

C6587636

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington®

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

DU PONT

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

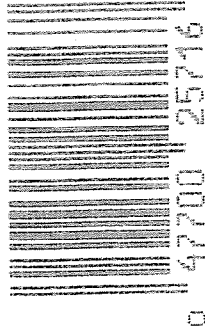
MODEL 700™ H24

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

SERIAL NO.
C6587606

ORDER NO.
5716

LPC



5716 C6587606

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587636

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1024	90	RW
600	Proof	1024	90	RW
607	Check Headspace	1024	90	RW
610	Dis-assemble Gun	1024	90	RW
612	Magnaflux Barrel Action		12/30/90	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	JS
617	Drill and Tap Sight Holes		11/5/90	FB
618	Polish Barrel AB		11/6/90	WB
620	Apply Coatings (Barrel Action)		1-28-90	TH
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		12/12/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/12/90	RW
	C) Inspect Ejector Hole for Chamfer		12/12/90	RW
	D) Oil Firing Pin Ass'y		12/12/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		1-3-91	TH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			1/3/91	WB
	G) Safety Off Force	2	2	2			1/3/91	WB
	H) Trigger Pull Test & Retainability						1-3-91	DH
	I) Firing Pin Indent	1.022	1.022	1.022			1/3/91	WB
	J) Assemble Stock						1/4/91	RW
	K) Assemble Swivel Studs						1-14-91	JH
	L) Attach Front and Rear Sight Assemblies						1/4/91	RW
	M) Iron Sight Alignment						1-14-91	RW
	N) Detach Front & Rear Sights & place in numbered container						1/4/91	RW
	O) Attach Scope to Rifle						1/4/91	RW
	P) Detach & Attach Scope 20 Times						1/4/91	RW
640	Gallery Target & Test						1/11/91	KJ
	A) Time							KJ
	B) Malfunctions							KJ
	C) Pierced Primers							KJ
	D) Optical Clarity of Scope							KJ
645	Inspect for Live Ammo						1/11/91	KJ
655	Final Inspection							
	A) Headspace						1-14-91	JH
	B) Trigger Pull	2.05	2.10	2.11	2.11	2.11	1-14-91	JH
	C) Function						1-14-91	JH
660	Pack						3-19-91	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. CG587636

DATE 1-3-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.49	2.45	2.51	2.05	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.49	2.36	2.57	2.10	
PULL #3	2.45	2.25	2.60	2.11	
PULL #4	2.47	2.48	2.55	2.11	
PULL #5	2.40	2.34	2.56	2.11	
TOTAL	12.30	12.88	12.79		
AVG.	2.46	2.51	2.55		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.10	3.20		
PULL #2	3.20	3.21		
PULL #3	3.06	3.12		
PULL #4	3.27	3.03		
PULL #5	3.21	3.01		
TOTAL	15.84	15.57		
AVG.	3.16	3.11		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.41	4.79		4.11
PULL #2	4.21	4.36		4.11
PULL #3	4.28	4.18		4.15
PULL #4	4.25	4.11		4.11
PULL #5	4.16	4.25		4.02
TOTAL	21.31	21.09		20.50
AVG.	4.26	4.21		4.10

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587636
11 Jan 1991

CENTROIDAL DISTANCES

0 TO	1	.171747
1 TO	2	.1014
1 TO	3	.273247
1 TO	4	.0440454
1 TO	5	.344023

20 <----POA

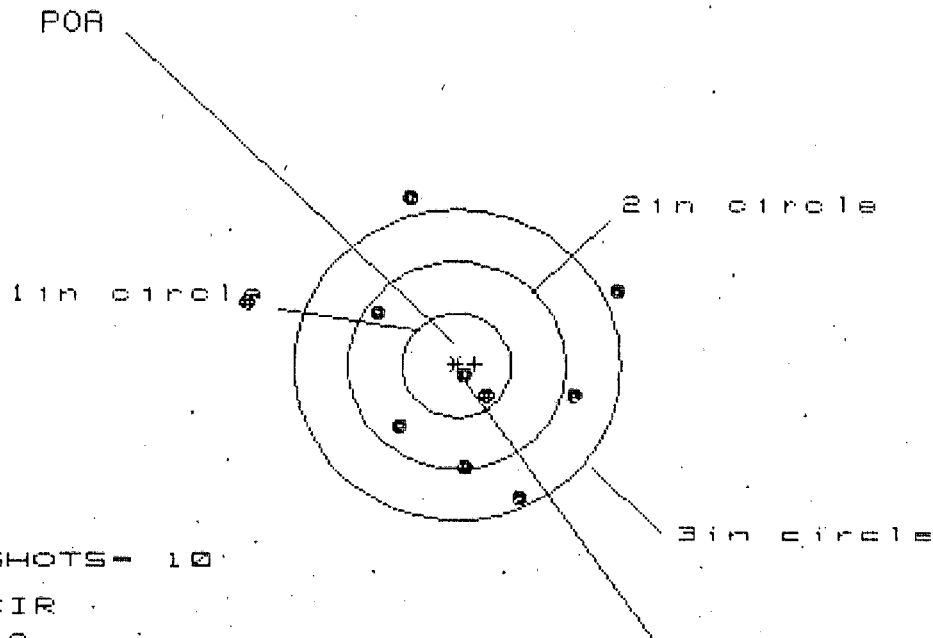
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0396
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.023
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0457948

THE AMR FOR THIS RIFLE IS: 1.14

11 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6587636

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 7

HS= 3.338

VS= 2.853

GS= 3.340

PATTERN #

1

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.453

1.243

1.161

MINIMUM X

-1.885

-0.967

-1.049

MAXIMUM Y

1.570

1.638

1.001

MINIMUM Y

-1.283

-1.215

-1.010

CENTROID X

-0.171

0.039

0.121

CENTROID Y

-0.016

-0.084

-0.289

POA TO CENTROID in.

0.171

0.093

0.313

MIN RADIUS

0.060

0.186

0.027

MEAN RADIUS

1.091

0.974

0.830

MAX RADIUS

1.982

1.766

1.533

HORIZONTAL SPREAD

3.338

2.210

2.210

VERTICAL SPREAD

2.853

2.853

2.011

EXTREME SPREAD

3.340

3.040

2.313

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

5

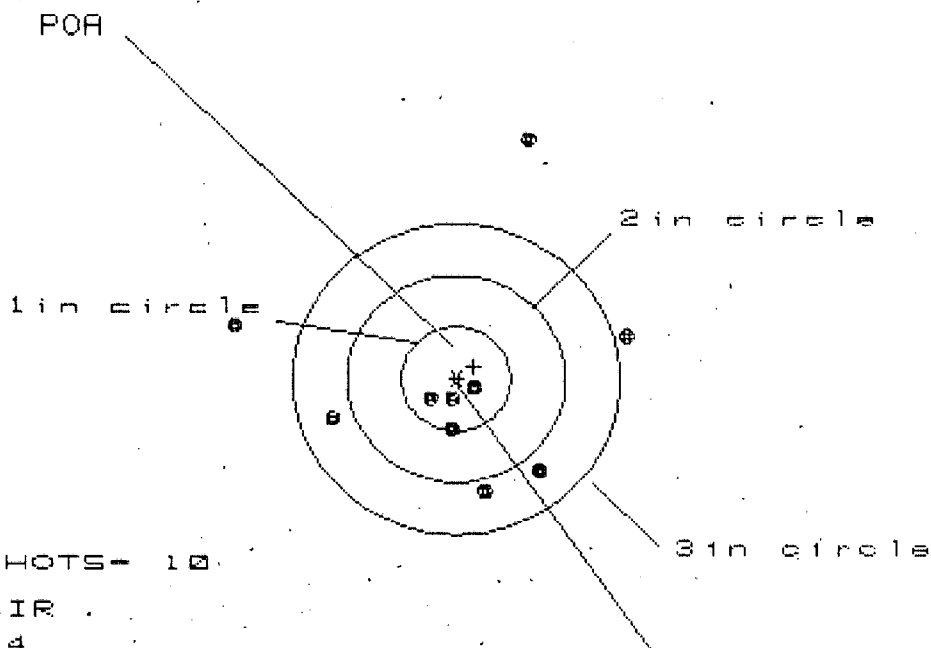
NUMBER IN THREE INCH CIRCLE =

7

11 Jan 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR .

1 in = 4

2 in = 4

3 in = 7

HS= 3.596

VS= 3.355

GS= 3.597

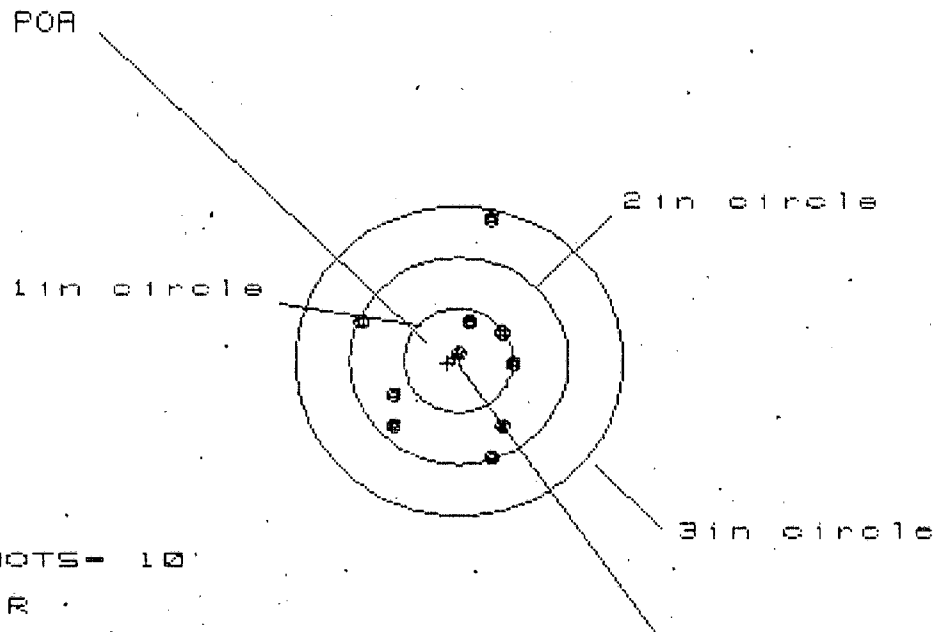
CENTROID #

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.556	1.633	1.387
MINIMUM X	-2.040	-1.963	-1.293
MAXIMUM Y	2.299	.762	.775
MINIMUM Y	-1.056	-.801	-.706
CENTROID X	-.162	-.239	.006
CENTROID Y	-.117	-.373	-.468
POA TO CENTROID in.	.200	.443	.468
MIN RADIUS	.207	.088	.212
MEAN RADIUS	1.065	.836	.678
MAX RADIUS	2.401	2.106	1.589
HORIZONTAL SPREAD	3.596	3.596	2.681
VERTICAL SPREAD	3.355	1.563	1.481
EXTREME SPREAD	3.597	3.597	2.797
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 9

3in = 10

HS= 1.401

VS= 2.252

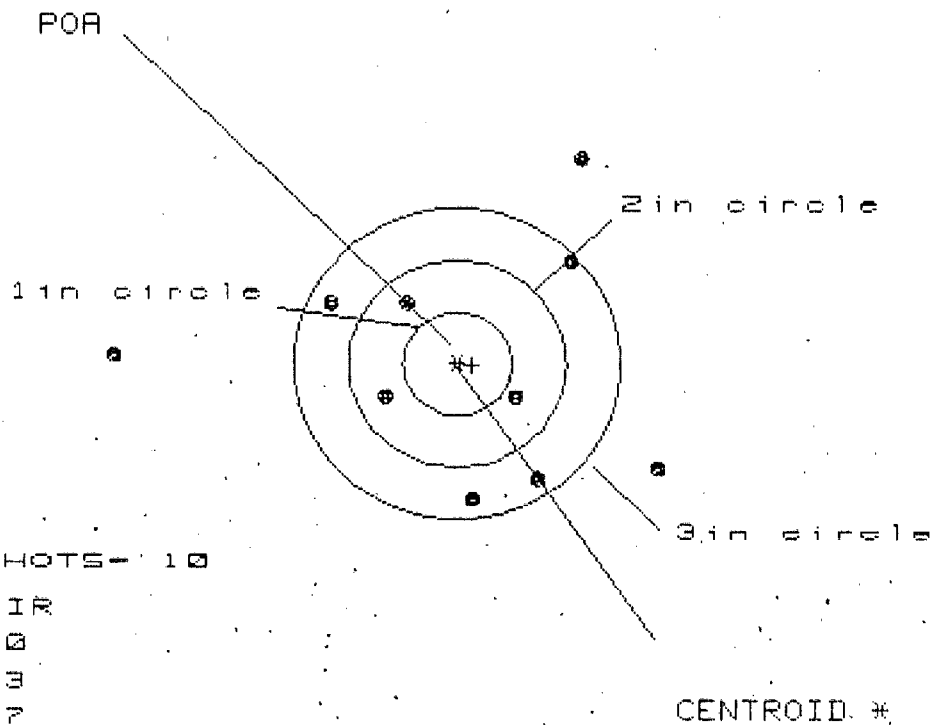
GS= 2.253

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	.530
MINIMUM X	-.871
MAXIMUM Y	1.372
MINIMUM Y	-.880
CENTROID X	.099
CENTROID Y	.026
POA TO CENTROID in.	.102
MIN RADIUS	.041
MEAN RADIUS	.709
MAX RADIUS	1.413
HORIZONTAL SPREAD	1.401
VERTICAL SPREAD	2.252
EXTREME SPREAD	2.253
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	9
NUMBER IN THREE INCH CIRCLE =	10

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 0

2in = 3

3in = 7

HS= 5.003

VS= 3.281

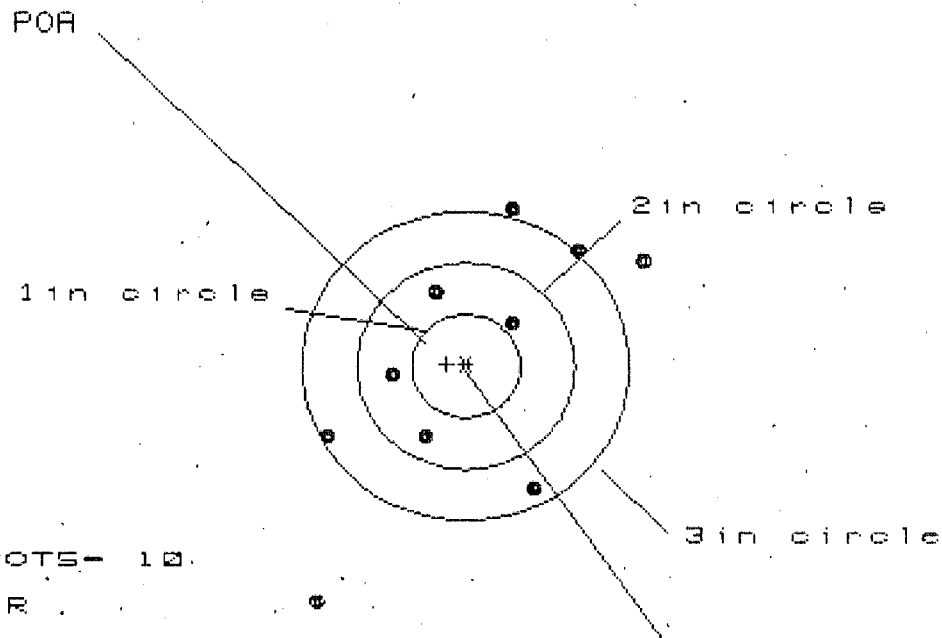
GS= 5.126

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.805	1.450	1.547
MINIMUM X	:	-3.198	-1.548	-1.451
MAXIMUM Y	:	1.938	1.952	1.234
MINIMUM Y	:	-1.343	-1.329	-1.085
CENTROID X	:	-.137	.218	.121
CENTROID Y	:	.012	-.002	-.246
POA TO CENTROID in.	:	.138	.218	.274
MIN RADIUS	:	.631	.378	.282
MEAN RADIUS	:	1.502	1.292	1.147
MAX RADIUS	:	3.200	2.102	1.713
HORIZONTAL SPREAD	:	5.003	2.998	2.998
VERTICAL SPREAD	:	3.281	3.281	2.319
EXTREME SPREAD	:	5.126	3.427	3.383
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 6

HS= 3.043

VS= 3.810

GS= 4.444

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.624	1.466	1.044
MINIMUM X	-1.419	-1.411	-1.227
MAXIMUM Y	1.557	1.307	1.399
MINIMUM Y	-2.253	-1.477	-1.385
CENTROID X	.173	.331	.147
CENTROID Y	-.020	.230	.138
POA TO CENTROID in.	.174	.403	.202
MIN RADIUS	.609	.325	.529
MEAN RADIUS	1.333	1.152	1.080
MAX RADIUS	2.662	1.664	1.528
HORIZONTAL SPREAD	3.043	2.877	2.271
VERTICAL SPREAD	3.810	2.784	2.784
EXTREME SPREAD	4.444	3.301	2.859
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	6		