

C6523397

MODEL 700TM M24

Model SWSTM

Action

Barrel Length

Capacity

Order No. 5715

*Includes 1 in chamber.

Remington




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

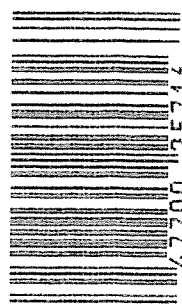
MODEL 700™ H24

SERIAL NO.
C6523397

ORDER NO.
5716

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

UPC



0 47700 25716 7



5716 C6523397

ET P.10

OK

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523397

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 24	90	RW
600	Proof	9 24	90	RW
607	Check Headspace	9 24	90	RW
610	Dis-assemble Gun	9 24	90	RW
612	Magnaflux Barrel Action		9-25-90	KR
	Magnaflux Bolt		9-20-90	KR
615	Rollmark Caliber		9-25-90	JS
617	Drill and Tap Sight Holes		9-25-90	FB
618	Polish Barrel AB		9-28-90	W/B
620	Apply Coatings (Barrel Action)		10-2-90	TS
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		10/9/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/9/90	RW
	C) Inspect Ejector Hole for Chamfer		10/9/90	RW
	D) Oil Firing Pin Ass'y		10/9/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11/1/90	JS

op. #	OP. NAME	READINGS			DATE	INIT		
625 nt.	F) Safety On Force	4	4	4	11/1/90	WB		
	G) Safety Off Force	2	2	2	11/1/90	WB		
	H) Trigger Pull Test & Retainability				11/1/90	WB		
	I) Firing Pin Indent	.0215	.022	.022	11/1/90	WB		
	J) Assemble Stock				11/2/90	RW		
	K) Assemble Swivel Studs				11/2-1-90	RW		
	L) Attach Front and Rear Sight Assemblies				11/2/90	RW		
	M) Iron Sight Alignment				11/2/90	RW		
	N) Detach Front & Rear Sights & place in numbered container				11/2/90	RW		
	O) Attach Scope to Rifle				11/2/90	RW		
	P) Detach & Attach Scope 20 Times				11/2/90	RW		
640	Gallery Target & Test				11/3/90	NF		
	A) Time				"	NF		
	B) Malfunctions				"	NF		
	C) Pierced Primers				"	NF		
	D) Optical Clarity of Scope				"	NF		
645	Inspect for Live Ammo				11/3/90	NF		
655	Final Inspection							
	A) Headspace				11-26-90	RW		
	B) Trigger Pull	241	249	257	259	258	12-1-90	RW
	C) Function						12-1-90	RW
660	Pack						12/1/90	RW

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. 06523397

DATE 11/1/90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.28	2.31	2.38	2.41	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.23	2.26	2.26	2.49	
PULL #3	2.17	2.25	2.29	2.57	
PULL #4	2.18	2.27	2.11	2.59	
PULL #5	2.15	2.20	2.34	2.58	
TOTAL	11.01	11.29	11.38		
AVG.	2.202	2.258	2.276		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.40	3.41		
PULL #2	3.42	3.33		
PULL #3	3.33	3.41		
PULL #4	3.36	3.35		
PULL #5	3.27	3.39		
TOTAL	16.78	16.89		
AVG.	3.356	3.378		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.39	4.33		4.25
PULL #2	4.30	4.30		4.17
PULL #3	4.33	4.34		4.21
PULL #4	4.34	4.35		4.22
PULL #5	4.12	4.31		4.23
TOTAL	21.48	21.63		21.08
AVG.	4.296	4.326		4.216

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523397
3 Nov 1990

CENTROIDAL DISTANCES

0 TO	1	.481715
1 TO	2	.426117
1 TO	3	.837302
1 TO	4	.334701
1 TO	5	.542672

Part
1

<----POA

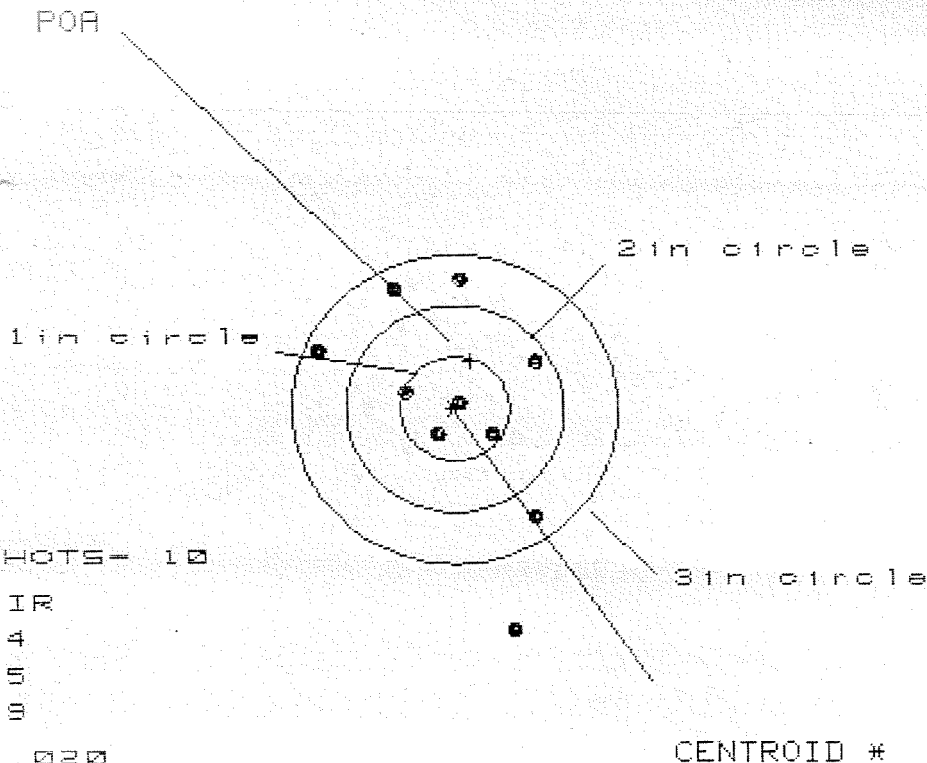
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0536
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0514
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0742625

THE AMR FOR THIS RIFLE IS: 1.05

3 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523397

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 4

2 in = 5

3 in = 9

HS= 2.020

VS= 3.461

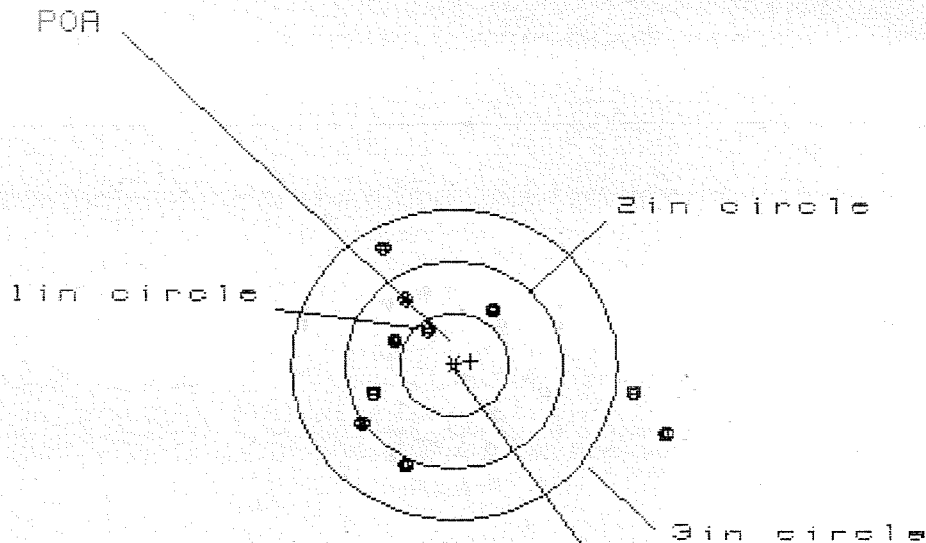
GS= 3.495

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.757	.815	.664
MINIMUM X	:	-1.263	-1.205	-.602
MAXIMUM Y	:	1.302	1.062	1.103
MINIMUM Y	:	-2.159	-1.318	-1.276
CENTROID X	:	-.143	-.201	-.050
CENTROID Y	:	-.460	-.220	-.261
POA TO CENTROID in.	:	.482	.298	.266
MIN RADIUS	:	.098	.172	.122
MEAN RADIUS	:	.966	.823	.759
MAX RADIUS	:	2.221	1.549	1.439
HORIZONTAL SPREAD	:	2.020	2.020	1.266
VERTICAL SPREAD	:	3.461	2.380	2.380
EXTREME SPREAD	:	3.495	2.608	2.549
NUMBER IN ONE INCH CIRCLE	=	4		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	9		

3 May 1998

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 2.747

VS= 2.097

GS= 3.172

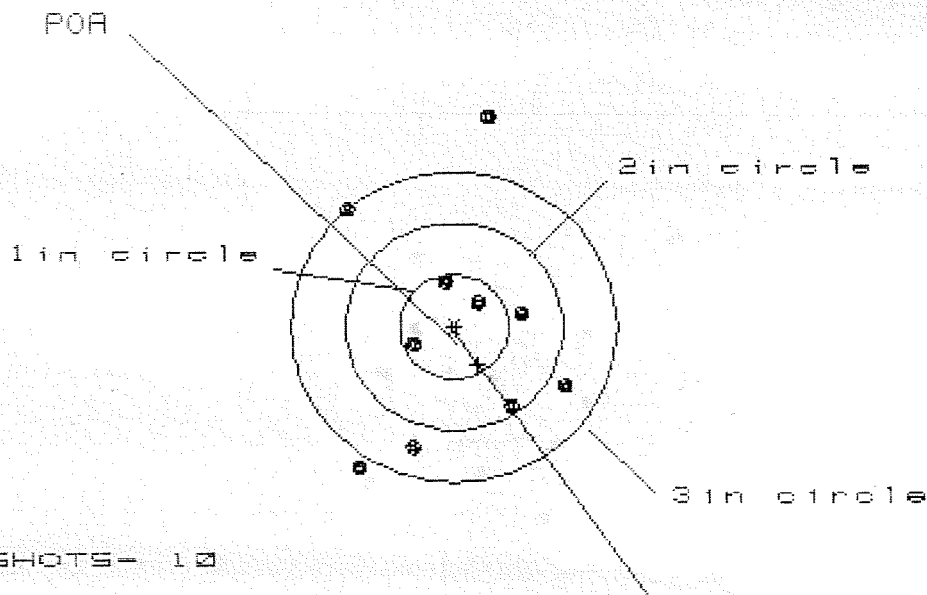
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.928	1.826	.750
MINIMUM X	:	-.819	-.605	-.376
MAXIMUM Y	:	1.124	1.047	1.008
MINIMUM Y	:	-.973	-1.050	-1.089
CENTROID X	:	-.153	-.367	-.596
CENTROID Y	:	-.034	.043	.082
POA TO CENTROID in.	:	.157	.370	.501
MIN RADIUS	:	.346	.207	.120
MEAN RADIUS	:	1.016	.827	.647
MAX RADIUS	:	2.048	1.853	1.090
HORIZONTAL SPREAD	:	2.747	2.431	1.126
VERTICAL SPREAD	:	2.097	2.097	2.097
EXTREME SPREAD	:	3.172	2.660	2.114
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

3 Nov 1998

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 8

HS= 1.930

VS= 3.395

GS= 3.591

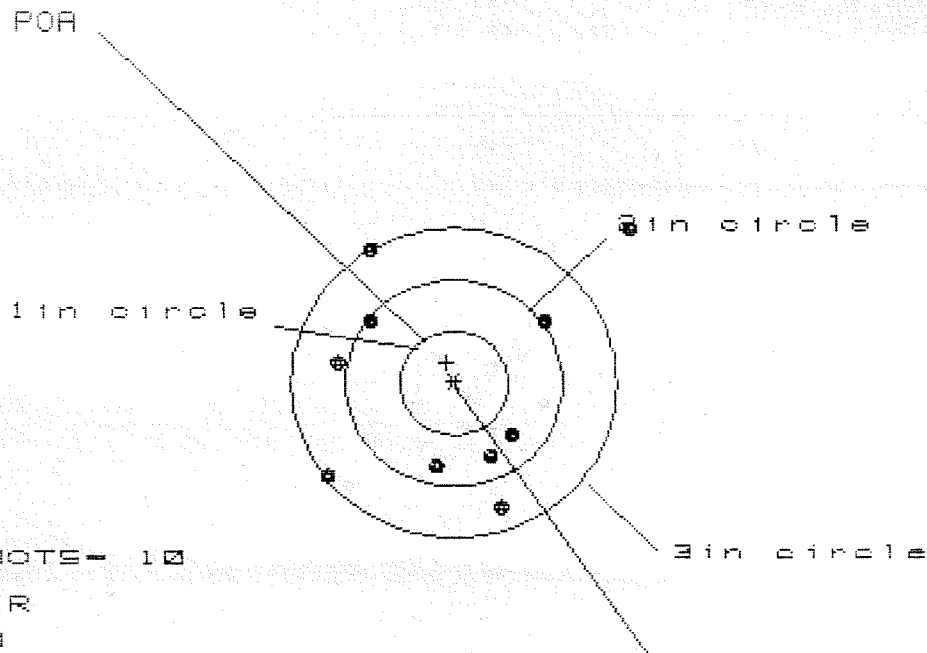
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.979	1.017	.917
MINIMUM X	:	-.951	-.913	-1.013
MAXIMUM Y	:	2.034	1.382	1.240
MINIMUM Y	:	-1.361	-1.135	-1.076
CENTROID X	:	-.220	-.258	-.158
CENTROID Y	:	.365	.139	.281
POA TO CENTROID in.	:	.426	.293	.322
MIN RADIUS	:	.265	.373	.298
MEAN RADIUS	:	1.017	.901	.811
MAX RADIUS	:	2.061	1.657	1.601
HORIZONTAL SPREAD	:	1.930	1.930	1.930
VERTICAL SPREAD	:	3.395	2.517	2.316
EXTREME SPREAD	:	3.591	2.609	2.609
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 0

2in = 4

3in = 8

HS = 2.779

VS = 2.650

GS = 3.671

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.647	1.034	.959
MINIMUM X	:	-1.132	-.949	-1.024
MAXIMUM Y	:	1.457	1.448	.910
MINIMUM Y	:	-1.193	-1.031	-.850
CENTROID X	:	.069	-.114	-.039
CENTROID Y	:	-.201	-.363	-.543
POA TO CENTROID in.	:	.212	.380	.545
MIN RADIUS	:	.736	.611	.427
MEAN RADIUS	:	1.176	1.032	.924
MAX RADIUS	:	2.199	1.568	1.322
HORIZONTAL SPREAD	:	2.779	1.983	1.983
VERTICAL SPREAD	:	2.650	2.479	1.761
EXTREME SPREAD	:	3.671	2.761	2.492
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

3 May 1998

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CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 6

3 in = 8

HS= 2.956

VS= 3.408

GS= 3.985

CENTROID *

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.962	.741	.601
MINIMUM X	-1.994	-1.235	-1.375
MAXIMUM Y	2.163	.629	.503
MINIMUM Y	-1.245	-1.005	-.577
CENTROID X	-.041	.180	.320
CENTROID Y	.073	-.167	-.041
POA TO CENTROID in.	.094	.246	.323
MIN RADIUS	.404	.387	.223
MEAN RADIUS	1.073	.774	.635
MAX RADIUS	2.941	1.506	1.426
HORIZONTAL SPREAD	2.956	1.976	1.976
VERTICAL SPREAD	3.408	1.634	1.000
EXTREME SPREAD	3.985	2.327	2.121
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	