

C6587737

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6587737DATE 3/22/96TESTER SF

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.80	2.84		2.83	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.78	2.60		2.94	
PULL #3	2.81	2.71		2.72	
PULL #4	2.84	2.70		2.74	
PULL #5	2.84	2.68		2.85	
TOTAL	14.02	13.53		14.08	
AVG.	2.804	2.706		2.816	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.02	3.00		
PULL #2	3.10	2.81		
PULL #3	2.97	2.99		
PULL #4	3.11	2.92		
PULL #5	3.10	2.90		
TOTAL	15.3	14.62		
AVG.	3.06	2.924		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	3.97	3.93		3.95
PULL #2	4.03	4.01		4.25
PULL #3	4.05	3.97		4.41
PULL #4	3.88	4.03		4.44
PULL #5	4.12	4.02		4.30
TOTAL	20.05	19.96		21.35
AVG.	4.01	3.992		4.27

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587737
5 Feb 1988

CENTROIDAL DISTANCES

0 TO	1	.789231
1 TO	2	.249898
1 TO	3	.311362
1 TO	4	.610764
1 TO	5	.334773

$\begin{matrix} 5_1 \\ 2_1 \\ 3_1 \\ 4_1 \end{matrix}$ <----POA

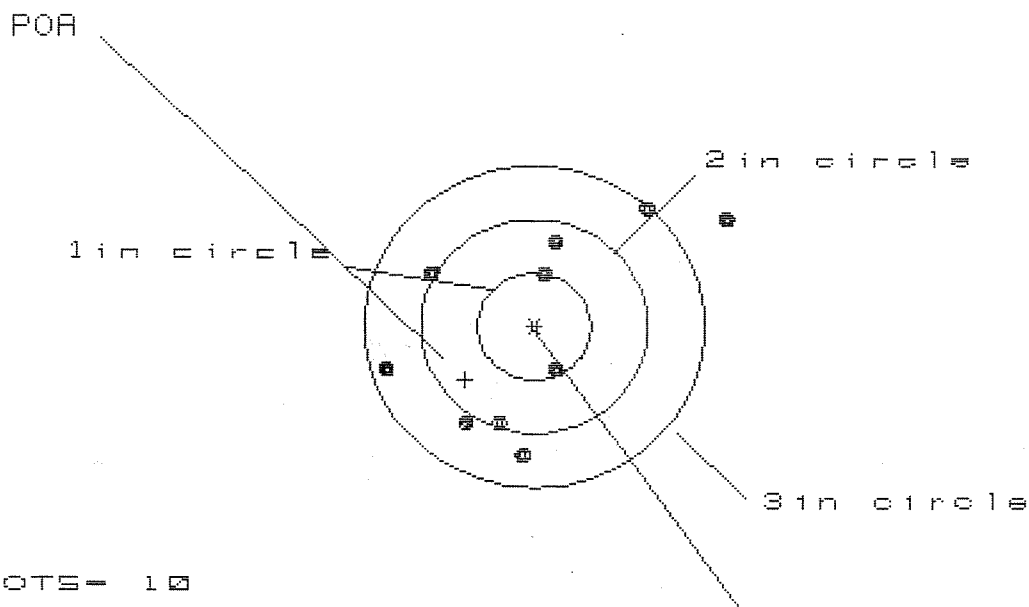
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .4564
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .338
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .56793
THE AMR FOR THIS RIFLE IS: 1.031

5 Feb 1900

FILE:/PATTERNING/CENTERFIRE_PATT/08587737

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 9

HS= 2.957

VS= 2.221

GS= 3.269

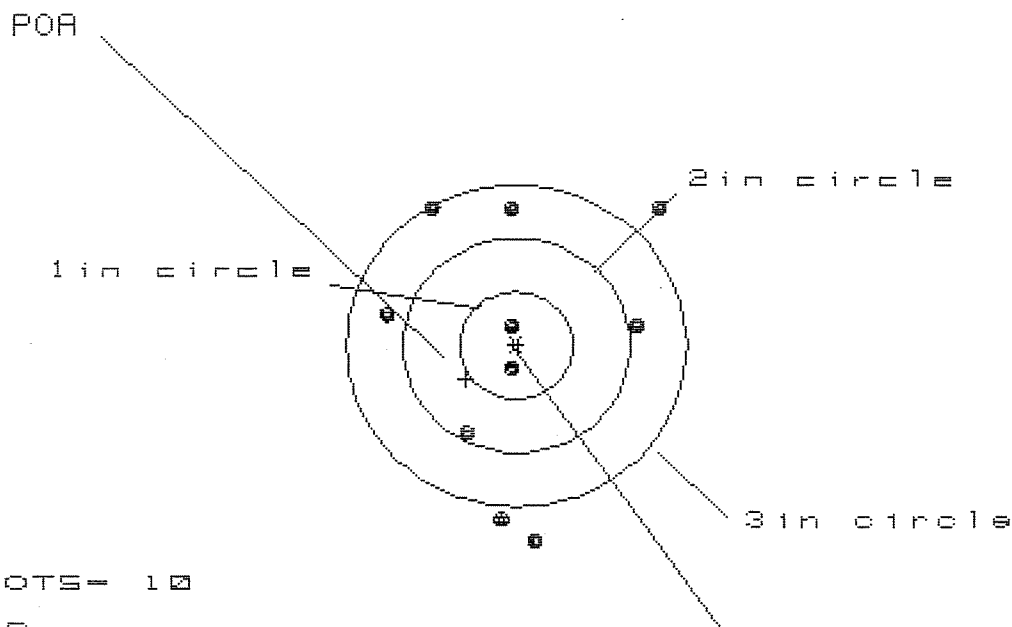
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.673	1.214	.572
MINIMUM X	:	-1.284	-1.098	-.947
MAXIMUM Y	:	1.057	1.164	1.000
MINIMUM Y	:	-1.164	-1.057	-.912
CENTROID X	:	.609	.423	.272
CENTROID Y	:	.502	.395	.250
POA TO CENTROID in.	:	.789	.579	.369
MIN RADIUS	:	.469	.510	.582
MEAN RADIUS	:	1.074	.959	.847
MAX RADIUS	:	1.930	1.681	1.152
HORIZONTAL SPREAD	:	2.957	2.312	1.519
VERTICAL SPREAD	:	2.221	2.221	1.912
EXTREME SPREAD	:	3.269	2.749	1.943
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	9		

5 Feb 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06587737

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 3

3 in = 7

HS= 2.365

VS= 3.102

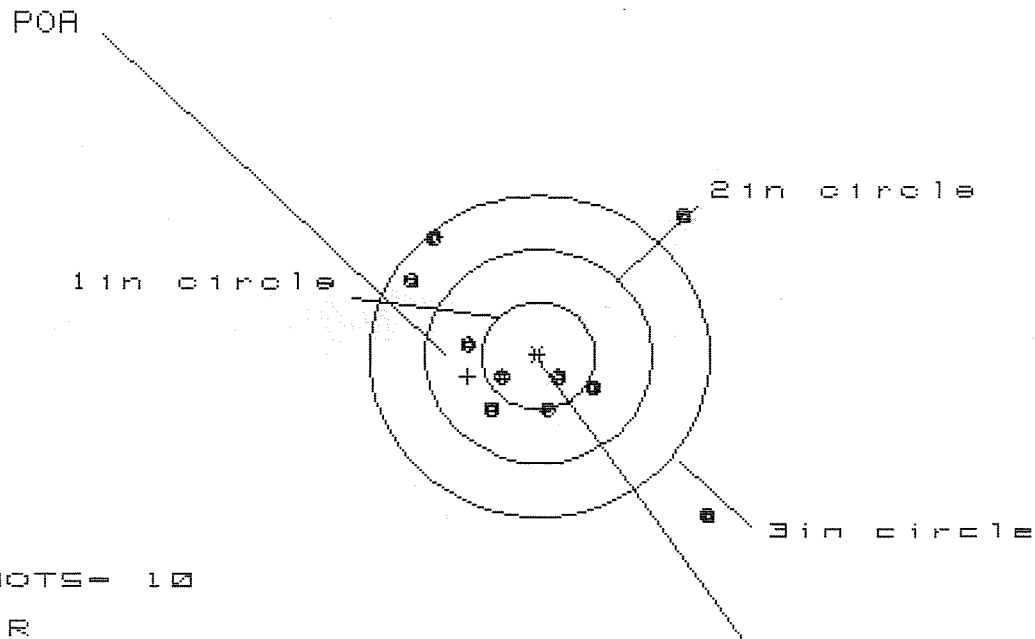
GS= 3.224

PATTERN #	:	2	3	8
SHOTS (BEST OF)	:	10	8	8
MAXIMUM X	:	1.239	1.259	1.265
MINIMUM X	:	-1.126	-1.106	-.948
MAXIMUM Y	:	1.327	1.130	1.263
MINIMUM Y	:	-1.775	-1.816	-1.683
CENTROID X	:	.441	.421	.263
CENTROID Y	:	.317	.514	.381
POA TO CENTROID in.	:	.543	.664	.463
MIN RADIUS	:	.176	.022	.194
MEAN RADIUS	:	1.157	1.072	.993
MAX RADIUS	:	1.784	1.818	1.685
HORIZONTAL SPREAD	:	2.365	2.365	2.213
VERTICAL SPREAD	:	3.102	2.946	2.946
EXTREME SPREAD	:	3.224	3.178	3.085
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	3		
NUMBER IN THREE INCH CIRCLE	=	7		

5 Feb 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08587737

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 3

2in = 6

3in = 8

HS= 2.597

VS= 2.859

GS= 3.562

CENTROID #

PATTERN #	:	10	8
SHOTS (BEST OF)	:	10	8
MAXIMUM X	:	1.428	.839
MINIMUM X	:	-1.163	-.825
MAXIMUM Y	:	1.336	1.084
MINIMUM Y	:	-1.523	-.536
CENTROID X	:	.624	.286
CENTROID Y	:	.191	.215
POA TO CENTROID in.	:	.652	.358
MIN RADIUS	:	.283	.196
MEAN RADIUS	:	.974	.679
MAX RADIUS	:	2.092	1.253
HORIZONTAL SPREAD	:	2.597	1.664
VERTICAL SPREAD	:	2.859	1.620
EXTREME SPREAD	:	3.562	2.056
NUMBER IN ONE INCH CIRCLE	=	3	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	8	

5 Feb 1908

FILE:/PATTERNING/CENTERFIRE_PATT/C6587737

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 2

3 in = 8

HS- 2.726

VS- 3.836

GS- 3.837

CENTROID #

PATTERN #

SHOTS (BEST OF)

MAXIMUM X

MINIMUM X

MAXIMUM Y

MINIMUM Y

CENTROID X

CENTROID Y

POA TO CENTROID in.

MIN RADIUS

MEAN RADIUS

MAX RADIUS

HORIZONTAL SPREAD

VERTICAL SPREAD

EXTREME SPREAD

NUMBER IN ONE INCH CIRCLE =

NUMBER IN TWO INCH CIRCLE =

NUMBER IN THREE INCH CIRCLE =

8

1.523

-1.203

1.355

-1.013

.148

.037

.153

.513

1.079

1.576

2.726

2.368

2.915

1

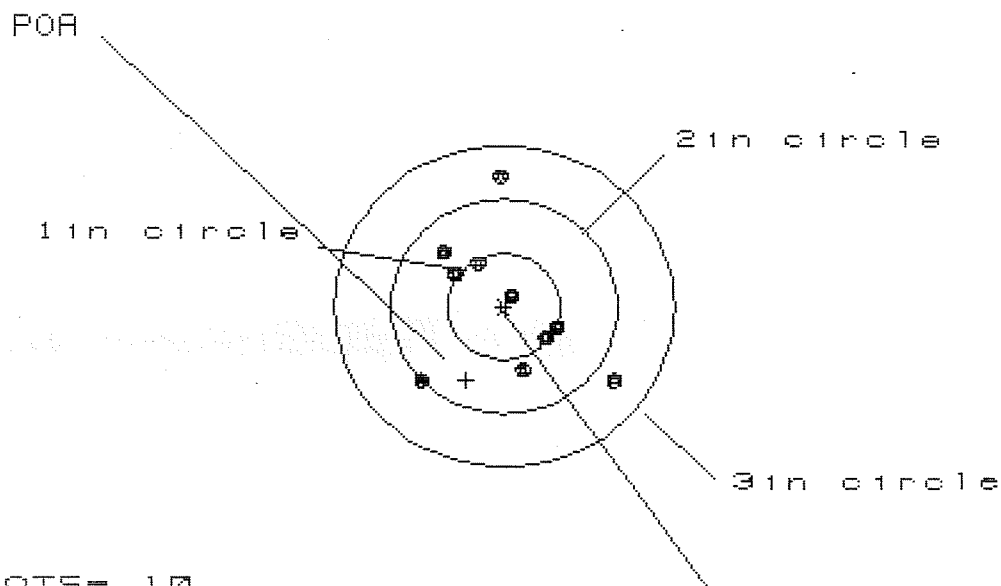
2

8

5 Feb 1900

FILE:/PATTERNING/CENTERFIRE_PATT/C6587737

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 10

CENTROID *

HS= 1.705

VS= 1.931

GS= 2.192

PATTERN #	:	:	:
SHOTS (BEST OF)	:	:	8
MAXIMUM X	:	1.201	.594
MINIMUM X	:	-.730	-.625
MAXIMUM Y	:	1.201	.532
MINIMUM Y	:	-.730	-.645
CENTROID X	:	.332	.219
CENTROID Y	:	.690	.631
POA TO CENTROID in.	:	.765	.668
MIN RADIUS	:	.124	.250
MEAN RADIUS	:	.679	.555
MAX RADIUS	:	1.212	.898
HORIZONTAL SPREAD	:	1.705	1.219
VERTICAL SPREAD	:	1.931	1.177
EXTREME SPREAD	:	2.192	1.340
NUMBER IN ONE INCH CIRCLE	=	3	
NUMBER IN TWO INCH CIRCLE	=	7	
NUMBER IN THREE INCH CIRCLE	=	10	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6587737

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 1/2	7 1/4	7 1/2			5/6/96	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			5/6/96	WB
	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	2.74	2.82	2.76	2.77	2.79	4/18/96	WB
	C) Function							
660	Pack							

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



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

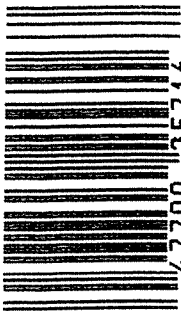
MODEL 700TM H24

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

SERIAL NO.
C6587737

ORDER NO.
5716

UPC



0 47700 25716 7



5716 C6587737

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6587737

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1019	90	Rw
600	Proof	1019	90	Rw
607	Check Headspace	1019	90	Rw
610	Dis-assemble Gun	1019	90	Rw
612	Magnaflux Barrel Action		10/23/90	KR
	Magnaflux Bolt		10/23/90	KR
615	Rollmark Caliber		10/23/90	GL
617	Drill and Tap Sight Holes		10/26/90	WB
618	Polish Barrel <i>RB</i>		10/29/90	WB
620	Apply Coatings (Barrel Action)		11-7-90	<i>TJ</i>
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		11/12/90	Rw
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/12/90	Rw
	C) Inspect Ejector Hole for Chamfer		11/12/90	Rw
	D) Oil Firing Pin Ass'y		11/12/90	Rw
	E) Adjust Trigger Pull to Min Setting and Stake		11/27/90	<i>HL</i>

op. #	OP. NAME	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	4	4	4	11/27/90	WB		
	G) Safety Off Force	3	3	3	11/27/90	WB		
	H) Trigger Pull Test & Retainability				11/27/90	JL		
	I) Firing Pin Indent	.023	.0235	.0235	11/27/90	WB		
	J) Assemble Stock				11/27/90	RW		
	K) Assemble Swivel Studs				11-29-90	JL		
	L) Attach Front and Rear Sight Assemblies				11/27/90	RW		
	M) Iron Sight Alignment				11/27/90	RW		
	N) Detach Front & Rear Sights & place in numbered container				11/27/90	RW		
	O) Attach Scope to Rifle				11/27/90	RW		
	P) Detach & Attach Scope 20 Times				11/27/90	RW		
640	Gallery Target & Test				11-28-90	DH		
	A) Time				11-28-90	DH		
	B) Malfunctions				11-28-90	DH		
	C) Pierced Primers				11-28-90	DH		
	D) Optical Clarity of Scope				11-28-90	DH		
645	Inspect for Live Ammo				11-28-90	DH		
655	Final Inspection							
	A) Headspace				11-29-90	JL		
	B) Trigger Pull	260	266	281	287	281	11-29-90	JL
	C) Function						11-29-90	JL
660	Pack						12/19/90	VF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. 06587737

DATE 11/27/90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.32	2.25	2.45	2.60	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.30	2.22	2.47	2.66	
PULL #3	2.30	2.20	2.32	2.81	
PULL #4	2.31	2.47	2.30	2.87	
PULL #5	2.35	2.41	2.25	2.81	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.39	3.12		
PULL #2	3.33	3.28		
PULL #3	3.43	3.36		
PULL #4	3.50	3.15		
PULL #5	3.23	3.31		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.31	4.24		4.24
PULL #2	4.39	4.27		4.21
PULL #3	4.39	4.22		4.22
PULL #4	4.28	4.22		4.24
PULL #5	4.31	4.17		4.19
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587737
28 Nov 1990

CENTROIDAL DISTANCES

0 TO 1	.146492
1 TO 2	.093145
1 TO 3	.380296
1 TO 4	.0403113
1 TO 5	.576428

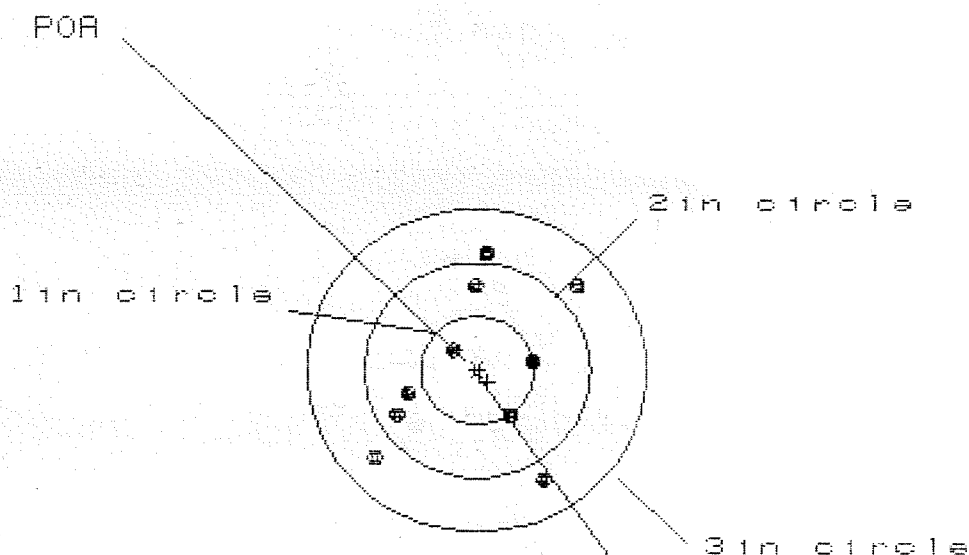
←----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0198
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0544
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0578913
THE AMR FOR THIS RIFLE IS: .8942

28 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08587737

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 10

HS= 1.741

VS= 2.158

GS= 2.320

CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.851	.919	.817
MINIMUM X	:	-.890	-.822	-.715
MAXIMUM Y	:	1.129	1.014	.901
MINIMUM Y	:	-1.029	-.907	-.671
CENTROID X	:	-.092	-.160	-.058
CENTROID Y	:	.114	.229	.342
POA TO CENTROID in.	:	.147	.279	.347
MIN RADIUS	:	.242	.118	.215
MEAN RADIUS	:	.812	.756	.697
MAX RADIUS	:	1.199	1.224	.965
HORIZONTAL SPREAD	:	1.741	1.741	1.532
VERTICAL SPREAD	:	2.158	1.921	1.572
EXTREME SPREAD	:	2.320	2.320	1.921
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	10		

28 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8587737

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 2

2 in = 8

3 in = 9

HS= 1.919

VS= 2.469

CS= 2.847

CENTROID #

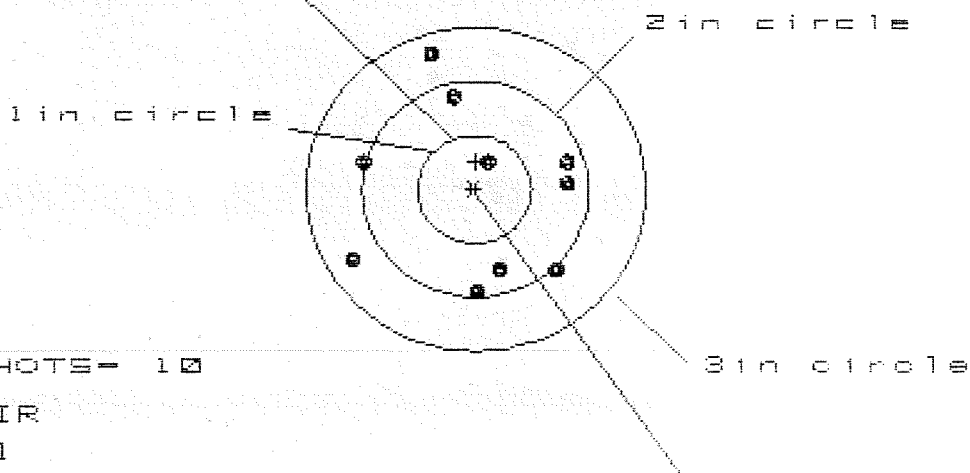
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.123	1.054	1.022
MINIMUM X	:	-.796	-.865	-.734
MAXIMUM Y	:	.877	.701	.760
MINIMUM Y	:	-1.591	-.752	-.693
CENTROID X	:	-.068	.001	-.131
CENTROID Y	:	.204	.380	.321
POA TO CENTROID in.	:	.215	.380	.346
MIN RADIUS	:	.057	.166	.076
MEAN RADIUS	:	.836	.728	.650
MAX RADIUS	:	1.710	1.157	1.051
HORIZONTAL SPREAD	:	1.919	1.919	1.755
VERTICAL SPREAD	:	2.469	1.453	1.453
EXTREME SPREAD	:	2.847	2.080	1.784
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

28 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587737

CENTERFIRE PATTERNS # 3

FOR



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 6

3 in = 10

HS= 1.941

VS= 2.214

GS= 2.293

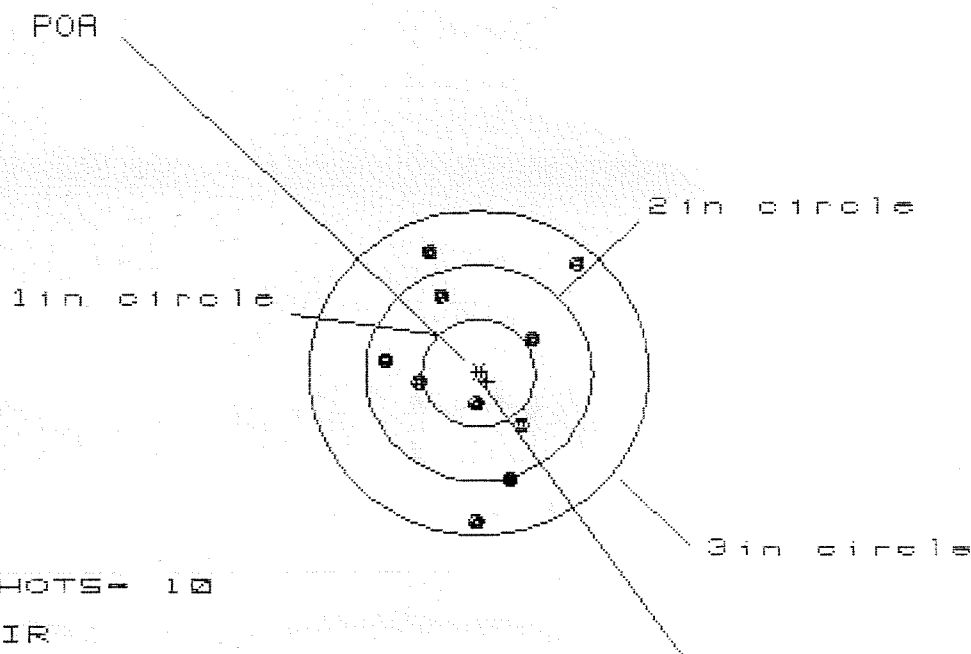
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.813	.772	.626
MINIMUM X	:	-1.128	-1.169	-1.150
MAXIMUM Y	:	1.296	1.050	.983
MINIMUM Y	:	-.918	-.774	-.841
CENTROID X	:	-.013	.028	.174
CENTROID Y	:	-.258	-.402	-.335
FOR TO CENTROID in.	:	.259	.403	.377
MIN RADIUS	:	.279	.409	.349
MEAN RADIUS	:	.931	.876	.797
MAX RADIUS	:	1.349	1.287	1.211
HORIZONTAL SPREAD	:	1.941	1.941	1.776
VERTICAL SPREAD	:	2.214	1.824	1.824
EXTREME SPREAD	:	2.293	2.163	1.978
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

28 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08587737

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 6

3 in = 10

HS= 1.714

VS= 2.496

GS= 2.534

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.907	.909	.616
MINIMUM X	:	-.807	-.805	-.692
MAXIMUM Y	:	1.117	.964	1.068
MINIMUM Y	:	-1.379	-1.159	-1.055
CENTROID X	:	-.072	-.074	-.187
CENTROID Y	:	.079	.232	.128
POA TO CENTROID in.	:	.107	.243	.227
MIN RADIUS	:	.276	.429	.337
MEAN RADIUS	:	.854	.797	.721
MAX RADIUS	:	1.379	1.231	1.135
HORIZONTAL SPREAD	:	1.714	1.714	1.308
VERTICAL SPREAD	:	2.496	2.123	2.123
EXTREME SPREAD	:	2.534	2.244	2.244
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

28 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587737

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HE= 1.901

VS= 2.377

GS= 2.882

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.982	.881	.956
MINIMUM X	:	-.919	-.810	-.735
MAXIMUM Y	:	1.055	.908	.742
MINIMUM Y	:	-1.322	-1.332	-1.056
CENTROID X	:	.146	.037	-.038
CENTROID Y	:	-.411	-.264	-.097
POA TO CENTROID in.	:	.436	.267	.105
MIN RADIUS	:	.430	.548	.566
MEAN RADIUS	:	1.038	.952	.863
MAX RADIUS	:	1.647	1.462	1.180
HORIZONTAL SPREAD	:	1.901	1.691	1.691
VERTICAL SPREAD	:	2.377	2.240	1.797
EXTREME SPREAD	:	2.882	2.500	1.951
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	