

C5649088

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 700™ 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.
 C6649088

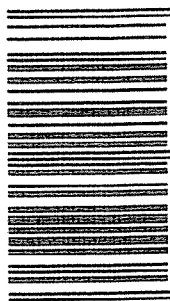
ORDER NO.
 5716

20



5716 C6649088

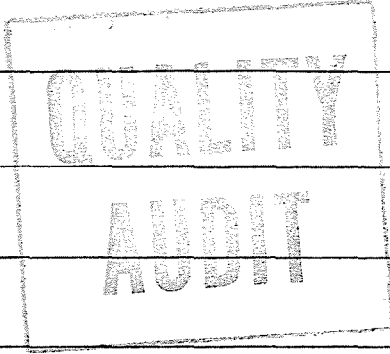
LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C 6649088**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/26/91	KL
600	Proof		6/26/91	KL
607	Check Headspace		6/26/91	KL
610	Dis-assemble Gun		6/26/91	KL
612	Magnaflux Barrel Action		JUL 1 8 1991	CS
	Magnaflux Bolt		JUL 1 8 1991	CS
615	Rollmark Caliber		JUL 1 8 1991	CS
617	Drill and Tap Sight Holes		JUL 1 8 1991	LB
618	Polish Barrel		JUL 2 0 1991	WB
620	Apply Coatings (Barrel Action)		8-7-91	
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/8/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/8/91	KL
	C) Inspect Ejector Hole for Chamfer		8/8/91	KL
	D) Oil Firing Pin Ass'y		8/8/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		8-9-91	KL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7	7	7			8-9-91	JH
	G) Safety Off Force	3	3	3			8-9-91	JH
	H) Trigger Pull Test & Retainability						8-9-91	JH
	I) Firing Pin Indent	.021	.0215	.0215			8-9-91	JH
	J) Assemble Stock						8/9/91	JH
	K) Assemble Swivel Studs						8-14-91	D/H
	L) Attach Front and Rear Sight Assemblies						8/9/91	JH
	M) Iron Sight Alignment						8/9/91	JH
	N) Detach Front & Rear Sights & place in numbered container						8/9/91	JH
	O) Attach Scope to Rifle						8/9/91	JH
	P) Detach & Attach Scope 20 Times						8/9/91	JH
640	Gallery Target & Test						8-13-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						8-13-91	NF
655	Final Inspection							
	A) Headspace						8-14-91	D/H
	B) Trigger Pull	2.45	2.49	2.50	2.45	2.38	8-14-91	JH
	C) Function						8-14-91	D/H
660	Pack						9-17-91	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. C6649088

DATE 8-9-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.60	2.31	2.36	2.45	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.44	2.26	2.40	2.49	
PULL #3	2.39	2.37	2.44	2.50	
PULL #4	2.29	2.43	2.22	2.45	
PULL #5	2.41	2.41	2.20	2.38	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.37	3.34		
PULL #2	3.29	3.37		
PULL #3	3.35	3.25		
PULL #4	3.42	3.36		
PULL #5	3.34	3.47		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.29	4.28		4.28
PULL #2	4.26	4.26		4.33
PULL #3	4.34	4.24		4.25
PULL #4	4.23	4.24		4.26
PULL #5	4.24	4.24		4.26
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649088
23 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.17789
1 TO	2	.140246
1 TO	3	.01772
1 TO	4	.23927
1 TO	5	.204414

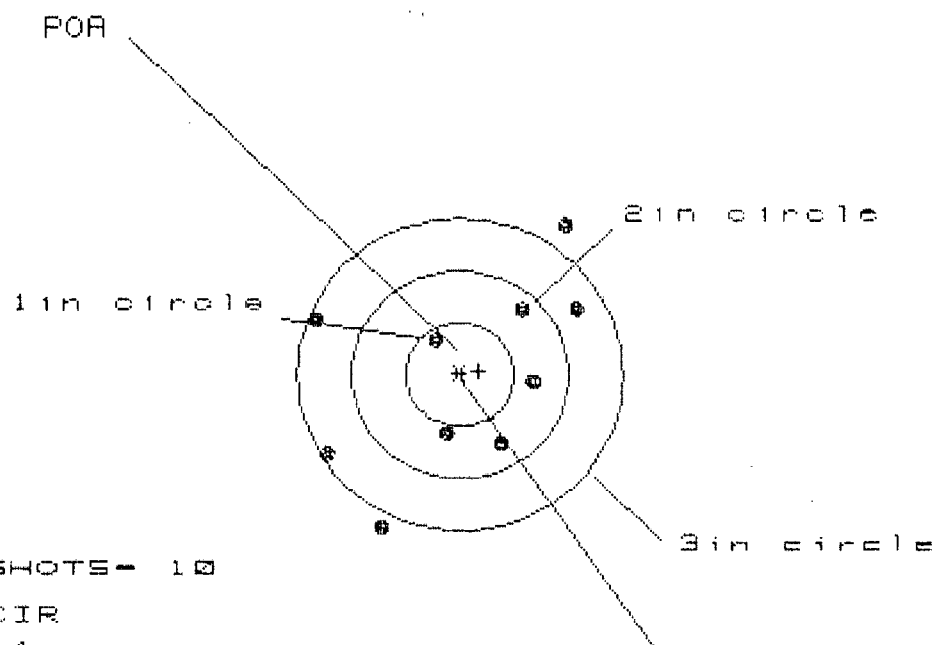
<----POR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.121
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0592
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .134706
THE AMR FOR THIS RIFLE IS: .9354

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649088

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 4

HS= 2.482

VS= 2.950

GS= 3.375

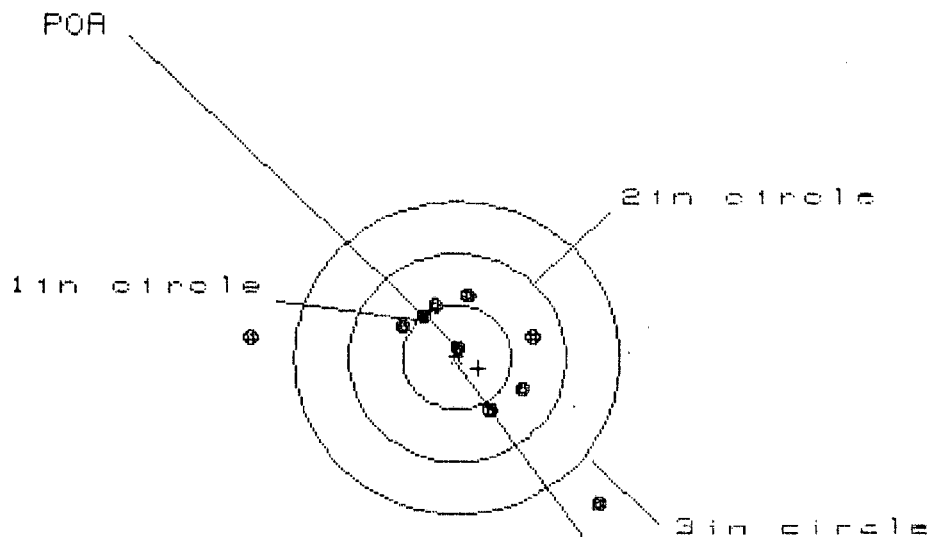
CENTROID *

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.114	1.218	1.143
MINIMUM X	:	-1.368	-1.264	-1.340
MAXIMUM Y	:	1.446	.774	.606
MINIMUM Y	:	-1.504	-1.343	-.767
CENTROID X	:	-.174	-.278	-.203
CENTROID Y	:	-.037	-.197	-.029
POA TO CENTROID in.	:	.177	.340	.205
MIN RADIUS	:	.438	.435	.417
MEAN RADIUS	:	1.094	1.018	.946
MAX RADIUS	:	1.722	1.471	1.463
HORIZONTAL SPREAD	:	2.482	2.482	2.482
VERTICAL SPREAD	:	2.950	2.117	1.373
EXTREME SPREAD	:	3.375	2.790	2.755
NUMBER IN ONE INCH CIRCLE	=	1	1	1
NUMBER IN TWO INCH CIRCLE	=	5	5	5
NUMBER IN THREE INCH CIRCLE	=	8	8	8

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649088

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 3.215

VS= 1.936

GS= 3.594

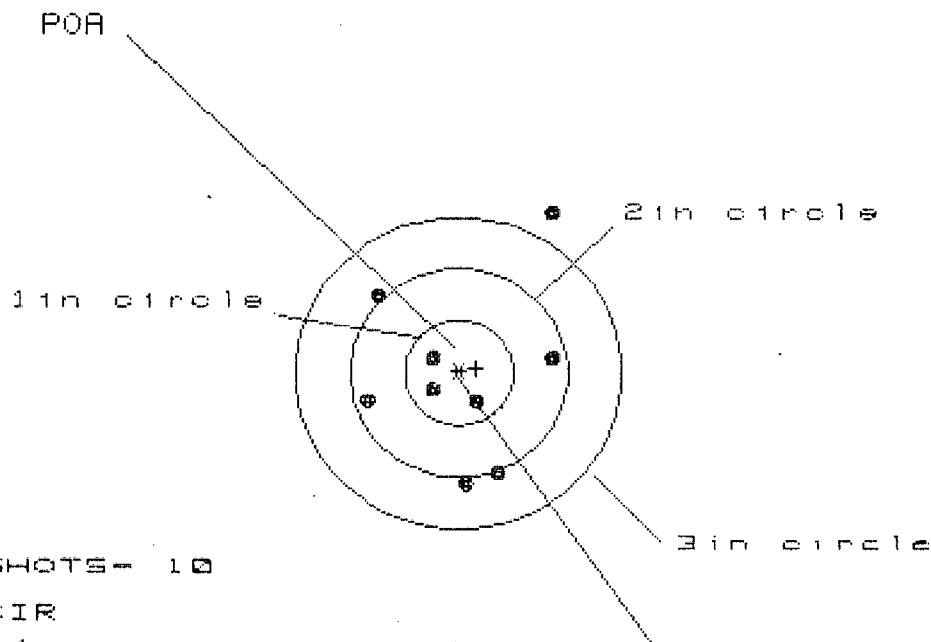
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.267	1.051	.609
MINIMUM X	:	-1.948	-.691	-.560
MAXIMUM Y	:	.563	.589	.420
MINIMUM Y	:	-1.373	-1.347	-.655
CENTROID X	:	-.199	.017	-.114
CENTROID Y	:	.101	.075	.244
POR TO CENTROID in.	:	.223	.077	.269
MIN RADIUS	:	.061	.240	.123
MEAN RADIUS	:	.803	.681	.503
MAX RADIUS	:	1.962	1.709	.691
HORIZONTAL SPREAD	:	3.215	1.742	1.169
VERTICAL SPREAD	:	1.936	1.936	1.075
EXTREME SPREAD	:	3.594	2.418	1.235
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649088

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 9

HS= 1.777

VS= 2.664

GS= 2.799

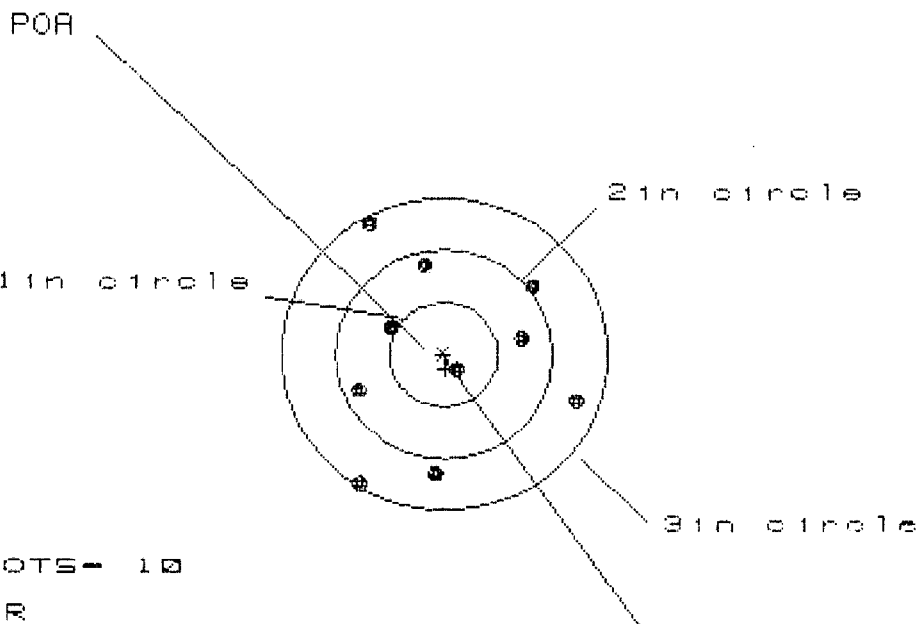
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.891	.971	.987
MINIMUM X	:	-.886	-.787	-.770
MAXIMUM Y	:	1.573	.867	.752
MINIMUM Y	:	-1.091	-.916	-.924
CENTROID X	:	-.157	-.256	-.272
CENTROID Y	:	-.042	-.217	-.102
POA TO CENTROID in.	:	.162	.335	.291
MIN RADIUS	:	.262	.138	.144
MEAN RADIUS	:	.787	.649	.595
MAX RADIUS	:	1.808	1.062	1.051
HORIZONTAL SPREAD	:	1.777	1.758	1.758
VERTICAL SPREAD	:	2.664	1.783	1.676
EXTREME SPREAD	:	2.799	2.003	2.003
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649008

CENTERFIRE PATTERNS # 4



* OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 2.0006

VS= 2.442

CS= 2.573

CENTROID *

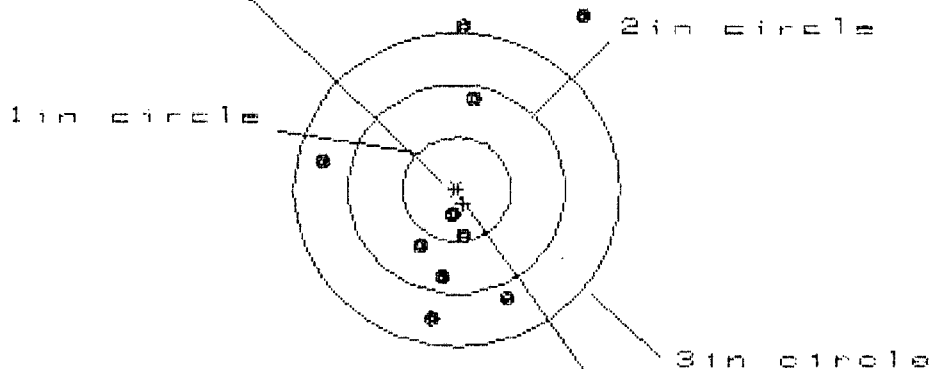
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.253	1.179	1.076
MINIMUM X	:	-.753	-.827	-.930
MAXIMUM Y	:	1.252	1.015	.883
MINIMUM Y	:	-1.190	-1.051	-1.165
CENTROID X	:	-.013	.061	.164
CENTROID Y	:	.140	.000	.132
POA TO CENTROID in.	:	.140	.061	.210
MIN RADIUS	:	.183	.025	.181
MEAN RADIUS	:	.961	.896	.840
MAX RADIUS	:	1.419	1.335	1.188
HORIZONTAL SPREAD	:	2.006	2.006	2.006
VERTICAL SPREAD	:	2.442	2.066	2.048
EXTREME SPREAD	:	2.573	2.419	2.054
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649088

CENTERFIRE PATTERNS # 5

POA



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 0.457

VS= 2.871

GS= 3.221

CENTROID *

PATTERN #	15	15	15
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.196	.604	.626
MINIMUM X	-1.261	-1.128	-1.106
MAXIMUM Y	1.681	1.770	1.233
MINIMUM Y	-1.190	-1.004	-.782
CENTROID X	-.062	-.195	-.217
CENTROID Y	.134	-.053	-.274
POA TO CENTROID in.	.147	.202	.350
MIN RADIUS	.259	.094	.182
MEAN RADIUS	1.032	.844	.665
MAX RADIUS	2.063	1.779	1.278
HORIZONTAL SPREAD	2.457	1.732	1.732
VERTICAL SPREAD	2.871	2.774	2.016
EXTREME SPREAD	3.221	2.791	2.130
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		