

C6594624

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington®

MODEL 700™ H24

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

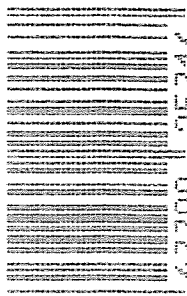
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

SERIAL NO.
C6594624

ORDER NO.
5716

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

UPC



0 4700 25716 7



5716 C6594624

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6594624

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		12/26/90	K.S.
600	Proof		12/26/90	K. S.
607	Check Headspace		12/26/90	K. S.
610	Dis-assemble Gun		12/26/90	K. S.
612	Magnaflux Barrel Action		1-17-91	KR
	Magnaflux Bolt		1-17-91	KR
615	Rollmark Caliber		1-17-91	GL
617	Drill and Tap Sight Holes	1	10 91	FB
618	Polish Barrel	1	10 91	WB
620	Apply Coatings (Barrel Action)		1-28-91	JA
	Apply Coating (Bolt)		1-28-91	JA
625	Final Assembly A) Clean inside of Bolt Assembly		2/4/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/4/91	KS
	C) Inspect Ejector Hole for Chamfer		2/4/91	KS
	D) Oil Firing Pin Ass'y		2/4/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		2/5/91	JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 ³ / ₄	5 ³ / ₄	5 ¹ / ₂			2/5/91	WB
	G) Safety Off Force	3	3	3			2/5/91	WB
	H) Trigger Pull Test & Retainability						2/5/91	WB
	I) Firing Pin Indent	.020	.020	.020			2/5/91	WB
	J) Assemble Stock						2/5/91	KA
	K) Assemble Swivel Studs						2-19-91	AC
	L) Attach Front and Rear Sight Assemblies						2/5/91	KA
	M) Iron Sight Alignment						2/5/91	KA
	N) Detach Front & Rear Sights & place in numbered container						2/5/91	KA
	O) Attach Scope to Rifle						2/5/91	KA
	P) Detach & Attach Scope 20 Times						2/5/91	KA
640	Gallery Target & Test						2/6/91	KS
	A) Time							KS
	B) Malfunctions							KS
	C) Pierced Primers							KS
	D) Optical Clarity of Scope							KS
645	Inspect for Live Ammo						2/6/91	KS
655	Final Inspection						2-19-91	AC
	A) Headspace							
	B) Trigger Pull	2.31	2.41	2.26	2.35	2.27	2/15/91	WB
	C) Function						2-19-91	AC
660	Pack						3-19-91	AC

SWS TRIGGER PULL TEST

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

SERIAL NO. C6594624
DATE 2/5/91
TESTER JP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.46	2.40	2.31	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.38	2.43	2.38	2.41	
PULL #3	2.45	2.50	2.40	2.26	
PULL #4	2.38	2.34	2.41	2.35	
PULL #5	2.44	2.44	2.30	2.27	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.50	3.42		
PULL #2	3.42	3.39		
PULL #3	3.47	3.35		
PULL #4	3.50	3.31		
PULL #5	3.28	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	4.20	4.38		4.40
PULL #2	4.43	4.43		4.41
PULL #3	4.24	4.41		4.37
PULL #4	4.52	4.42		4.45
PULL #5	4.43	4.42		4.37
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594624
7 Feb 1991

CENTROIDAL DISTANCES

0 TO	1	.130863
1 TO	2	.330776
1 TO	3	.121824
1 TO	4	.109604
1 TO	5	.310363

✱ <----POB

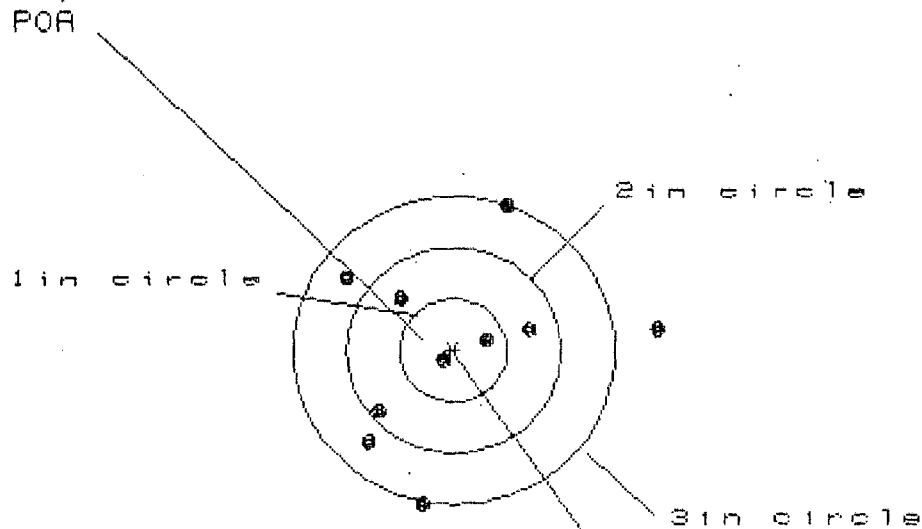
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1788
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2218
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .284894
THE AMR FOR THIS RIFLE IS: .9026

2 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594624

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 7

HS= 2.846

VS= 2.927

GS= 3.051

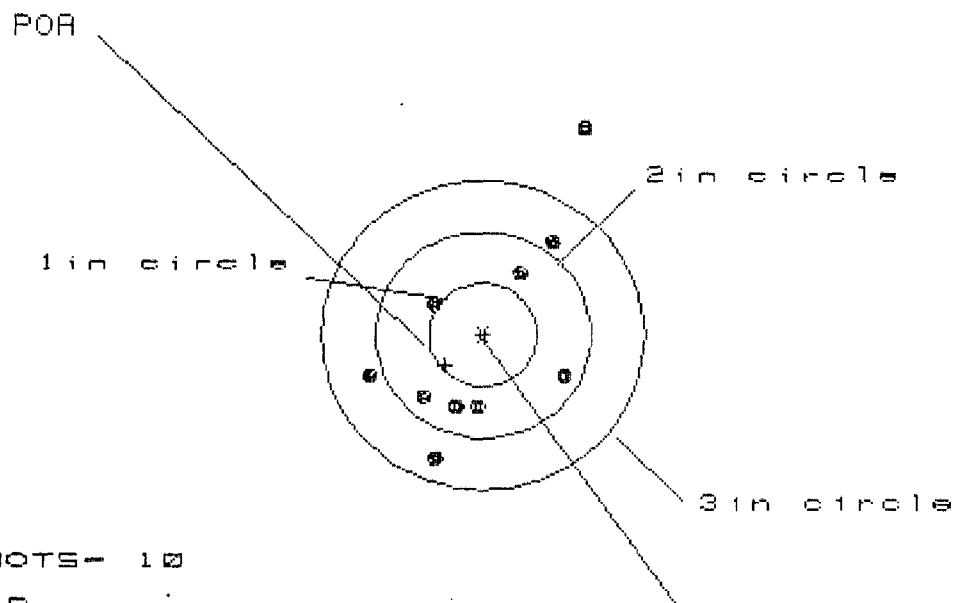
CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.857	.916	.902
MINIMUM X	:	-.989	-.783	-.797
MAXIMUM Y	:	1.401	1.429	1.242
MINIMUM Y	:	-1.526	-1.498	-1.082
CENTROID X	:	.095	-.111	-.097
CENTROID Y	:	.090	.062	.249
POA TO CENTROID in.	:	.131	.127	.267
MIN RADIUS	:	.174	.132	.295
MEAN RADIUS	:	1.030	.923	.850
MAX RADIUS	:	1.874	1.615	1.445
HORIZONTAL SPREAD	:	2.846	1.699	1.699
VERTICAL SPREAD	:	2.927	2.927	2.324
EXTREME SPREAD	:	3.051	3.051	2.680
NUMBER IN ONE INCH CIRCLE =	:	2		
NUMBER IN TWO INCH CIRCLE =	:	5		
NUMBER IN THREE INCH CIRCLE =	:	7		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 6

3 in = 9

ISI = 1.956

VS = 3.203

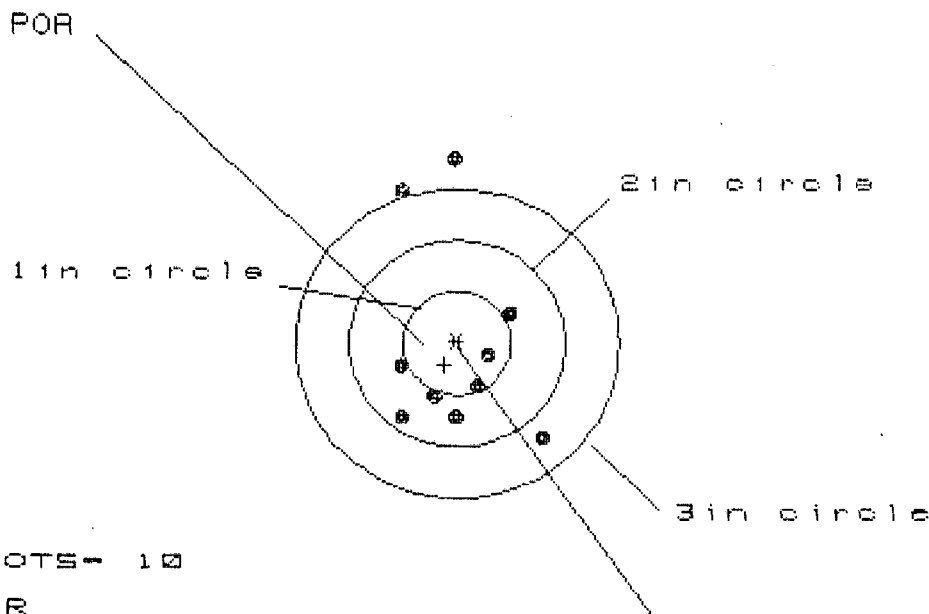
GS = 3.479

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.949	.859	.821
MINIMUM X	:	-1.007	-.901	-.940
MAXIMUM Y	:	2.020	1.169	1.051
MINIMUM Y	:	-1.175	-.950	-.595
CENTROID X	:	.353	.247	.285
CENTROID Y	:	.297	.072	.190
POA TO CENTROID in.	:	.461	.258	.343
MIN RADIUS	:	.583	.451	.562
MEAN RADIUS	:	1.011	.819	.809
MAX RADIUS	:	2.239	1.416	1.297
HORIZONTAL SPREAD	:	1.956	1.760	1.760
VERTICAL SPREAD	:	3.203	2.119	1.646
EXTREME SPREAD	:	3.479	2.388	2.142
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	9		

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in - 2

2in - 7

3in = 8

HS- 1.309

VS= 2.745

GS= 2.851

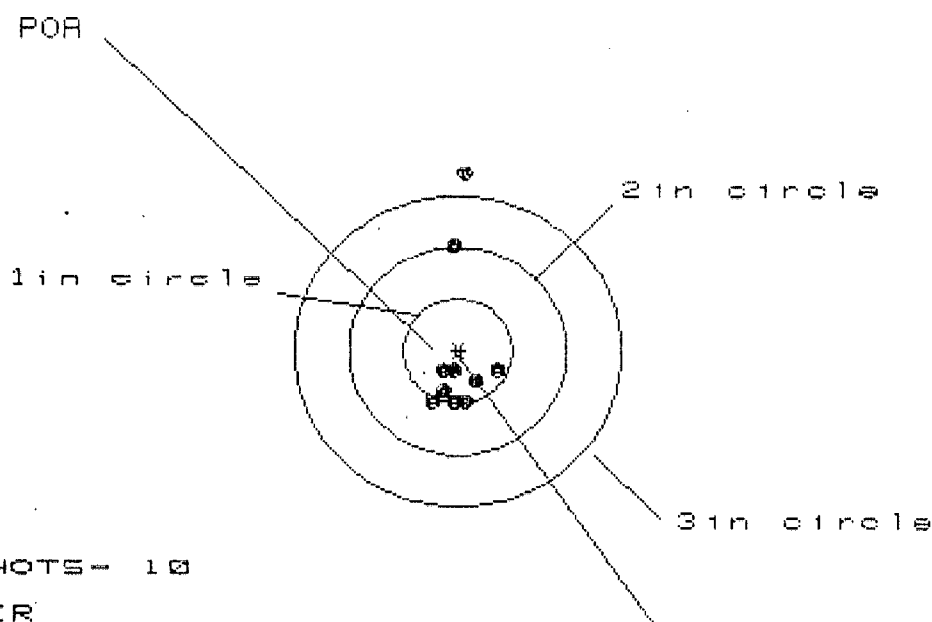
CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.795	.798	.740
MINIMUM X	-.514	-.511	-.569
MAXIMUM Y	1.805	1.705	.738
MINIMUM Y	-.940	-.740	-.526
CENTROID X	.116	.113	.171
CENTROID Y	.210	.010	-.204
POR TO CENTROID in.	.240	.113	.266
MIN RADIUS	.275	.255	.108
MEAN RADIUS	.863	.695	.512
MAX RADIUS	1.805	1.768	.908
HORIZONTAL SPREAD	1.309	1.309	1.309
VERTICAL SPREAD	2.745	2.445	1.264
EXTREME SPREAD	2.851	2.752	1.484
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 6

2in = 8

3in = 9

HS= .594

VS= 2.174

GS= 2.199

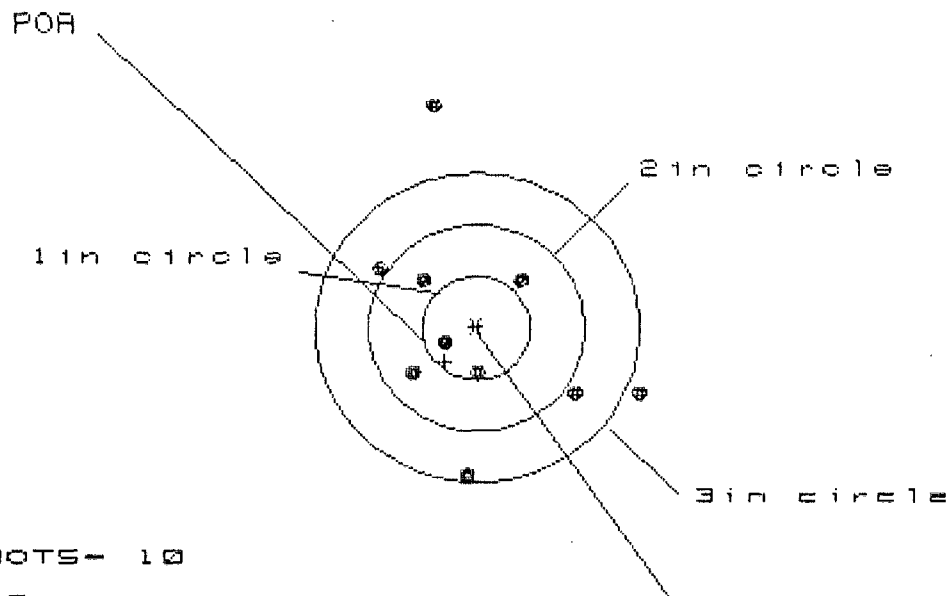
CENTROID #

PATTERN #	:	14	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.330	.337	.331
MINIMUM X	:	-.264	-.257	-.264
MAXIMUM Y	:	1.668	1.212	.175
MINIMUM Y	:	-.506	-.321	-.169
CENTROID X	:	.037	.030	.036
CENTROID Y	:	.183	-.002	-.154
POA TO CENTROID in.	:	.187	.030	.158
MIN RADIUS	:	.188	.076	.109
MEAN RADIUS	:	.574	.350	.205
MAX RADIUS	:	1.669	1.214	.361
HORIZONTAL SPREAD	:	.594	.594	.594
VERTICAL SPREAD	:	2.174	1.533	.344
EXTREME SPREAD	:	2.199	1.547	.671
NUMBER IN ONE INCH CIRCLE	=		6	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.329

VS= 3.633

GS= 3.640

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.463	1.422	1.070
MINIMUM X	:	-.865	-.907	-.729
MAXIMUM Y	:	2.183	.803	.760
MINIMUM Y	:	-1.450	-1.207	-1.250
CENTROID X	:	.293	.335	.157
CENTROID Y	:	.329	.086	.129
POA TO CENTROID in.	:	.441	.345	.203
MIN RADIUS	:	.360	.226	.183
MEAN RADIUS	:	1.035	.879	.768
MAX RADIUS	:	2.215	1.463	1.250
HORIZONTAL SPREAD	:	2.329	2.329	1.799
VERTICAL SPREAD	:	3.633	2.010	2.010
EXTREME SPREAD	:	3.640	2.595	2.173

NUMBER IN TWO INCH CIRCLE = 5
NUMBER IN THREE INCH CIRCLE = 8