

C6635027

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington




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

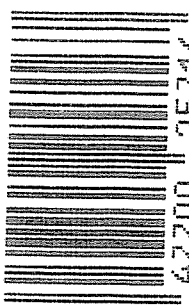
MODEL 700TM N24

SERIAL NO.
C6636027

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 C6636027

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636027

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		5/1/91	KS
600	Proof		5/1/91	KS
607	Check Headspace		5/1/91	KS
610	Dis-assemble Gun		5/1/91	KS
612	Magnaflux Barrel Action	5 8 9 1		KCR
	Magnaflux Bolt	5 8 9 1		KCR
615	Rollmark Caliber			GS
617	Drill and Tap Sight Holes	5 15 9 1		LB
618	Polish Barrel	5 15 9 1		WJH
620	Apply Coatings (Barrel Action)		5-31-91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		9/4/91	JK
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/4/91	JK
	C) Inspect Ejector Hole for Chamfer		9/4/91	JK
	D) Oil Firing Pin Ass'y		9/4/91	JK
	E) Adjust Trigger Pull to Min Setting and Stake		9/10/91	JK

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			9/10/91	JK
	G) Safety Off Force	3	3	3			9/10/91	JK
	H) Trigger Pull Test & Retainability						9/10/91	JK
	I) Firing Pin Indent	1.023	1.0235	1.0235			9/10/91	JK
	J) Assemble Stock						9/12/91	JK
	K) Assemble Swivel Studs						9-13-91	DH
	L) Attach Front and Rear Sight Assemblies						9/12/91	JK
	M) Iron Sight Alignment						9/12/91	JK
	N) Detach Front & Rear Sights & place in numbered container						9/12/91	JK
	O) Attach Scope to Rifle						9/12/91	JK
	P) Detach & Attach Scope 20 Times						9/12/91	JK
640	Gallery Target & Test						9-13-91	DH
	A) Time						9-13-91	DH
	B) Malfunctions						9-13-91	DH
	C) Pierced Primers						9-13-91	DH
	D) Optical Clarity of Scope						9-13-91	DH
645	Inspect for Live Ammo						9-13-91	DH
655	Final Inspection						9-13-91	DH
	A) Headspace							
	B) Trigger Pull	2.33	2.20	2.15	2.18	2.21	9-13-91	JK
	C) Function						9-13-91	DH
660	Pack						9-18-91	JK

SWS TRIGGER PULL TEST

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

SERIAL NO. C6636027
DATE 9-10-91
TESTER JM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.31	2.28	2.33	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.39	2.31	2.37	2.20	
PULL #3	2.37	2.30	2.35	2.15	
PULL #4	2.51	2.43	2.40	2.18	
PULL #5	2.36	2.37	2.44	2.21	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.53	3.39		
PULL #2	3.51	3.32		
PULL #3	3.26	3.47		
PULL #4	3.44	3.46		
PULL #5	3.38	3.40		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.39	4.46		4.47
PULL #2	4.46	4.41		4.40
PULL #3	4.35	4.25		4.44
PULL #4	4.29	4.43		4.50
PULL #5	4.45	4.37		4.45
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636027
13 Sep 1991

CENTROIDAL DISTANCES

0 TO 1	.281469
1 TO 2	.345349
1 TO 3	.196329
1 TO 4	.574889
1 TO 5	.337001

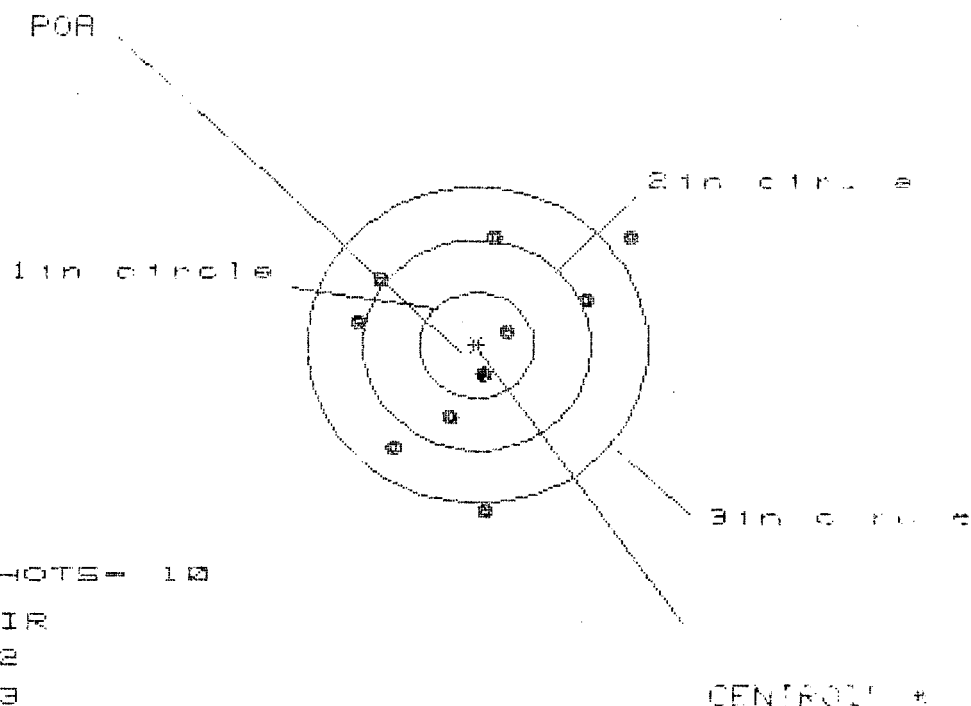
45 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1028
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0482
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .113539
THE AMR FOR THIS RIFLE IS: .8438

13 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66J6027

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 3

3in = 8

HS= 2.372

VS= 2.534

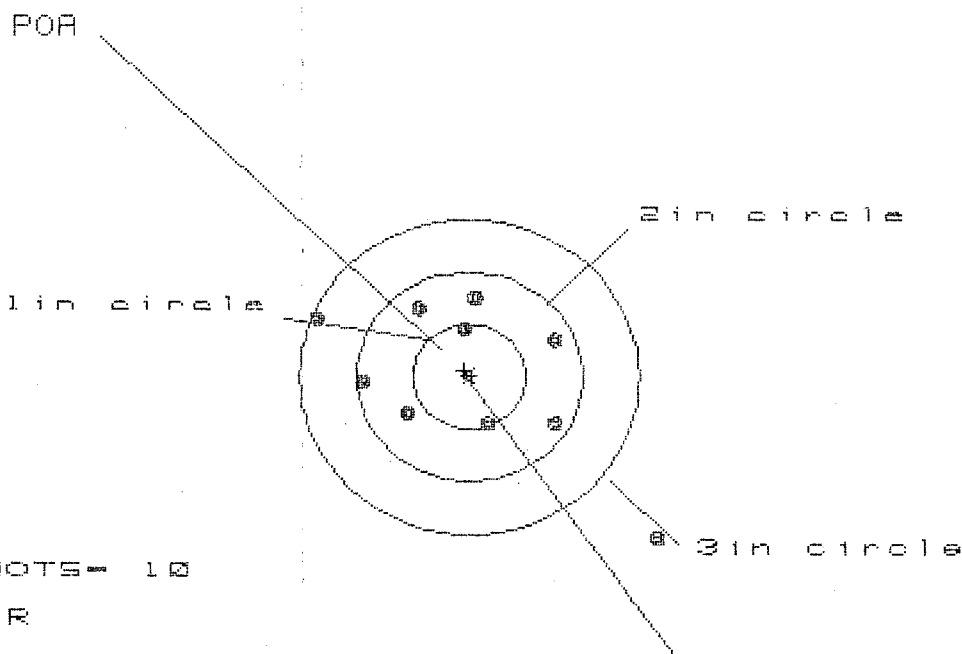
GS= 2.955

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.362	1.070	1.057
MINIMUM X	-1.010	-0.859	-0.832
MAXIMUM Y	1.053	1.152	.974
MINIMUM Y	-1.541	-1.424	-1.069
CENTROID X	-.060	-.211	-.238
CENTROID Y	.275	.158	.336
POA TO CENTROID in.	.282	.264	.412
MIN RADIUS	.274	.272	.419
MEAN RADIUS	.998	.910	.844
MAX RADIUS	1.721	1.440	1.215
HORIZONTAL SPREAD	2.372	1.929	1.929
VERTICAL SPREAD	2.594	2.576	2.043
EXTREME SPREAD	2.955	2.579	2.250
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 8

3 in = 9

HS= 3.024

VS= 2.259

GS= 3.668

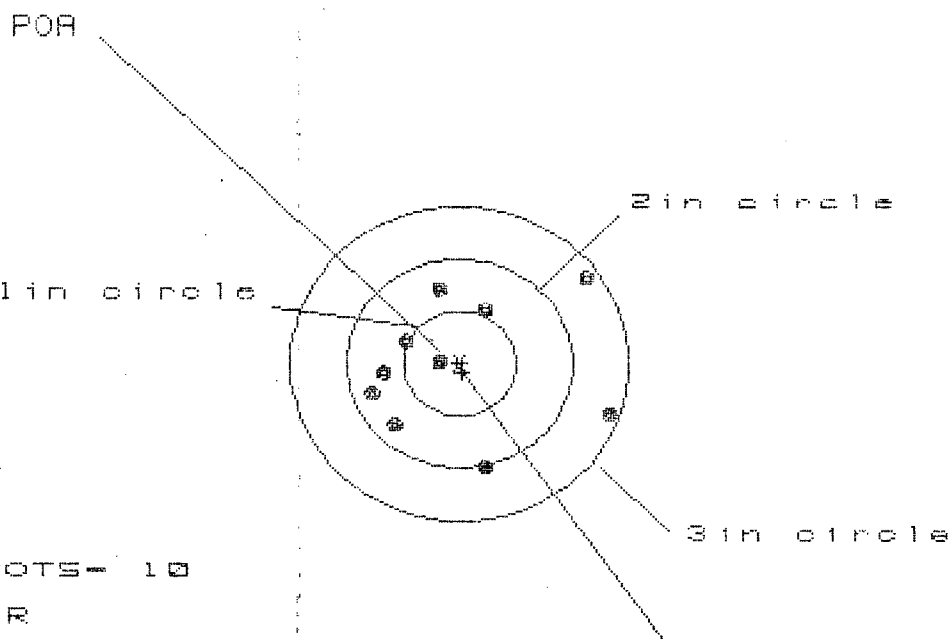
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.634	.935	.784
MINIMUM X	:	-1.390	-1.208	-.876
MAXIMUM Y	:	.715	.544	.589
MINIMUM Y	:	-1.544	-.611	-.566
CENTROID X	:	.045	-.137	.014
CENTROID Y	:	-.054	.117	.072
POA TO CENTROID in.	:	.070	.180	.073
MIN RADIUS	:	.452	.345	.341
MEAN RADIUS	:	.938	.757	.688
MAX RADIUS	:	2.248	1.261	.967
HORIZONTAL SPREAD	:	3.024	2.143	1.660
VERTICAL SPREAD	:	2.259	1.155	1.155
EXTREME SPREAD	:	3.668	2.353	1.717
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			9	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10
IN CIR
1in = 1
2in = 7
3in = 10
HS= 2.063
VS= 1.798
GS= 2.193

CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.331	1.247	.533
MINIMUM X	:	-.733	-.585	-.429
MAXIMUM Y	:	.799	.746	.785
MINIMUM Y	:	-.999	-1.052	-.959
CENTROID X	:	-.024	-.171	-.327
CENTROID Y	:	.082	.135	.042
POA TO CENTROID in.	:	.086	.218	.330
MIN RADIUS	:	.192	.043	.140
MEAN RADIUS	:	.809	.687	.564
MAX RADIUS	:	1.412	1.453	1.097
HORIZONTAL SPREAD	:	2.063	1.832	.962
VERTICAL SPREAD	:	1.798	1.798	1.744
EXTREME SPREAD	:	2.193	2.193	1.798
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS - 10

IN CIR

1 in = 4

2 in = 7

3 in = 10

HS = 2.019

VS = 2.500

GS = 2.543

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.872	.813	.662
MINIMUM X	:	-1.147	-1.206	-.703
MAXIMUM Y	:	1.119	.966	1.010
MINIMUM Y	:	-1.381	-.344	-.300
CENTROID X	:	.344	.403	.554
CENTROID Y	:	-.134	.019	-.025
POA TO CENTROID in.	:	.369	.403	.554
MIN RADIUS	:	.061	.216	.180
MEAN RADIUS	:	.687	.612	.497
MAX RADIUS	:	1.479	1.256	1.046
HORIZONTAL SPREAD	:	2.019	2.019	1.365
VERTICAL SPREAD	:	2.500	1.310	1.310
EXTREME SPREAD	:	2.543	2.103	1.524
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS

5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 2

2 in = 8

3 in = 9

HS = 2.419

VS = 1.960

GS = 2.422

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.508	.765	.702
MINIMUM X	:	-.911	-.742	-.648
MAXIMUM Y	:	.992	.971	.685
MINIMUM Y	:	-.968	-.989	-.867
CENTROID X	:	.209	.041	-.054
CENTROID Y	:	.072	.093	-.029
POA TO CENTROID in.	:	.221	.101	.062
MIN RADIUS	:	.328	.325	.377
MEAN RADIUS	:	.787	.676	.599
MAX RADIUS	:	1.519	1.236	.867
HORIZONTAL SPREAD	:	2.419	1.588	1.350
VERTICAL SPREAD	:	1.960	1.960	1.552
EXTREME SPREAD	:	2.422	2.134	1.553
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	