

C6636226

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington®



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

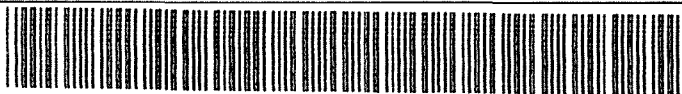
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700™ H24

SERIAL NO.
C6636226

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

ORDER NO.
5716



5716 C6636226



CONTRACT # DAAA21-87-C-0086

C 6636276

GUN SERIAL # [REDACTED]

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/30/90	Kd
600	Proof		10/30/90	Kd
607	Check Headspace		10/30/90	Kd
610	Dis-assemble Gun		10/30/90	Kd
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		8/29/91	Kd
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/29/91	Kd
	C) Inspect Ejector Hole for Chamfer		8/29/91	Kd
	D) Oil Firing Pin Ass'y		8/29/91	Kd
	E) Adjust Trigger Pull to Min Setting and Stake		9/13/91	Kd

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	4			9/3/91	SH
	G) Safety Off Force	4	4	4			9/3/91	SH
	H) Trigger Pull Test & Retainability						9/3/91	SH
	I) Firing Pin Indent	.023	.023	.023			9/3/91	SH
	J) Assemble Stock						9/3/91	SH
	K) Assemble Swivel Studs						9/29/91	DH
	L) Attach Front and Rear Sight Assemblies						9/3/91	SH
	M) Iron Sight Alignment						9/3/91	SH
	N) Detach Front & Rear Sights & place in numbered container						9/3/91	SH
	O) Attach Scope to Rifle						9/3/91	SH
	P) Detach & Attach Scope 20 Times						9/3/91	SH
640	Gallery Target & Test						9/5/91	KT
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	KT
645	Inspect for Live Ammo						9/5/91	KT
655	Final Inspection						9/29/91	DH
	A) Headspace						9/6/91	SH
	B) Trigger Pull	261	251	249	254	241	9/6/91	SH
	C) Function						9/29/91	DH
660	Pack						9-18-91	VF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50#+ .50#
3.00#+ .75#
4.00#+1.00#

SERIAL NO. C6636226

DATE 9-3-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.27	2.21	2.46	2.61	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.22	2.41	2.40	2.51	
PULL #3	2.23	2.38	2.36	2.49	
PULL #4	2.25	2.36	2.35	2.54	
PULL #5	2.20	2.39	2.43	2.41	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.43	3.47		
PULL #2	3.56	3.59		
PULL #3	3.21	3.55		
PULL #4	3.58	3.55		
PULL #5	3.58	3.54		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.21	4.48		4.38
PULL #2	4.31	4.41		4.46
PULL #3	4.43	4.31		4.44
PULL #4	4.45	4.36		4.37
PULL #5	4.41	4.44		4.35
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636226
5 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.157258
1 TO	2	.240751
1 TO	3	.238724
1 TO	4	.181463
1 TO	5	.0998499

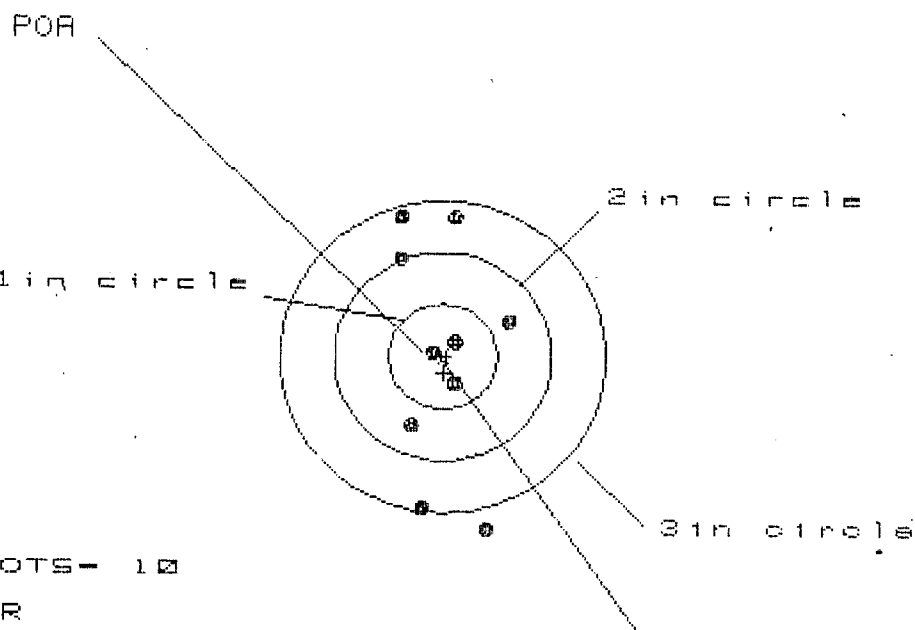
2.8
3.8 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0128
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1802
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .180654
THE AMR FOR THIS RIFLE IS: 1.003

5 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636226

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 8

IS = 1.044

VS = 2.986

GS = 3.074

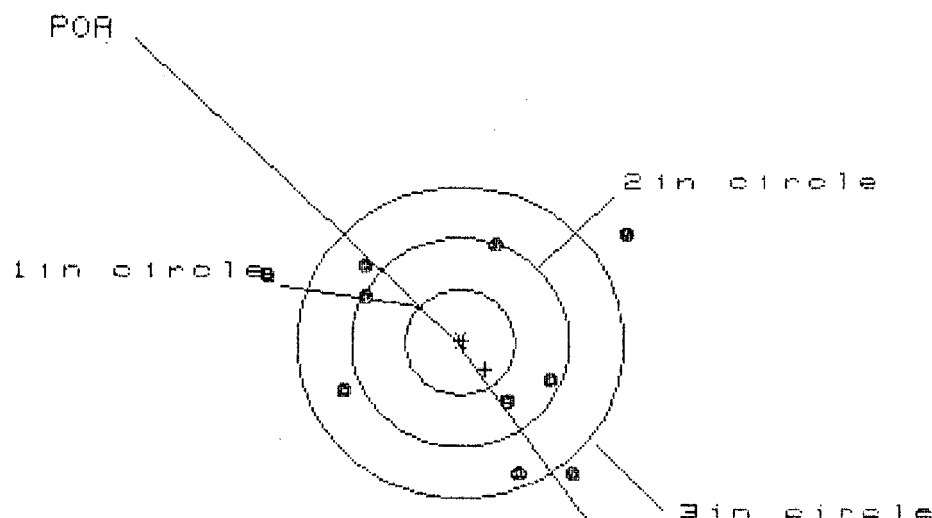
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.605	.645	.631
MINIMUM X	:	-.439	-.399	-.413
MAXIMUM Y	:	1.330	1.146	.939
MINIMUM Y	:	-1.656	-1.658	-1.017
CENTROID X	:	-.009	-.049	-.035
CENTROID Y	:	.157	.341	.548
POA TO CENTROID in.	:	.157	.344	.549
MIN RADIUS	:	.055	.149	.335
MEAN RADIUS	:	.888	.806	.718
MAX RADIUS	:	1.695	1.661	1.062
HORIZONTAL SPREAD	:	1.044	1.044	1.044
VERTICAL SPREAD	:	2.986	2.804	1.956
EXTREME SPREAD	:	3.074	2.821	2.017
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

5 Sep 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 0

2 in = 3

3 in = 7

IS = 2.256

VS = 2.392

GS = 3.344

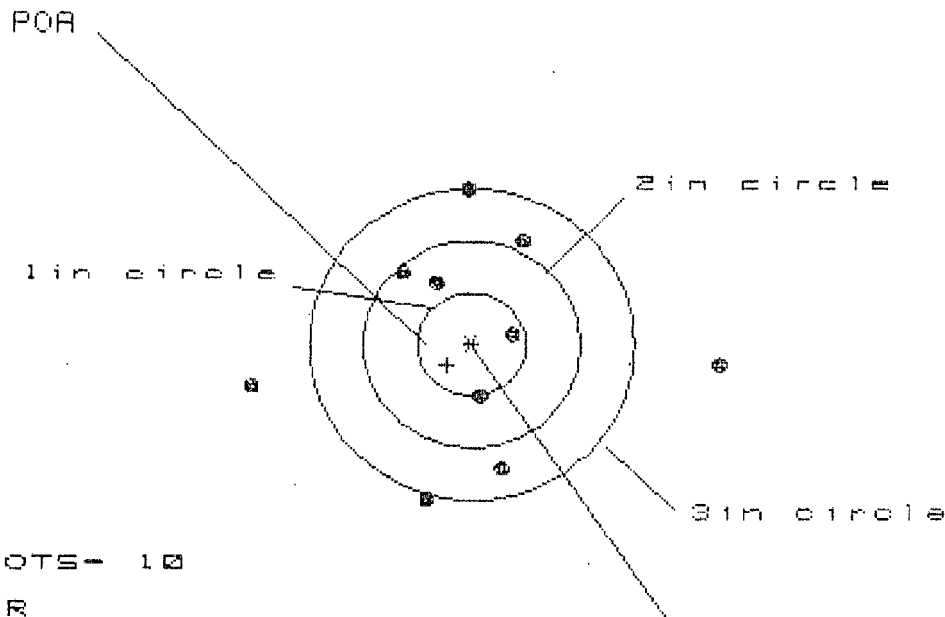
CENTROID #

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.506	1.312	.989
MINIMUM X	-1.750	-1.314	-1.150
MAXIMUM Y	1.090	1.162	1.112
MINIMUM Y	-1.302	-1.230	-1.085
CENTROID X	-.228	-.034	-.198
CENTROID Y	.257	.185	.040
POR TO CENTROID in.	.344	.188	.202
MIN RADIUS	.733	.561	.561
MEAN RADIUS	1.268	1.179	1.098
MAX RADIUS	1.866	1.753	1.413
HORIZONTAL SPREAD	3.256	2.626	2.139
VERTICAL SPREAD	2.392	2.392	2.197
EXTREME SPREAD	3.344	3.041	2.766
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		7	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 7

IS = 4.375

VS = 3.010

GS = 4.379

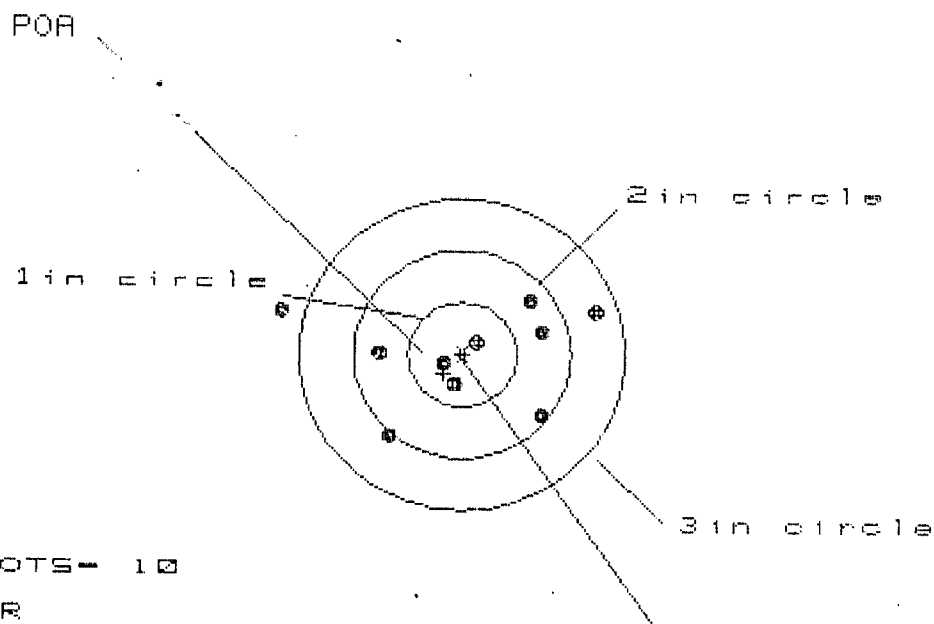
CENTROID *

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	2.385
MINIMUM X	-2.070
MAXIMUM Y	1.483
MINIMUM Y	-1.527
CENTROID X	.226
CENTROID Y	.199
POA TO CENTROID in.	.301
MIN RADIUS	.362
MEAN RADIUS	1.241
MAX RADIUS	2.312
HORIZONTAL SPREAD	4.375
VERTICAL SPREAD	3.010
EXTREME SPREAD	4.379
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	7

5 Sep 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 2.951

VS= 1.385

GS= 2.952

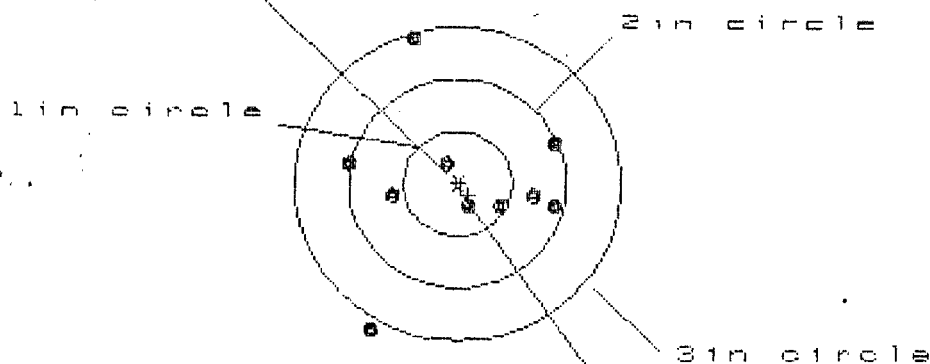
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.232	1.041	.693
MINIMUM X	:	-1.719	-.959	-.829
MAXIMUM Y	:	.557	.607	.660
MINIMUM Y	:	-.828	-.778	-.725
CENTROID X	:	.171	.362	.232
CENTROID Y	:	.180	.130	.077
POA TO CENTROID in.	:	.249	.385	.245
MIN RADIUS	:	.182	.125	.194
MEAN RADIUS	:	.809	.689	.621
MAX RADIUS	:	1.778	1.194	1.061
HORIZONTAL SPREAD	:	2.951	2.000	1.522
VERTICAL SPREAD	:	1.385	1.385	1.385
EXTREME SPREAD	:	2.952	2.288	1.987
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5

FOR



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 9

HS= 1.819

VS= 2.857

GS= 2.882

CENTROID *

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.857	.768	.785
MINIMUM X	-.962	-1.051	-1.114
MAXIMUM Y	1.432	1.274	.368
MINIMUM Y	-1.425	-.349	-.190
CENTROID X	-.096	-.007	.056
CENTROID Y	.108	.266	.107
FOR TO CENTROID in.	.144	.267	.121
MIN RADIUS	.234	.198	.191
MEAN RADIUS	.808	.713	.592
MAX RADIUS	1.633	1.371	1.130
HORIZONTAL SPREAD	1.819	1.819	1.819
VERTICAL SPREAD	2.857	1.623	.558
EXTREME SPREAD	2.882	2.048	1.854
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		9	