

C6349205

MODEL 700TM N24

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.

Remington®

MODEL 700™ H24

Ø1

SERIAL NO.
C6349205

ORDER NO.
5716

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

UPC

0 47700 25716 7

RC-20
Replaced

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349205

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		KCR
	Magnaflux Bolt	1-5-90		
615	Rollmark Caliber		1/3/90	JS
617	Drill and Tap Sight Holes		1/8/90	KOB
618	Polish Barrel RB		1/9/90	WB
620	Apply Coatings (Barrel Action)		1-15-90	JA
	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		22 Jan 90	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			1-22-90	JS
	G) Safety Off Force	4	4	4			1-22-90	JS
	H) Trigger Pull Test & Retainability						2/27/90	JS
	I) Firing Pin Indent	.021	.021	.021			1-22-90	JS
	J) Assemble Stock						1-29-90	AC
	K) Assemble Swivel Studs						2/25/90	WB
	L) Attach Front and Rear Sight Assemblies						1-29-90	AC
	M) Iron Sight Alignment						1-29-90	AC
	N) Detach Front & Rear Sights & place in numbered container						1-29-90	AC
	O) Attach Scope to Rifle						2/16/90	WB
	P) Detach & Attach Scope 20 Times						2/16/90	WB
640	Gallery Target & Test						2-26-90	AC
	A) Time						"	AC
	B) Malfunctions						"	AC
	C) Pierced Primers						"	AC
	D) Optical Clarity of Scope						"	AC
645	Inspect for Live Ammo						2-26-90	AC
655	Final Inspection						2/28/90	WB
	A) Headspace							
	B) Trigger Pull	2.54	2.58	2.54	2.53	2.52	2/27/90	WB
	C) Function						2/28/90	WB
660	Pack						2/28/90	JS

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6349205

DATE 22 Jan 90

TESTER [Signature]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.35	2.17	2.46	2.55	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.32	2.40	2.26	2.61	
PULL #3	2.37	2.34	2.36	2.52	
PULL #4	2.25	2.32	2.40	2.55	
PULL #5	2.32	2.37	2.49	2.47	
TOTAL	11.61	11.60	11.97	12.70	
AVG.	2.322	2.32	2.394	2.54	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	2.95	3.10		
PULL #2	2.91	3.12		
PULL #3	2.59	2.99		
PULL #4	2.85	3.12		
PULL #5	2.81	3.15		
TOTAL	14.11	15.48		
AVG.	2.822	3.096		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.36	5.03		3.97
PULL #2	4.16	3.91		3.88
PULL #3	3.65	4.28		3.65
PULL #4	4.26	4.16		3.94
PULL #5	4.21	4.13		3.90
TOTAL	20.64	20.51		19.34
AVG.	4.128	4.102		3.868

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06349205
27 Feb 1990

CENTROIDAL DISTANCES

0 TO	1	.332737
1 TO	2	.586121
1 TO	3	.792881
1 TO	4	.165082
1 TO	5	.478357

3
5⁺₄ 2 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .012
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2042
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .204552
THE AMR FOR THIS RIFLE IS: .9454

26 Feb 1980

FILE:/PATTERNING/CENTERFIRE_PATT/C6349205

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 10

HS = 0.152

VS = 1.957

GS = 2.571

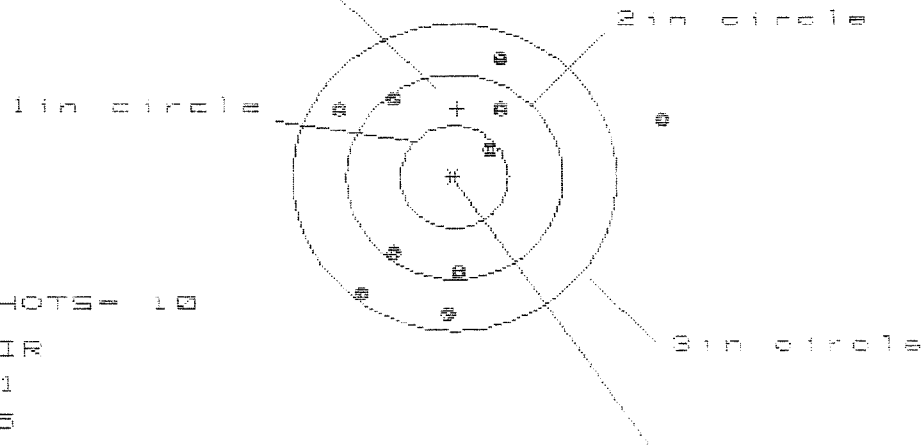
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.184	.757	.775
MINIMUM X	-.968	-.837	-.820
MAXIMUM Y	.703	.601	.432
MINIMUM Y	-1.254	-1.356	-.962
CENTROID X	.283	.152	.134
CENTROID Y	-.175	-.073	.096
POA TO CENTROID in.	.333	.169	.165
MIN RADIUS	.190	.185	.335
MEAN RADIUS	.793	.679	.564
MAX RADIUS	1.498	1.363	1.235
HORIZONTAL SPREAD	2.152	1.594	1.594
VERTICAL SPREAD	1.957	1.957	1.394
EXTREME SPREAD	2.571	1.997	1.983
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

26 Feb 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6349285

CENTERFIRE PATTERNS # 2

POA



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS = 2.006

VS = 2.495

GS = 3.204

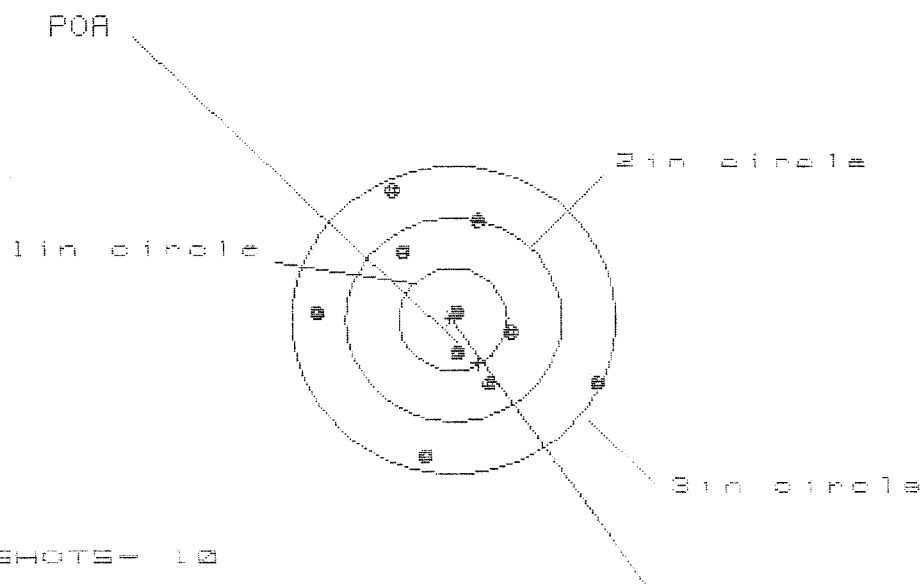
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.899	.630	.552
MINIMUM X	:	-1.107	-.896	-.974
MAXIMUM Y	:	1.200	1.262	1.132
MINIMUM Y	:	-1.295	-1.233	-1.363
CENTROID X	:	-.034	-.245	-.167
CENTROID Y	:	-.668	-.730	-.600
POA TO CENTROID in.	:	.669	.771	.623
MIN RADIUS	:	.489	.697	.566
MEAN RADIUS	:	1.139	1.036	.996
MAX RADIUS	:	1.980	1.411	1.367
HORIZONTAL SPREAD	:	3.006	1.526	1.526
VERTICAL SPREAD	:	2.495	2.495	2.495
EXTREME SPREAD	:	3.204	2.628	2.537
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

28 Feb 1998

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 2

2in = 6

3in = 10

HS = 2.612

VS = 2.582

GS = 2.699

CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.335	.668	.614
MINIMUM X	:	-1.277	-1.129	-1.183
MAXIMUM Y	:	1.258	1.193	1.037
MINIMUM Y	:	-1.324	-1.389	-1.240
CENTROID X	:	-.233	-.381	-.327
CENTROID Y	:	.427	.492	.343
POA TO CENTROID in.	:	.487	.622	.474
MIN RADIUS	:	.056	.190	.102
MEAN RADIUS	:	.889	.845	.768
MAX RADIUS	:	1.457	1.396	1.255
HORIZONTAL SPREAD	:	2.612	1.797	1.797
VERTICAL SPREAD	:	2.582	2.582	2.277
EXTREME SPREAD	:	2.699	2.599	2.340
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

28 Feb 1988

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CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 4

2in = 7

3in = 8

HE= 2.154

VS= 2.661

GS= 3.353

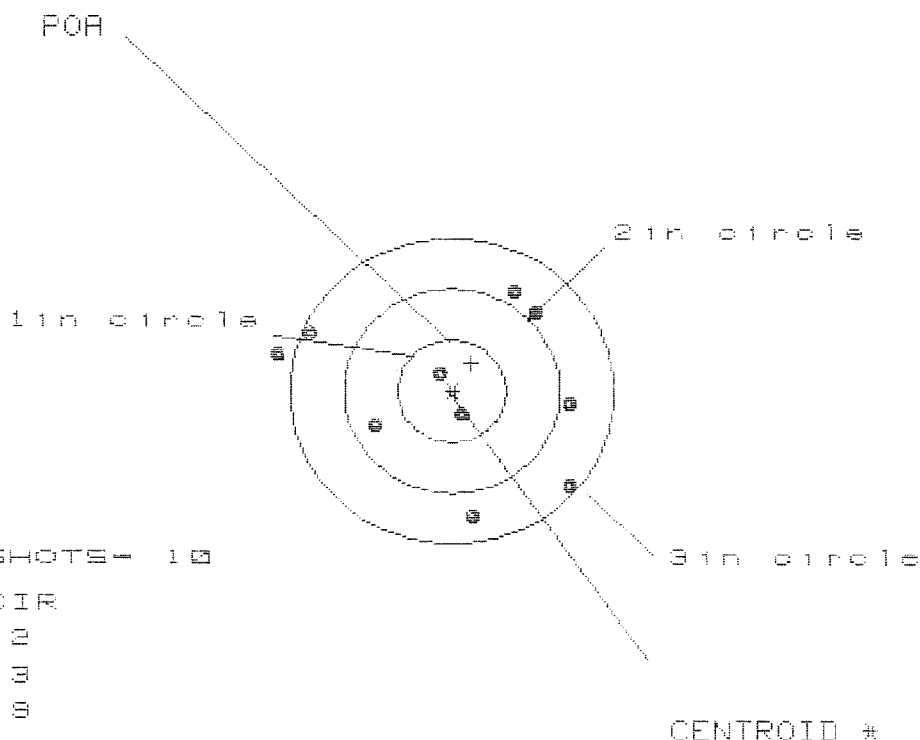
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.042	.736	.612
MINIMUM X	:	-1.112	-.996	-.662
MAXIMUM Y	:	1.532	1.111	1.002
MINIMUM Y	:	-1.129	-.959	-1.068
CENTROID X	:	.229	.113	.237
CENTROID Y	:	-.331	-.501	-.392
POA TO CENTROID in.	:	.402	.513	.459
MIN RADIUS	:	.276	.201	.323
MEAN RADIUS	:	.871	.758	.668
MAX RADIUS	:	1.853	1.321	1.114
HORIZONTAL SPREAD	:	2.154	1.732	1.274
VERTICAL SPREAD	:	2.661	2.070	2.070
EXTREME SPREAD	:	3.353	2.379	2.135
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

26 Feb 1988

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 3

3in = 9

HS= 2.751

VS= 2.131

GS= 3.008

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.111	.929	.738
MINIMUM X	-1.640	-1.526	-1.133
MAXIMUM Y	.926	.963	1.034
MINIMUM Y	-1.205	-1.168	-1.097
CENTROID X	-.185	-.003	.188
CENTROID Y	-.274	-.311	-.363
POA TO CENTROID in.	.331	.311	.426
MIN RADIUS	.210	.219	.287
MEAN RADIUS	1.035	.952	.865
MAX RADIUS	1.674	1.629	1.153
HORIZONTAL SPREAD	2.751	2.455	1.871
VERTICAL SPREAD	2.131	2.131	2.131
EXTREME SPREAD	3.008	2.832	2.137
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		9	