

C6611459

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

M2400077287

Remington®

MODEL 700™ H24

MADE IN ILION, 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.

REG. U.S. PAT. & T.M. OFF.

SERIAL NO.
C6611459

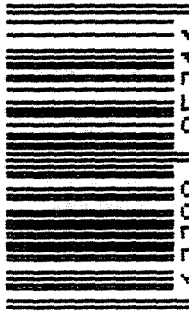
ORDER NO.
5716

20



5716 C6611459

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611459

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	4/3/91	KS.
600	Proof		4/3/91	KS.
607	Check Headspace		4/3/91	KS.
610	Dis-assemble Gun		4/3/91	KS.
612	Magnaflux Barrel Action		4/10/91	KR
	Magnaflux Bolt		4/10/91	U
615	Rollmark Caliber		4/10/91	JS
617	Drill and Tap Sight Holes		APR 19 1991	FB
618	Polish Barrel		APR 19 1991	WB
620	Apply Coatings (Barrel Action)		5-10-91	JS
	Apply Coating (Bolt)			
625	Final Assembly		5/22/91	KS
	A) Clean inside of Bolt Assembly		5/22/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/22/91	KS
	C) Inspect Ejector Hole for Chamfer		5/22/91	KS
	D) Oil Firing Pin Ass'y		5/22/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		5/24/91	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5/24/91	KL
	G) Safety Off Force	4	4	4			5/24/91	KL
	H) Trigger Pull Test & Retainability	.6					5/24/91	KL
	I) Firing Pin Indent	.021	.020	.020			5/24/91	KL
	J) Assemble Stock						5/25/91	KS
	K) Assemble Swivel Studs				6-1-91		5/25/91	DH
	L) Attach Front and Rear Sight Assemblies						5/25/91	KS
	M) Iron Sight Alignment						5/25/91	KS
	N) Detach Front & Rear Sights & place in numbered container						5/25/91	KS
	O) Attach Scope to Rifle						5/25/91	KS
	P) Detach & Attach Scope 20 Times						5/25/91	KS
640	Gallery Target & Test						5/29/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						5/29/91	KT
655	Final Inspection						6-1-91	DH
	A) Headspace							
	B) Trigger Pull	2.19	2.21	2.22	2.34	2.26	6/1/91	KL
	C) Function						6-1-91	DH
660	Pack						6-20-91	N

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6611459

DATE 5/24/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.45	2.34	2.20	2.19	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.34	2.26	2.35	2.21	
PULL #3	2.28	2.20	2.36	2.22	
PULL #4	2.30	2.29	2.20	2.34	
PULL #5	2.25	2.19	2.21	2.26	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.65	3.56		
PULL #2	3.59	3.50		
PULL #3	3.45	3.59		
PULL #4	3.57	3.56		
PULL #5	3.59	3.68		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX-SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.59	4.43		4.44
PULL #2	4.37	4.41		4.50
PULL #3	4.46	4.46		4.43
PULL #4	4.48	4.36		4.41
PULL #5	4.44	4.52		4.43
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611459
29 May 1991

CENTROIDAL DISTANCES

Ø TO	1	.11957
1 TO	2	.126016
1 TO	3	.356849
1 TO	4	.227759
1 TO	5	.150083

From <----POB

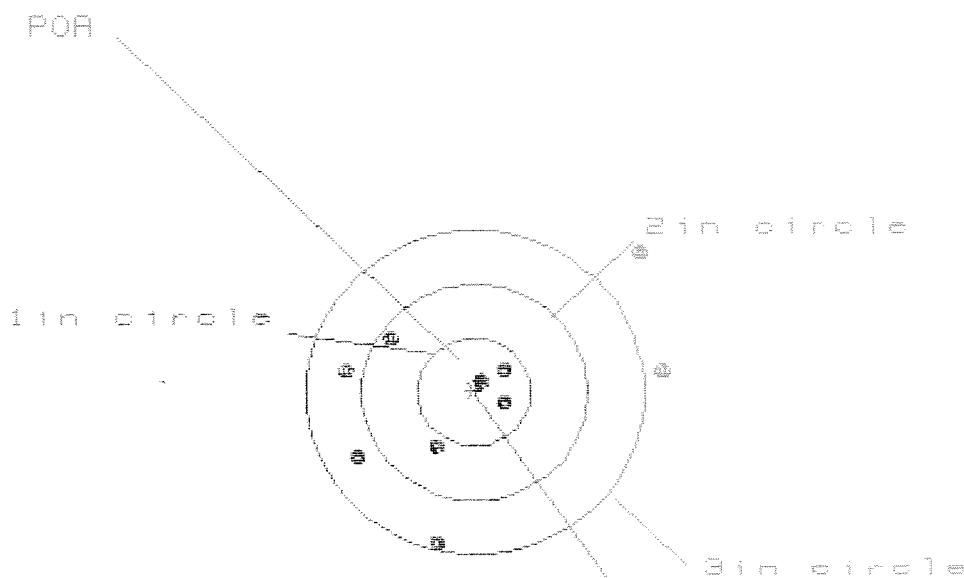
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0614
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1332
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .14667
THE AMR FOR THIS RIFLE IS: .8034

29 May 1981

FILE:/PATTERNING/CENTERFIRE_PATT/08611459

CENTERFIRE PATTERNS

1



OF SHOTS = 10

IN CIR

1in = 3

2in = 5

3in = 8

HS = 2.726

VS = 2.653

GS = 3.202

PATTERN #

:

1

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

1.615

1.774

.684

MINIMUM X

:

-1.111

-.952

-.730

MAXIMUM Y

:

1.279

.606

.653

MINIMUM Y

:

-1.374

-1.231

-1.184

CENTROID X

:

-.059

-.218

-.440

CENTROID Y

:

-.104

-.246

-.293

POA TO CENTROID in.:

.119

.329

.529

MIN RADIUS

:

.097

.297

.291

MEAN RADIUS

:

.952

.844

.721

MAX RADIUS

:

1.922

1.815

1.184

HORIZONTAL SPREAD

:

2.726

2.726

1.414

VERTICAL SPREAD

:

2.653

1.837

1.837

EXTREME SPREAD

:

3.202

2.773

1.883

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

5

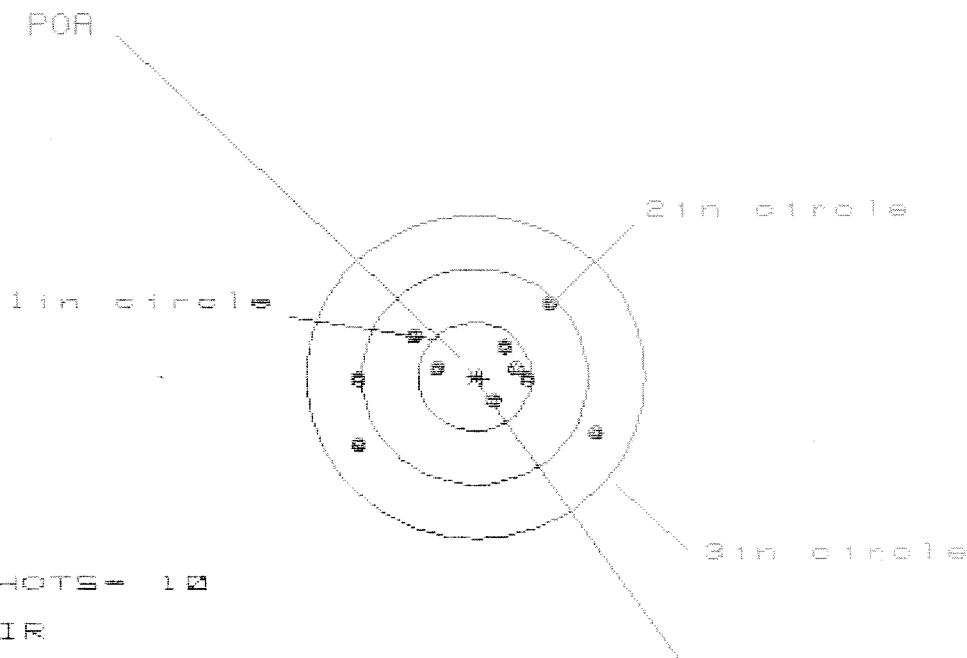
NUMBER IN THREE INCH CIRCLE =

8

29 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08611459

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 5

2in = 7

3in = 10

HS = 2.138

VS = 1.373

GS = 2.209

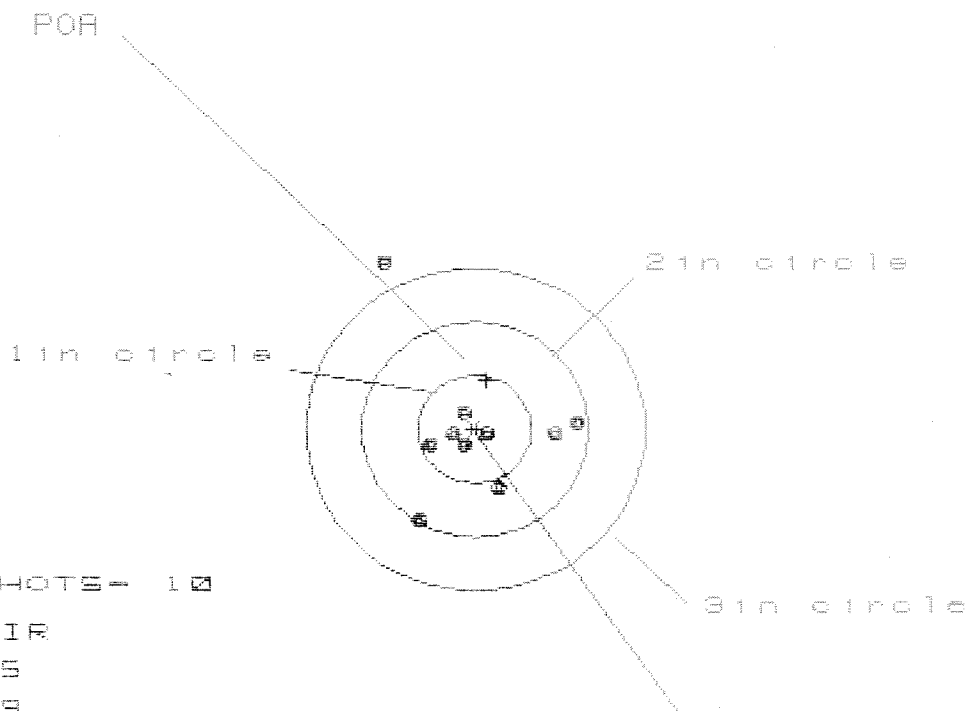
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.052	.931	.640
MINIMUM X	:	-1.086	-1.155	-1.038
MAXIMUM Y	:	.723	.651	.573
MINIMUM Y	:	-.650	-.627	-.369
CENTROID X	:	-.061	.060	-.057
CENTROID Y	:	.022	.094	.172
POA TO CENTROID in.	:	.065	.111	.182
MIN RADIUS	:	.265	.224	.278
MEAN RADIUS	:	.683	.592	.535
MAX RADIUS	:	1.265	1.161	1.057
HORIZONTAL SPREAD	:	2.138	2.086	1.678
VERTICAL SPREAD	:	1.373	1.278	.942
EXTREME SPREAD	:	2.209	2.146	1.847
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

29 May 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 5

2in = 9

3in = 9

HS= 1.692

VS= 2.351

GS= 2.366

CENTROID #

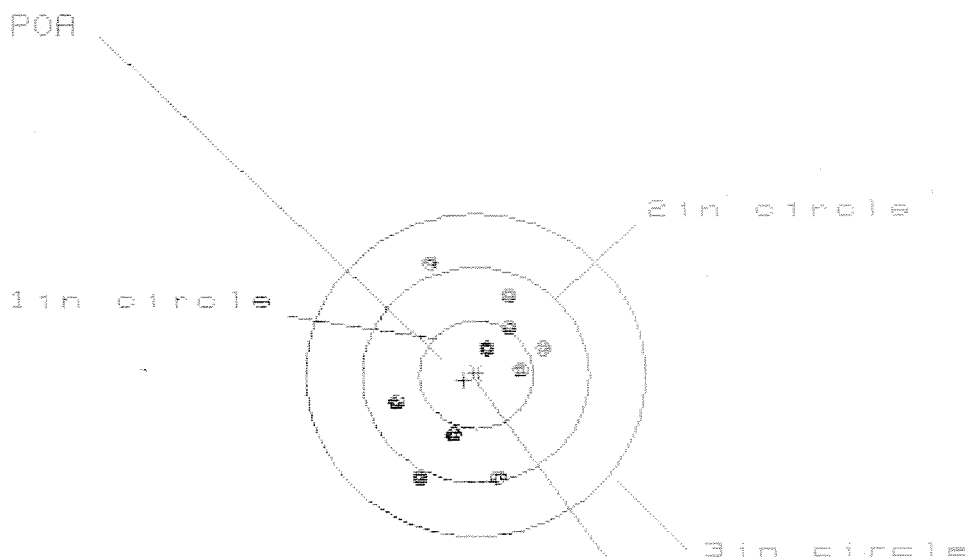
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.944	.860	.739
MINIMUM X	:	-.748	-.567	-.459
MAXIMUM Y	:	1.540	.303	.332
MINIMUM Y	:	-.811	-.640	-.611
CENTROID X	:	-.104	-.020	-.128
CENTROID Y	:	-.458	-.629	-.658
POA TO CENTROID in.	:	.469	.629	.671
MIN RADIUS	:	.095	.103	.107
MEAN RADIUS	:	.589	.463	.389
MAX RADIUS	:	1.712	.892	.764
HORIZONTAL SPREAD	:	1.692	1.427	1.198
VERTICAL SPREAD	:	2.351	.943	.943
EXTREME SPREAD	:	2.366	1.674	1.426
NUMBER IN ONE INCH CIRCLE =			5	
NUMBER IN TWO INCH CIRCLE =			9	
NUMBER IN THREE INCH CIRCLE =			9	

28 May 1991

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CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1in = 2

2in = 8

3in = 10

HS= 1.262

VS= 1.991

GS= 2.057

CENTROID *

PATTERN #

4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.571	.521	.455
MINIMUM X	-.692	-.741	-.807
MAXIMUM Y	1.005	.824	.715
MINIMUM Y	-.986	-.874	-.940
CENTROID X	.106	.155	.221
CENTROID Y	.053	-.059	.050
POA TO CENTROID in.	.118	.166	.227
MIN RADIUS	.252	.347	.236
MEAN RADIUS	.705	.662	.585
MAX RADIUS	1.100	1.023	.945
HORIZONTAL SPREAD	1.262	1.262	1.262
VERTICAL SPREAD	1.991	1.698	1.655
EXTREME SPREAD	2.057	1.847	1.655
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	

28 May 1991

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CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS - 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 2.539

VS= 3.159

GS= 3.831

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X : 1.254

1.112

.961

MINIMUM X : -1.285

-1.203

-.883

MAXIMUM Y : .965

.721

.543

MINIMUM Y : -2.194

-.879

-.789

CENTROID X : -.189

-.047

.104

CENTROID Y : -.179

.065

-.025

POA TO CENTROID in.: .260

.080

.107

MIN RADIUS : .368

.544

.669

MEAN RADIUS : 1.088

.915

.854

MAX RADIUS : 2.543

1.403

1.081

HORIZONTAL SPREAD : 2.539

2.315

1.844

VERTICAL SPREAD : 3.159

1.600

1.332

EXTREME SPREAD : 3.831

2.555

1.959

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

5

NUMBER IN THREE INCH CIRCLE =

9