

C6587586

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

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

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

Remington[®]

MODEL 700[™] H24

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

SERIAL NO.
C6587586

ORDER NO.
5716

UPC

0 4700 25716

5716 C6587586

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587586

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		11-7-91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	GL
617	Drill and Tap Sight Holes	1 10	91	LB
618	Polish Barrel	1 10	91	LB
620	Apply Coatings (Barrel Action)		1-28-91	TH
	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		4/6/91	TH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 3/4	4 3/4	4 3/4			7/6/91	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			7/6/91	WB
	H) Trigger Pull Test & Retainability						2/6/91	MF
	I) Firing Pin Indent	.0225	.0215	.022			7/6/91	WB
	J) Assemble Stock						2/7/91	RW
	K) Assemble Swivel Studs						2-21-91	AE
	L) Attach Front and Rear Sight Assemblies						2/7/91	RW
	M) Iron Sight Alignment						2/7/91	RW
	N) Detach Front & Rear Sights & place in numbered container						2/7/91	RW
	O) Attach Scope to Rifle						2/7/91	RW
	P) Detach & Attach Scope 20 Times						2/7/91	RW
640	Gallery Target & Test						2-8-91	MF
	A) Time						"	MF
	B) Malfunctions						"	MF
	C) Pierced Primers						"	MF
	D) Optical Clarity of Scope						"	MF
645	Inspect for Live Ammo						2-8-91	MF
655	Final Inspection						2-21-91	AE
	A) Headspace						7/19/91	WB
	B) Trigger Pull	2.42	2.37	2.31	2.50	2.53	7/19/91	WB
	C) Function						2-21-91	AE
660	Pack						2-18-91	MF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6587586

DATE 2/2/91

TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.27	2.35	2.30	2.42	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.37	2.35	2.31	2.37	
PULL #3	2.39	2.30	2.30	2.31	
PULL #4	2.32	2.41	2.39	2.50	
PULL #5	2.35	2.31	2.29	2.53	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.37	3.21		
PULL #2	3.31	3.23		
PULL #3	3.31	3.20		
PULL #4	3.18	3.30		
PULL #5	3.17	3.37		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.34	4.30		4.20
PULL #2	4.32	4.34		4.18
PULL #3	4.33	4.35		4.21
PULL #4	4.35	4.20		4.45
PULL #5	4.28	4.36		4.47
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587586
9 Feb 1991

CENTROIDAL DISTANCES

Ø TO	1	.198849
1 TO	2	.353842
1 TO	3	.116417
1 TO	4	.603511
1 TO	5	.236755

$\bar{x} = .0396$
 $\bar{y} = .1568$
4 <----POA

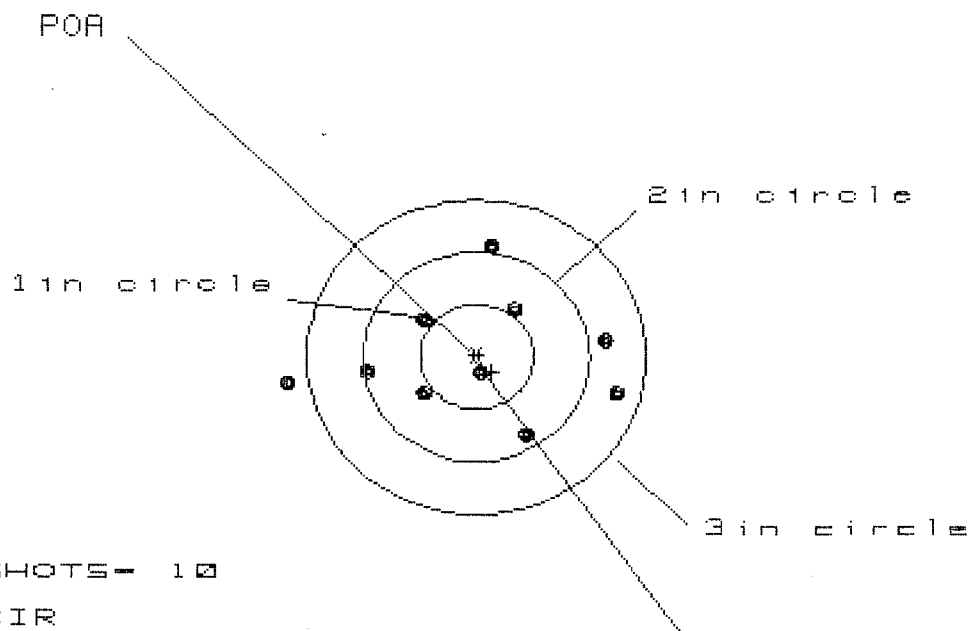
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0396
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1568
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .161723

THE AMR FOR THIS RIFLE IS: 1.05

9 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6587586

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 2.929

VS= 1.756

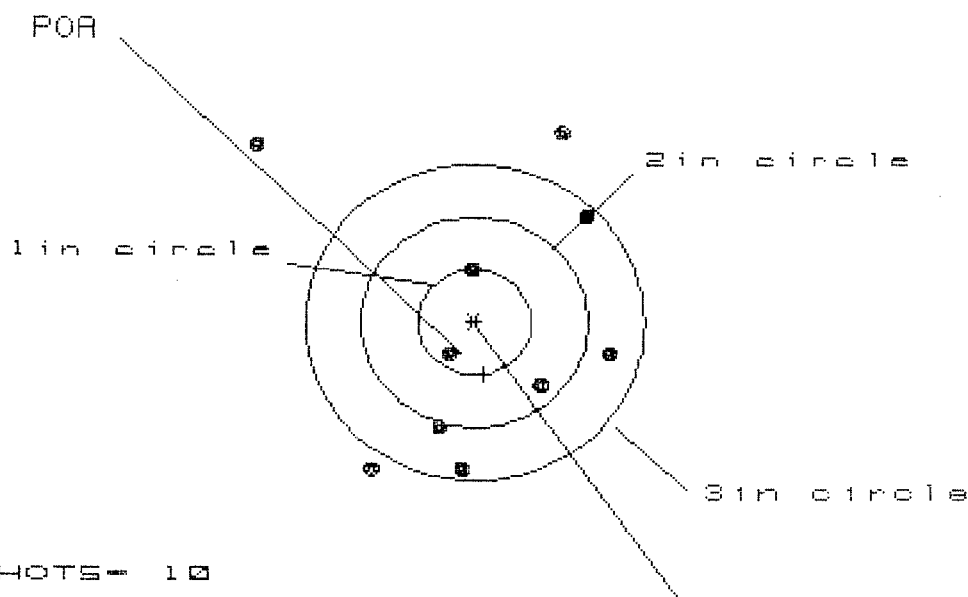
GS= 2.931

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.269	1.084	1.092
MINIMUM X	-1.660	-1.116	-.980
MAXIMUM Y	1.003	.977	.931
MINIMUM Y	-.752	-.779	-.825
CENTROID X	-.135	.050	-.086
CENTROID Y	.146	.173	.219
POA TO CENTROID in.	.199	.180	.235
MIN RADIUS	.142	.185	.196
MEAN RADIUS	.882	.792	.732
MAX RADIUS	1.678	1.144	1.095
HORIZONTAL SPREAD	2.929	2.200	2.072
VERTICAL SPREAD	1.756	1.756	1.756
EXTREME SPREAD	2.931	2.205	2.101
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 7

HS= 3.092

VS= 3.193

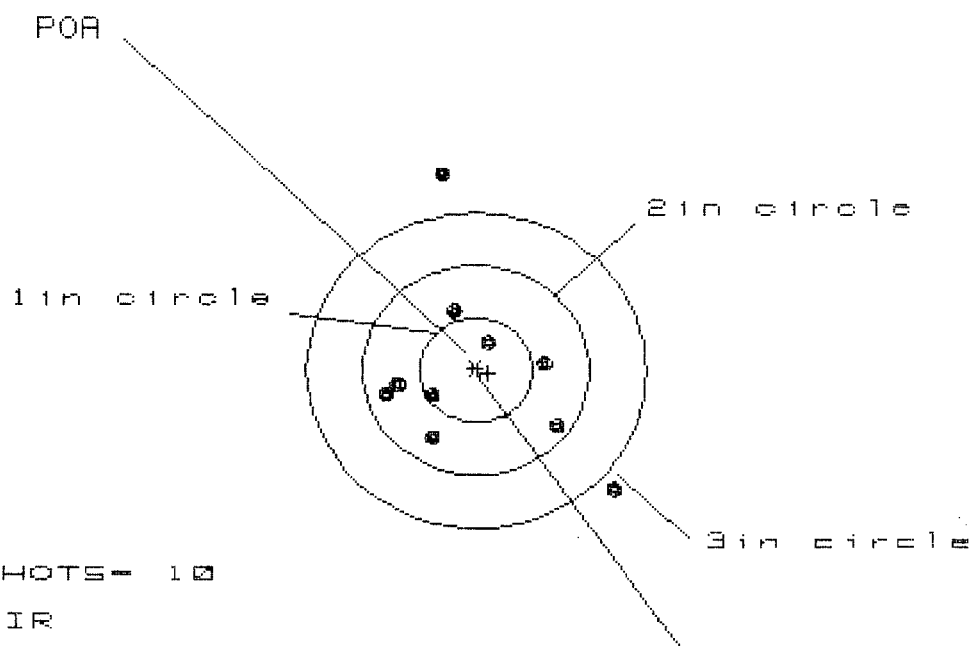
GS= 3.695

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.209	.999	1.071
MINIMUM X	:	-1.883	-1.167	-1.095
MAXIMUM Y	:	1.764	1.953	1.457
MINIMUM Y	:	-1.429	-1.240	-.996
CENTROID X	:	-.083	.127	.055
CENTROID Y	:	.496	.307	.063
POA TO CENTROID in.	:	.503	.332	.084
MIN RADIUS	:	.360	.458	.415
MEAN RADIUS	:	1.304	1.132	.979
MAX RADIUS	:	2.537	2.034	1.678
HORIZONTAL SPREAD	:	3.092	2.166	2.166
VERTICAL SPREAD	:	3.193	3.193	2.453
EXTREME SPREAD	:	3.695	3.592	3.082
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 8

3in = 8

HS= 2.019

VS= 3.081

GS= 3.416

CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.210	1.180	.792
MINIMUM X	:	-.809	-.839	-.692
MAXIMUM Y	:	1.987	.797	.677
MINIMUM Y	:	-1.174	-.962	-.495
CENTROID X	:	-.107	-.077	-.225
CENTROID Y	:	.033	-.179	-.059
POA TO CENTROID in.	:	.111	.195	.232
MIN RADIUS	:	.271	.384	.271
MEAN RADIUS	:	.860	.741	.604
MAX RADIUS	:	1.926	1.522	.898
HORIZONTAL SPREAD	:	2.019	2.019	1.484
VERTICAL SPREAD	:	3.081	1.759	1.172
EXTREME SPREAD	:	3.416	2.234	1.513
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			8	

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CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS= 1.993

VS= 3.214

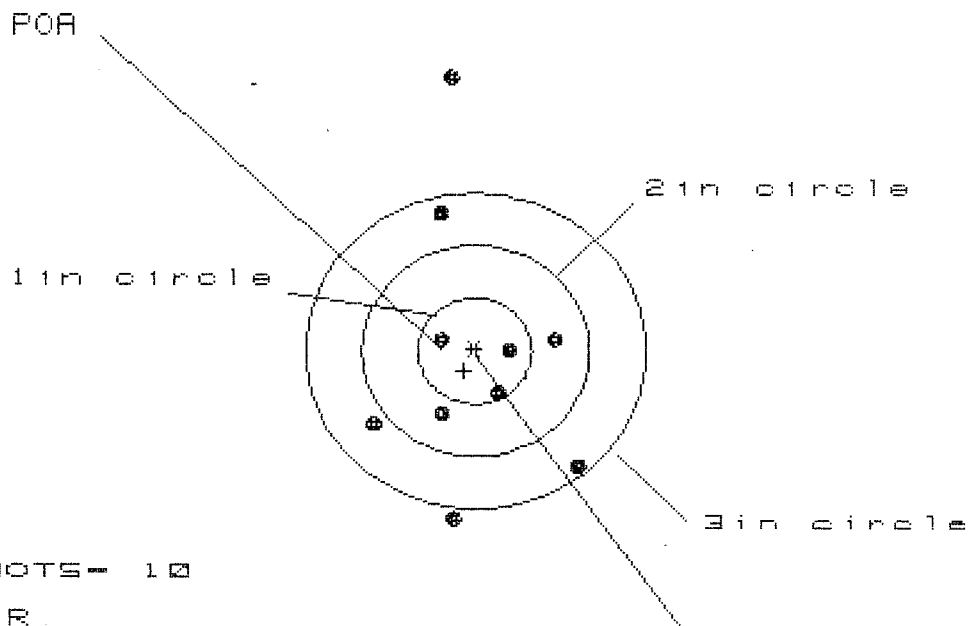
GS= 3.226

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.083	1.077	.802
MINIMUM X	:	-.910	-.789	-.654
MAXIMUM Y	:	1.931	1.705	1.572
MINIMUM Y	:	-1.283	-1.069	-1.060
CENTROID X	:	.425	.304	.169
CENTROID Y	:	-.079	-.293	-.160
POA TO CENTROID in.	:	.432	.423	.233
MIN RADIUS	:	.279	.481	.357
MEAN RADIUS	:	1.152	1.001	.908
MAX RADIUS	:	2.214	1.706	1.576
HORIZONTAL SPREAD	:	1.993	1.866	1.457
VERTICAL SPREAD	:	3.214	2.774	2.632
EXTREME SPREAD	:	3.226	2.984	2.721
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 5

3 in = 8

HS = 1.877

VS = 4.214

GS = 4.214

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.933	.913	.883
MINIMUM X	:	-.944	-.964	-.994
MAXIMUM Y	:	2.645	1.559	1.480
MINIMUM Y	:	-1.569	-1.276	-.937
CENTROID X	:	.098	.118	.148
CENTROID Y	:	.188	-.105	.054
POA TO CENTROID in.	:	.212	.158	.157
MIN RADIUS	:	.313	.217	.298
MEAN RADIUS	:	1.053	.836	.770
MAX RADIUS	:	2.651	1.597	1.449
HORIZONTAL SPREAD	:	1.877	1.877	1.877
VERTICAL SPREAD	:	4.214	2.835	2.337
EXTREME SPREAD	:	4.214	2.837	2.653
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	