

C6649267

MODEL 700TM M24

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.
C6649267

ORDER NO.
5716

MODEL 700TM H24

20

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



5716 C6649267

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649267

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 25	9 1	RW
600	Proof	6 25	9 1	RW
607	Check Headspace	6 25	8 1	RW
610	Dis-assemble Gun	6 25	-	RW
612	Magnaflux Barrel Action	JUL	1 1991	KR
	Magnaflux Bolt	JUL	1 1991	KR
615	Rollmark Caliber	JUL	1 1991	LG
617	Drill and Tap Sight Holes	JUL	1 1991	LB
618	Polish Barrel	JUL	2 19.	WB
620	Apply Coatings (Barrel Action)		8/27/91	WB
	Apply Coating (Bolt)			WB
625	Final Assembly A) Clean inside of Bolt Assembly		8/28/91	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/28/91	WB
	C) Inspect Ejector Hole for Chamfer		8/28/91	WB
	D) Oil Firing Pin Ass'y		8/28/91	WB
	E) Adjust Trigger Pull to Min Setting and Stake		8/26/91	JU.

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5	4		8/26/91	DH
	G) Safety Off Force	3	3	3			8/26/91	DH
	H) Trigger Pull Test & Retainability						8/26/91	JU
	I) Firing Pin Indent	.020	.020	.021			8/26/91	DH
	J) Assemble Stock							
	K) Assemble Swivel Studs						8-31-91	DH
	L) Attach Front and Rear Sight Assemblies						8/28/91	RW
	M) Iron Sight Alignment						8/28/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/28/91	RW
	O) Attach Scope to Rifle						8/28/91	RW
	P) Detach & Attach Scope 20 Times						8/28/91	RW
640	Gallery Target & Test						8-31-91	AC
	A) Time						8-31-91	AC
	B) Malfunctions						8-31-91	AC
	C) Pierced Primers						8-31-91	AC
	D) Optical Clarity of Scope						8-31-91	AC
645	Inspect for Live Ammo						8-31-91	AC
655	Final Inspection						8-31-91	DH
	A) Headspace							
	B) Trigger Pull	2.63	2.38	2.40	2.36	2.44	8/29/91	JU
	C) Function						8-31-91	DH
660	Pack						9-17-91	DH

SWS TRIGGER PULL TEST

TIME 317

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C-6649267

DATE 8/26/91

TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.25	2.36	2.63	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.33	2.26	2.44	2.38	
PULL #3	2.23	2.56	2.50	2.40	
PULL #4	2.25	2.41	2.51	2.36	
PULL #5	2.19	2.53	2.50	2.44	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.67	3.45		
PULL #2	3.66	3.42		
PULL #3	3.56	3.56		
PULL #4	3.42	3.49		
PULL #5	3.48	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	4.18	4.34		4.54
PULL #2	4.36	4.41		4.49
PULL #3	4.43	4.46		4.49
PULL #4	4.37	4.39		4.49
PULL #5	4.33	4.45		4.50
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649267
27 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.80506
1 TO	2	1.05268
1 TO	3	.772544
1 TO	4	.601592
1 TO	5	.755219

24
5) <----POR

AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2228
AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0854
RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .238606
RMR FOR THIS RIFLE IS: 1.217

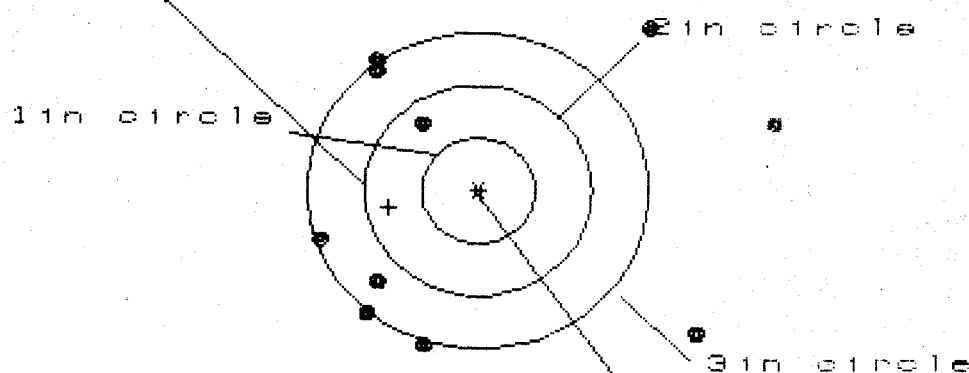
27 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649267

CENTERFIRE PATTERNS

1

POA



OF SHOTS- 10

IN CIR

1in = 0

2in = 1

3in = 4

HS= 3.996

VS= 2.931

GS= 4.128

CENTROID *

PATTERN #

SHOTS (BEST OF)

MAXIMUM X

MINIMUM X

MAXIMUM Y

MINIMUM Y

CENTROID X

CENTROID Y

POA TO CENTROID in.

MIN RADIUS

MEAN RADIUS

MAX RADIUS

HORIZONTAL SPREAD

VERTICAL SPREAD

EXTREME SPREAD

NUMBER IN ONE INCH CIRCLE =

NUMBER IN TWO INCH CIRCLE =

NUMBER IN THREE INCH CIRCLE =

10

9

8

2.614

2.172

2.121

-1.382

-1.091

-.820

1.504

1.573

1.416

-1.427

-1.358

-1.515

.789

.498

.227

.160

.091

.248

.805

.506

.336

.795

.731

.558

1.668

1.478

1.280

2.688

2.508

2.551

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3.263

2.941

2.931

2.931

2.931

4.128

3.808

3.715

0

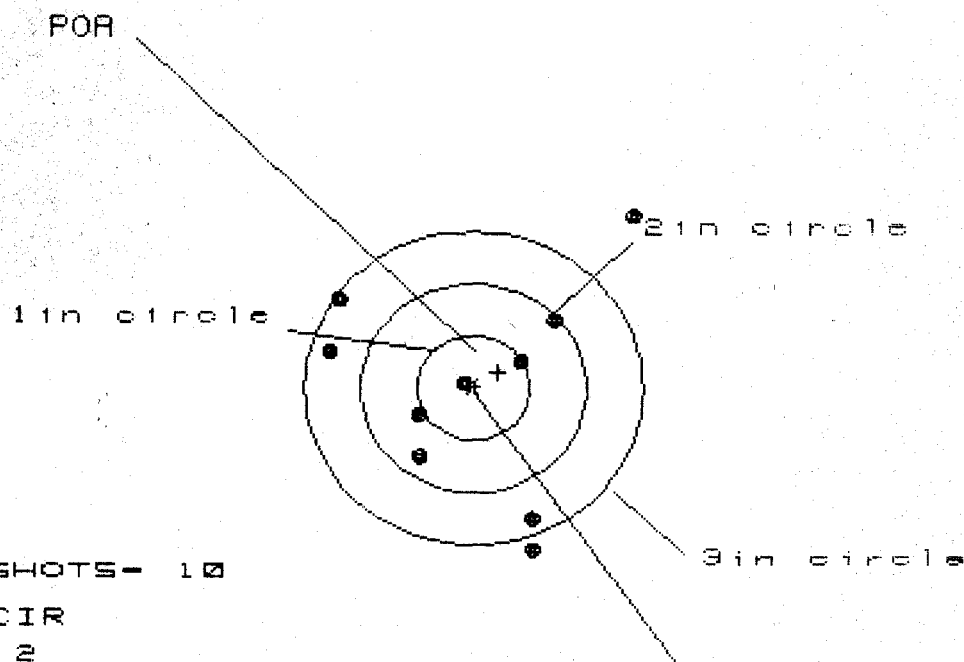
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4

27 Aug 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.730

VS= 3.178

GS= 3.293

CENTROID #

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.403	.839	.926
MINIMUM X	:	-1.327	-1.172	-1.085
MAXIMUM Y	:	1.606	.998	.823
MINIMUM Y	:	-1.572	-1.393	-1.230
CENTROID X	:	-.217	-.373	-.460
CENTROID Y	:	-.150	-.329	-.154
POR TO CENTROID in.	:	.264	.497	.485
MIN RADIUS	:	.136	.257	.152
MEAN RADIUS	:	1.074	.941	.843
MAX RADIUS	:	2.132	1.557	1.446
HORIZONTAL SPREAD	:	2.730	2.011	2.011
VERTICAL SPREAD	:	3.178	2.391	2.053
EXTREME SPREAD	:	3.293	2.938	2.657
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			8	

27 Aug 1991

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CENTERFIRE PATTERNS

3

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 1

2in = 4

3in = 8

HS= 2.356

VS= 2.975

GS= 3.654

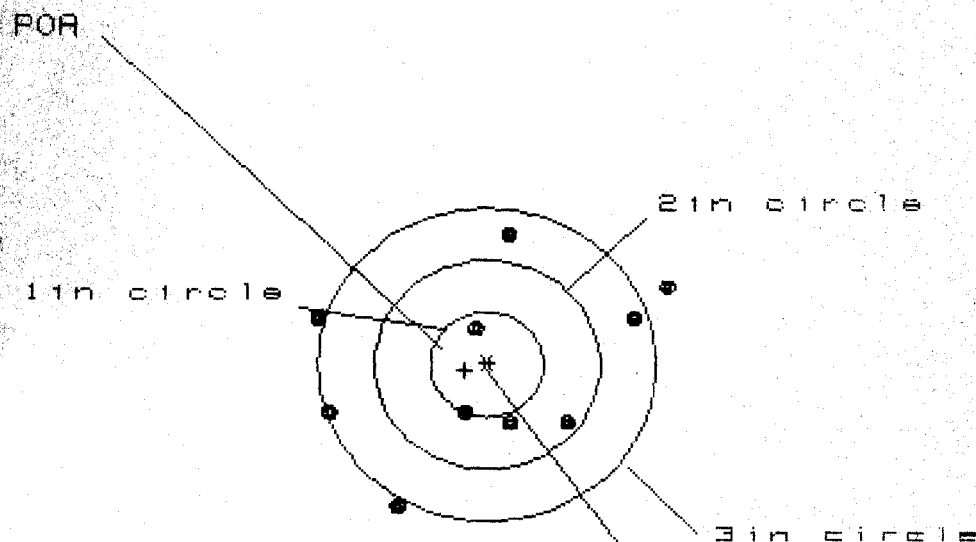
CENTROID *

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.234	1.340	1.246
MINIMUM X	:	-1.122	-.985	-1.079
MAXIMUM Y	:	1.515	1.372	1.211
MINIMUM Y	:	-1.460	-1.292	-.887
CENTROID X	:	.056	-.081	.013
CENTROID Y	:	-.084	-.252	-.091
POA TO CENTROID in.	:	.101	.265	.092
MIN RADIUS	:	.342	.125	.309
MEAN RADIUS	:	1.188	1.075	1.023
MAX RADIUS	:	1.954	1.514	1.517
HORIZONTAL SPREAD	:	2.356	2.325	2.325
VERTICAL SPREAD	:	2.975	2.664	2.098
EXTREME SPREAD	:	3.654	2.920	2.540
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			4	
NUMBER IN THREE INCH CIRCLE =			8	

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CENTERFIRE PATTERNS # 4



* OF SHOTS- 10

* IN CIR

1in = 1

2in = 4

3in = 7

HS= 3.129

VS= 2.625

GS= 3.234

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.595	1.529	1.359
MINIMUM X	:	-1.534	-1.357	-1.373
MAXIMUM Y	:	1.285	1.373	1.439
MINIMUM Y	:	-1.340	-1.252	-1.186
CENTROID X	:	.197	.020	.190
CENTROID Y	:	.053	-.035	-.101
POA TO CENTROID in.	:	.204	.040	.215
MIN RADIUS	:	.346	.393	.396
MEAN RADIUS	:	1.150	1.066	.996
MAX RADIUS	:	1.779	1.631	1.500
HORIZONTAL SPREAD	:	3.129	2.886	2.732
VERTICAL SPREAD	:	2.625	2.625	2.625
EXTREME SPREAD	:	3.234	2.886	2.875
NUMBER IN ONE INCH CIRCLE =	:	1	4	7
NUMBER IN TWO INCH CIRCLE =	:	4	7	
NUMBER IN THREE INCH CIRCLE =	:	7		

CENTERFIRE PATTERNS

5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 3

2 in = 6

3 in = 7

HS = 3.362

VS = 2.413

GS = 3.408

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.459	1.248	1.342
MINIMUM X	:	-1.903	-.712	-.618
MAXIMUM Y	:	.910	.907	.719
MINIMUM Y	:	-1.503	-1.506	-1.032
CENTROID X	:	.289	.500	.406
CENTROID Y	:	-.406	-.403	-.215
POA TO CENTROID in.	:	.499	.643	.459
MIN RADIUS	:	.334	.472	.297
MEAN RADIUS	:	1.004	.931	.767
MAX RADIUS	:	1.903	1.686	1.383
HORIZONTAL SPREAD	:	3.362	1.960	1.960
VERTICAL SPREAD	:	2.413	2.413	1.751
EXTREME SPREAD	:	3.408	2.691	2.117
NUMBER IN ONE INCH CIRCLE =	:	3		
NUMBER IN TWO INCH CIRCLE =	:	6		
NUMBER IN THREE INCH CIRCLE =	:	7		