

C6649123

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington




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

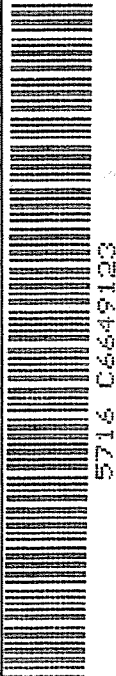
REG. U.S. PAT. & TM. OFF.

MODEL 700TM H24

SERIAL NO. C6649123

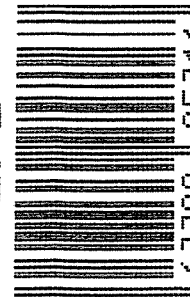
ORDER NO. 5716

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



5716 C6649123

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6649123

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/26/91	KH
600	Proof		6/26/91	KH
607	Check Headspace		6/26/91	KH
610	Dis-assemble Gun		6/26/91	KH
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	AS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/29/91	KH
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/29/91	KH
	C) Inspect Ejector Hole for Chamfer		8/29/91	KH
	D) Oil Firing Pin Ass'y		8/29/91	KH
	E) Adjust Trigger Pull to Min Setting and Stake		9/14/91	GH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			9/4/91	JK
	G) Safety Off Force	2	2	2			9/4/91	JK
	H) Trigger Pull Test & Retainability						9/4/91	JK
	I) Firing Pin Indent	.0225	.0215	.022			9/4/91	JK
	J) Assemble Stock						9/4/91	JK
	K) Assemble Swivel Studs						9/12/91	JK
	L) Attach Front and Rear Sight Assemblies						9/4/91	JK
	M) Iron Sight Alignment						9/4/91	JK
	N) Detach Front & Rear Sights & place in numbered container						9/4/91	JK
	O) Attach Scope to Rifle						9/4/91	JK
	P) Detach & Attach Scope 20 Times						9/4/91	JK
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							
	A) Headspace						9/12/91	JK
	B) Trigger Pull	2.56	2.59	2.68	2.70	2.76	9/6/91	JK
	C) Function						9/12/91	JK
660	Pack						9-15-91	AF

SWS TRIGGER PULL TEST

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

SERIAL NO C-6649123

DATE 9/4/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.40	2.44	2.56	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.38	2.39	2.40	2.54	
PULL #3	2.40	2.44	2.39	2.68	
PULL #4	2.38	2.38	2.45	2.70	
PULL #5	2.32	2.42	2.41	2.70	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.58	3.53		
PULL #2	3.54	3.60		
PULL #3	3.57	3.54		
PULL #4	3.57	3.53		
PULL #5	3.40	3.56		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.30	4.31		4.37
PULL #2	4.32	4.36		4.42
PULL #3	4.31	4.38		4.36
PULL #4	4.31	4.36		4.30
PULL #5	4.30	4.34		4.44
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649123
5 Sep 1991

CENTROIDAL DISTANCES

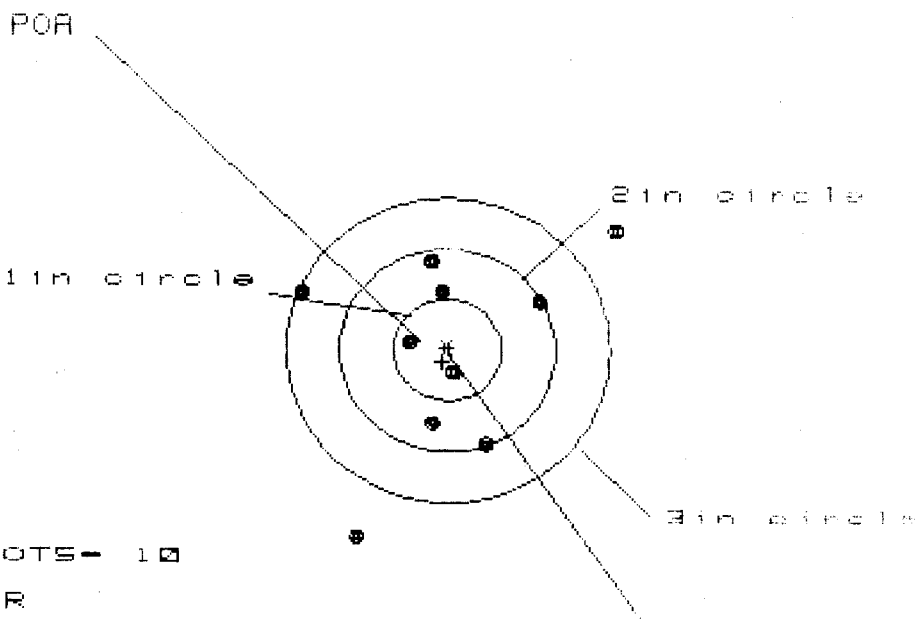
0 TO	1	.0939628
1 TO	2	.194139
1 TO	3	.209955
1 TO	4	.247032
1 TO	5	.0817068

38 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0344
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0954
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .101415
THE AMR FOR THIS RIFLE IS: .9732

FILE:/PATTERNING/CENTERFIRE_PATT/C6649123

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 2.915

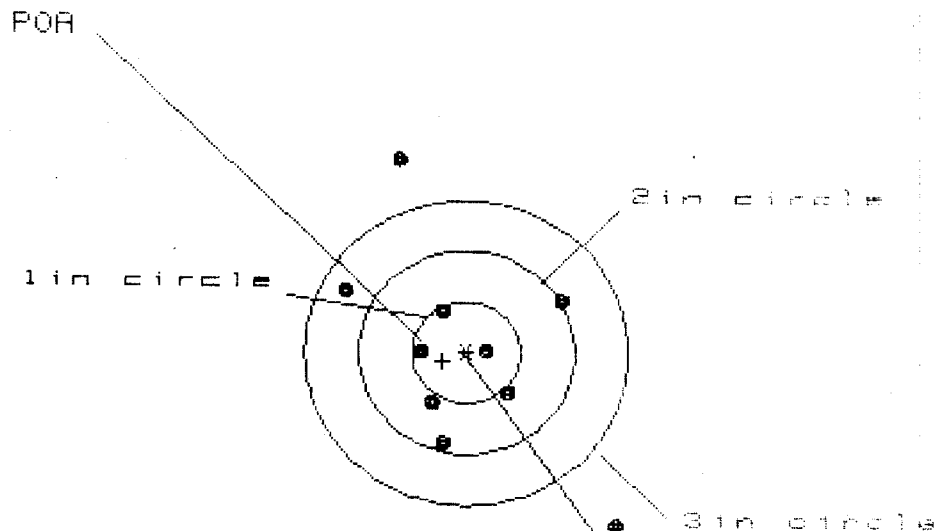
VS= 2.978

GS= 3.818

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.549	1.456	.982
MINIMUM X	:	-1.366	-1.459	-1.277
MAXIMUM Y	:	1.165	.964	.770
MINIMUM Y	:	-1.813	-1.131	-1.011
CENTROID X	:	.049	.142	-.040
CENTROID Y	:	.120	.321	.201
POA TO CENTROID in.	:	.130	.351	.205
MIN RADIUS	:	.276	.430	.244
MEAN RADIUS	:	1.024	.917	.782
MAX RADIUS	:	1.998	1.746	1.361
HORIZONTAL SPREAD	:	2.915	2.915	2.260
VERTICAL SPREAD	:	2.978	2.095	1.781
EXTREME SPREAD	:	3.818	2.979	2.276
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in - 4

2 in - 6

3 in - 8

HS- 2.515

VS- 3.573

GS- 4.115

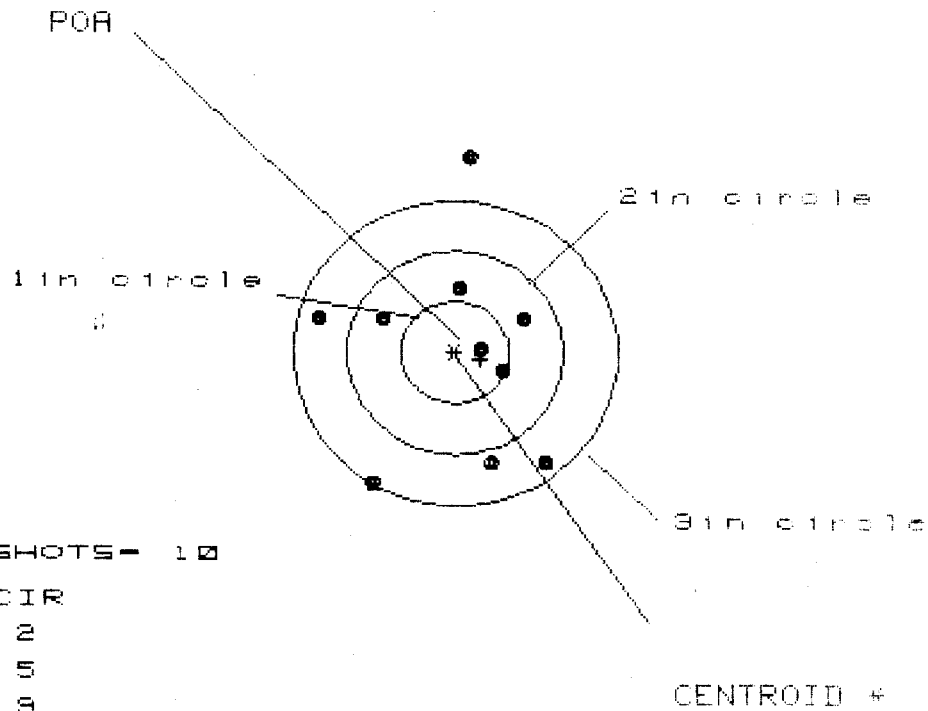
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.394	1.057	.996
MINIMUM X	-1.121	-.966	-1.027
MAXIMUM Y	1.881	1.693	.604
MINIMUM Y	-1.692	-1.054	-.843
CENTROID X	.220	.065	.126
CENTROID Y	.086	.274	.063
POA TO CENTROID in.	.236	.282	.141
MIN RADIUS	.200	.233	.296
MEAN RADIUS	.945	.810	.656
MAX RADIUS	2.193	1.763	1.192
HORIZONTAL SPREAD	2.515	2.023	2.023
VERTICAL SPREAD	3.573	2.747	1.447
EXTREME SPREAD	4.115	2.782	2.026
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 2.137

VS= 3.161

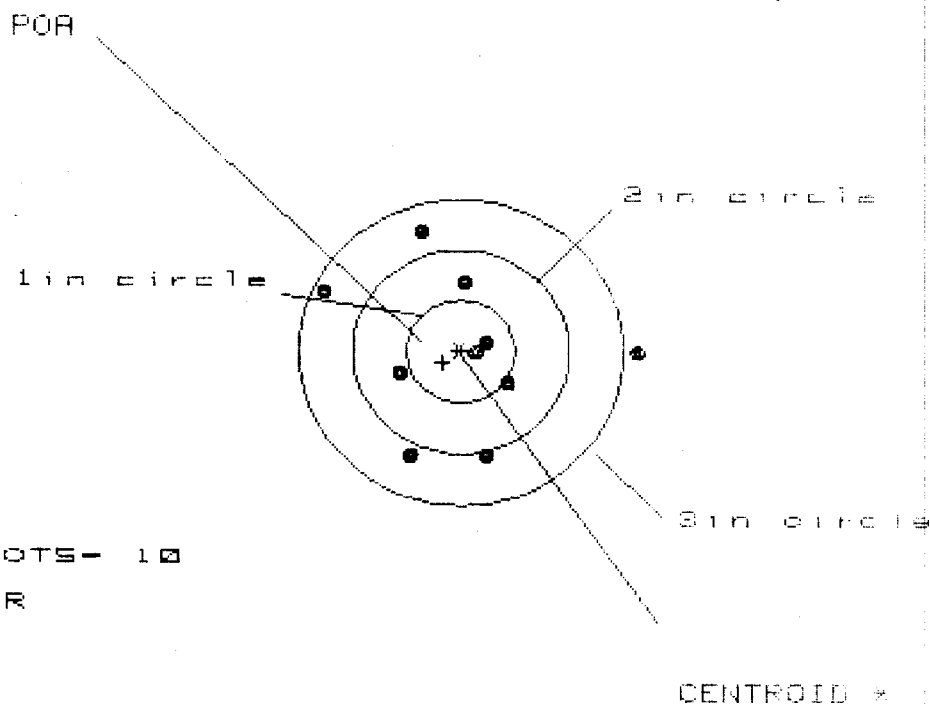
GS= 3.302

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.844	.862	.765
MINIMUM X	:	-1.293	-1.275	-1.372
MAXIMUM Y	:	1.904	.854	.724
MINIMUM Y	:	-1.257	-1.046	-.961
CENTROID X	:	-.236	-.254	-.157
CENTROID Y	:	.070	-.141	-.011
POA TO CENTROID in.	:	.246	.290	.157
MIN RADIUS	:	.201	.296	.140
MEAN RADIUS	:	.988	.893	.797
MAX RADIUS	:	1.911	1.381	1.429
HORIZONTAL SPREAD	:	2.137	2.137	2.137
VERTICAL SPREAD	:	3.161	1.900	1.685
EXTREME SPREAD	:	3.302	2.534	2.534
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

10/1/1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS= 2.899

VS= 2.188

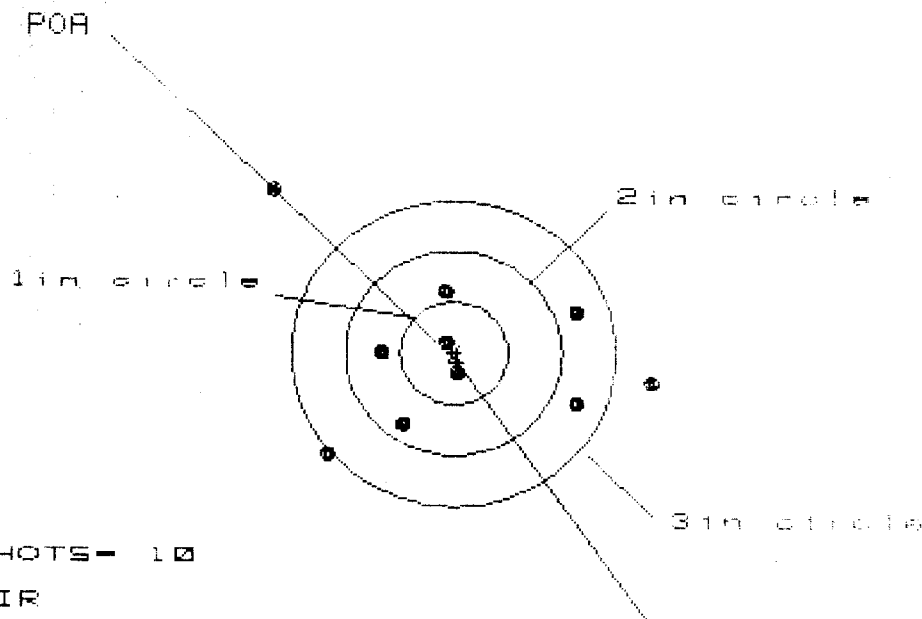
GS= 2.963

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.638	.585	.450
MINIMUM X	:	-1.261	-1.079	-.522
MAXIMUM Y	:	1.168	1.170	1.248
MINIMUM Y	:	-1.020	-1.018	-.940
CENTROID X	:	.166	-.016	.118
CENTROID Y	:	.111	.109	.031
POA TO CENTROID in.	:	.199	.110	.122
MIN RADIUS	:	.115	.297	.185
MEAN RADIUS	:	.863	.793	.706
MAX RADIUS	:	1.638	1.247	1.286
HORIZONTAL SPREAD	:	2.899	1.664	.972
VERTICAL SPREAD	:	2.188	2.188	2.188
EXTREME SPREAD	:	2.963	2.270	2.270
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	9		

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FILE: PATTERNING/CENTERFIRE_PATT/06649123

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 7

HS= 3.418

VS= 2.626

GS= 3.903

CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.782	1.600	1.157
MINIMUM X	:	-1.636	-1.366	-1.165
MAXIMUM Y	:	1.608	.789	.777
MINIMUM Y	:	-1.018	-.840	-.852
CENTROID X	:	-.027	.155	-.045
CENTROID Y	:	.090	-.088	-.076
POA TO CENTROID in.	:	.094	.178	.009
MIN RADIUS	:	.123	.134	.074
MEAN RADIUS	:	1.046	.925	.894
MAX RADIUS	:	2.294	1.603	1.157
HORIZONTAL SPREAD	:	3.418	2.966	2.000
VERTICAL SPREAD	:	2.626	1.629	1.629
EXTREME SPREAD	:	3.903	3.057	2.706
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	