

C6611544

MODEL 700™ M24

Model SWS™

Action _____

Barrel Length _____

Capacity _____

Order No. 5716

*Includes 1 in chamber.

Remington

SWS TRIGGER PULL TEST

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

SERIAL NO. C6611544

DATE 2-8-96

TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.73	2.74	2.68		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.57	2.73	2.62		
PULL #3	2.57	2.57	2.77		
PULL #4	2.51	2.81	2.67		
PULL #5	2.60	2.78	2.66		
TOTAL	12.98	13.63	13.40		
AVG.	2.59	2.72	2.68		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.15	3.08		
PULL #2	3.23	3.17		
PULL #3	3.23	3.11		
PULL #4	3.21	3.07		
PULL #5	3.04	3.20		
TOTAL	15.86	15.63		
AVG.	3.17	3.12		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.02	4.02	L	4.05
PULL #2	4.14	4.00		4.10
PULL #3	4.05	3.94		4.16
PULL #4	4.19	4.08		4.03
PULL #5	4.02	4.13		4.00
TOTAL	20.42	20.17		20.30
AVG.	4.08	4.03		4.06

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6611544

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock			
600	Proof			
607	Check Headspace			
610	Dis-assemble Gun			
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2			2/27/96	WB
	G) Safety Off Force	2 3/4	2 1/2	2 1/2			2/27/96	WB
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent							
	J) Assemble Stock							
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies							
	M) Iron Sight Alignment							
	N) Detach Front & Rear Sights & place in numbered container							
	O) Attach Scope to Rifle							
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test							
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection A) Headspace							
	B) Trigger Pull	2.43	2.36	2.27	2.28	2.30	2/27/96	WB
	C) Function							
660	Pack							

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



Remington

MODEL 700TM H24

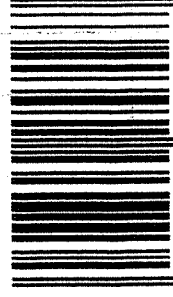
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada. Marque Deposee.

20

SERIAL NO.
C6611544

ORDER NO.
5716

UPC



0 47700 25716 7



5716 C6611544

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6611544

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		2/1/91	KJ
5 600	Proof		2/1/91	KJ
607	Check Headspace		2/1/91	KJ
610	Dis-assemble Gun		2/1/91	KJ
612	Magnaflux Barrel Action	2 11 91		KJ
	Magnaflux Bolt	2 11 91		KJ
615	Rollmark Caliber	2 11 91		GS
617	Drill and Tap Sight Holes	2 13 91		FB
618	Polish Barrel RBB	2 13 91		WB
620	Apply Coatings (Barrel Action)		3/2/91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		3/20/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		3/20/91	KS
	C) Inspect Ejector Hole for Chamfer		3/20/91	KS
	D) Oil Firing Pin Ass'y		3/20/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		4-29/91	DH

FILL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	4 $\frac{3}{4}$	4 $\frac{1}{4}$			4-2-91	DH
	G) Safety Off Force	2	2	2			4-2-91	DH
	H) Trigger Pull Test & Retainability						4-2-91	D/H
	I) Firing Pin Indent	.021	.021	.021			4-2-91	DH
	J) Assemble Stock						4/4/91	KS
	K) Assemble Swivel Studs						4-10-91	DH
	L) Attach Front and Rear Sight Assemblies						4/4/91	KS
	M) Iron Sight Alignment						4/4/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/4/91	KS
	O) Attach Scope to Rifle						4/4/91	KS
	P) Detach & Attach Scope 20 Times						4/4/91	KS
640	Gallery Target & Test						4/5/91	KS
	A) Time						"	KS
	B) Malfunctions						"	KS
	C) Pierced Primers						"	KS
	D) Optical Clarity of Scope						"	KS
645	Inspect for Live Ammo						4/5/91	KS
655	Final Inspection							
	A) Headspace						4-11-91	D/H
	B) Trigger Pull	2.26	2.31	2.36	2.34	2.36	4/10/91	KS
	C) Function						4-11-91	D/H
660	Pack						6-17-91	NF

SWS TRIGGER PULL TEST

T171 3.00#

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6611544

DATE 4-2-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.46	2.58	2.26	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.43	2.31	2.55	2.31	
PULL #3	2.42	2.42	2.45	2.36	
PULL #4	2.45	2.38	2.52	2.34	
PULL #5	2.39	2.38	2.56	2.36	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.27	3.29		
PULL #2	3.36	3.43		
PULL #3	3.35	3.43		
PULL #4	3.30	3.44		
PULL #5	3.41	3.40		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.56	4.31		4.06
PULL #2	4.33	4.31		4.07
PULL #3	4.30	4.15		4.10
PULL #4	4.30	4.23		4.09
PULL #5	4.22	4.20		3.85
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611544
5 Apr 1991

CENTROIDAL DISTANCES

Ø TO	1	.102259
1 TO	2	.097
1 TO	3	.153639
1 TO	4	.601908
1 TO	5	.291673

$\frac{1}{5}$ <----POA
4

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .109
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0904
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .141609
THE AMR FOR THIS RIFLE IS: .0162

5 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611544

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 8

2in = 10

3in = 10

HS= .862

VS= .894

GS= 1.055

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.325	.265	.210
MINIMUM X	-.537	-.437	-.403
MAXIMUM Y	.421	.456	.402
MINIMUM Y	-.473	-.438	-.340
CENTROID X	.016	.076	.131
CENTROID Y	.101	.066	.120
POA TO CENTROID in.	.102	.101	.178
MIN RADIUS	.133	.067	.065
MEAN RADIUS	.362	.320	.272
MAX RADIUS	.624	.619	.423
HORIZONTAL SPREAD	.862	.702	.613
VERTICAL SPREAD	.894	.894	.742
EXTREME SPREAD	1.055	1.055	.749
NUMBER IN ONE INCH CIRCLE	= 8		
NUMBER IN TWO INCH CIRCLE	= 10		
NUMBER IN THREE INCH CIRCLE	= 10		

5 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6811544

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS= 10

IN CIR

1in = 6

2in = 9

3in = 10

HS= 1.819

VS= .977

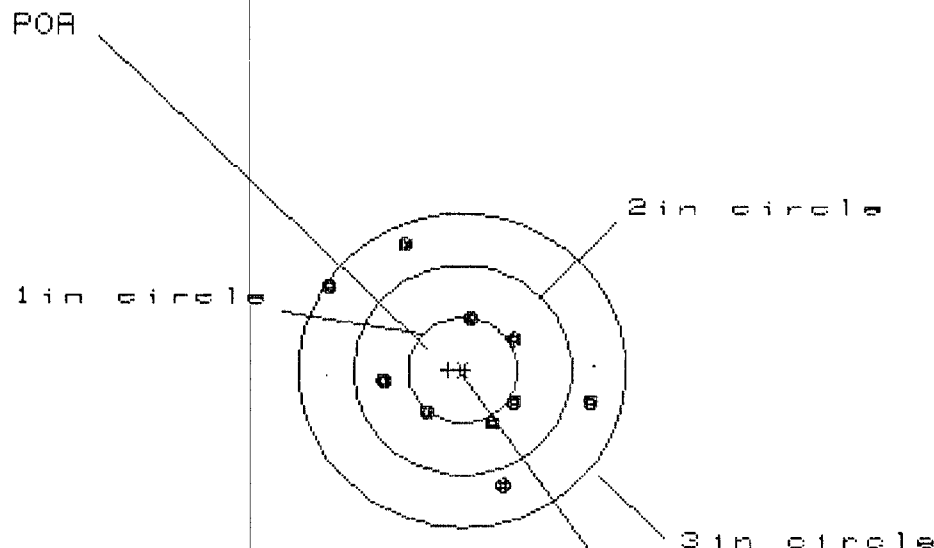
GS= 1.945

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.763	.646	.332
MINIMUM X	:	-1.056	-.723	-.642
MAXIMUM Y	:	.532	.513	.575
MINIMUM Y	:	-.445	-.464	-.482
CENTROID X	:	.113	.230	.149
CENTROID Y	:	.101	.120	.058
POA TO CENTROID in.	:	.151	.259	.160
MIN RADIUS	:	.334	.215	.311
MEAN RADIUS	:	.566	.488	.449
MAX RADIUS	:	1.069	.816	.677
HORIZONTAL SPREAD	:	1.819	1.369	.974
VERTICAL SPREAD	:	.977	.977	.977
EXTREME SPREAD	:	1.945	1.412	1.009
NUMBER IN ONE INCH CIRCLE	=		6	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

5 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611544

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 10

HS= 2.436

VS= 2.359

GS= 2.677

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.190	1.051	.962
MINIMUM X	-1.246	-.851	-.940
MAXIMUM Y	1.212	1.299	.746
MINIMUM Y	-1.147	-1.060	-.898
CENTROID X	.130	.268	.356
CENTROID Y	-.002	-.089	-.251
POA TO CENTROID in.	.130	.282	.436
MIN RADIUS	.484	.405	.262
MEAN RADIUS	.868	.777	.661
MAX RADIUS	1.472	1.479	.966
HORIZONTAL SPREAD	2.436	1.902	1.902
VERTICAL SPREAD	2.359	2.359	1.644
EXTREME SPREAD	2.677	2.545	1.916
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

5 Apr 1981

FILE:/PATTERNING/CENTERFIRE_PATT/C6611544

CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 0

2 in = 4

3 in = 7

HS= 2.827

VS= 3.431

GS= 3.729

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.494	.931	.956
MINIMUM X	-1.333	-1.167	-1.142
MAXIMUM Y	1.451	1.363	1.135
MINIMUM Y	-1.981	-1.819	-.909
CENTROID X	.218	.052	.027
CENTROID Y	-.466	-.627	-.399
POA TO CENTROID in.	.514	.629	.400
MIN RADIUS	.539	.309	.495
MEAN RADIUS	1.272	1.147	1.078
MAX RADIUS	2.082	1.830	1.386
HORIZONTAL SPREAD	2.827	2.098	2.098
VERTICAL SPREAD	3.431	3.182	2.044
EXTREME SPREAD	3.729	3.216	2.564
NUMBER IN ONE INCH CIRCLE	= 0		
NUMBER IN TWO INCH CIRCLE	= 4		
NUMBER IN THREE INCH CIRCLE	= 7		

5 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611544

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS= 2.727

VS= 2.323

GS= 2.845

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.044	.857	.877
MINIMUM X	-1.683	-1.592	-1.572
MAXIMUM Y	.671	.709	.507
MINIMUM Y	-1.652	-1.614	-1.665
CENTROID X	.068	.255	.235
CENTROID Y	-.186	-.224	-.023
POA TO CENTROID in.	.198	.340	.236
MIN RADIUS	.038	.169	.196
MEAN RADIUS	1.013	.901	.806
MAX RADIUS	1.718	1.621	1.584
HORIZONTAL SPREAD	2.727	2.449	2.449
VERTICAL SPREAD	2.323	2.323	1.172
EXTREME SPREAD	2.845	2.546	2.546
NUMBER IN ONE INCH CIRCLE	= 1		
NUMBER IN TWO INCH CIRCLE	= 5		
NUMBER IN THREE INCH CIRCLE	= 8		