

C6348819

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Smead[®]



MODEL 700™ H24



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

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

SERIAL NO.
C6348819

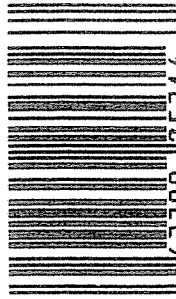
ORDER NO.
5716

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



5716 C6348819

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6348819

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 11	89	RW
600	Proof	7 11	89	RW
607	Check Headspace	7 11	89	RW
610	Dis-assemble Gun			RW
612	Magnaflux Barrel Action		7/13	KCR
	Magnaflux Bolt	8 13	7/13	KCR
615	Rollmark Caliber		7/13	LSJ.
617	Drill and Tap Sight Holes	7 13	89	YB
618	Polish Barrel RB	7 13	89	BT
620	Apply Coatings (Barrel Action)		7/21/89	TJA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		7/25/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/25/89	RW
	C) Inspect Ejector Hole for Chamfer		7/25/89	RW
	D) Oil Firing Pin Ass'y		7/25/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		7/28/89	FC

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/4	5 1/4	5 1/4			7/28/89	WB
	G) Safety Off Force	3	3	3			7/28/89	WB
	H) Trigger Pull Test & Retainability						7/28/89	JU.
	I) Firing Pin Indent	.022	.022	.0215			7/28/89	WB
	J) Assemble Stock						7/31/89	RW
	K) Assemble Swivel Studs						1 Aug 89	JSS
	L) Attach Front and Rear Sight Assemblies						7/31/89	RW
	M) Iron Sight Alignment						7/31/89	RW
	N) Detach Front & Rear Sights & place in numbered container						7/31/89	RW
	O) Attach Scope to Rifle						7/31/89	JU
	P) Detach & Attach Scope 20 Times						7/31/89	JU
640	Gallery Target & Test	75 R	75 L				7-31-89	AC
	A) Time						7-31-89	AC
	B) Malfunctions						7-31-89	AC
	C) Pierced Primers						7-31-89	AC
	D) Optical Clarity of Scope						7-31-89	AC
645	Inspect for Live Ammo						7-31-89	AC
655	Final Inspection							
	A) Headspace						1 Aug 89	JSS
	B) Trigger Pull	2.41	2.54	2.07	2.47	2.32	1 Aug 89	JSS
	C) Function						1 Aug 89	JSS
660	Pack						20 Sept 89	JSS

Repaired Stock at Front Swivel
9/13/89

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50#+.50#
3.00#+.75#
4.00#+1.00#

SERIAL NO. 8819
C6348785

DATE 27 Oct 89

TESTER JS

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	254	246	248	246	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	254	248	249	248	
PULL #3	247	246	271	246	
PULL #4	243	248	257	246	
PULL #5	244	242	252	251	
TOTAL	1242	1230	1275	1237	
AVG.	2.484	2.46	2.55	2.474	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	335	333		
PULL #2	333	339		
PULL #3	343	335		
PULL #4	338	338		
PULL #5	337	330		
TOTAL	1686	1675		
AVG.	3.372	3.35		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	393	399		412
PULL #2	407	405		410
PULL #3	401	407		391
PULL #4	418	412		384
PULL #5	410	385		392
TOTAL	2029	2008		1989
AVG.	4.058	4.016		3.978

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348819
31 Jul 1989

CENTROIDAL DISTANCES

0 TO 1	.647476
1 TO 2	.295652
1 TO 3	.552835
1 TO 4	.120934
1 TO 5	.162114

+24 ←---POA
34

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .45
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2786
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .529262
THE AMR FOR THIS RIFLE IS: 1.167

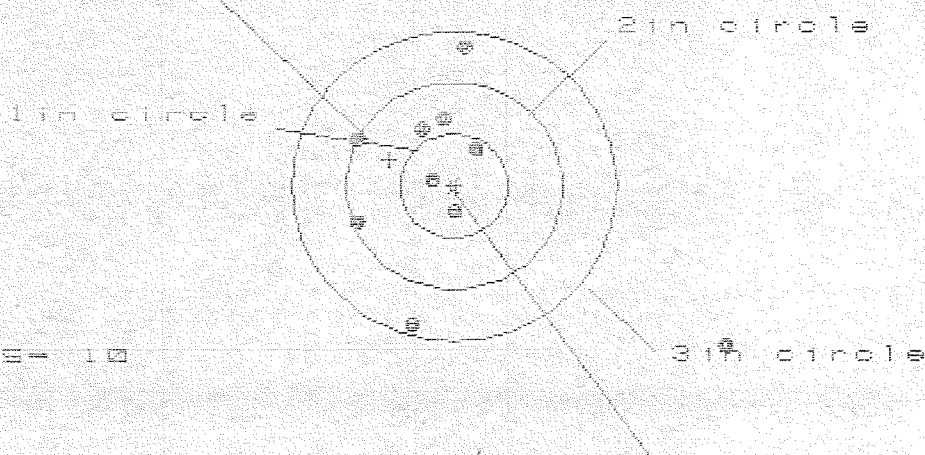
31 Jul 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C834B819

CENTERFIRE PATTERNS

1

POA



OF SHOTS= 10

IN CIR

1in = 3

2in = 6

3in = 9

HS= 3.409

VS= 2.943

GS= 3.967

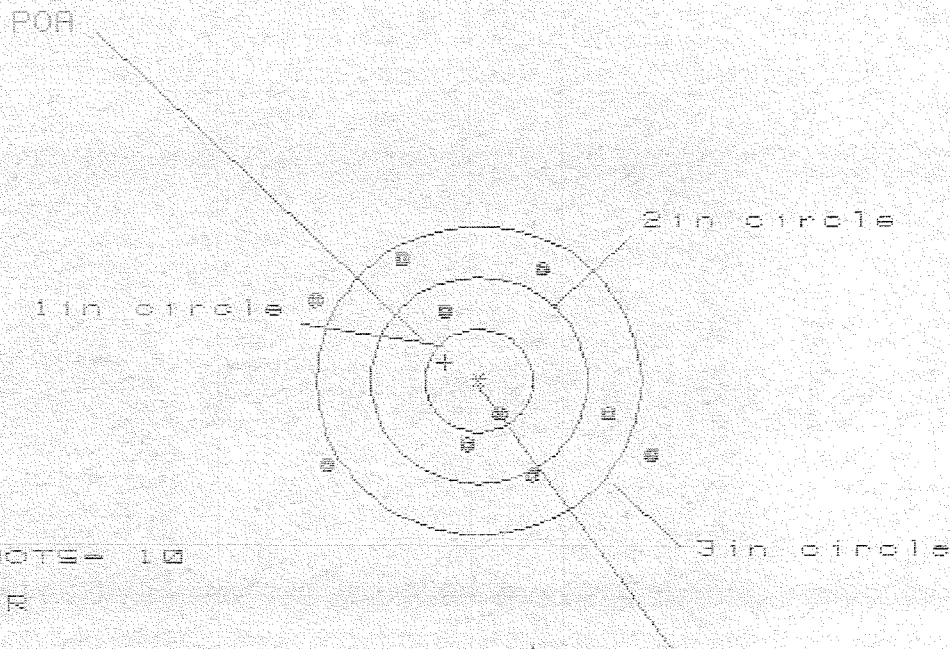
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.505	.486	.531
MINIMUM X	:	-.905	-.626	-.581
MAXIMUM Y	:	1.401	1.230	.682
MINIMUM Y	:	-1.542	-1.481	-1.327
CENTROID X	:	.596	.317	.272
CENTROID Y	:	-.253	-.082	-.236
POA TO CENTROID in.	:	.647	.329	.360
MIN RADIUS	:	.244	.169	.081
MEAN RADIUS	:	.993	.713	.642
MAX RADIUS	:	2.941	1.482	1.327
HORIZONTAL SPREAD	:	3.409	1.112	1.112
VERTICAL SPREAD	:	2.943	2.711	2.089
EXTREME SPREAD	:	3.967	2.745	2.025
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

31 Jul 1989

FILE:/PATTERNING/CENTERFIRE_PATT/CS348819

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 3

3 in = 7

HS= 3.169

VS= 2.056

GS= 3.497

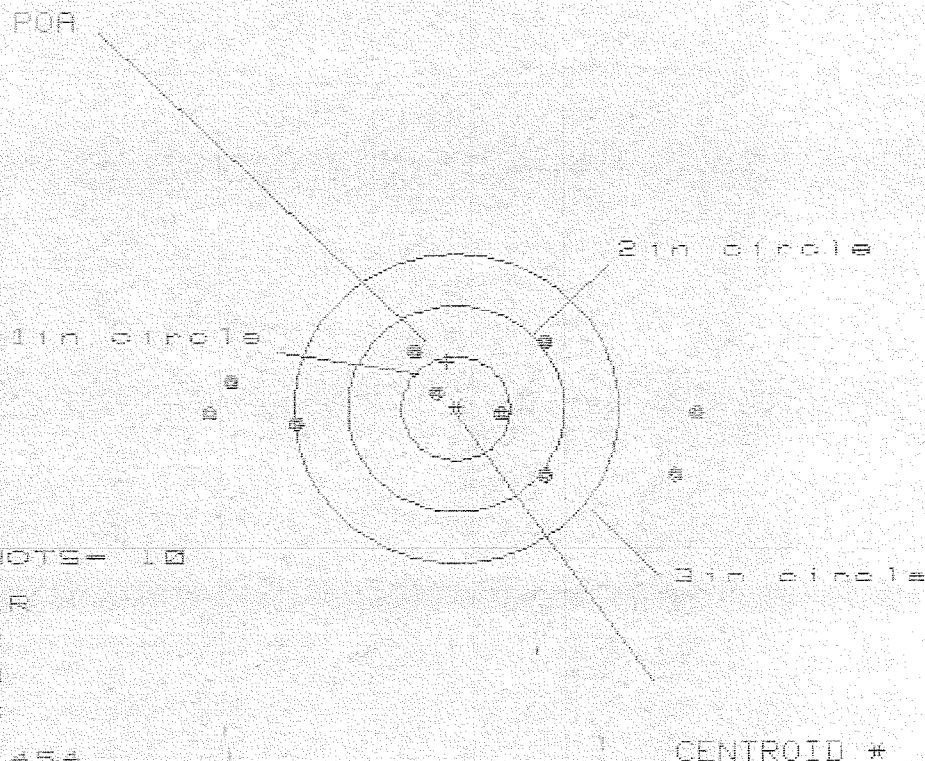
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.631	1.355	1.185
MINIMUM X	:	-1.538	-1.357	-1.400
MAXIMUM Y	:	1.176	1.095	1.179
MINIMUM Y	:	-0.880	-0.961	-0.877
CENTROID X	:	.309	.128	.298
CENTROID Y	:	-.182	-.101	-.185
POA TO CENTROID in.	:	.359	.163	.350
MIN RADIUS	:	.333	.503	.336
MEAN RADIUS	:	1.169	1.106	1.024
MAX RADIUS	:	1.785	1.539	1.633
HORIZONTAL SPREAD	:	3.169	2.712	2.585
VERTICAL SPREAD	:	2.056	2.056	2.056
EXTREME SPREAD	:	3.497	2.911	2.723
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		7	

31 Jul 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C834B813

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 2

2in = 3

3in = 6

HS = 4.454

VS = 1.386

GS = 4.455

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.209	1.960	2.049
MINIMUM X	:	-2.245	-2.284	-2.039
MAXIMUM Y	:	.691	.690	.678
MINIMUM Y	:	-.695	-.696	-.708
CENTROID X	:	.081	.330	.085
CENTROID Y	:	-.454	-.453	-.442
POA TO CENTROID in.	:	.481	.561	.450
MIN RADIUS	:	.234	.145	.228
MEAN RADIUS	:	1.354	1.232	1.134
MAX RADIUS	:	2.245	2.298	2.149
HORIZONTAL SPREAD	:	4.454	4.244	4.089
VERTICAL SPREAD	:	1.386	1.386	1.386
EXTREME SPREAD	:	4.455	4.258	4.185
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		6	

31 Jul 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C834B019

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS = 4.364

VS = 1.868

GS = 4.370

CENTROID *

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.769	1.481	.865
MINIMUM X	:	-2.595	-1.166	-.981
MAXIMUM Y	:	.884	.943	.990
MINIMUM Y	:	-.984	-.925	-.878
CENTROID X	:	.548	.836	.651
CENTROID Y	:	-.142	-.201	-.247
POA TO CENTROID in.	:	.566	.860	.697
MIN RADIUS	:	.161	.176	.016
MEAN RADIUS	:	1.046	.850	.736
MAX RADIUS	:	2.649	1.526	1.193
HORIZONTAL SPREAD	:	4.364	2.647	1.846
VERTICAL SPREAD	:	1.868	1.868	1.868
EXTREME SPREAD	:	4.370	2.647	2.352
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

31 Jul 1989

FILE:/PATTERNING/CENTERFIRE_PATT/08348819

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 2

2in = 4

3in = 6

HS = 4.209

VS = 2.768

GS = 4.732

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

2.476

2.171

2.031

MINIMUM X

-1.733

-1.457

-1.597

MAXIMUM Y

1.839

1.741

.520

MINIMUM Y

-.929

-1.027

-.889

CENTROID X

.716

.440

.580

CENTROID Y

-.362

-.264

-.482

POA TO CENTROID in.

.802

.514

.754

MIN RADIUS

.227

.209

.105

MEAN RADIUS

1.274

1.067

.924

MAX RADIUS

2.629

2.179

2.071

HORIZONTAL SPREAD

4.209

3.628

3.628

VERTICAL SPREAD

2.768

2.768

1.329

EXTREME SPREAD

4.732

3.637

3.628

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

4

NUMBER IN THREE INCH CIRCLE =

6