

C6534568

MODEL 700TM M24

Model **SWS**TM

Action

Barrel Length

Capacity

Order No. **5716**

* Includes 1 in chamber.

Remington




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

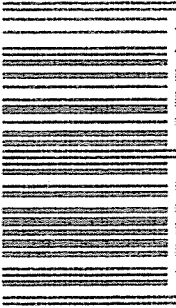
MODEL 700TH H24

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

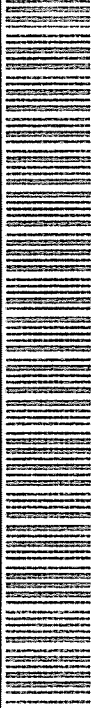
SERIAL NO.
C6594568

ORDER NO.
5716

UPC



0 47700 25716 7



5716 C6594568

MOD. _____ GA. CAL. _____ GUN # _____

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st	<i>Bolt Rel. sticks.</i>	<i>K.S.</i>
	2nd	REP'D 11-11-91	K.S.
	3rd		
	4th		

FUNCTION _____

RD 6654 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6594568

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/30/90	Kd
600	Proof		10/30/90	Kd
607	Check Headspace		10/30/90	Kd
610	Dis-assemble Gun		10/30/90	Kd
612	Magnaflux Barrel Action		11/1/90	Kcd
	Magnaflux Bolt		11/1/90	Kcd
615	Rollmark Caliber		11/1/90	CS
617	Drill and Tap Sight Holes		11/6/90	WB
618	Polish Barrel RB		11/7/90	WB
620	Apply Coatings (Barrel Action)		11/20/90	WB
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		12/14/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/14/90	KS
	C) Inspect Ejector Hole for Chamfer		12/14/90	KS
	D) Oil Firing Pin Ass'y		12/14/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		12/27/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/4	4 1/4	4 1/4			1/2/91	WB
	G) Safety Off Force	2	2	2			1/2/91	WB
	H) Trigger Pull Test & Retainability						1/27/90	WB
	I) Firing Pin Indent	.0205	.0205	.0205			1/2/91	WB
	J) Assemble Stock						1/3/91	KS
	K) Assemble Swivel Studs						1-14-91	JH
	L) Attach Front and Rear Sight Assemblies						1/3-91	KS
	M) Iron Sight Alignment						1/3/91	KS
	N) Detach Front & Rear Sights & place in numbered container						1/3/91	KS
	O) Attach Scope to Rifle						1/3/91	KS
	P) Detach & Attach Scope 20 Times						1/3-91	KS
640	Gallery Target & Test						1-11-91	AC
	A) Time						1-11-91	AC
	B) Malfunctions						1-11-91	AC
	C) Pierced Primers						1-11-91	AC
	D) Optical Clarity of Scope						1-11-91	AC
645	Inspect for Live Ammo						1-11-91	AC
655	Final Inspection							
	A) Headspace						1-14-91	JH
	B) Trigger Pull	2.16	2.14	2.18	2.20	2.20	1-14-91	JH
	C) Function						1-14-91	JH
660	Pack						3-19-91	W

SWS TRIGGER PULL TEST

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

SERIAL NO. C6594568
DATE 12/27/90
TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.50	2.40	2.24	2.16	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.48	2.49	2.23	2.14	
PULL #3	2.48	2.40	2.21	2.18	
PULL #4	2.46	2.45	2.34	2.20	
PULL #5	2.43	2.37	2.26	2.20	
TOTAL	12.35	12.11	11.28		
AVG.	2.47	2.42	2.25		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.08	3.07		
PULL #2	3.15	3.05		
PULL #3	3.10	3.07		
PULL #4	3.11	3.05		
PULL #5	3.05	3.04		
TOTAL	15.49	15.28		
AVG.	3.10	3.05		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX-SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.18	4.21		3.95
PULL #2	4.22	4.14		4.00
PULL #3	4.23	4.11		3.96
PULL #4	4.12	4.02		4.10
PULL #5	4.18	4.16		4.14
TOTAL	20.93	20.64		20.15
AVG.	4.19	4.13		4.03

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594568
11 Jan 1991

CENTROIDAL DISTANCES

0 TO	1	.132966
1 TO	2	.127581
1 TO	3	.163835
1 TO	4	.173367
1 TO	5	.425748

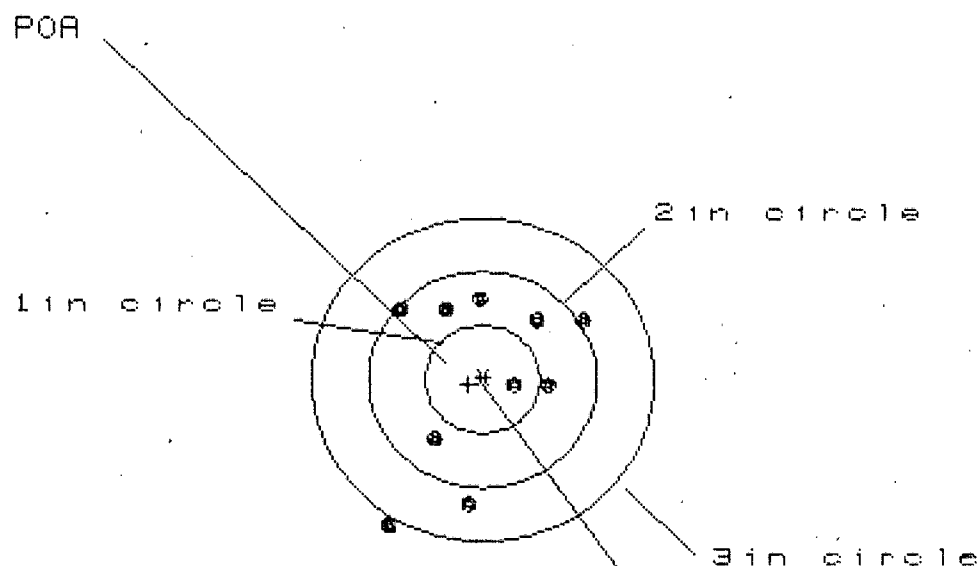
5th <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0266
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0182
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0322304
THE AMR FOR THIS RIFLE IS: .9742

11 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594568

CENTERFIRE PATTERNS # 1



OF SHOTS- 10.

IN CIR .

1in = 1

2in = 8

3in = 9

HS= 1.637

VS= 2.024

GS= 2.454

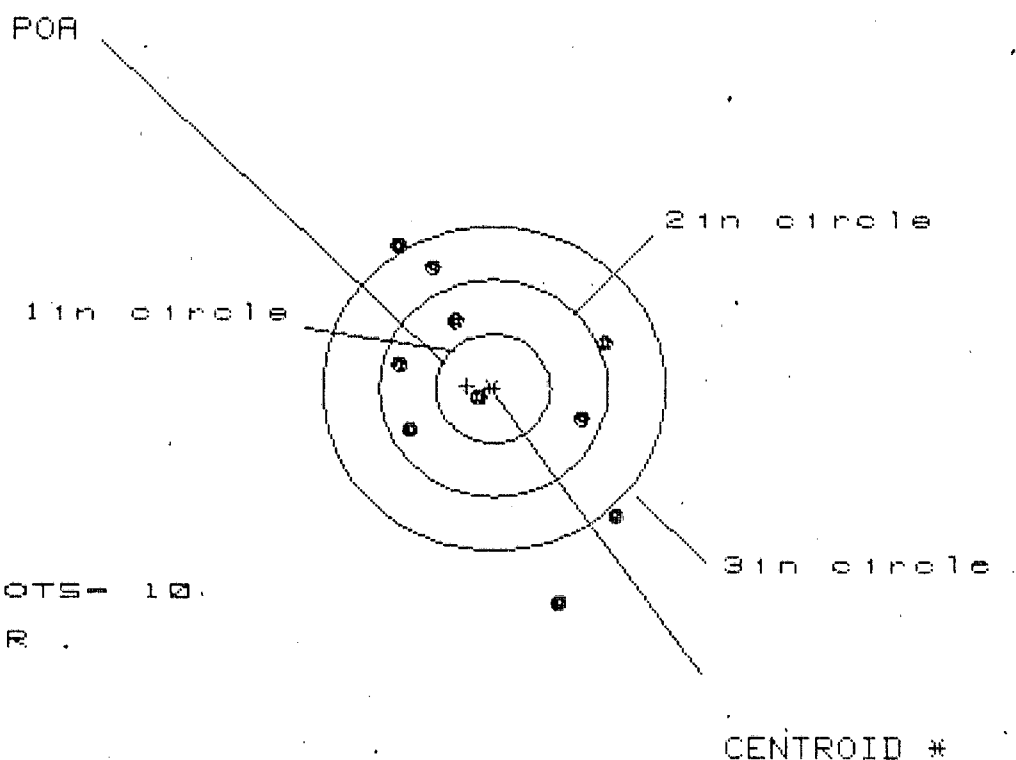
CENTROID *

PATTERN #		10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.847	.759	.739
MINIMUM X	:	-.790	-.773	-.793
MAXIMUM Y	:	.719	.574	.407
MINIMUM Y	:	-1.305	-1.334	-.881
CENTROID X	:	.124	.212	.232
CENTROID Y	:	.048	.193	.360
POA TO CENTROID in.	:	.133	.287	.428
MIN RADIUS	:	.264	.276	.414
MEAN RADIUS	:	.847	.739	.639
MAX RADIUS	:	1.526	1.344	1.027
HORIZONTAL SPREAD	:	1.637	1.532	1.532
VERTICAL SPREAD	:	2.024	1.908	1.288
EXTREME SPREAD	:	2.454	1.957	1.672
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10.

IN CIR .

1in = 1

2in = 5

3in = 7

HS= 1.870

VS= 3.291

GS= 3.575

CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.023	1.088	1.167
MINIMUM X	:	-.847	-.782	-.646
MAXIMUM Y	:	1.334	1.116	.941
MINIMUM Y	:	-1.957	-1.403	-.754
CENTROID X	:	.230	.165	.029
CENTROID Y	:	-.023	.195	.370
POA TO CENTROID in.	:	.231	.256	.371
MIN RADIUS	:	.112	.289	.286
MEAN RADIUS	:	1.085	.960	.829
MAX RADIUS	:	2.041	1.775	1.169
HORIZONTAL SPREAD	:	1.870	1.870	1.813
VERTICAL SPREAD	:	3.291	2.519	1.695
EXTREME SPREAD	:	3.575	3.121	2.254
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

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 0

2 in = 4

3 in = 10

HS = 2.484

VS = 2.220

GS = 2.527

PATTERN #

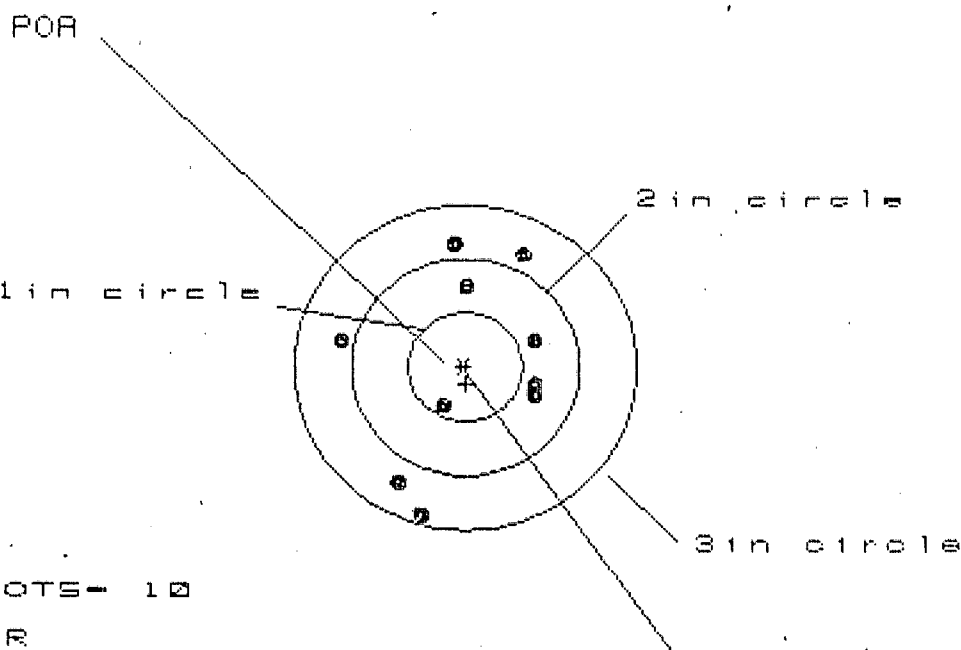
3

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.281	1.213	1.081
MINIMUM X	-1.203	-1.271	-1.403
MAXIMUM Y	1.290	1.203	1.112
MINIMUM Y	-.930	-.787	-.878
CENTROID X	-.005	.063	.195
CENTROID Y	-.053	-.196	-.105
POA TO CENTROID in.	.053	.206	.222
MIN RADIUS	.523	.461	.621
MEAN RADIUS	1.056	.996	.952
MAX RADIUS	1.427	1.352	1.451
HORIZONTAL SPREAD	2.484	2.484	2.484
VERTICAL SPREAD	2.220	1.990	1.990
EXTREME SPREAD	2.527	2.527	2.527
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		10	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

HS= 1.736

VS= 2.493

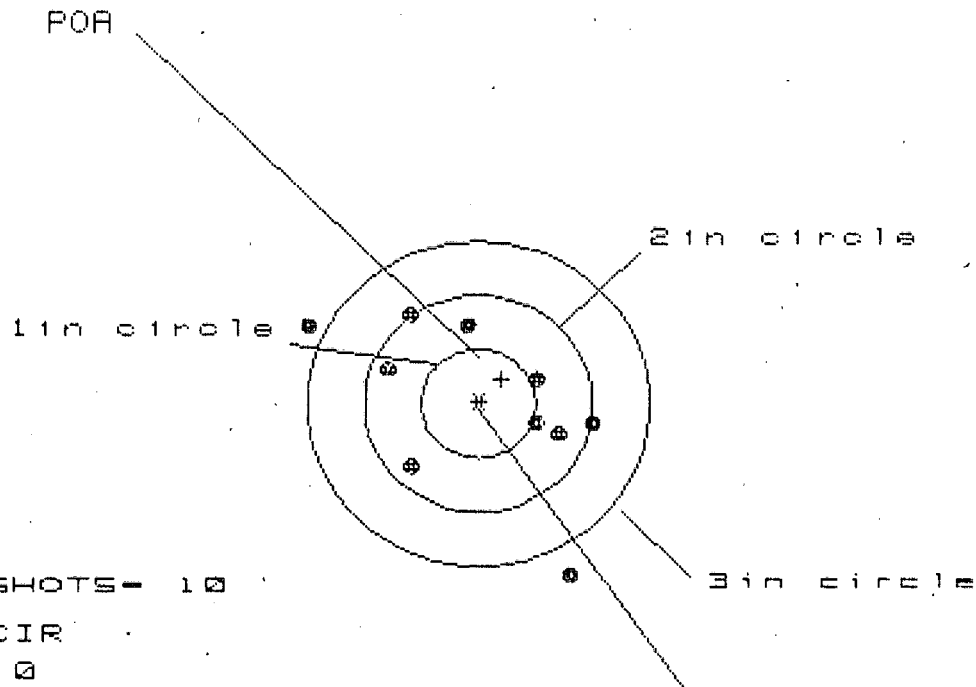
GS= 2.559

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.615	.572	.490
MINIMUM X	:	-1.121	-1.164	-1.246
MAXIMUM Y	:	1.107	.953	.805
MINIMUM Y	:	-1.386	-1.186	-.688
CENTROID X	:	-.010	.033	.115
CENTROID Y	:	.158	.312	.460
POA TO CENTROID in.	:	.158	.314	.474
MIN RADIUS	:	.431	.555	.420
MEAN RADIUS	:	.907	.834	.745
MAX RADIUS	:	1.439	1.354	1.249
HORIZONTAL SPREAD	:	1.736	1.736	1.736
VERTICAL SPREAD	:	2.493	2.139	1.493
EXTREME SPREAD	:	2.559	2.335	1.837
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			10	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in - 0

2in - 6

3in - 8

HS- 2.493

VS- 2.363

GS- 3.275

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.995	1.087	.912
MINIMUM X	:	-1.498	-1.406	-.902
MAXIMUM Y	:	.789	.615	.684
MINIMUM Y	:	-1.574	-.779	-.710
CENTROID X	:	-.206	-.298	-.123
CENTROID Y	:	-.221	-.047	-.116
POA TO CENTROID in.	:	.303	.302	.169
MIN RADIUS	:	.518	.525	.409
MEAN RADIUS	:	.976	.877	.769
MAX RADIUS	:	1.779	1.511	.991
HORIZONTAL SPREAD	:	2.493	2.493	1.814
VERTICAL SPREAD	:	2.363	1.394	1.394
EXTREME SPREAD	:	3.275	2.638	1.882
NUMBER IN ONE INCH CIRCLE =			0	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			8	