

06594607

MODEL 700TM M24

Model **SWS**TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington




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

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

MODEL 700™ H24

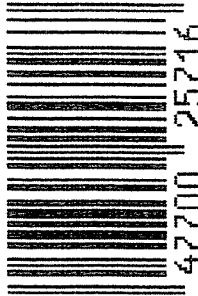
SERIAL NO.
C6594607

ORDER NO.
5716

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

20

UPC



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5716 C6594607

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6594607

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 25	91	RW
600	Proof	3 25	91	RW
607	Check Headspace	3 25	91	RW
610	Dis-assemble Gun	3 25	91	RW
612	Magnaflux Barrel Action	3 28	91	KR
	Magnaflux Bolt	3 28	91	11
615	Rollmark Caliber	3 28	91	LS
617	Drill and Tap Sight Holes	APR	3 1991	EB
618	Polish Barrel	APR	3 1991	WB
620	Apply Coatings (Barrel Action)		4-11-91	11
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		4/16/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/16/91	RW
	C) Inspect Ejector Hole for Chamfer		4/16/91	RW
	D) Oil Firing Pin Ass'y		4/16/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/14/91	11

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5-14-91	RU
	G) Safety Off Force	4	4	4			5-14-91	RU
	H) Trigger Pull Test & Retainability						5/14/91	RU
	I) Firing Pin Indent	.021	.021	.021			5-14-91	RU
	J) Assemble Stock						5/15/91	RW
	K) Assemble Swivel Studs						5-20-91	K
	L) Attach Front and Rear Sight Assemblies						5/15/91	RW
	M) Iron Sight Alignment						5/15/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/15/91	RW
	O) Attach Scope to Rifle						5/15/91	RW
	P) Detach & Attach Scope 20 Times						5/15/91	RW
640	Gallery Target & Test						5-16-91	DH
	A) Time						5-16-91	AC
	B) Malfunctions						5-16-91	AC
	C) Pierced Primers						5-16-91	AC
	D) Optical Clarity of Scope						5-16-91	AC
645	Inspect for Live Ammo						5-16-91	AC
655	Final Inspection							
	A) Headspace						5-20-91	AC
	B) Trigger Pull	2.54	2.55	2.58	2.59	2.59	5/20/91	RU
	C) Function						5-20-91	K
660	Pack						6-18-91	NF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6594607

DATE 5/14/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.57	2.50	2.49	2.54	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.59	2.51	2.52	2.55	
PULL #3	2.27	2.41	2.50	2.58	
PULL #4	2.55	2.54	2.53	2.59	
PULL #5	2.59	2.61	2.51	2.59	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.20	3.27		
PULL #2	3.21	3.28		
PULL #3	3.49	3.35		
PULL #4	3.41	3.34		
PULL #5	3.46	3.32		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.33	4.41		4.31
PULL #2	4.36	4.30		4.31
PULL #3	4.35	4.29		4.33
PULL #4	4.33	4.29		4.33
PULL #5	4.12	4.39		4.35
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594607
16 May 1991

CENTROIDAL DISTANCES

Ø TO	1	.662451
1 TO	2	.204353
1 TO	3	.165012
1 TO	4	.675036
1 TO	5	.580904

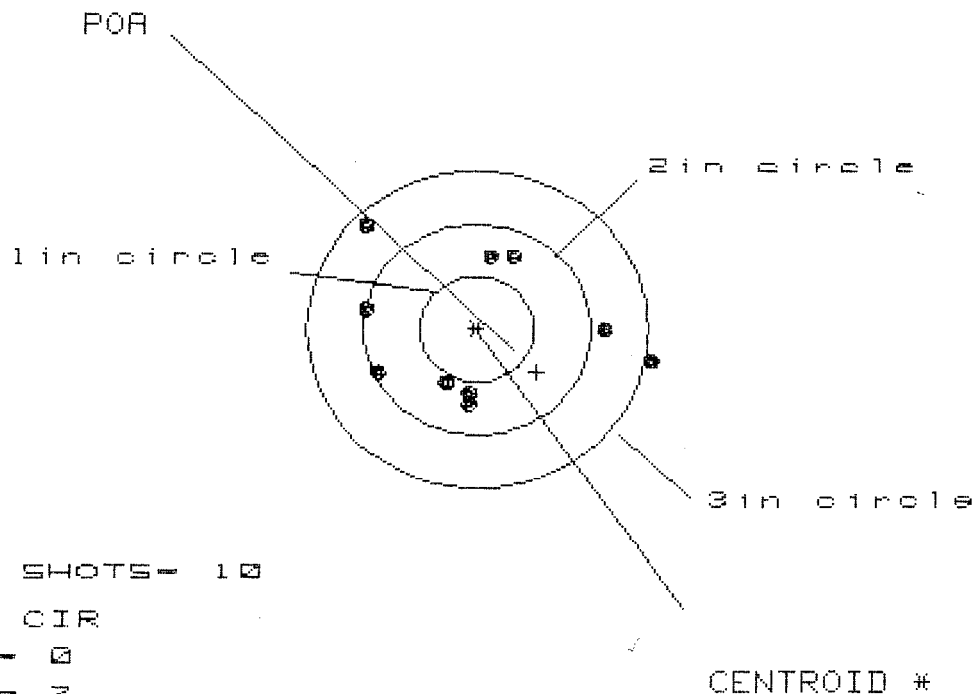
$\bar{x}$ $\bar{y}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2394
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .3154
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .395967
THE AMR FOR THIS RIFLE IS: .9314

16 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594607

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 7

3 in = 9

HS= 2.495

VS= 1.747

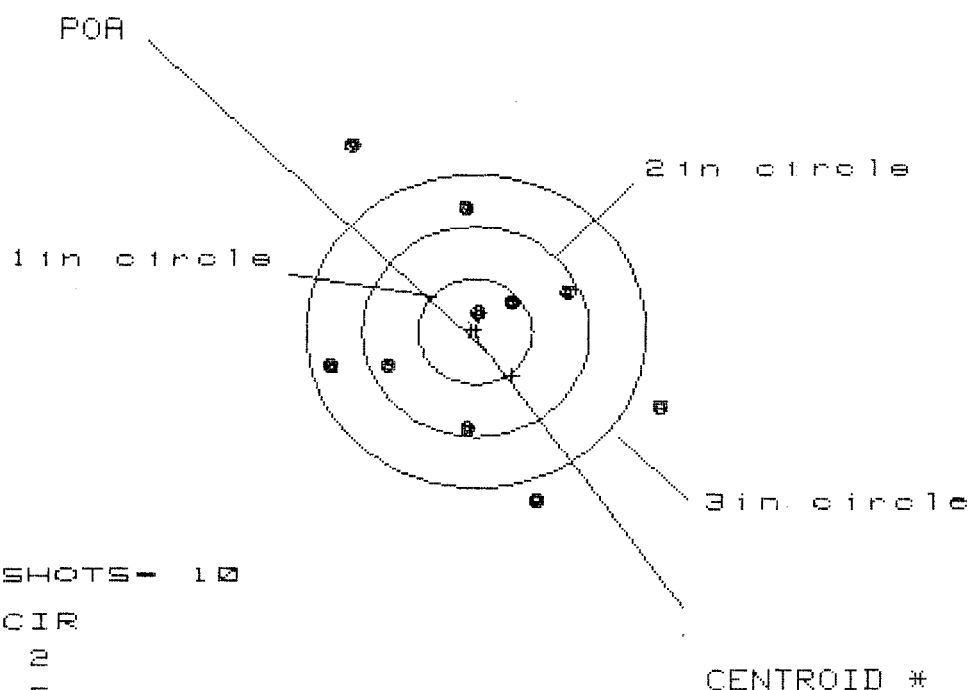
GS= 2.818

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.518	1.340	1.240
MINIMUM X	:	-.977	-.809	-.909
MAXIMUM Y	:	1.035	1.004	.762
MINIMUM Y	:	-.712	-.743	-.617
CENTROID X	:	-.525	-.693	-.593
CENTROID Y	:	.404	.435	.309
POA TO CENTROID in.	:	.662	.819	.669
MIN RADIUS	:	.584	.559	.469
MEAN RADIUS	:	.938	.857	.782
MAX RADIUS	:	1.543	1.342	1.241
HORIZONTAL SPREAD	:	2.495	2.149	2.149
VERTICAL SPREAD	:	1.747	1.747	1.379
EXTREME SPREAD	:	2.818	2.402	2.163
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 7

HS= 2.900

VS= 3.442

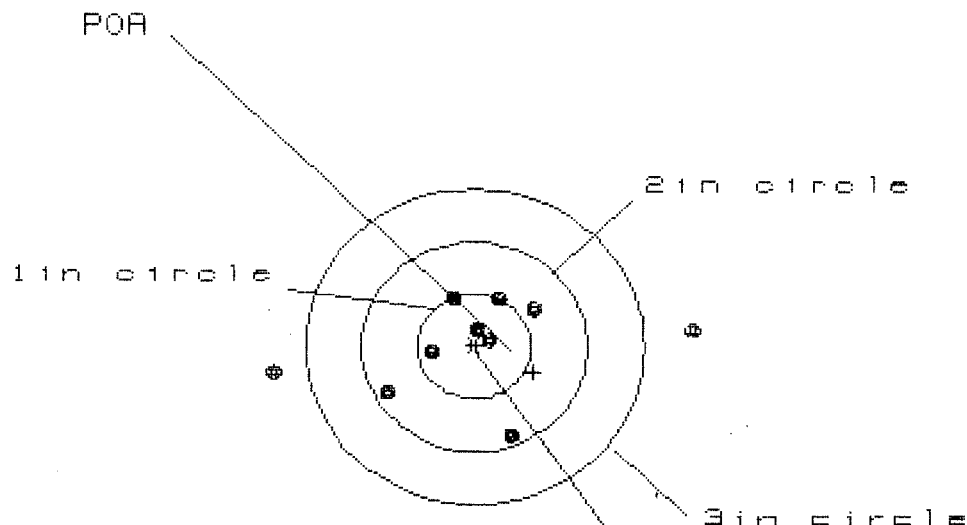
GS= 3.786

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.629	1.512	.903
MINIMUM X	:	-1.271	-1.388	-1.199
MAXIMUM Y	:	1.824	1.385	1.326
MINIMUM Y	:	-1.618	-1.415	-1.474
CENTROID X	:	-.321	-.204	-.393
CENTROID Y	:	.416	.213	.273
POA TO CENTROID in.	:	.525	.296	.479
MIN RADIUS	:	.203	.416	.357
MEAN RADIUS	:	1.145	1.050	.962
MAX RADIUS	:	2.102	1.585	1.594
HORIZONTAL SPREAD	:	2.900	2.900	2.102
VERTICAL SPREAD	:	3.442	2.800	2.800
EXTREME SPREAD	:	3.786	2.918	2.874
NUMBER IN ONE INCH CIRCLE =	:	2		
NUMBER IN TWO INCH CIRCLE =	:	5		
NUMBER IN THREE INCH CIRCLE =	:	7		

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 5

2in = 8

3in = 8

HS= 3.737

VS= 1.312

GS= 3.761

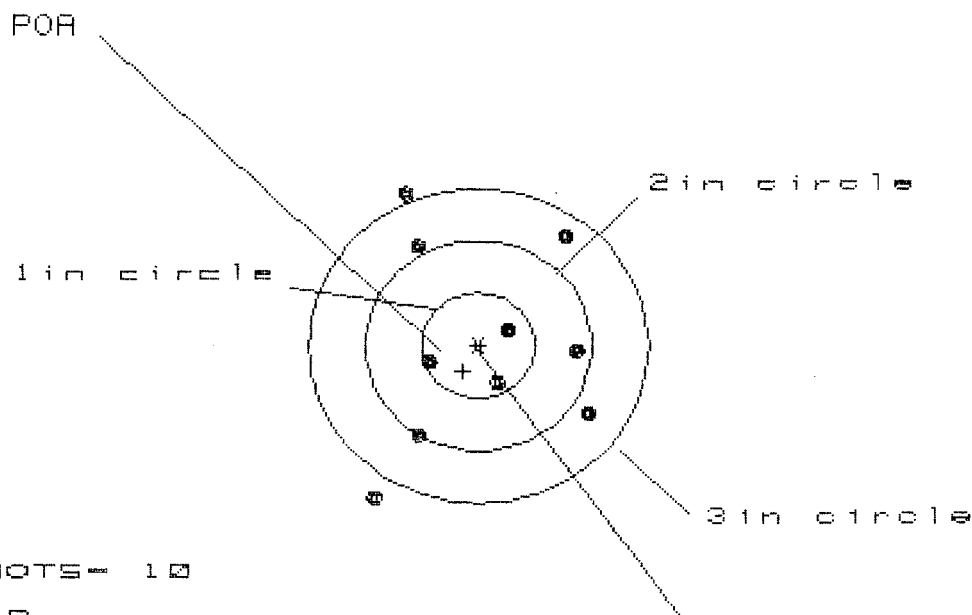
CENTROID #

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.917	.760	.559
MINIMUM X	:	-1.820	-1.607	-.800
MAXIMUM Y	:	.473	.492	.463
MINIMUM Y	:	-.839	-.820	-.849
CENTROID X	:	-.523	-.736	-.535
CENTROID Y	:	.239	.220	.249
POA TO CENTROID in.	:	.575	.768	.590
MIN RADIUS	:	.092	.165	.099
MEAN RADIUS	:	.780	.672	.503
MAX RADIUS	:	1.925	1.623	.910
HORIZONTAL SPREAD	:	3.737	2.367	1.359
VERTICAL SPREAD	:	1.312	1.312	1.312
EXTREME SPREAD	:	3.761	2.443	1.565
NUMBER IN ONE INCH CIRCLE =	:	5		
NUMBER IN TWO INCH CIRCLE =	:	8		
NUMBER IN THREE INCH CIRCLE =	:	8		

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 5

3 in = 8

HS = 1.871

VS = 2.837

GS = 2.959

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.965	.864	.776
MINIMUM X	:	-.906	-.708	-.725
MAXIMUM Y	:	1.419	1.261	1.029
MINIMUM Y	:	-1.418	-.989	-.831
CENTROID X	:	.132	.233	.321
CENTROID Y	:	.249	.407	.249
POA TO CENTROID in.	:	.282	.469	.406
MIN RADIUS	:	.286	.158	.144
MEAN RADIUS	:	.974	.888	.787
MAX RADIUS	:	1.683	1.446	1.176
HORIZONTAL SPREAD	:	1.871	1.572	1.501
VERTICAL SPREAD	:	2.837	2.250	1.860
EXTREME SPREAD	:	2.959	2.564	2.266
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

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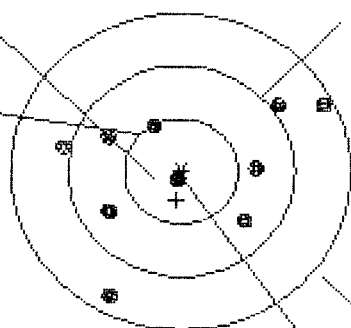
CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle



CENTROID #

OF SHOTS- 10

IN CIR

1 in - 2

2 in - 6

3 in = 10

HS- 2.215

VS= 1.840

GS= 2.633

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.217	.995	.929
MINIMUM X	-.998	-.863	-.929
MAXIMUM Y	.643	.691	.550
MINIMUM Y	-1.197	-1.125	-.543
CENTROID X	.040	-.095	-.029
CENTROID Y	.269	.197	.338
POA TO CENTROID in.	.272	.219	.339
MIN RADIUS	.116	.096	.178
MEAN RADIUS	.820	.745	.677
MAX RADIUS	1.376	1.244	1.079
HORIZONTAL SPREAD	2.215	1.858	1.858
VERTICAL SPREAD	1.840	1.816	1.093
EXTREME SPREAD	2.633	2.372	1.892
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		