

C6611380

MODEL 700TM M24

Model **SWS**TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



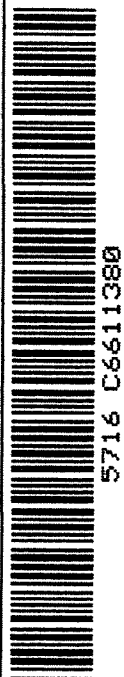
Remington[®] **DU PONT**
REG. U.S. PAT. & TM. OFF.

MODEL 700TM H24

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

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

SERIAL NO. C6611380	ORDER NO. 5716
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CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611380

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 25 91		RW
600	Proof	1 25 91		RW
607	Check Headspace	1 25 91		RW
610	Dis-assemble Gun	1 25 91		RW
612	Magnaflux Barrel Action	1 25 91		KR
	Magnaflux Bolt	1 25 91		KR
615	Rollmark Caliber	1 25 91		GL
617	Drill and Tap Sight Holes	1 30 91		FB
618	Polish Barrel RBB	1 30 91		WB
620	Apply Coatings (Barrel Action)		2-10-91	TJA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		2/11/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/11/91	RW
	C) Inspect Ejector Hole for Chamfer		2/11/91	RW
	D) Oil Firing Pin Ass'y		2/11/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2/14/91	RU

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 3/4	4 3/4	4 3/4			2/14/91	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			2/14/91	WB
	H) Trigger Pull Test & Retainability						2/14/91	JL
	I) Firing Pin Indent	.023	.023	.023			2/14/91	WB
	J) Assemble Stock						2/18/91	RW
	K) Assemble Swivel Studs						2-25-91	A
	L) Attach Front and Rear Sight Assemblies						2/18/91	RW
	M) Iron Sight Alignment						2/18/91	RW
	N) Detach Front & Rear Sights & place in numbered container						2/18/91	RW
	O) Attach Scope to Rifle						2/18/91	RW
	P) Detach & Attach Scope 20 Times						2/18/91	RW
640	Gallery Target & Test						2/19/91	KL
	A) Time							KL
	B) Malfunctions							14
	C) Pierced Primers							14
	D) Optical Clarity of Scope							KL
645	Inspect for Live Ammo						2/19/91	KL
655	Final Inspection							
	A) Headspace						2-25-91	A
	B) Trigger Pull	2.21	2.31	2.32	2.24	2.26	2/21/91	JL
	C) Function						2-25-91	A
660	Pack						3-19-91	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO.

C6611380

DATE

2/14/91

TESTER

JPL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.34	2.23	2.30	2.21	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.17	2.30	2.28	2.31	
PULL #3	2.44	2.26	2.33	2.32	
PULL #4	2.40	2.29	2.26	2.24	
PULL #5	2.33	2.33	2.32	2.26	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.33	3.45		
PULL #2	3.38	3.41		
PULL #3	3.35	3.23		
PULL #4	3.34	3.19		
PULL #5	3.36	3.18		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.27	4.26		4.50
PULL #2	4.23	4.42		4.49
PULL #3	4.22	4.40		4.58
PULL #4	4.25	4.56		4.46
PULL #5	4.21	4.49		4.39
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611380
20 Feb 1991

CENTROIDAL DISTANCES

0 TO 1	.0711758
1 TO 2	.0633246
1 TO 3	.0888876
1 TO 4	.13636
1 TO 5	.127098

-----POA

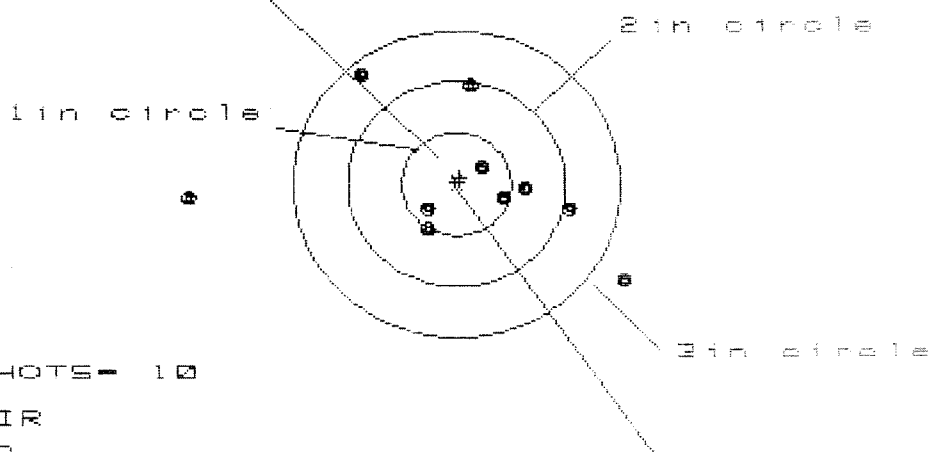
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0048
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0402
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0404856
THE AMR FOR THIS RIFLE IS: .9116

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CENTERFIRE PATTERNS # 1

POA



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 8

HS= 3.985

VS= 1.994

GS= 4.065

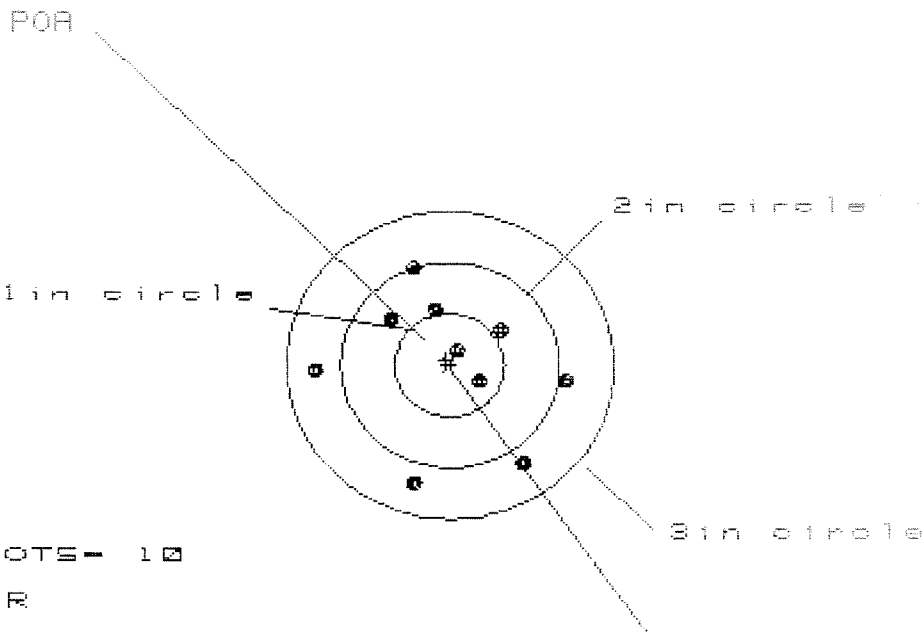
CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.513	1.239	.938
MINIMUM X	:	-2.472	-1.184	-1.029
MAXIMUM Y	:	1.030	1.012	.889
MINIMUM Y	:	-.964	-.982	-.592
CENTROID X	:	-.029	.245	.090
CENTROID Y	:	-.065	-.047	.076
POA TO CENTROID in.	:	.071	.250	.118
MIN RADIUS	:	.282	.188	.101
MEAN RADIUS	:	.999	.785	.692
MAX RADIUS	:	2.477	1.581	1.360
HORIZONTAL SPREAD	:	3.985	2.423	1.968
VERTICAL SPREAD	:	1.994	1.994	1.481
EXTREME SPREAD	:	4.065	3.138	2.316
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in - 2

2 in - 6

3 in - 10

HS= 2.273

VS= 2.110

GS= 2.277

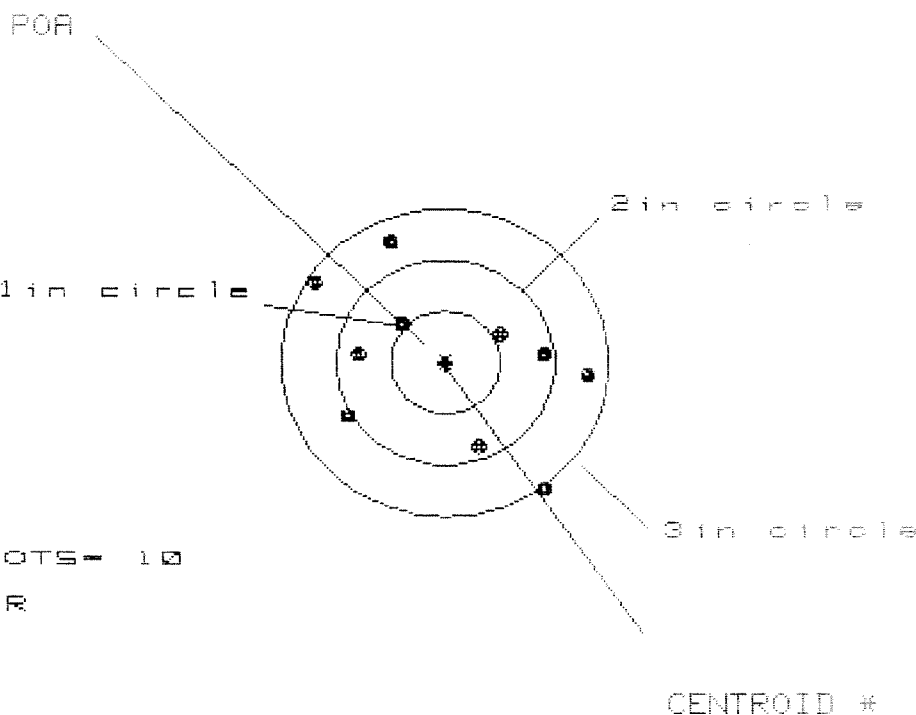
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.075	1.037	.883
MINIMUM X	:	-1.198	-1.236	-.734
MAXIMUM Y	:	.928	.797	.778
MINIMUM Y	:	-1.182	-1.043	-1.062
CENTROID X	:	.032	.070	.224
CENTROID Y	:	-.048	.083	.102
POA TO CENTROID in.	:	.058	.109	.246
MIN RADIUS	:	.180	.044	.133
MEAN RADIUS	:	.801	.719	.647
MAX RADIUS	:	1.230	1.245	1.100
HORIZONTAL SPREAD	:	2.273	2.273	1.617
VERTICAL SPREAD	:	2.110	1.840	1.840
EXTREME SPREAD	:	2.277	2.277	2.123
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in - 1

2 in - 5

3 in - 9

HS - 2.474

VS - 2.401

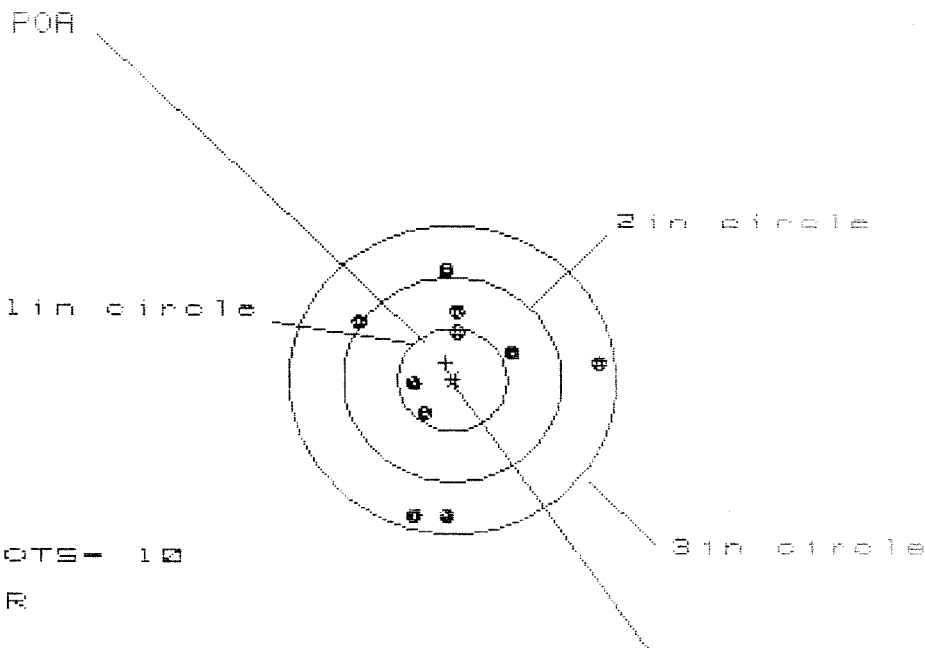
GS - 2.884

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.277	1.375	1.238
MINIMUM X	-1.197	-1.099	-0.983
MAXIMUM Y	1.150	1.011	1.087
MINIMUM Y	-1.251	-1.005	-0.929
CENTROID X	-0.003	-0.101	0.037
CENTROID Y	0.020	0.159	0.083
POA TO CENTROID in.	0.020	0.188	0.090
MIN RADIUS	0.497	0.331	0.486
MEAN RADIUS	1.025	0.949	0.909
MAX RADIUS	1.531	1.398	1.250
HORIZONTAL SPREAD	2.474	2.474	2.221
VERTICAL SPREAD	2.401	2.016	2.016
EXTREME SPREAD	2.884	2.619	2.256
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 10

HS= 2.109

VS= 2.403

GS= 2.421

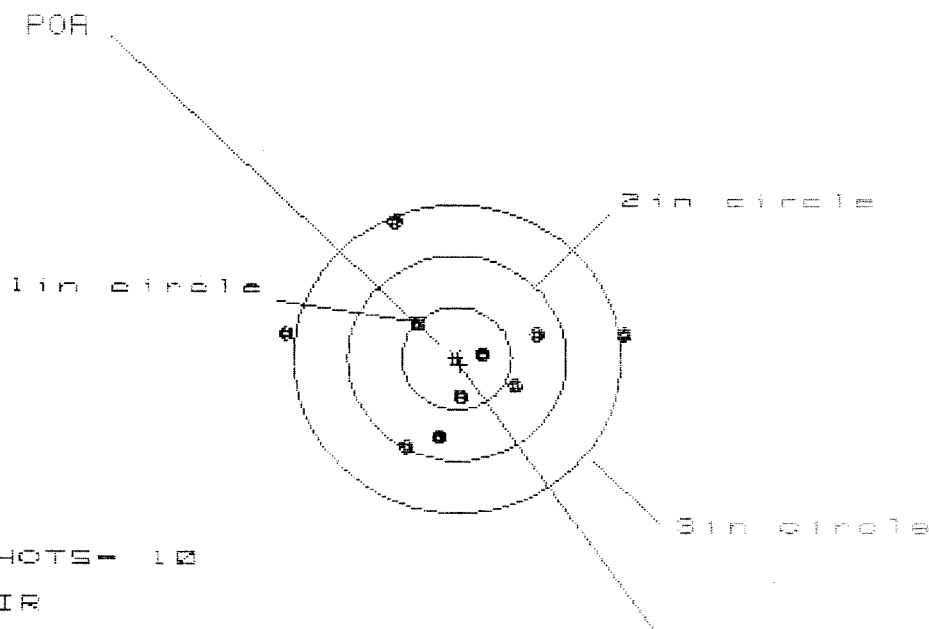
CENTROID #

PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	1.297
MINIMUM X	-.812
MAXIMUM Y	1.025
MINIMUM Y	-1.378
CENTROID X	.058
CENTROID Y	-.170
POA TO CENTROID in.	.179
MIN RADIUS	.349
MEAN RADIUS	.867
MAX RADIUS	1.434
HORIZONTAL SPREAD	2.109
VERTICAL SPREAD	2.403
EXTREME SPREAD	2.421
NUMBER IN ONE INCH CIRCLE	3
NUMBER IN TWO INCH CIRCLE	6
NUMBER IN THREE INCH CIRCLE	10

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in - 3

2 in - 7

3 in - 8

HS= 3.104

VS= 2.238

GS= 3.104

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.525	1.350	.682
MINIMUM X	:	-1.579	-.727	-.559
MAXIMUM Y	:	1.354	1.379	1.406
MINIMUM Y	:	-.884	-.859	-.832
CENTROID X	:	-.034	.141	-.027
CENTROID Y	:	.062	.037	.010
POA TO CENTROID in.	:	.071	.146	.029
MIN RADIUS	:	.222	.084	.233
MEAN RADIUS	:	.866	.753	.683
MAX RADIUS	:	1.594	1.559	1.513
HORIZONTAL SPREAD	:	3.104	2.077	1.241
VERTICAL SPREAD	:	2.238	2.238	2.238
EXTREME SPREAD	:	3.104	2.379	2.242

NUMBER IN ONE INCH CIRCLE = 6
NUMBER IN TWO INCH CIRCLE = 7
NUMBER IN THREE INCH CIRCLE = 8