

C6594580

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6594580

DATE 8/22/96

TESTER RW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.34	2.46	2.64	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.34	2.48	2.66	
PULL #3	2.31	2.42	2.59	
PULL #4	2.36	2.42	2.57	
PULL #5	2.34	2.28	2.42	
TOTAL	11.69	12.06	12.88	
AVG.	2.34	2.41	2.58	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.21	3.22	
PULL #2	3.20	3.08	
PULL #3	3.01	3.20	
PULL #4	3.21	3.24	
PULL #5	3.13	3.21	
TOTAL	15.76	15.95	
AVG.	3.15	3.19	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.14	4.26		4.12
PULL #2	4.24	4.30		4.25
PULL #3	4.27	4.26		4.25
PULL #4	4.19	4.25		4.23
PULL #5	4.21	4.24		4.28
TOTAL	21.05	21.31		21.13
AVG.	4.21	4.26		4.23

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # *06594580*

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock			
600	Proof			
607	Check Headspace			
610	Dis-assemble Gun			
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	7	7			8/24/96	RW
	G) Safety Off Force	3	3	3			8/24/96	RW
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent							
	J) Assemble Stock							
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies							
	M) Iron Sight Alignment							
	N) Detach Front & Rear Sights & place in numbered container							
	O) Attach Scope to Rifle							
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test							
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection							
	A) Headspace							
	B) Trigger Pull	2.69	2.69	2.67	2.68	2.67	8/24/96	RW
	C) Function							
660	Pack							

Remington [®]		DU PONT REG. U.S. PAT. & TM. OFF.	VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700TM H24		SERIAL NO. C6594580	
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		ORDER NO. 5716	



5716 C6594580



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CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6594580

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1228	90	RW
600	Proof	1228	90	RW
607	Check Headspace	1228	90	RW
610	Dis-assemble Gun	1228	90	RW
612	Magnaflux Barrel Action		1-7-91	KR
	Magnaflux Bolt		1-7-91	KR
615	Rollmark Caliber		1-7-91	GL
617	Drill and Tap Sight Holes	1 10 91		FB
618	Polish Barrel	1 10 91		WB
620	Apply Coatings (Barrel Action)		1-26-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		1/28/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/28/91	RW
	C) Inspect Ejector Hole for Chamfer		1/28/91	RW
	D) Oil Firing Pin Ass'y		1/28/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2/8/91	GI

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/4	5 1/4	5 1/4			2/8/91	WB
	G) Safety Off Force	2 3/4	2 3/4	2 3/4			2/8/91	WB
	H) Trigger Pull Test & Retainability						2/8/91	JH
	I) Firing Pin Indent	.0225	.0215	.022			2/8/91	WB
	J) Assemble Stock						2/11/91	RW
	K) Assemble Swivel Studs						2-21-91	✓
	L) Attach Front and Rear Sight Assemblies						2/11/91	RW
	M) Iron Sight Alignment						2/11/91	RW
	N) Detach Front & Rear Sights & place in numbered container						2/11/91	RW
	O) Attach Scope to Rifle						2/11/91	RW
	P) Detach & Attach Scope 20 Times						2/11/91	RW
640	Gallery Target & Test						2/11/91	KS
	A) Time						"	12
	B) Malfunctions						"	12
	C) Pierced Primers						"	12
	D) Optical Clarity of Scope						"	12
645	Inspect for Live Ammo						2/11/91	12
655	Final Inspection							
	A) Headspace						2-21-91	✓
	B) Trigger Pull	2.17	2.20	2.23	2.26	2.24	2/19/91	WB
	C) Function						2-21-91	✓
660	Pack						3-18-91	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6594580

DATE 2/8/91

TESTER JH.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.25	2.21	2.25	2.17	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.38	2.16	2.26	2.20	
PULL #3	2.33	2.15	2.34	2.23	
PULL #4	2.41	2.15	2.17	2.26	
PULL #5	2.53	2.33	2.44	2.24	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.29	3.34		
PULL #2	3.21	3.40		
PULL #3	3.17	3.36		
PULL #4	3.27	3.40		
PULL #5	3.20	3.49		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.31	4.28		4.24
PULL #2	4.17	4.25		4.19
PULL #3	4.16	4.30		4.18
PULL #4	4.21	4.18		4.18
PULL #5	4.32	4.27		4.20
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594580
12 Feb 1991

CENTROIDAL DISTANCES

Ø TO	1	.263685
1 TO	2	.411647
1 TO	3	.248244
1 TO	4	.284121
1 TO	5	.215604

8 4 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0186
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0414
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0453863
THE AMR FOR THIS RIFLE IS: 1.012

12 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8594580

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 3

2in = 5

3in = 8

HS = 2.199

VS = 2.653

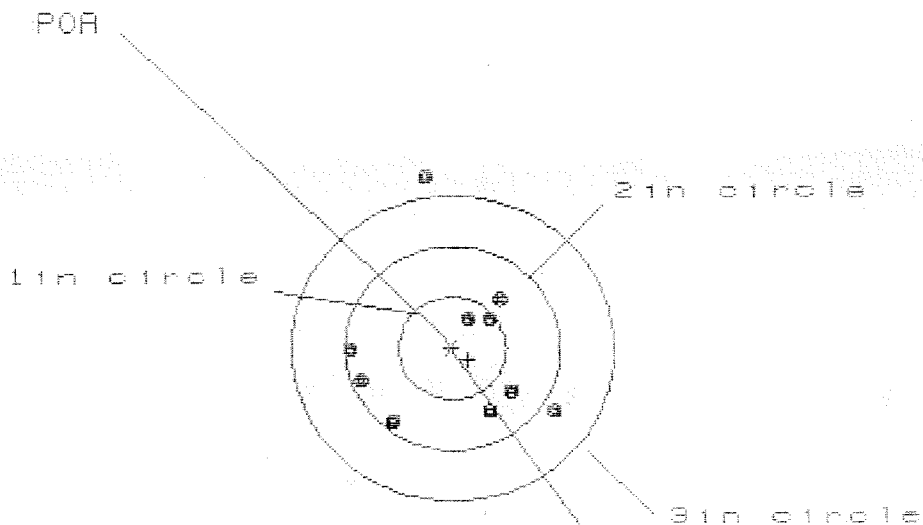
GS = 3.016

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.902	.758	.618
MINIMUM X	-1.297	-1.127	-.549
MAXIMUM Y	1.284	1.140	.951
MINIMUM Y	-1.369	-1.513	-.795
CENTROID X	.019	.163	.303
CENTROID Y	-.263	-.119	.070
POA TO CENTROID in.	.264	.202	.311
MIN RADIUS	.277	.428	.348
MEAN RADIUS	.954	.840	.690
MAX RADIUS	1.834	1.886	1.007
HORIZONTAL SPREAD	2.199	1.985	1.167
VERTICAL SPREAD	2.653	2.653	1.746
EXTREME SPREAD	3.016	2.931	1.859
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

12 Feb 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 2

2in = 8

3in = 9

HS = 1.860

VS = 2.313

CS = 2.601

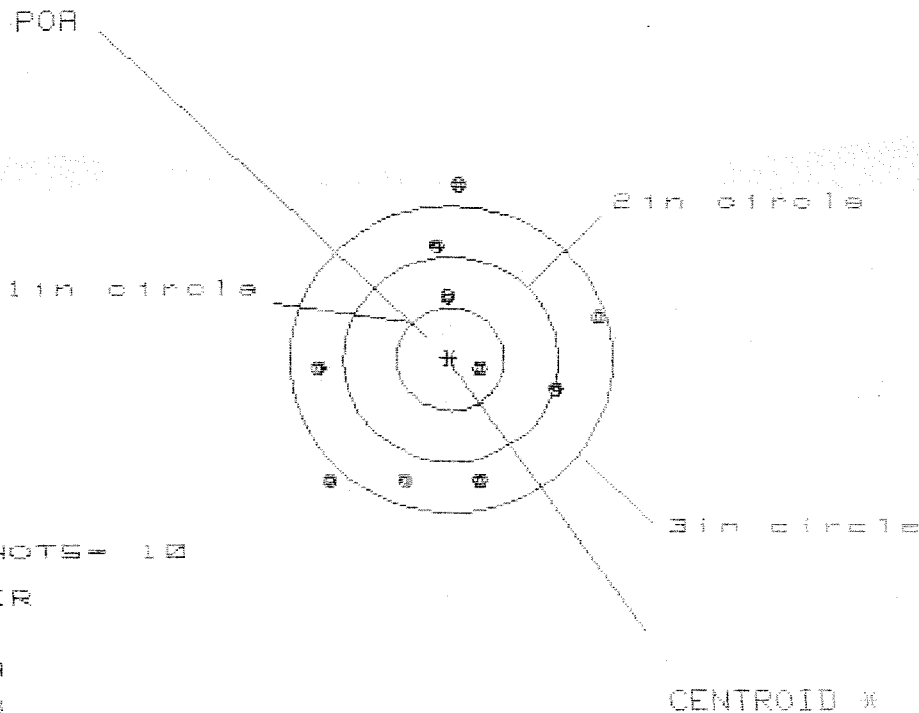
CENTROID #

PATTERN #	2
SHOTS (BEST OF)	10
MAXIMUM X	.909
MINIMUM X	-.951
MAXIMUM Y	1.646
MINIMUM Y	-.667
CENTROID X	-.144
CENTROID Y	.115
POA TO CENTROID in.	.184
MIN RADIUS	.281
MEAN RADIUS	.834
MAX RADIUS	1.674
HORIZONTAL SPREAD	1.860
VERTICAL SPREAD	2.313
EXTREME SPREAD	2.601
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	8
NUMBER IN THREE INCH CIRCLE =	9

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 1

2in = 3

3in = 8

HS= 2.514

VS= 2.859

GS= 3.126

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.399
MINIMUM X	-1.221
MAXIMUM Y	1.668
MINIMUM Y	-1.191
CENTROID X	.030
CENTROID Y	-.015
POA TO CENTROID in.	.033
MIN RADIUS	.258
MEAN RADIUS	1.142
MAX RADIUS	1.672
HORIZONTAL SPREAD	2.614
VERTICAL SPREAD	2.859
EXTREME SPREAD	3.126
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	3
NUMBER IN THREE INCH CIRCLE =	8

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CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

CENTROID #.

HS= 2.096

VS= 1.870

CS= 2.282

PATTERN #

4

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.006	.885	.769
MINIMUM X	:	-1.090	-.929	-.558
MAXIMUM Y	:	.807	.860	.738
MINIMUM Y	:	-1.063	-.973	-.696
CENTROID X	:	.061	.182	.298
CENTROID Y	:	.010	-.072	.050
POA TO CENTROID in.	:	.064	.196	.302
MIN RADIUS	:	.339	.435	.356
MEAN RADIUS	:	.788	.715	.621
MAX RADIUS	:	1.356	1.346	.892
HORIZONTAL SPREAD	:	2.096	1.814	1.327
VERTICAL SPREAD	:	1.870	1.833	1.434
EXTREME SPREAD	:	2.282	2.282	1.653
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

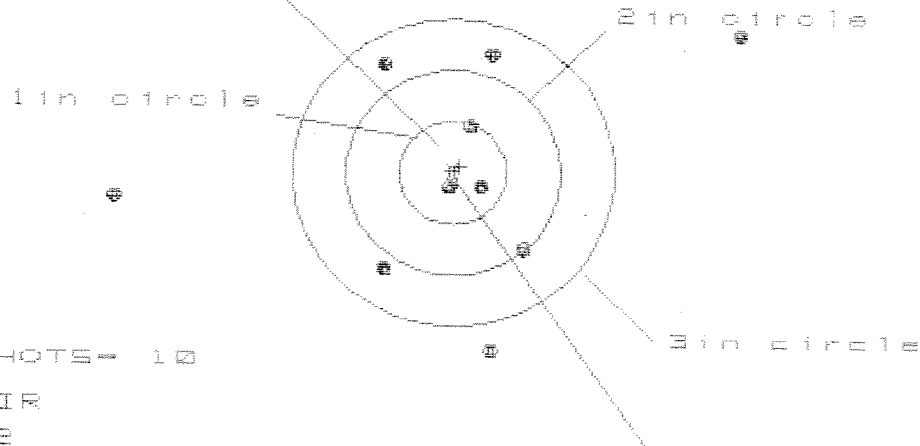
12 Feb 1991

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CENTERFIRE PATTERNS

5

POA



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 4

HS= 5.782

VS= 3.079

GS= 5.994

CENTROID #

PATTERN #

5

SHOTS (BEST OF)

MAXIMUM X	2.664	2.317	.581
MINIMUM X	-3.118	-1.035	-.745
MAXIMUM Y	1.329	1.301	1.287
MINIMUM Y	-1.750	-1.778	-1.615
CENTROID X	-.059	.288	-.002
CENTROID Y	-.062	-.034	-.197
POA TO CENTROID in.	.086	.290	.197
MIN RADIUS	.175	.186	.077
MEAN RADIUS	1.342	1.145	.895
MAX RADIUS	3.128	2.658	1.647
HORIZONTAL SPREAD	5.782	3.352	1.326
VERTICAL SPREAD	3.079	3.079	2.902
EXTREME SPREAD	5.994	4.054	2.935
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		7	