

C6594637

MODEL 700TM M24

Model **SWS**TM

Action

Barrel Length

Capacity

Order No. **5715**

*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. C6594637

DATE 3-13-96

TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.72	2.55	2.70		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.65	2.71	2.74		
PULL #3	2.64	2.64	2.75		
PULL #4	2.63	2.63	2.76		
PULL #5	2.49	2.64	2.75		
TOTAL	13.13	13.17	13.70		
AVG.	2.62	2.63	2.74		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.01	2.94		
PULL #2	3.03	2.96		
PULL #3	2.96	2.96		
PULL #4	2.97	2.94		
PULL #5	2.94	2.90		
TOTAL	14.91	14.70		
AVG.	2.98	2.94		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.20	4.20		4.18
PULL #2	4.27	4.28		4.17
PULL #3	4.30	4.27		4.00
PULL #4	4.33	4.33		4.10
PULL #5	4.32	4.30		4.08
TOTAL	21.42	21.38		20.53
AVG.	4.28	4.27		4.10

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594637
22 Jan 1900

CENTROIDAL DISTANCES

Ø TO	1	.977446
1 TO	2	.381084
1 TO	3	.235325
1 TO	4	.233658
1 TO	5	.306297

#2

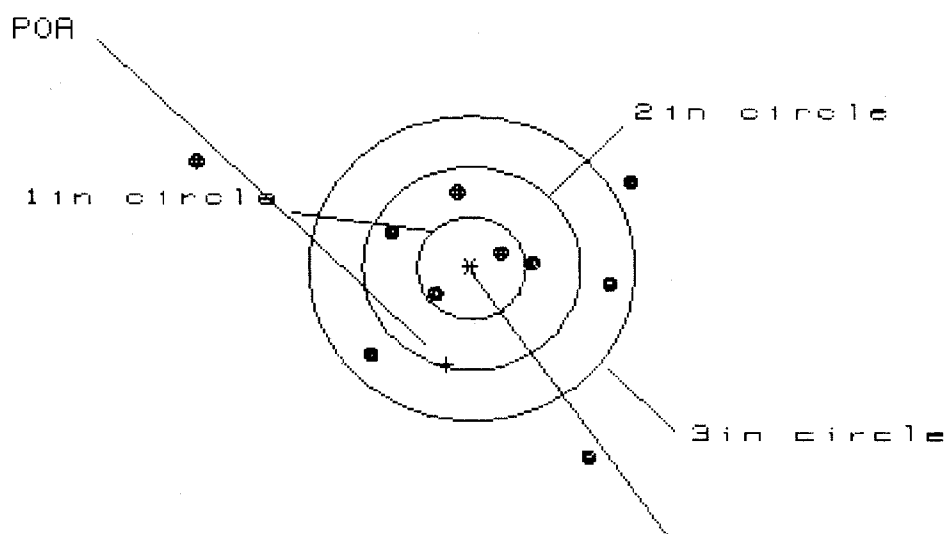
+ (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2912
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .7882
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .840272
THE AMR FOR THIS RIFLE IS: 1.048

22 Jan 1900

FILE:/PATTERNING/CENTERFIRE_PATT/C6594637

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 7

HS= 4.019

VS= 2.966

GS= 4.691

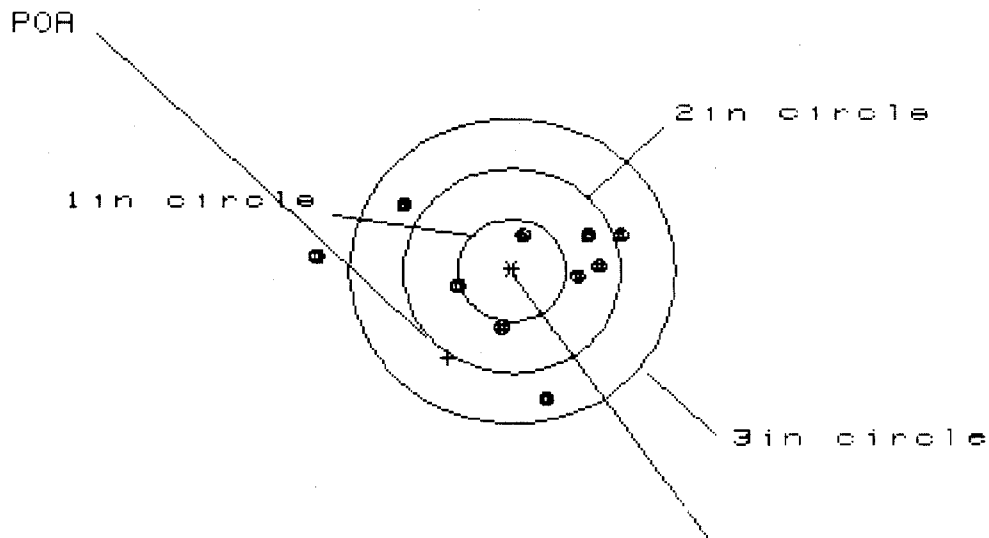
CENTROID *

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.484	1.202	1.304
MINIMUM X	:	-2.535	-1.191	-1.089
MAXIMUM Y	:	1.082	1.002	.781
MINIMUM Y	:	-1.884	-1.764	-.980
CENTROID X	:	.230	.512	.410
CENTROID Y	:	.950	.830	1.051
POA TO CENTROID in.	:	.978	.975	1.128
MIN RADIUS	:	.287	.242	.084
MEAN RADIUS	:	1.206	1.021	.858
MAX RADIUS	:	2.756	1.944	1.520
HORIZONTAL SPREAD	:	4.019	2.393	2.393
VERTICAL SPREAD	:	2.966	2.766	1.761
EXTREME SPREAD	:	4.691	2.971	2.971
NUMBER IN ONE INCH CIRCLE =	:	2		
NUMBER IN TWO INCH CIRCLE =	:	5		
NUMBER IN THREE INCH CIRCLE =	:	7		

22 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8594637

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 2.787

VS= 1.898

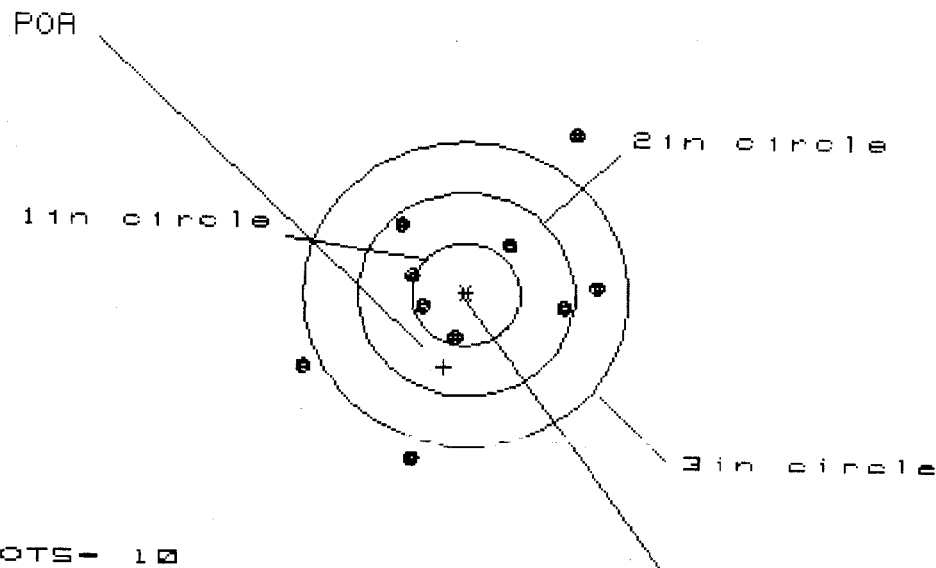
GS= 2.789

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.014	.816	.825
MINIMUM X	-1.773	-1.239	-1.230
MAXIMUM Y	.673	.695	.544
MINIMUM Y	-1.225	-1.203	-.675
CENTROID X	.598	.796	.787
CENTROID Y	.851	.829	.980
POA TO CENTROID in.	1.041	1.149	1.257
MIN RADIUS	.414	.397	.260
MEAN RADIUS	.902	.765	.694
MAX RADIUS	1.784	1.420	1.345
HORIZONTAL SPREAD	2.787	2.055	2.055
VERTICAL SPREAD	1.898	1.898	1.219
EXTREME SPREAD	2.789	2.305	2.087
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

22 Jan 1900

FILE:/PATTERNING/CENTERFIRE_PATT/C8594637

CENTERFIRE PATTERNS # 3



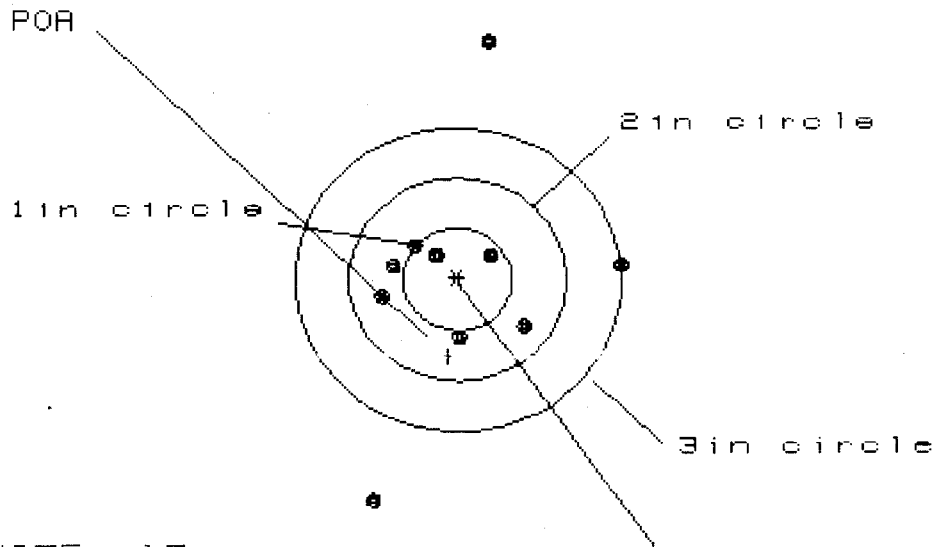
OF SHOTS- 10
 # IN CIR
 1in = 2
 2in = 6
 3in = 7
 HS= 2.743
 VS= 3.207
 GS= 3.524

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.197	1.308	1.129
MINIMUM X	:	-1.546	-1.445	-.663
MAXIMUM Y	:	1.607	.829	.757
MINIMUM Y	:	-1.600	-1.422	-1.494
CENTROID X	:	.197	.086	.265
CENTROID Y	:	.717	.539	.611
POA TO CENTROID in.	:	.744	.546	.666
MIN RADIUS	:	.381	.269	.364
MEAN RADIUS	:	1.030	.918	.839
MAX RADIUS	:	1.894	1.548	1.584
HORIZONTAL SPREAD	:	2.743	2.743	1.792
VERTICAL SPREAD	:	3.207	2.251	2.251
EXTREME SPREAD	:	3.524	2.881	2.388
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

22 Jan 1900

FILE:/PATTERNING/CENTERFIRE_PATT/06594637

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 7

HS= 2.334

VS= 4.464

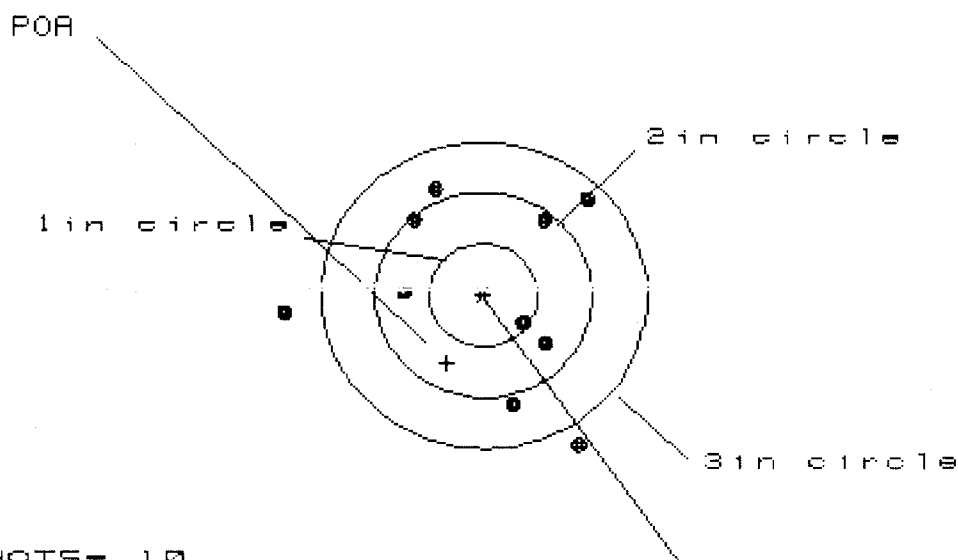
GS= 4.591

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.526	1.543	1.458
MINIMUM X	:	-.808	-.791	-.796
MAXIMUM Y	:	2.301	2.075	.386
MINIMUM Y	:	-2.163	1.907	-.583
CENTROID X	:	.094	.065	.163
CENTROID Y	:	.760	.504	.743
POA TO CENTROID in.	:	.766	.509	.760
MIN RADIUS	:	.276	.345	.337
MEAN RADIUS	:	1.015	.884	.700
MAX RADIUS	:	2.316	2.060	1.463
HORIZONTAL SPREAD	:	2.334	2.060	2.254
VERTICAL SPREAD	:	4.464	2.532	.969
EXTREME SPREAD	:	4.591	3.261	2.269
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	7		

22 Jan 1908

FILE:/PATTERNING/CENTERFIRE_PATT/C6594637

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in - 1

2in - 5

3in = 8

HS= 2.856

VS= 2.428

GS= 3.072

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.98
MINIMUM X	-1.87
MAXIMUM Y	1.01
MINIMUM Y	-1.416
CENTROID X	.337
CENTROID Y	.663
POA TO CENTROID in.	.744
MIN RADIUS	.489
MEAN RADIUS	1.088
MAX RADIUS	1.885
HORIZONTAL SPREAD	2.856
VERTICAL SPREAD	2.428
EXTREME SPREAD	3.072
NUMBER IN ONE INCH CIRCLE	= 1
NUMBER IN TWO INCH CIRCLE	= 5
NUMBER IN THREE INCH CIRCLE	= 8

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6594637

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	7	7	7			5/4/96	fw
	G) Safety Off Force	4	4	4			5/4/96	fw
	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	2.75	2.65	2.74	2.79	2.79	5/4/96	fw
	C) Function							
660	Pack							

900

280

232

050 #

Remington®



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

MODEL 700™ H24

SERIAL NO.
C6594637

ORDER NO.
5716

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

20



5716 C6594637

UPC



0 47700 25716 7

GEM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6594637

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		1/22/91	KS
600	Proof		1/22/91	KS
607	Check Headspace		1/22/91	KS
610	Dis-assemble Gun		1/22/91	KS
612	Magnaflux Barrel Action		1/29/91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	LS.
617	Drill and Tap Sight Holes	2 2 91		LB
618	Polish Barrel <i>ReB</i>	2 2 91		WB
620	Apply Coatings (Barrel Action)		2-11-91	KA
	Apply Coating (Bolt)			KA
625	Final Assembly			
	A) Clean inside of Bolt Assembly		3/4/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		3/4/91	KA
	C) Inspect Ejector Hole for Chamfer		3/4/91	KA
	D) Oil Firing Pin Ass'y		3/4/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		3/5/91	KA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	3	3	3			3/5/91	PH
	G) Safety Off Force	2	2	2			3/5/91	PH
	H) Trigger Pull Test & Retainability						3-5-91	PH
	I) Firing Pin Indent	.021	.020	.0205			3/5/91	PH
	J) Assemble Stock						3/5/91	PH
	K) Assemble Swivel Studs						3-11-91	D/H
	L) Attach Front and Rear Sight Assemblies						3/5/91	PH
	M) Iron Sight Alignment						3/5/91	PH
	N) Detach Front & Rear Sights & place in numbered container						3/5/91	PH
	O) Attach Scope to Rifle						3/5/91	PH
	P) Detach & Attach Scope 20 Times						3/5/91	PH
640	Gallery Target & Test						3-6-91	D/H
	A) Time						3-6-91	D/H
	B) Malfunctions						3-6-91	D/H
	C) Pierced Primers						3-6-91	D/H
	D) Optical Clarity of Scope						3-6-91	D/H
645	Inspect for Live Ammo						3-6-91	D/H
655	Final Inspection							
	A) Headspace						3-11-91	D/H
	B) Trigger Pull	2.23	2.21	2.18	2.20	2.18	3/9/91	PH
	C) Function						3-11-91	D/H
660	Pack						3/5/91	D/H

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50#+ .50#
3.00#+ .75#
4.00#+1.00#

SERIAL NO. C6594637

DATE 3-5-91

TESTER JM.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.34	2.23	2.22	2.23	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.34	2.33	2.33	2.21	
PULL #3	2.35	2.31	2.31	2.18	
PULL #4	2.34	2.34	2.30	2.20	
PULL #5	2.28	2.37	2.36	2.18	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.39		
PULL #2	3.34	3.30		
PULL #3	3.39	3.32		
PULL #4	3.41	3.40		
PULL #5	3.32	3.42		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.49	4.42		4.41
PULL #2	4.45	4.50		4.59
PULL #3	4.43	4.48		4.35
PULL #4	4.34	4.38		4.27
PULL #5	4.52	4.49		4.16
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594637
6 Mar 1991

CENTROIDAL DISTANCES

0 TO	1	.0444072
1 TO	2	.236935
1 TO	3	.0318277
1 TO	4	.437919
1 TO	5	.074793

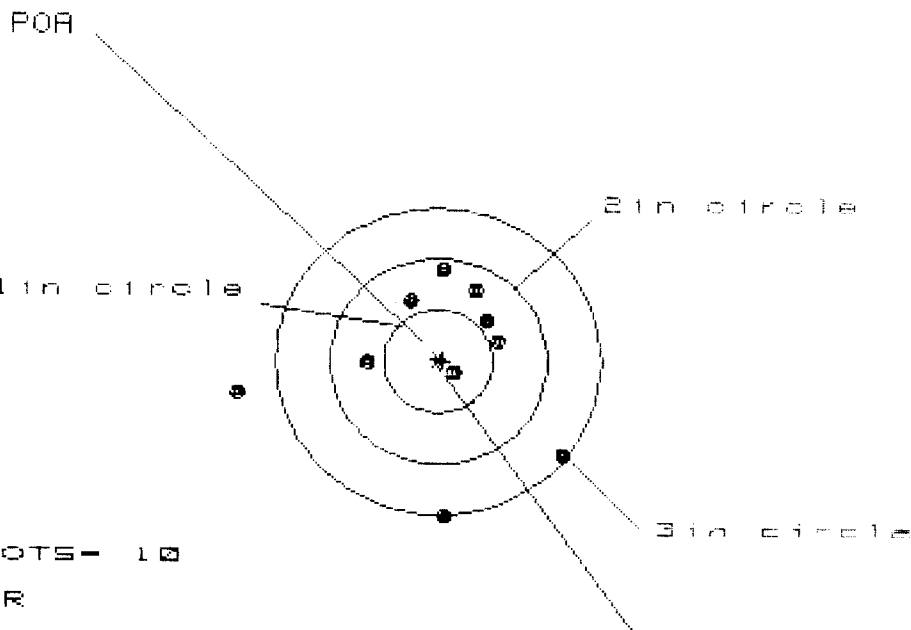
43 (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1778
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0392
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .181857
THE AMR FOR THIS RIFLE IS: .8438

6 Mar 1991

FILE://PATTERNING/CENTERFIRE_PATT/C6594637

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 1

2in = 7

3in = 9

HS= 3.045

VS= 2.440

GS= 3.105

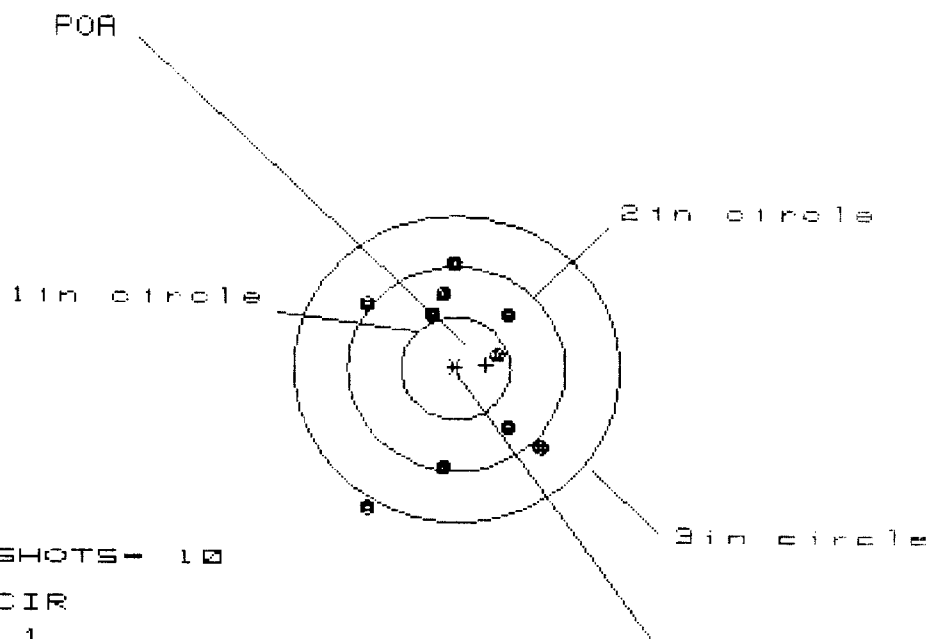
CENTROID *

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.146	.935	.918
MINIMUM X	:	-1.899	-.896	-.913
MAXIMUM Y	:	.943	.908	.716
MINIMUM Y	:	-1.497	-1.532	-1.150
CENTROID X	:	-.044	.167	.184
CENTROID Y	:	.006	.041	.233
POA TO CENTROID in.	:	.044	.172	.297
MIN RADIUS	:	.139	.171	.300
MEAN RADIUS	:	.933	.792	.654
MAX RADIUS	:	1.926	1.538	1.472
HORIZONTAL SPREAD	:	3.045	1.831	1.831
VERTICAL SPREAD	:	2.440	2.440	1.866
EXTREME SPREAD	:	3.105	2.440	2.161
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	9		

6 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594637

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 1.548

VS= 2.438

GS= 2.567

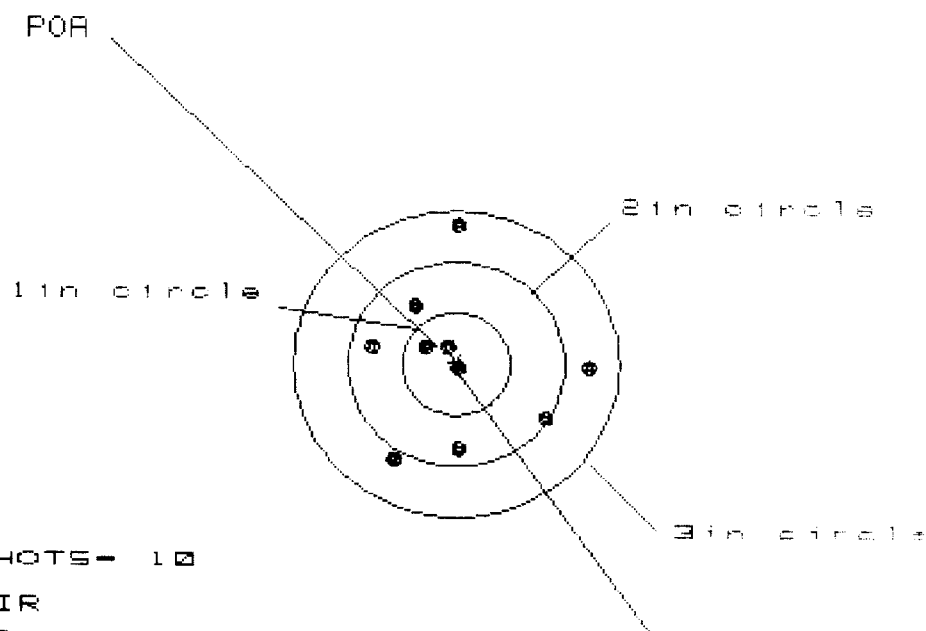
CENTROID *

PATTERN #	2	2	2
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.734	.643	.584
MINIMUM X	-.814	-.865	-.784
MAXIMUM Y	1.031	.875	.762
MINIMUM Y	-1.407	-1.152	-1.264
CENTROID X	-.277	-.186	-.267
CENTROID Y	-.037	.119	.231
POA TO CENTROID in.	.279	.221	.353
MIN RADIUS	.371	.249	.350
MEAN RADIUS	.892	.769	.704
MAX RADIUS	1.625	1.174	1.273
HORIZONTAL SPREAD	1.548	1.508	1.288
VERTICAL SPREAD	2.438	2.027	2.027
EXTREME SPREAD	2.567	2.072	2.031
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

8 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594637

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in - 3

2 in - 7

3 in - 10

HS- 1.971

VS- 2.253

GS- 2.331

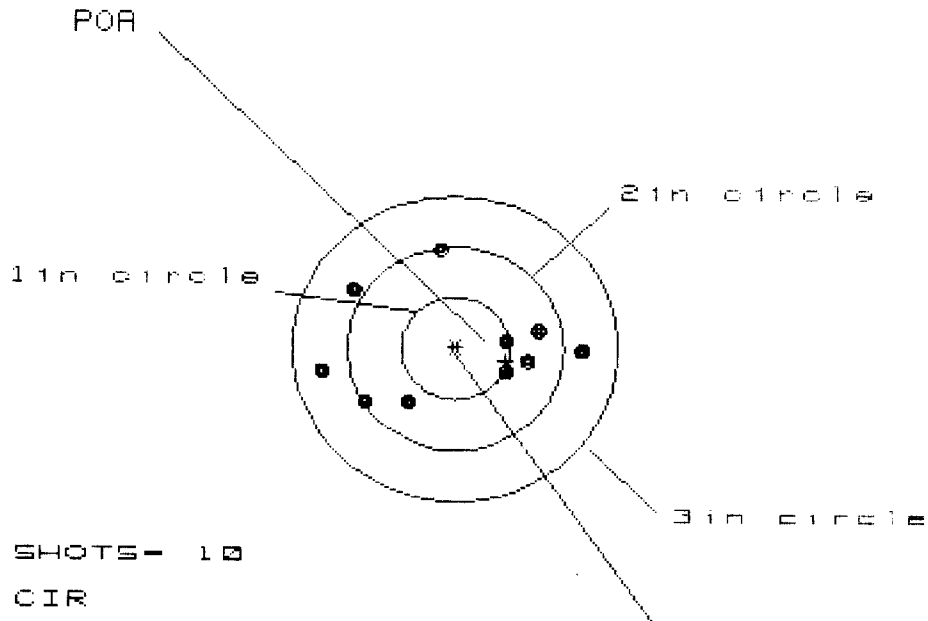
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.193	1.198	.964
MINIMUM X	:	-.778	-.773	-.623
MAXIMUM Y	:	1.324	.750	.764
MINIMUM Y	:	-.929	-.782	-.768
CENTROID X	:	-.021	-.026	-.176
CENTROID Y	:	.028	-.119	-.133
POA TO CENTROID in.	:	.035	.121	.220
MIN RADIUS	:	.016	.159	.225
MEAN RADIUS	:	.746	.703	.627
MAX RADIUS	:	1.324	1.204	1.045
HORIZONTAL SPREAD	:	1.971	1.971	1.587
VERTICAL SPREAD	:	2.253	1.532	1.532
EXTREME SPREAD	:	2.331	1.977	1.731
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

8 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594637

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 10

HS= 2.398

VS= 1.504

GS= 2.402

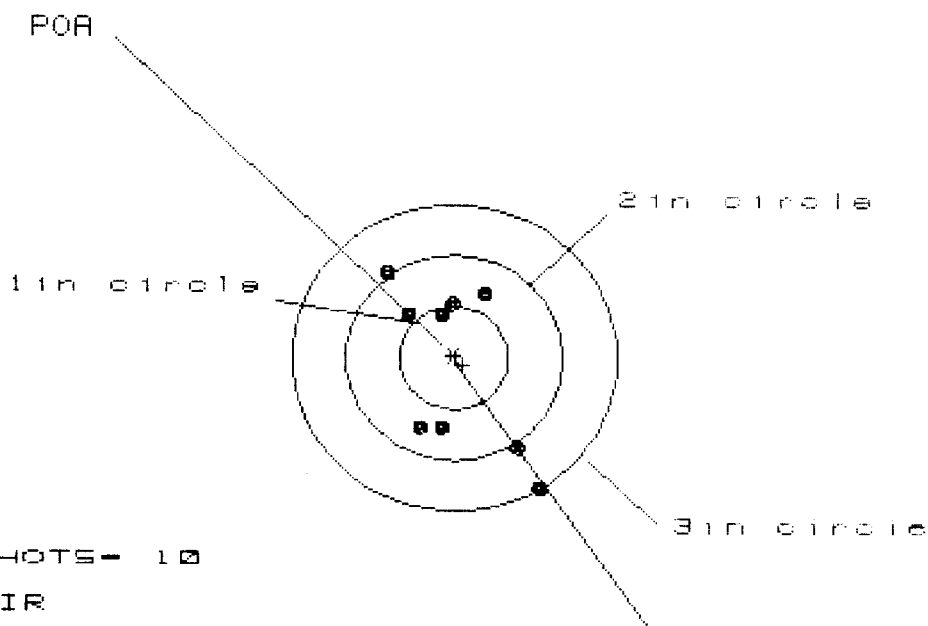
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.185	1.050	.740
MINIMUM X	:	-1.213	-1.092	-.961
MAXIMUM Y	:	.946	.923	.912
MINIMUM Y	:	-.558	-.581	-.592
CENTROID X	:	-.466	-.331	-.462
CENTROID Y	:	.123	.145	.156
POA TO CENTROID in.	:	.482	.361	.488
MIN RADIUS	:	.488	.352	.482
MEAN RADIUS	:	.862	.790	.776
MAX RADIUS	:	1.230	1.205	1.083
HORIZONTAL SPREAD	:	2.398	2.142	1.701
VERTICAL SPREAD	:	1.504	1.504	1.504
EXTREME SPREAD	:	2.402	2.224	1.731
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

6 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06594637

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 10

HS= 1.358

VS= 2.101

GS= 2.502

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.785	.689	.629
MINIMUM X	-.573	-.486	-.419
MAXIMUM Y	.868	.731	.622
MINIMUM Y	-1.233	-.979	-.888
CENTROID X	-.081	-.168	-.108
CENTROID Y	.071	.208	.117
POA TO CENTROID in.	.108	.268	.159
MIN RADIUS	.410	.258	.359
MEAN RADIUS	.786	.663	.657
MAX RADIUS	1.462	1.197	1.088
HORIZONTAL SPREAD	1.358	1.175	1.048
VERTICAL SPREAD	2.101	1.710	1.510
EXTREME SPREAD	2.502	2.075	1.682
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		