZONTAL SPREAD	:	1.715	1.418	1.098
VERTICAL SPREAD	:	1.435	1.435	1.435
EXTREME SPREAD	:	1.726	1.649	1.614
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		10	
NUMBER IN THREE INCH CIRCLE	=		10	

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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 = 9

HS= 2.349

VS= 2.787

GS= 2.811

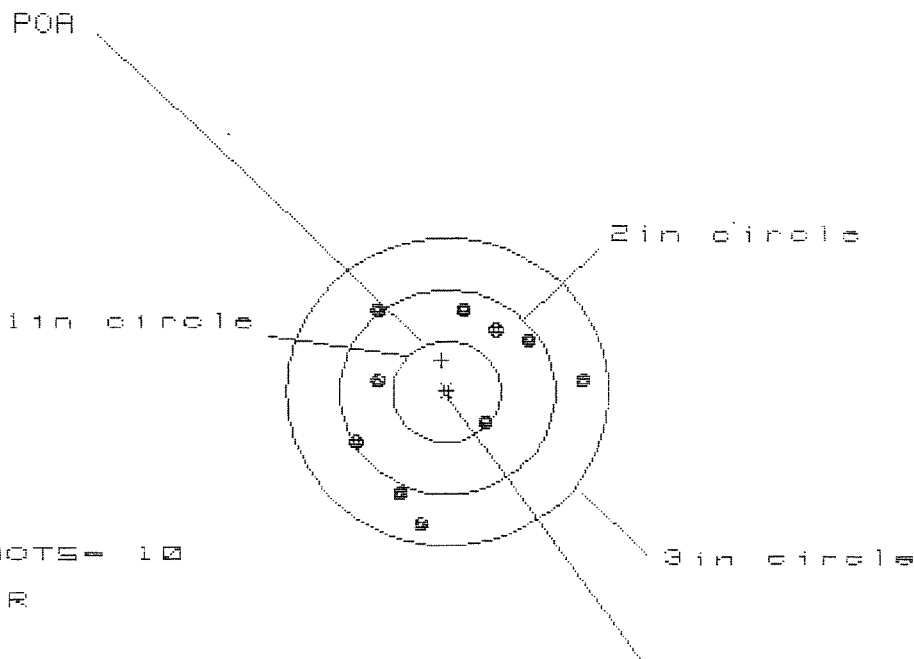
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.978	.992	.822
MINIMUM X	:	-1.371	-1.357	-.754
MAXIMUM Y	:	1.789	.960	.925
MINIMUM Y	:	-.998	-.799	-.834
CENTROID X	:	.204	.190	.360
CENTROID Y	:	-.461	-.660	-.625
POA TO CENTROID in.	:	.504	.687	.721
MIN RADIUS	:	.151	.330	.377
MEAN RADIUS	:	.890	.775	.686
MAX RADIUS	:	1.793	1.386	1.193
HORIZONTAL SPREAD	:	2.349	2.349	1.576
VERTICAL SPREAD	:	2.787	1.759	1.759
EXTREME SPREAD	:	2.811	2.367	2.068
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 10

HS= 2.091

VS= 2.093

GS= 2.191

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.267	1.236	.875
MINIMUM X	:	-.824	-.855	-.701
MAXIMUM Y	:	.842	.703	.703
MINIMUM Y	:	-1.251	-1.110	-1.110
CENTROID X	:	.044	.075	-.079
CENTROID Y	:	-.310	-.171	-.171
POA TO CENTROID in.	:	.313	.186	.189
MIN RADIUS	:	.441	.521	.559
MEAN RADIUS	:	.928	.873	.821
MAX RADIUS	:	1.284	1.236	1.153
HORIZONTAL SPREAD	:	2.091	2.091	1.576
VERTICAL SPREAD	:	2.093	1.813	1.813
EXTREME SPREAD	:	2.191	2.191	1.929
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

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

Remington®

MODEL 700™ H24

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

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

SERIAL NO.
C6498864

ORDER NO.
5716

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