

C6636059

MODEL 700TM N24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5716**

* Includes 1 in chamber.

Remington

Remington




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

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

SERIAL NO.
C6636059

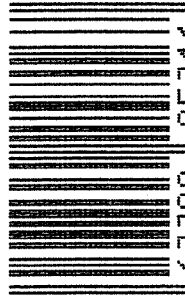
ORDER NO.
5716

MODEL 700TM M24

20

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

LPC



0 47700 25716 7



5716 C6636059

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636059

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 30	91	RW
600	Proof	4 30	91	RW
607	Check Headspace	4 30	91	RW
610	Dis-assemble Gun			RW
612	Magnaflux Barrel Action	5 6	91	Kcd
	Magnaflux Bolt	5 6	91	Kcd
615	Rollmark Caliber	5 6	91	GB
617	Drill and Tap Sight Holes	5 10	91	FB
618	Polish Barrel	5 10	91	WB
620	Apply Coatings (Barrel Action)		5-30-91	JS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		6/5/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6/5/91	RW
	C) Inspect Ejector Hole for Chamfer		6/5/91	RW
	D) Oil Firing Pin Ass'y		6/5/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		6-11-91	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 ³ / ₄	6	6			6-29-91	DH
	G) Safety Off Force	3	3	3			6-29-91	DH
	H) Trigger Pull Test & Retainability						6-11-91	JH
	I) Firing Pin Indent	.020	.020	.020			6-12-91	DH
	J) Assemble Stock						7/22/91	RW
	K) Assemble Swivel Studs						7-23-91	DH
	L) Attach Front and Rear Sight Assemblies						7/22/91	RW
	M) Iron Sight Alignment						7/22/91	RW
	N) Detach Front & Rear Sights & place in numbered container						7/22/91	RW
	O) Attach Scope to Rifle						7/22/91	RW
	P) Detach & Attach Scope 20 Times						7/22/91	RW
640	Gallery Target & Test						7-22-91	AC
	A) Time						7-22-91	AC
	B) Malfunctions						7-22-91	AC
	C) Pierced Primers						7-22-91	AC
	D) Optical Clarity of Scope						7-22-91	AC
645	Inspect for Live Ammo						7-22-91	AC
655	Final Inspection							
	A) Headspace						7-23-91	DH
	B) Trigger Pull	2.60	2.64	2.69	2.67	2.70	7-23-91	JH
	C) Function						7-23-91	DH
660	Pack						9-18-91	RF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO 66636059

DATE 6-11-81

TESTER Q1

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.16	2.41	2.60	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.43	2.35	2.39	2.64	
PULL #3	2.45	2.20	2.35	2.69	
PULL #4	2.28	2.43	2.44	2.67	
PULL #5	2.46	2.40	2.41	2.70	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.37	3.28		
PULL #2	3.37	3.46		
PULL #3	3.37	3.32		
PULL #4	3.34	3.43		
PULL #5	3.39	3.41		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.19	4.44		4.52
PULL #2	4.43	4.48		4.46
PULL #3	4.37	4.44		4.42
PULL #4	4.43	4.50		4.40
PULL #5	4.46	4.49		
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636059
23 Jul 1991

CENTROIDAL DISTANCES

0 TO 1	.293656
1 TO 2	.233418
1 TO 3	.324777
1 TO 4	.382256
1 TO 5	.293002

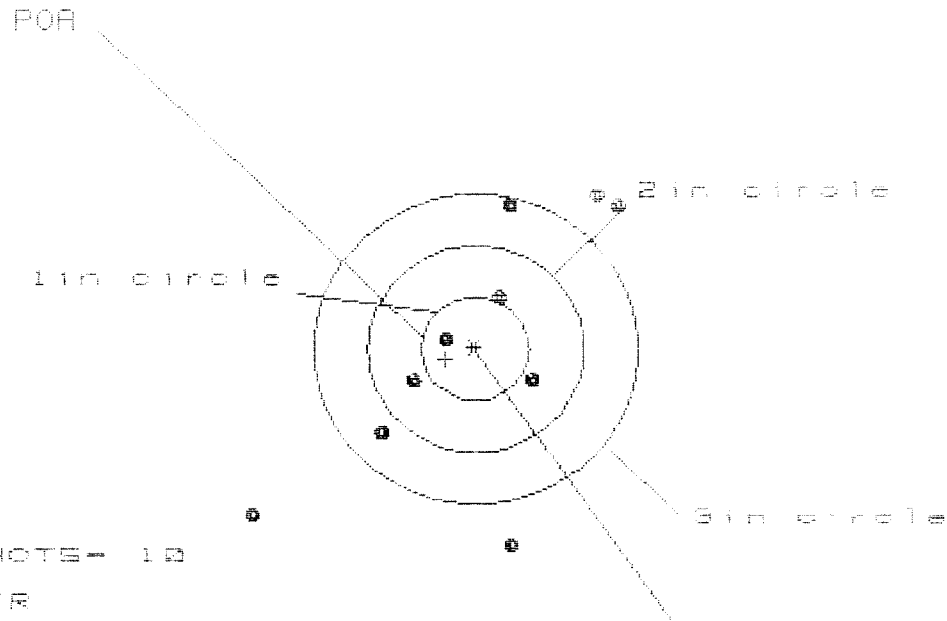
2, 4 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1888
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.055
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .197508
THE AMR FOR THIS RIFLE IS: 1.238

29 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08B36059

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 6

HS= 3.412

VS= 3.405

GS= 4.512

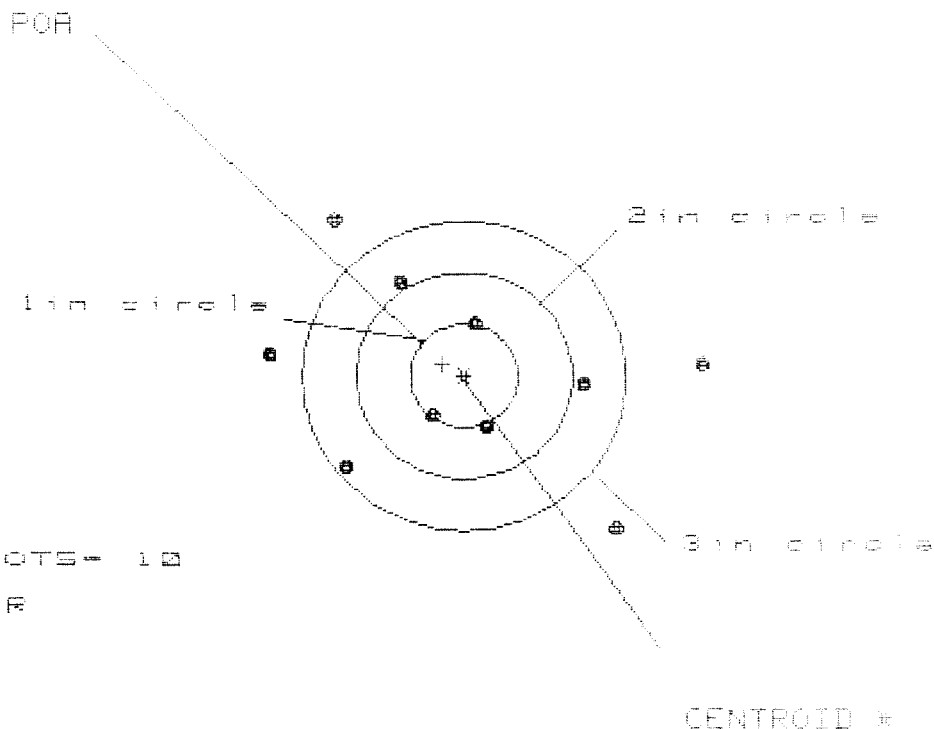
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.292	1.057	1.174
MINIMUM X	-2.121	-1.120	-1.003
MAXIMUM Y	1.514	1.339	1.374
MINIMUM Y	-1.891	-2.066	-1.898
CENTROID X	.275	.510	.393
CENTROID Y	.103	.278	.110
POA TO CENTROID in.	.293	.581	.408
MIN RADIUS	.315	.280	.424
MEAN RADIUS	1.298	1.137	1.059
MAX RADIUS	2.639	2.067	1.907
HORIZONTAL SPREAD	3.413	2.177	2.177
VERTICAL SPREAD	3.405	3.405	3.272
EXTREME SPREAD	4.512	3.515	3.394
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	6		

23 JUL 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8836059

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 1

2in = 3

3in = 6

HS= 3.972

VS= 3.027

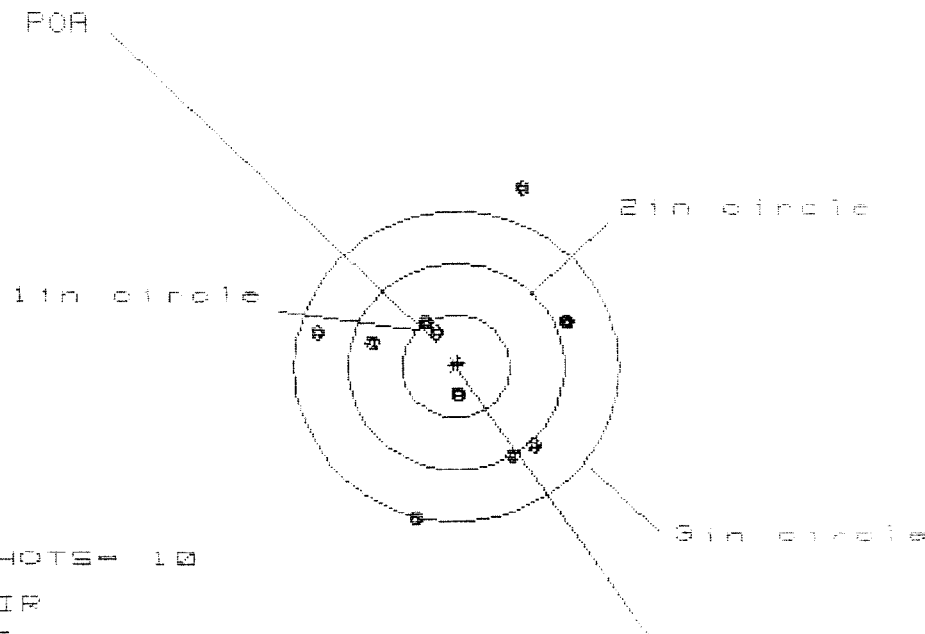
GS= 3.972

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	6
MAXIMUM X	2.178	1.608	1.538
MINIMUM X	-1.797	-1.555	-1.355
MAXIMUM Y	1.562	1.574	1.393
MINIMUM Y	-1.465	-1.453	-1.072
CENTROID X	.197	-.045	-.246
CENTROID Y	-.117	-.129	.052
POA TO CENTROID in.	.229	.137	.251
MIN RADIUS	.479	.382	.587
MEAN RADIUS	1.309	1.200	1.082
MAX RADIUS	2.178	2.167	1.584
HORIZONTAL SPREAD	3.972	3.163	2.884
VERTICAL SPREAD	3.027	3.027	2.465
EXTREME SPREAD	3.972	3.967	2.891
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	6		

23 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636059

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 2

2in = 4

3in = 8

HS = 2.231

VS = 3.200

CS = 3.360

CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.993	1.061	1.018
MINIMUM X	:	-1.238	-1.170	-1.213
MAXIMUM Y	:	1.696	.672	.508
MINIMUM Y	:	-1.504	-1.316	-1.866
CENTROID X	:	-.019	-.087	-.044
CENTROID Y	:	-.035	-.223	-.058
FOR TO CENTROID in.	:	.040	.239	.073
MIN RADIUS	:	.306	.155	.286
MEAN RADIUS	:	.991	.891	.817
MAX RADIUS	:	1.802	1.361	1.271
HORIZONTAL SPREAD	:	2.231	2.231	2.231
VERTICAL SPREAD	:	3.200	1.988	1.373
EXTREME SPREAD	:	3.360	2.386	2.300
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

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FILE:/PATTERNING/CENTERFIRE_PATT/08636359

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 0

2in = 1

3in = 6

HS= 2.942

VS= 3.728

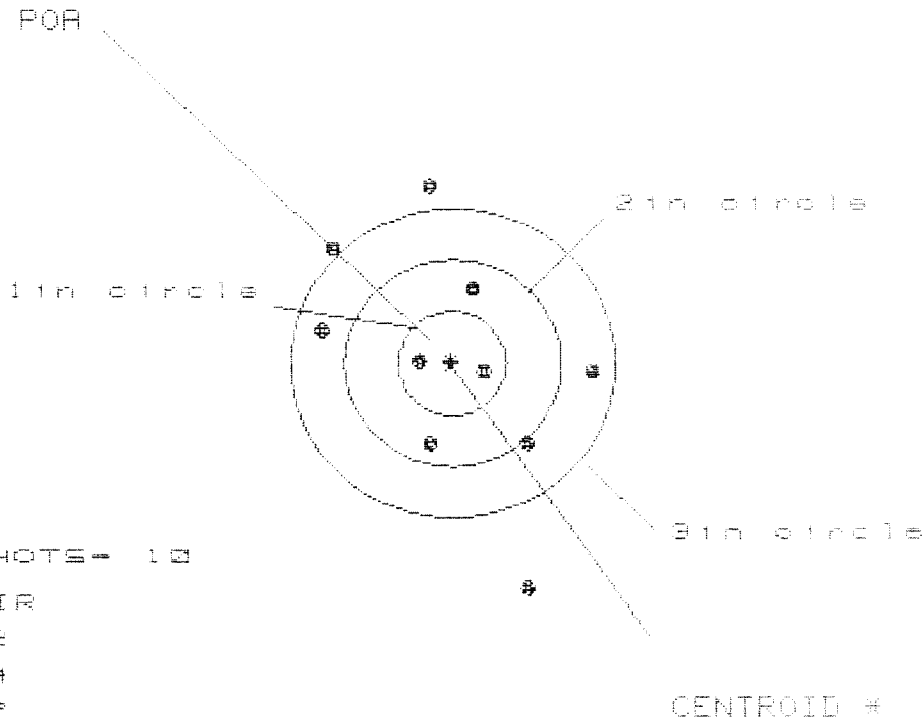
GS= 3.956

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.753	1.885	1.784
MINIMUM X	:	-1.189	-1.137	-1.238
MAXIMUM Y	:	1.679	1.452	1.489
MINIMUM Y	:	-2.049	-1.611	-1.438
CENTROID X	:	.481	.429	.536
CENTROID Y	:	-.219	.068	-.173
POA TO CENTROID in.	:	.529	.429	.557
MIN RADIUS	:	.823	.874	.772
MEAN RADIUS	:	1.439	1.343	1.381
MAX RADIUS	:	2.101	1.816	1.746
HORIZONTAL SPREAD	:	2.942	2.942	2.942
VERTICAL SPREAD	:	3.728	3.063	2.839
EXTREME SPREAD	:	3.956	3.263	2.958
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	1		
NUMBER IN THREE INCH CIRCLE	=	6		

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CENTERFIRE PATTERNS # 5



OF SHOTS = 10
 # IN CIR
 1in = 2
 2in = 4
 3in = 7
 HS = 2.440
 VS = 3.946
 GS = 4.065

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.242	1.323	1.302
MINIMUM X	-1.198	-1.117	-1.138
MAXIMUM Y	1.764	1.522	1.030
MINIMUM Y	-2.182	-1.035	-1.845
CENTROID X	.010	-.071	-.050
CENTROID Y	-.022	.220	.030
POA TO CENTROID in.	.024	.231	.058
MIN RADIUS	.296	.329	.230
MEAN RADIUS	1.127	.993	.900
MAX RADIUS	2.299	1.531	1.449
HORIZONTAL SPREAD	2.440	2.440	2.440
VERTICAL SPREAD	3.946	2.557	1.875
EXTREME SPREAD	4.065	2.714	2.550
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		