

C6349204

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington




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

MODEL 700™ H24

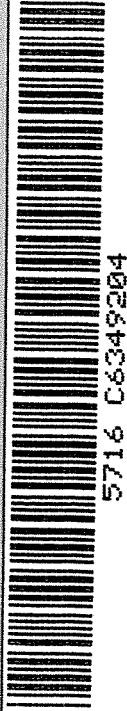
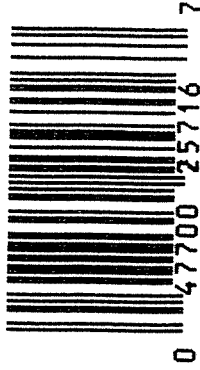
SERIAL NO.
C6349204

ORDER NO.
5716

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

Ø1

UPC



Replace

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349204

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	12-20	89	RW
600	Proof	12-20	89	A
607	Check Headspace	12-20	89	A
610	Dis-assemble Gun	12-20	89	RW
612	Magnaflux Barrel Action	1-5-90		KGR
	Magnaflux Bolt	1-5-90		
615	Rollmark Caliber		1/3/90	JS
617	Drill and Tap Sight Holes		1/8/90	FB
618	Polish Barrel RB		1/9/90	WB
620	Apply Coatings (Barrel Action)		1-15-90	TA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		1/15/90 1/16/90	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/16/90	RW
	C) Inspect Ejector Hole for Chamfer		1/16/90	RW
	D) Oil Firing Pin Ass'y		1/16/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		1/16/90	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			1-17-90	JR
	G) Safety Off Force	3	3	3			1-17-90	JR.
	H) Trigger Pull Test & Retainability						1/17/90	JR
	I) Firing Pin Indent	.020	.0205	.0205			1-17-90	JR
	J) Assemble Stock						3/8/90	RW
	K) Assemble Swivel Studs						3/15/90	WB
	L) Attach Front and Rear Sight Assemblies						3/8/90	RW
	M) Iron Sight Alignment						3/8/90	RW
	N) Detach Front & Rear Sights & place in numbered container						3/8/90	RW
	O) Attach Scope to Rifle						3/8/90	WB
	P) Detach & Attach Scope 20 Times						3/8/90	WB
640	Gallery Target & Test						3/9/90	J.S. Temp Help
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection						15 MAR 90	JR
	A) Headspace						15 MAR 90	JR
	B) Trigger Pull	2.12	2.12	2.10	2.07	2.09	15 MAR 90	JR
	C) Function						15 MAR 90	JR
660	Pack						19 MAR 90	JR

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6349204

DATE 17 Jan 90

TESTER ELB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.14	2.76	2.34	2.12	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.21	2.83	2.28	2.12	
PULL #3	2.26	2.32	2.35	2.10	
PULL #4	2.00	2.12	2.07	2.07	
PULL #5	2.27	2.09	2.22	2.09	
TOTAL	10.94	12.02	11.16	10.50	
AVG.	2.188	2.404	2.232	2.10	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.48	3.43		
PULL #2	3.12	3.17		
PULL #3	3.17	3.33		
PULL #4	3.50	3.40		
PULL #5	3.52	3.22		
TOTAL	16.79	16.55		
AVG.	3.358	3.31		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	3.97	3.92		3.69
PULL #2	4.00	3.95		4.06
PULL #3	3.83	4.00		4.10
PULL #4	4.10	4.19		4.04
PULL #5	3.97	4.17		4.13
TOTAL	19.87	20.29		20.02
AVG.	3.974	4.058		4.004

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349204
9 Mar 1990

CENTROIDAL DISTANCES

0 TO	1	.469026
1 TO	2	.677097
1 TO	3	.286246
1 TO	4	.866637
1 TO	5	.471027

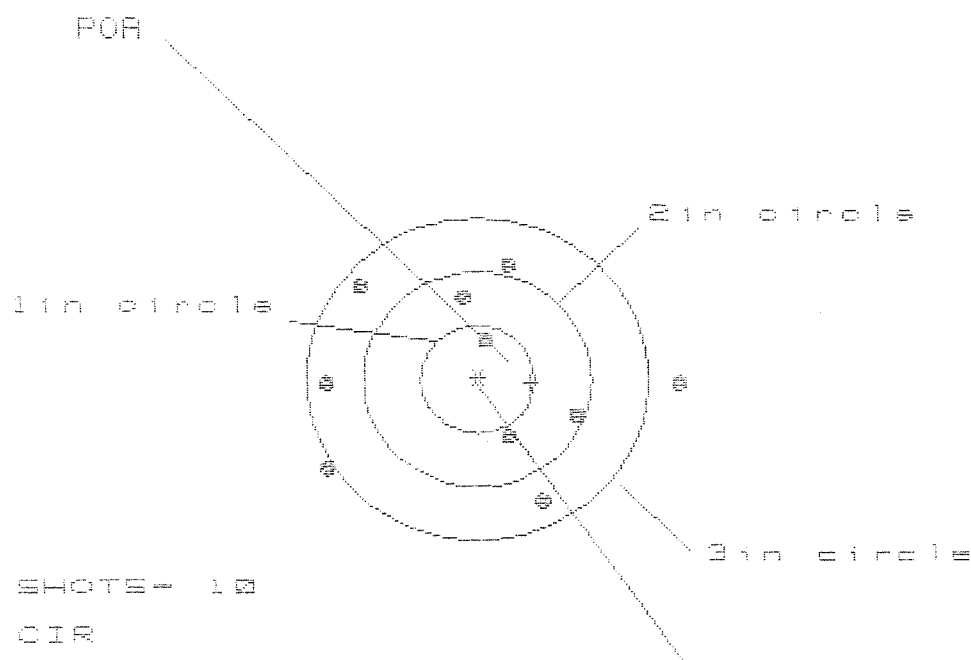
$s_{1/2}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2614
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1264
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .290357
THE AMR FOR THIS RIFLE IS: 1.038

9 Mar 1990

FILE:/PATTERNING/CENTERFIRE_PATT/08349204

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 1

2in = 4

3in = 8

HS = 2.004

VS = 2.191

GS = 3.162

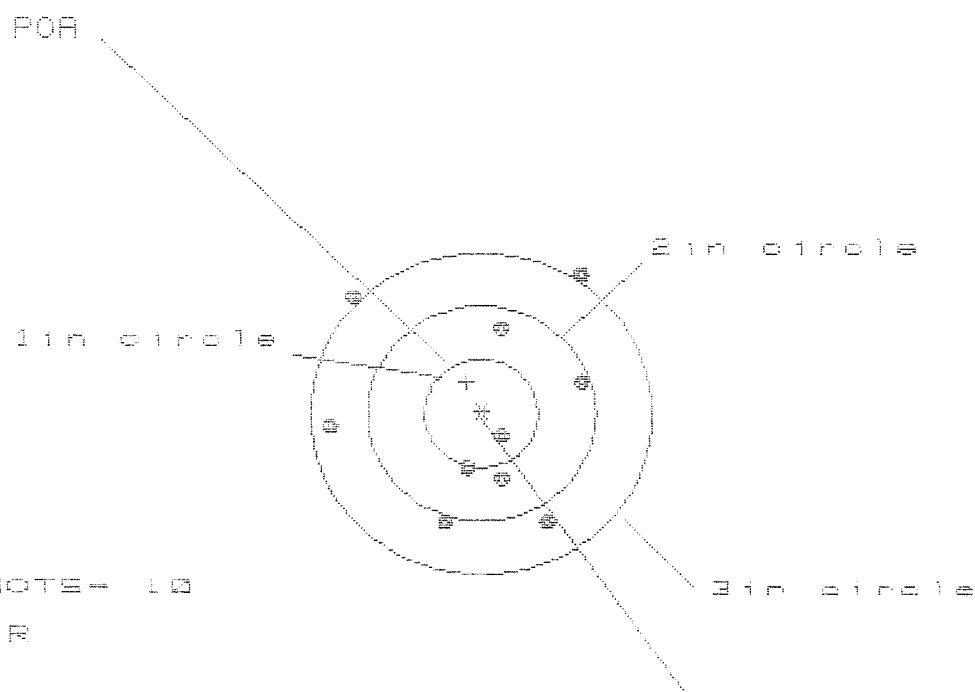
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.746	1.094	.955
MINIMUM X	-1.348	-1.154	-1.293
MAXIMUM Y	1.026	1.018	.969
MINIMUM Y	-1.165	-1.173	-1.282
CENTROID X	-.468	-.662	-.523
CENTROID Y	.031	.039	.148
FOR TO CENTROID in.	.469	.663	.543
MIN RADIUS	.336	.417	.247
MEAN RADIUS	1.100	1.032	.945
MAX RADIUS	1.748	1.419	1.407
HORIZONTAL SPREAD	3.094	2.248	2.248
VERTICAL SPREAD	2.191	2.191	2.191
EXTREME SPREAD	3.162	2.575	2.575
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

9 Mar 1938

FILE:/PATTERNING/CENTERFIRE_PATT/C83492B4

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HM = 2.218

VS = 2.297

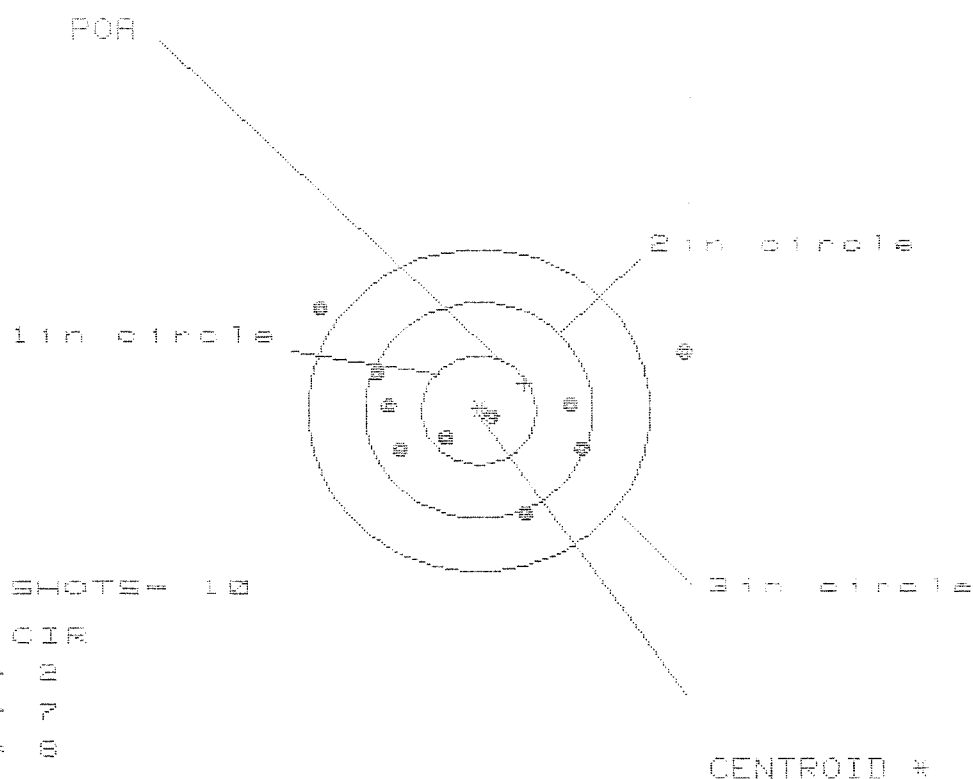
GS = 2.663

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.907	1.002	.878
MINIMUM X	:	-1.310	-1.216	-1.340
MAXIMUM Y	:	1.290	1.201	1.085
MINIMUM Y	:	-1.007	-.864	-.714
CENTROID X	:	.126	.031	.155
CENTROID Y	:	-.294	-.437	-.587
POA TO CENTROID in.	:	.320	.438	.608
MIN RADIUS	:	.242	.244	.152
MEAN RADIUS	:	.977	.888	.745
MAX RADIUS	:	1.545	1.558	1.351
HORIZONTAL SPREAD	:	2.218	2.218	2.218
VERTICAL SPREAD	:	2.297	2.065	1.799
EXTREME SPREAD	:	2.663	2.663	2.259
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

9 Mar 1998

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 7

3 in = 8

HS = 3.182

VS = 1.895

GS = 3.212

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.796	1.131	.983
MINIMUM X	:	-1.386	-1.187	-.837
MAXIMUM Y	:	.935	.991	.537
MINIMUM Y	:	-.960	-.904	-.780
CENTROID X	:	-.484	-.604	-.456
CENTROID Y	:	-.248	-.304	-.428
POR TO CENTROID in.	:	.474	.676	.625
MIN RADIUS	:	.122	.236	.186
MEAN RADIUS	:	.933	.803	.699
MAX RADIUS	:	1.866	1.546	.995
HORIZONTAL SPREAD	:	3.183	2.318	1.820
VERTICAL SPREAD	:	1.895	1.895	1.317
EXTREME SPREAD	:	3.212	2.627	1.936
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

9 Mar 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08345284

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 0

2 in = 5

3 in = 8

HSI = 0.481

VS = 3.250

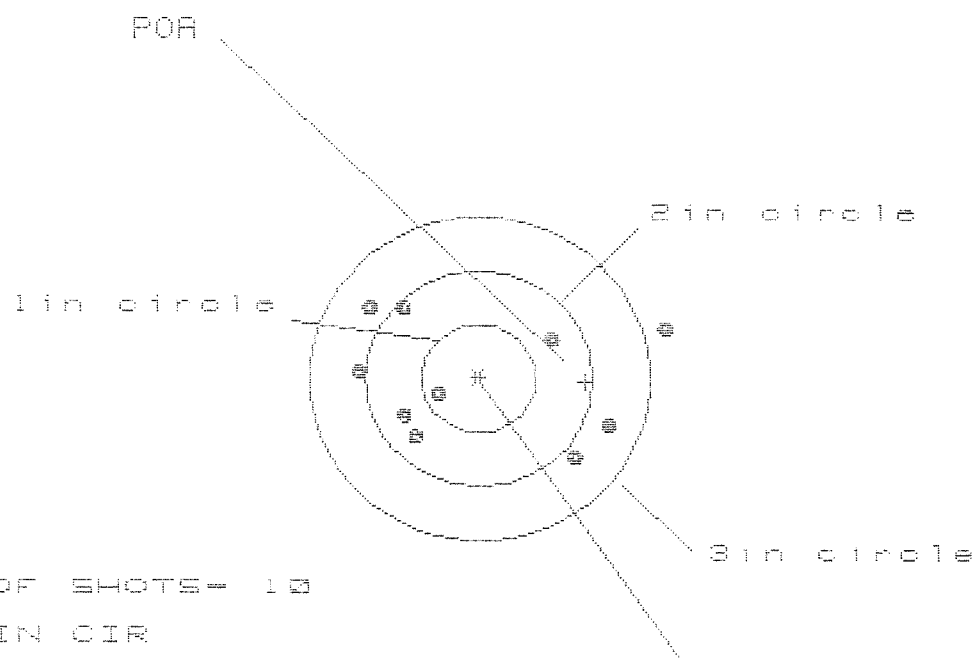
GS = 3.289

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.029	1.114	1.016
MINIMUM X	:	-1.402	-1.317	-1.179
MAXIMUM Y	:	1.371	1.162	.955
MINIMUM Y	:	-1.879	-1.655	-1.967
CENTROID X	:	.378	.293	.154
CENTROID Y	:	-.157	.052	.259
POA TO CENTROID in.	:	.409	.298	.301
MIN RADIUS	:	.684	.459	.217
MEAN RADIUS	:	1.192	1.051	.882
MAX RADIUS	:	2.027	1.995	1.363
HORIZONTAL SPREAD	:	2.431	2.431	2.194
VERTICAL SPREAD	:	3.250	2.817	1.922
EXTREME SPREAD	:	3.289	3.011	2.430
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

9 Mar 1998

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 2.684

VS= 1.417

GS= 2.718

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.638	1.344	1.211
MINIMUM X	:	-1.054	-.873	-.795
MAXIMUM Y	:	.658	.714	.665
MINIMUM Y	:	-.759	-.763	-.752
CENTROID X	:	-.939	-1.120	-1.288
CENTROID Y	:	.036	-.020	.029
POA TO CENTROID in.	:	.940	1.120	1.289
MIN RADIUS	:	.421	.232	.115
MEAN RADIUS	:	.987	.857	.737
MAX RADIUS	:	1.706	1.401	1.426
HORIZONTAL SPREAD	:	2.684	2.217	1.916
VERTICAL SPREAD	:	1.417	1.417	1.417
EXTREME SPREAD	:	2.718	2.408	2.319
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	