

06523419

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington[®] **DUPONT**
REG. U.S. PAT. & TM. OFF.

MODEL 700TM M24

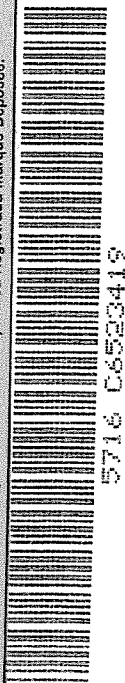
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

01

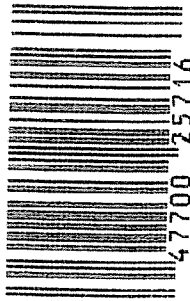
VERY IMPORTANT:
 Instruction Book
 enclosed to assure
 safe use of this
 firearm.

SERIAL NO.
 C6520419

ORDER NO.
 5716



UPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6523419

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		9-25-90	KR
615	Rollmark Caliber		9-25-90	SS
617	Drill and Tap Sight Holes		9-25-90	FB
618	Polish Barrel RB		9/28/90	WB
620	Apply Coatings (Barrel Action)		9-25-90	SA
	Apply Coating (Bolt)		10	SA
625	Final Assembly A) Clean inside of Bolt Assembly		10/8/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/8/90	RW
	C) Inspect Ejector Hole for Chamfer		10/8/90	RW
	D) Oil Firing Pin Ass'y		10/8/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/15/90	JU

op. #	OP. NAME	READINGS					DATE	INIT
625 nt.	F) Safety On Force	5 1/2	5 1/2	5 1/2			10/13/90	WLB
	G) Safety Off Force	3 1/2	3 1/2	3 1/2			10/13/90	WLB
	H) Trigger Pull Test & Retainability						10/15/90	WLB
	I) Firing Pin Indent	0.070	0.070	0.070			10/13/90	WLB
	J) Assemble Stock						10/17/90	RW
	K) Assemble Swivel Studs						2/16/90	JSB
	L) Attach Front and Rear Sight Assemblies						10/17/90	RW
	M) Iron Sight Alignment						10/17/90	RW
	N) Detach Front & Rear Sights & place in numbered container						10/17/90	RW
	O) Attach Scope to Rifle						10/19/90	RW
	P) Detach & Attach Scope 20 Times						10/19/90	RW
640	Gallery Target & Test						10/24/90	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						10/24/90	AF
655	Final Inspection							
	A) Headspace						2/16/90	JSB
	B) Trigger Pull	232	240	234	220	213	2/16/90	JSB
	C) Function						2/16/90	JSB
660	Pack						12-17-90	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6523419

DATE 10/15/90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.36	2.31	2.40	2.32	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.34	2.47	2.43	2.40	
PULL #3	2.37	2.42	2.36	2.34	
PULL #4	2.40	2.28	2.47	2.20	
PULL #5	2.40	2.42	2.40	2.13	
TOTAL	11.87	11.90	12.06		
AVG.	2.374	2.38	2.412		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.10	3.35		
PULL #2	3.22	3.26		
PULL #3	3.14	3.21		
PULL #4	3.20	3.42		
PULL #5	3.23	3.26		
TOTAL	15.89	16.5		
AVG.	3.179	3.3		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.48	4.26		4.52
PULL #2	4.37	4.27		4.14
PULL #3	4.43	4.26		4.45
PULL #4	4.36	4.24		4.48
PULL #5	4.39	4.09		4.32
TOTAL	22.03	21.12		21.91
AVG.	4.406	4.224		4.382

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523419
25 Oct 1990

CENTROIDAL DISTANCES

0 TO	1	.0587282
1 TO	2	.0948472
1 TO	3	.0796304
1 TO	4	.494434
1 TO	5	.467603

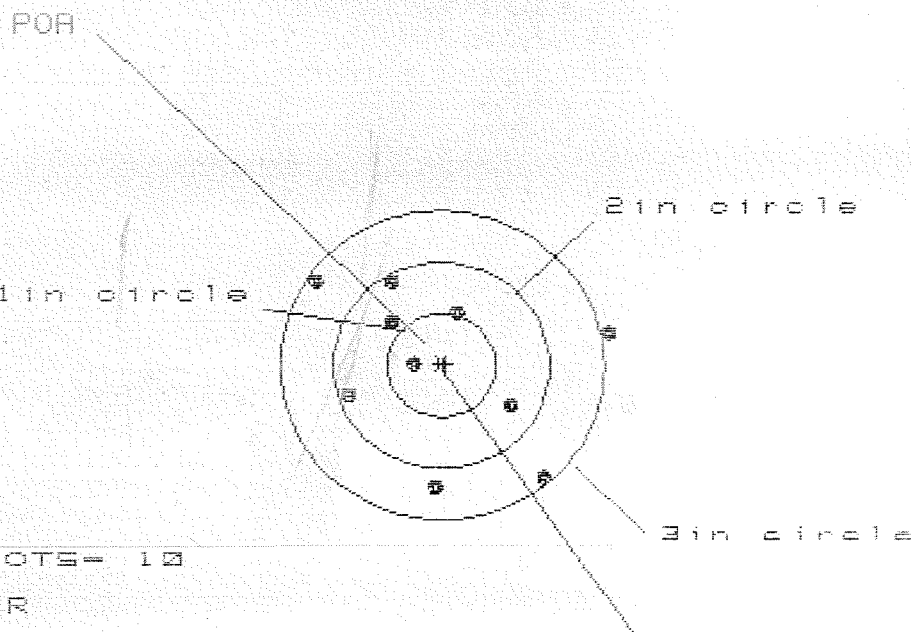
+ 2₅ <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0794
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0442
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0908735
THE AMR FOR THIS RIFLE IS: 1.178

25 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523419

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS= 2.731

VS= 2.041

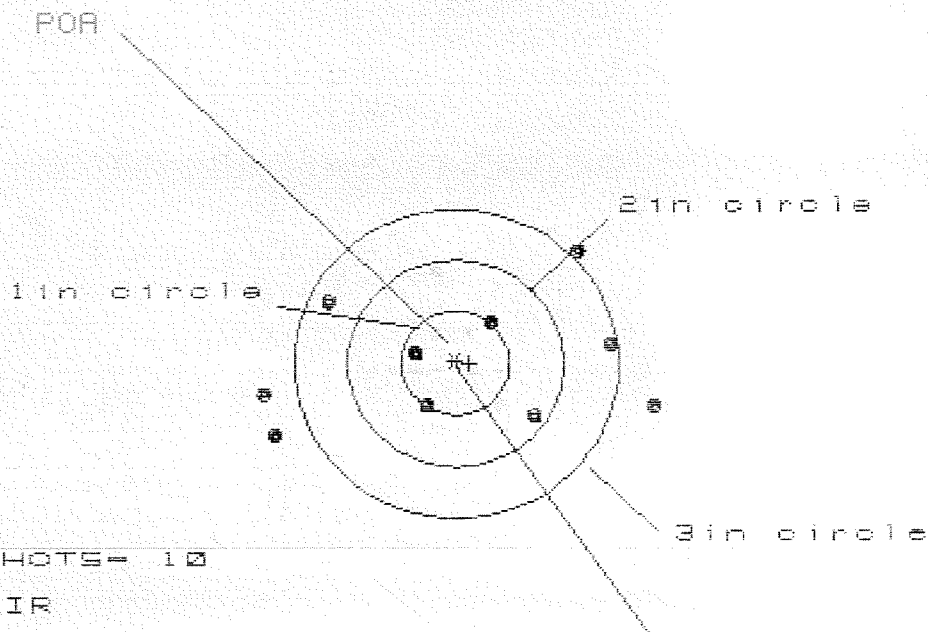
GS= 2.939

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.523	1.148	.986
MINIMUM X	:	-1.208	-1.039	-.896
MAXIMUM Y	:	.867	.901	.765
MINIMUM Y	:	-1.174	-1.140	-1.276
CENTROID X	:	-.040	-.209	-.352
CENTROID Y	:	-.018	-.052	.004
POA TO CENTROID in.	:	.043	.215	.362
MIN RADIUS	:	.274	.125	.076
MEAN RADIUS	:	.972	.879	.749
MAX RADIUS	:	1.553	1.580	1.303
HORIZONTAL SPREAD	:	2.731	2.187	1.882
VERTICAL SPREAD	:	2.041	2.041	2.041
EXTREME SPREAD	:	2.939	2.939	2.326
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

25 Oct 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6523413

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 1

2in = 4

3in = 6

HS = 3.613

VS = 1.804

GS = 3.616

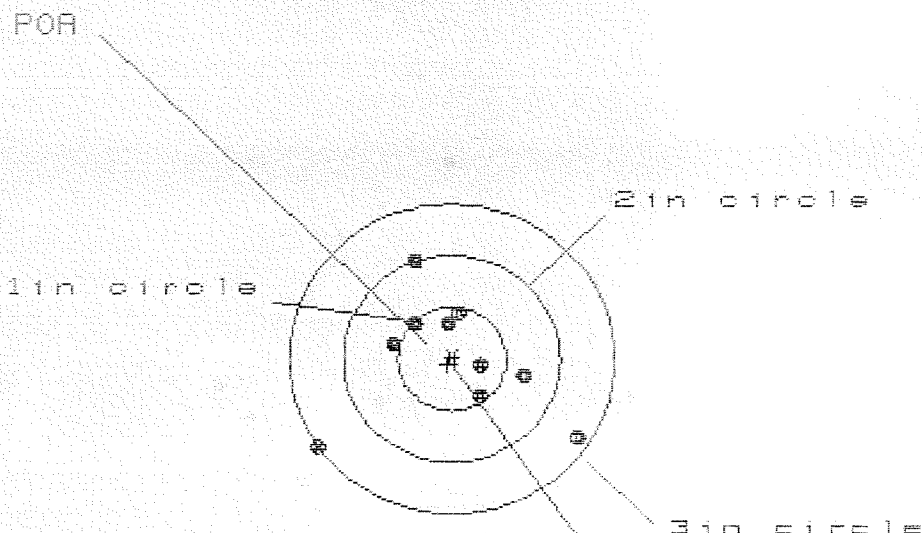
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.817	1.581	1.395
MINIMUM X	:	-1.795	-1.593	-1.779
MAXIMUM Y	:	1.054	1.004	.904
MINIMUM Y	:	-.750	-.800	-.640
CENTROID X	:	-.126	-.328	-.142
CENTROID Y	:	.003	.053	.153
FOR TO CENTROID in.	:	.126	.332	.209
MIN RADIUS	:	.407	.199	.382
MEAN RADIUS	:	1.216	1.125	1.050
MAX RADIUS	:	1.872	1.687	1.830
HORIZONTAL SPREAD	:	3.612	3.174	3.174
VERTICAL SPREAD	:	1.804	1.804	1.544
EXTREME SPREAD	:	3.616	3.365	3.237
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	

25 Oct 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6523419

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 5

2in = 7

3in = 10

HS= 2.345

VS= 1.774

GS= 2.346

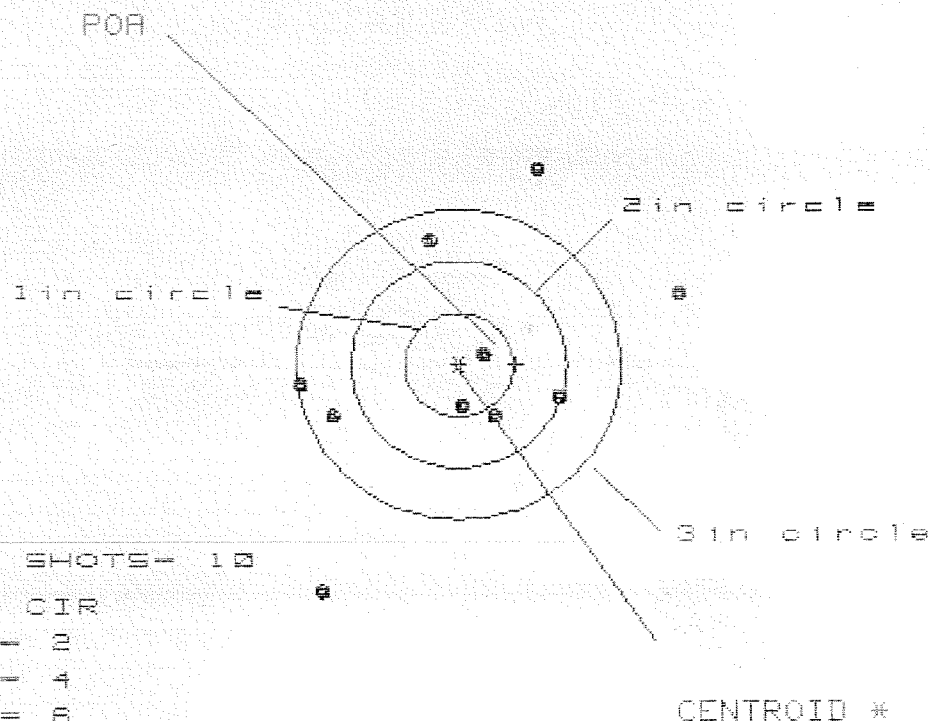
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.139	1.004	.702
MINIMUM X	:	-1.206	-.714	-.588
MAXIMUM Y	:	.970	.880	.778
MINIMUM Y	:	-.804	-.815	-.581
CENTROID X	:	.039	.173	.047
CENTROID Y	:	.053	.143	.245
POA TO CENTROID in.	:	.066	.224	.249
MIN RADIUS	:	.290	.227	.148
MEAN RADIUS	:	.714	.613	.500
MAX RADIUS	:	1.450	1.293	.837
HORIZONTAL SPREAD	:	2.345	1.718	1.290
VERTICAL SPREAD	:	1.774	1.695	1.359
EXTREME SPREAD	:	2.346	2.222	1.541
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

25 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523419

CENTERFIRE PATTERNS # 4



OF SHOTS= 10
 # IN CIR
 1 in = 2
 2 in = 4
 3 in = 6
 HS= 3.486
 VS= 4.086
 GS= 4.520

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.989	1.852	1.020
MINIMUM X	:	-1.497	-1.634	-1.402
MAXIMUM Y	:	1.928	1.688	1.752
MINIMUM Y	:	-2.158	-1.765	-1.781
CENTROID X	:	-.532	-.395	-.627
CENTROID Y	:	-.086	.234	.170
POA TO CENTROID in.	:	.532	.459	.650
MIN RADIUS	:	.211	.151	.293
MEAN RADIUS	:	1.298	1.172	1.076
MAX RADIUS	:	2.485	1.922	1.924
HORIZONTAL SPREAD	:	3.486	3.486	2.422
VERTICAL SPREAD	:	4.086	2.453	2.453
EXTREME SPREAD	:	4.520	3.602	3.100
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	

25 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523419

CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 2

2in = 3

3in = 5

HS= 5.810

VS= 3.982

GS= 5.951

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.909	2.586	1.794
MINIMUM X	:	-2.901	-2.665	-2.341
MAXIMUM Y	:	1.320	1.440	1.430
MINIMUM Y	:	-2.662	-2.542	-2.552
CENTROID X	:	.262	.585	.261
CENTROID Y	:	-.314	-.434	-.424
POA TO CENTROID in.	:	.409	.728	.498
MIN RADIUS	:	.108	.265	.062
MEAN RADIUS	:	1.691	1.550	1.368
MAX RADIUS	:	3.096	3.029	2.743
HORIZONTAL SPREAD	:	5.810	5.251	4.135
VERTICAL SPREAD	:	3.982	3.982	3.982
EXTREME SPREAD	:	5.951	5.468	4.801
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			3	
NUMBER IN THREE INCH CIRCLE =			5	