

C6523497

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington[®] **DUPONT**
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.

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

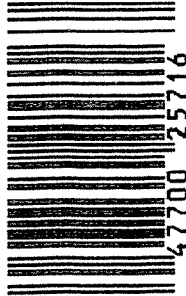
SERIAL NO. C6523497	ORDER NO. 5716
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5716 C6523497

UPC



0 47700 25716 7

21.8

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523497

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		1/10/90	JS
600	Proof		1/10/90	JS
607	Check Headspace		1/10/90	JS
610	Dis-assemble Gun		1/10/90	JS
612	Magnaflux Barrel Action		10/3/90	KR
	Magnaflux Bolt		10/3/90	KR
615	Rollmark Caliber		10/3/90	JS
617	Drill and Tap Sight Holes		10/4/90	FB
618	Polish Barrel RB		10/5/90	WB
620	Apply Coatings (Barrel Action)		10-20-90	JS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/21/90	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/21/90	WB
	C) Inspect Ejector Hole for Chamfer		10/21/90	WB
	D) Oil Firing Pin Ass'y		10/21/90	WB
	E) Adjust Trigger Pull to Min Setting and Stake		10/23/90	JS

op. #	OP. NAME	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2	10/24/90	WB		
	G) Safety Off Force	2	2	2	10/25/90	WB		
	H) Trigger Pull Test & Retainability				10/23/90	JM		
	I) Firing Pin Indent	.0205	.021	.021	10/25/90	WB		
	J) Assemble Stock				10/25/90	Kd		
	K) Assemble Swivel Studs				11-20-90	928		
	L) Attach Front and Rear Sight Assemblies				10/25/90	Kd		
	M) Iron Sight Alignment				10/25/90	Kd		
	N) Detach Front & Rear Sights & place in numbered container				10/25/90	Kd		
	O) Attach Scope to Rifle				10/25/90	Kd		
	P) Detach & Attach Scope 20 Times				10/25/90	Kd		
640	Gallery Target & Test				10-26-90	KT		
	A) Time				10-26-90	KT		
	B) Malfunctions				10/26-90	KT		
	C) Pierced Primers				10/24/90	KT		
	D) Optical Clarity of Scope				10/24/90	KT		
645	Inspect for Live Ammo				10/26/90	KT		
655	Final Inspection				11-20-90	928		
	A) Headspace				11-20-90	928		
	B) Trigger Pull	232	245	240	243	229	11-20-90	928
	C) Function						11-20-90	928
660	Pack						12/7-90	D/H

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6523497

DATE 10/23/90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.45	2.34	2.23	2.32	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.50	2.33	2.50	2.45	
PULL #3	2.39	2.23	2.45	2.40	
PULL #4	2.42	2.48	2.44	2.43	
PULL #5	2.50	2.47	2.50	2.29	
TOTAL	12.26	11.85	12.12		
AVG.	2.452	2.37	2.424		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.13	3.16		
PULL #2	3.19	3.27		
PULL #3	3.26	3.24		
PULL #4	3.30	3.12		
PULL #5	3.33	3.33		
TOTAL	16.21	16.12		
AVG.	3.242	3.224		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.24	4.46		4.38
PULL #2	4.43	4.43		4.50
PULL #3	4.24	4.32		4.32
PULL #4	4.12	4.46		4.48
PULL #5	4.17	4.33		4.40
TOTAL	21.2	22.00		22.08
AVG.	4.24	4.4		4.416

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523497
26 Oct 1990

CENTROIDAL DISTANCES

0 TO	1	.0917824
1 TO	2	.514566
1 TO	3	.173349
1 TO	4	.225178
1 TO	5	.440247

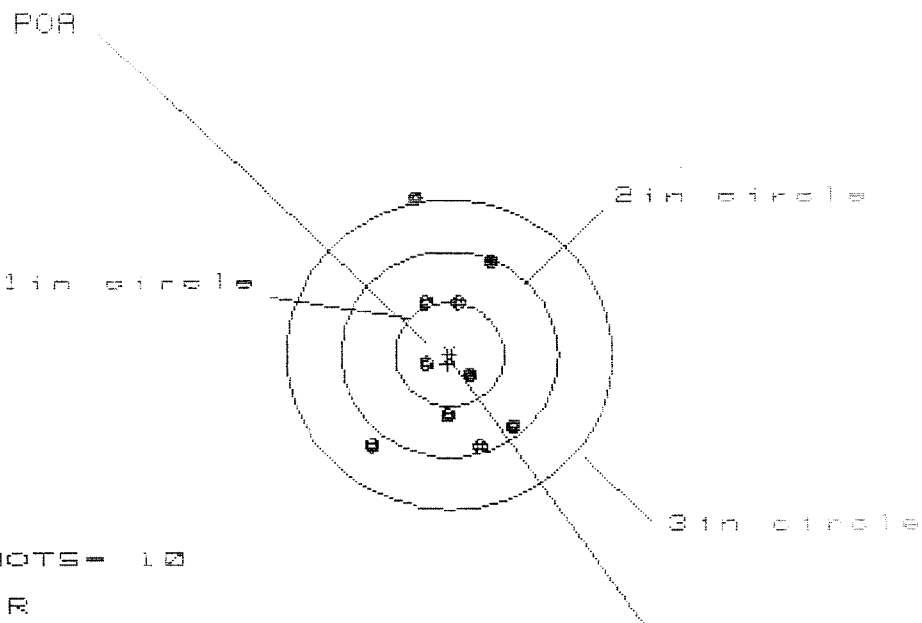
$\frac{10}{25}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0288
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1492
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .151954
THE AMR FOR THIS RIFLE IS: .7486

26 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8523497

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 8

3in = 9

HS= 1.323

VS= 2.452

GS= 2.505

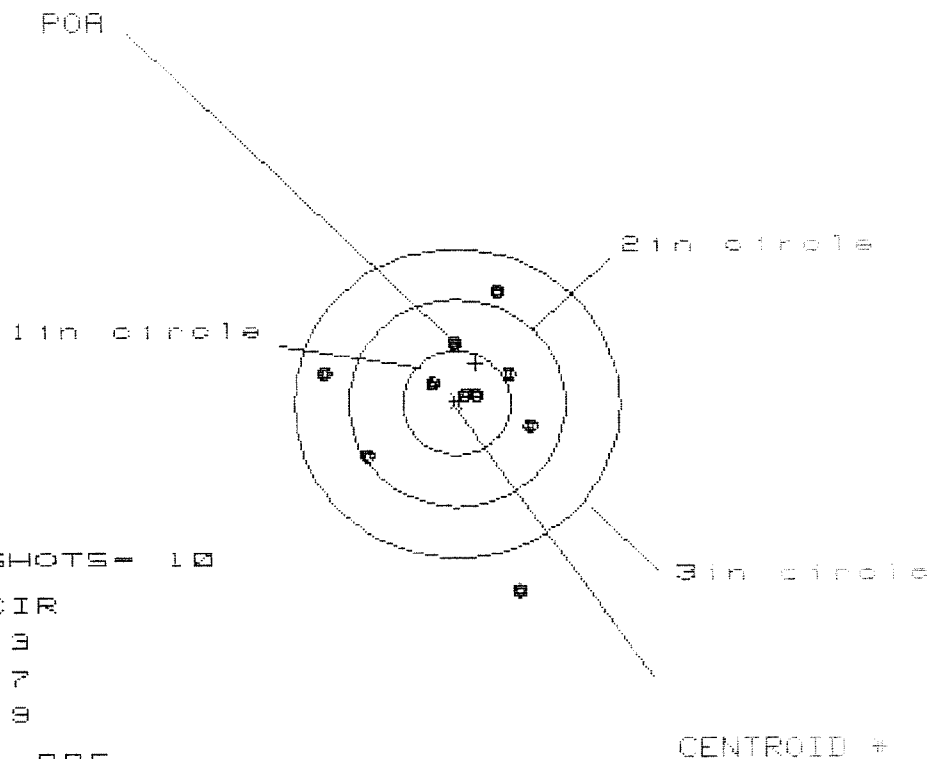
CENTROID #

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.686	.568	.474
MINIMUM X	:	-.717	-.755	-.890
MAXIMUM Y	:	1.530	1.042	.943
MINIMUM Y	:	-.922	-.752	-.815
CENTROID X	:	.018	.056	.150
CENTROID Y	:	.090	-.080	.014
POA TO CENTROID in.	:	.092	.098	.151
MIN RADIUS	:	.244	.177	.160
MEAN RADIUS	:	.780	.669	.621
MAX RADIUS	:	1.567	1.094	.977
HORIZONTAL SPREAD	:	1.323	1.323	.864
VERTICAL SPREAD	:	2.452	1.794	1.763
EXTREME SPREAD	:	2.505	2.097	1.764
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

25 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08583497

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 1.886

VS= 2.941

GS= 2.945

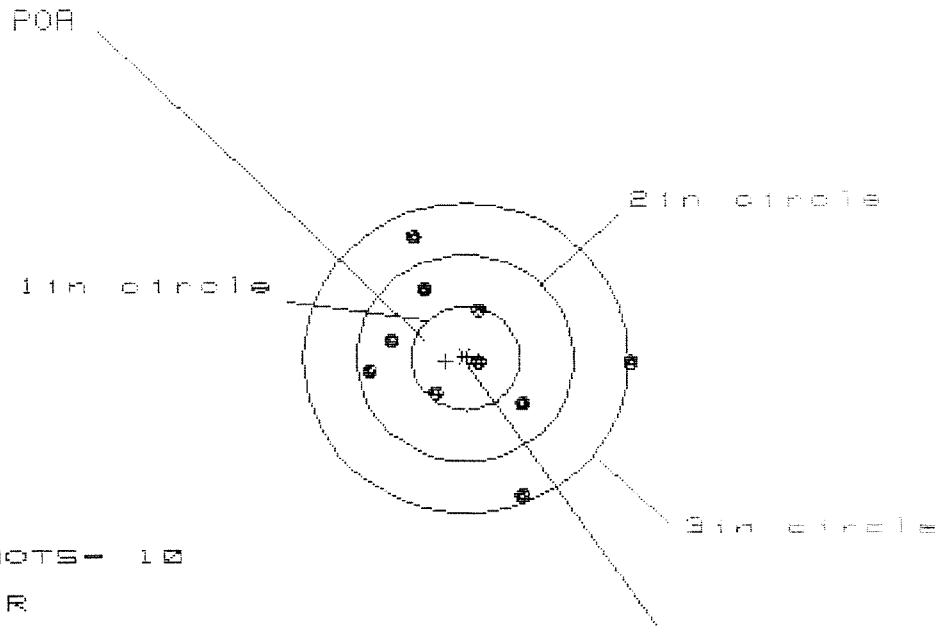
CENTROID +

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.650	.710	.563
MINIMUM X	:	-1.236	-1.176	-.885
MAXIMUM Y	:	1.094	.888	.900
MINIMUM Y	:	-1.847	-.717	-.705
CENTROID X	:	-.175	-.235	-.088
CENTROID Y	:	-.387	-.181	-.193
POA TO CENTROID in.	:	.425	.297	.212
MIN RADIUS	:	.103	.166	.112
MEAN RADIUS	:	.764	.612	.511
MAX RADIUS	:	1.923	1.180	1.132
HORIZONTAL SPREAD	:	1.886	1.886	1.448
VERTICAL SPREAD	:	2.941	1.605	1.605
EXTREME SPREAD	:	2.945	1.989	1.989
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

28 Oct 1998

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10
 # IN CIR
 1in = 3
 2in = 7
 3in = 10
 HS= 2.417
 VS= 2.551
 GS= 2.716

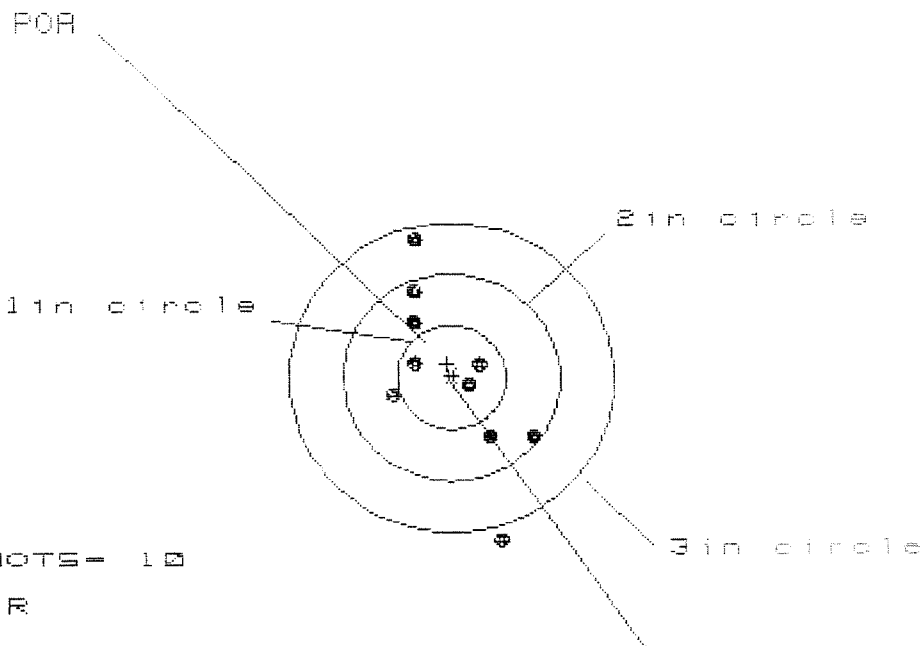
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.498	.783	.783
MINIMUM X	:	-.919	-.752	-.672
MAXIMUM Y	:	1.181	1.180	1.088
MINIMUM Y	:	-1.370	-1.371	-.581
CENTROID X	:	.181	.014	-.066
CENTROID Y	:	.031	.032	.204
POA TO CENTROID in.	:	.183	.035	.214
MIN RADIUS	:	.168	.265	.409
MEAN RADIUS	:	.831	.747	.641
MAX RADIUS	:	1.498	1.513	1.031
HORIZONTAL SPREAD	:	2.417	1.455	1.455
VERTICAL SPREAD	:	2.551	2.551	1.589
EXTREME SPREAD	:	2.716	2.716	1.875
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

26 Oct 1998

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 9

HS= 1.239

VS= 2.831

GS= 2.943

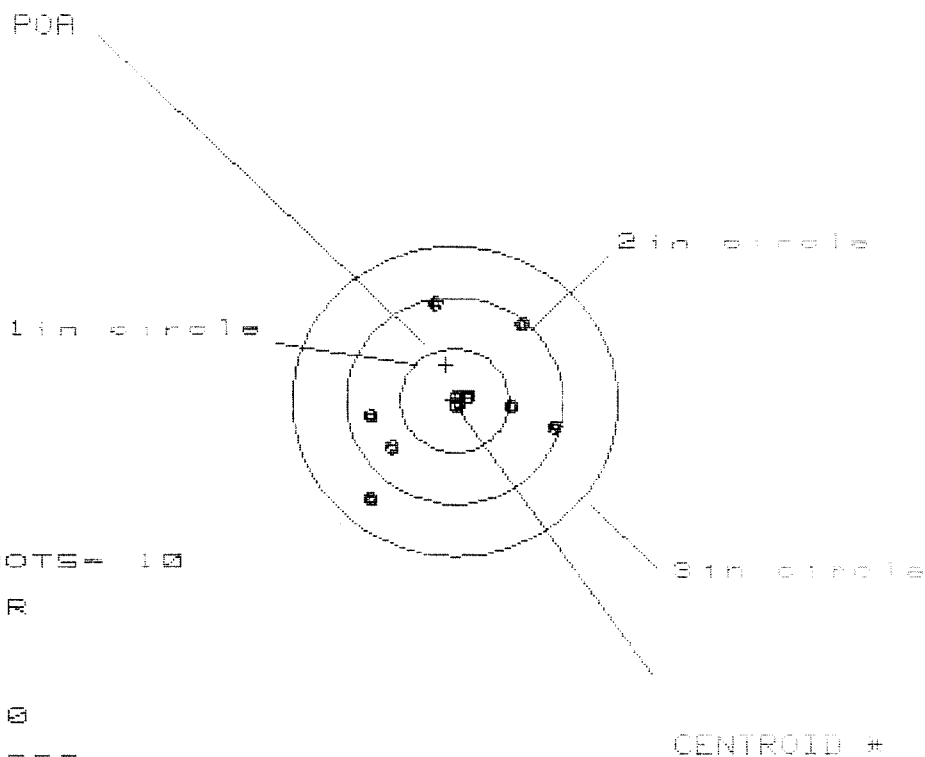
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.724	.771	.730
MINIMUM X	:	-.515	-.468	-.509
MAXIMUM Y	:	1.311	1.142	.762
MINIMUM Y	:	-1.520	-.717	-.574
CENTROID X	:	.041	-.006	.035
CENTROID Y	:	-.134	.035	-.108
POR TO CENTROID in.	:	.140	.036	.113
MIN RADIUS	:	.165	.290	.185
MEAN RADIUS	:	.729	.628	.543
MAX RADIUS	:	1.579	1.188	.914
HORIZONTAL SPREAD	:	1.239	1.239	1.239
VERTICAL SPREAD	:	2.831	1.859	1.336
EXTREME SPREAD	:	2.943	2.138	1.658
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

26 Oct 1998

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 9

3 in = 10

HS= 1.687

VS= 1.889

GS= 2.149

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.944	.861	.827
MINIMUM X	:	-.743	-.813	-.847
MAXIMUM Y	:	.969	.867	.780
MINIMUM Y	:	-.920	-.510	-.402
CENTROID X	:	.079	.162	.196
CENTROID Y	:	-.346	-.244	-.352
POA TO CENTROID in.	:	.355	.292	.403
MIN RADIUS	:	.088	.045	.100
MEAN RADIUS	:	.639	.568	.521
MAX RADIUS	:	1.183	.932	.907
HORIZONTAL SPREAD	:	1.687	1.674	1.674
VERTICAL SPREAD	:	1.889	1.377	1.182
EXTREME SPREAD	:	2.149	1.678	1.678
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			9	
NUMBER IN THREE INCH CIRCLE =			10	