

C6349212

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.
C6349212**

**ORDER NO.
5716**

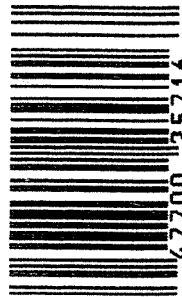
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MADE IN ILLION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



5716 C6349212

UPC



0 47700 25716 7

PC 52

M-24

317

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349212

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 12	90	RW
600	Proof	1 12	90	L
607	Check Headspace	1 12	90	L
610	Dis-assemble Gun	1 12	90	RW
612	Magnaflux Barrel Action	1-16-90		KCR
	Magnaflux Bolt	1-17-90		KCR
615	Rollmark Caliber	1-17-90		ES
617	Drill and Tap Sight Holes	1-19-90		FB
618	Polish Barrel RB	22 1-22-90		WB
620	Apply Coatings (Barrel Action)		20-90	DA
	Apply Coating (Bolt)			
625	Final Assembly		2/2/90	WB
	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		3/1/90	DS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			1-31-90	GU
	G) Safety Off Force	3	3	3			1-31-90	GU
	H) Trigger Pull Test & Retainability						31/1/90	GU
	I) Firing Pin Indent	.023	.023	.023			1-31-90	GU
	J) Assemble Stock						1-31-90	K
	K) Assemble Swivel Studs						1/28/90	WB
	L) Attach Front and Rear Sight Assemblies						1-31-90	K
	M) Iron Sight Alignment						1-31-90	K
	N) Detach Front & Rear Sights & place in numbered container						1-31-90	K
	O) Attach Scope to Rifle						2-23-90	GU
640	P) Detach & Attach Scope 20 Times						2-23-90	GU
	Gallery Target & Test						2-26-90	K
	A) Time						"	K
	B) Malfunctions						"	K
	C) Pierced Primers						"	K
645	D) Optical Clarity of Scope						"	K
	Inspect for Live Ammo						2-26-90	K
	Final Inspection						1/28/90	WB
	A) Headspace						1/27/90	WB
655	B) Trigger Pull	2.78	2.77	2.78	2.78	2.78	1/27/90	WB
	C) Function						1/28/90	WB
660	Pack						20/1/90	GU

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6349212

DATE 31 Jan 90

TESTER hss

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	251	268	239	278	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	255	260	230	277	
PULL #3	253	257	233	278	
PULL #4	245	258	231	278	
PULL #5	251	253	234	278	
TOTAL	1255	1293	1167		
AVG.	2.51	2.586	2.334		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	279	299		
PULL #2	306	272		
PULL #3	306	267		
PULL #4	306	290		
PULL #5	282	292		
TOTAL	1479	1420		
AVG.	2.958	2.84		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	396	404		4.05
PULL #2	395	364		3.91
PULL #3	386	372		3.84
PULL #4	394	393		3.77
PULL #5	391	379		3.86
TOTAL	1962	1912		1948
AVG.	3.924	3.824		3.896

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06349212
26 Feb 1990

CENTROIDAL DISTANCES

0 TO 1	.215058
1 TO 2	.481627
1 TO 3	.201457
1 TO 4	.0845044
1 TO 5	.437696

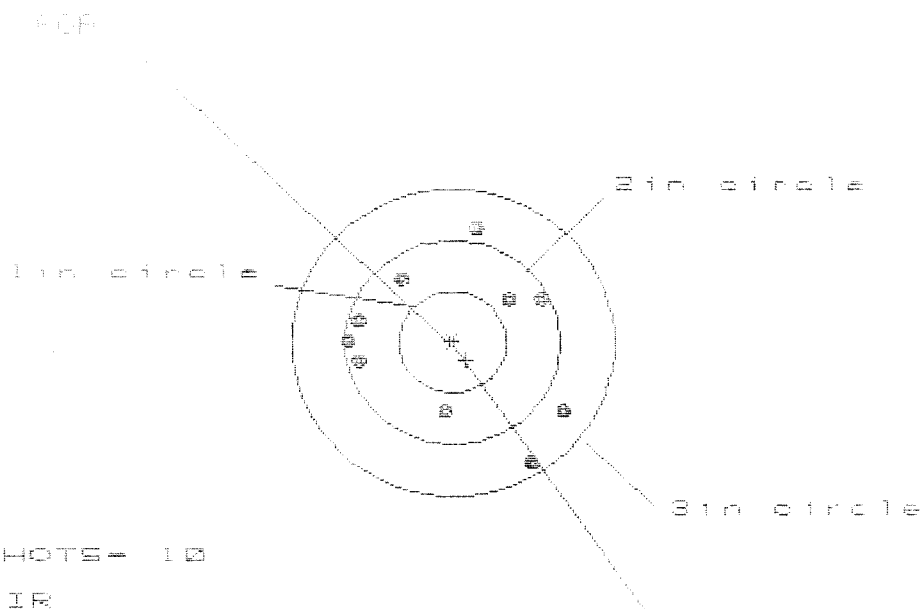
5 <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0728
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0054
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .073
THE AMR FOR THIS RIFLE IS: .8554

48

FILE: \PATTERNING\CENTERFIRE_PATT\08349212

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 10

2in = 7

3in = 10

HS = 1.953

VS = 2.343

GS = 2.389

CENTROID *

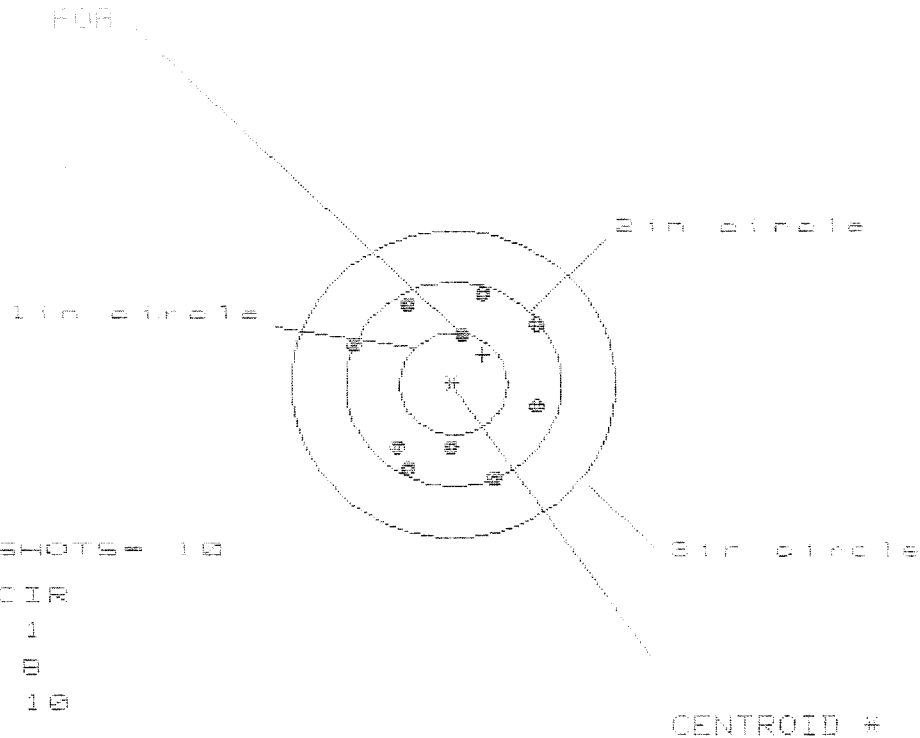
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.975	1.055	1.038
MINIMUM X	-.978	-.898	-.766
MAXIMUM Y	1.129	.995	.897
MINIMUM Y	-1.214	-.843	-.941
CENTROID X	-.125	-.205	-.337
CENTROID Y	.175	.318	.488
POB TO CENTROID in.	.216	.372	.529
MIN RADIUS	.661	.646	.490
MEAN RADIUS	.959	.890	.812
MAX RADIUS	1.412	1.313	1.042
HORIZONTAL SPREAD	1.953	1.953	1.796
VERTICAL SPREAD	2.343	1.838	1.838
EXTREME SPREAD	2.389	2.058	1.673
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

01-01-1998

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CENTERFIRE PATTERNS

2



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 8

3 in = 10

HS = 1.774

VS = 1.734

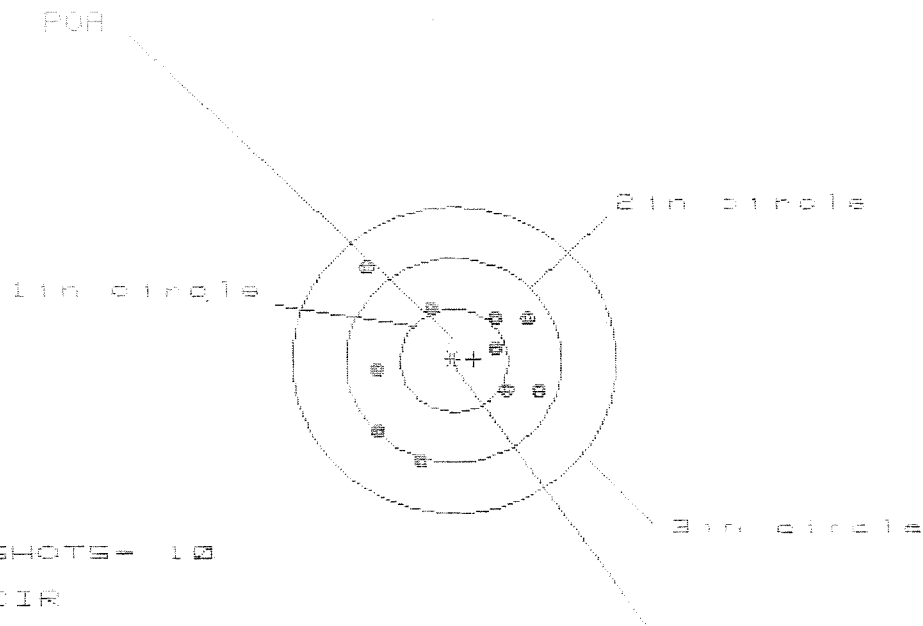
GS = 1.881

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.800	.692	.719
MINIMUM X	-.974	-.621	-.535
MAXIMUM Y	.856	.899	.983
MINIMUM Y	-.878	-.835	-.751
CENTROID X	-.274	-.166	-.252
CENTROID Y	-.283	-.326	-.410
FOR TO CENTROID in.	.394	.366	.482
MIN RADIUS	.437	.481	.467
MEAN RADIUS	.836	.804	.773
MAX RADIUS	1.048	1.000	1.038
HORIZONTAL SPREAD	1.774	1.313	1.254
VERTICAL SPREAD	1.734	1.734	1.734
EXTREME SPREAD	1.881	1.881	1.877
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	

13 Feb 1980

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 8

3in = 10

HS= 1.621

VS= 1.876

GS= 1.983

CENTROID *

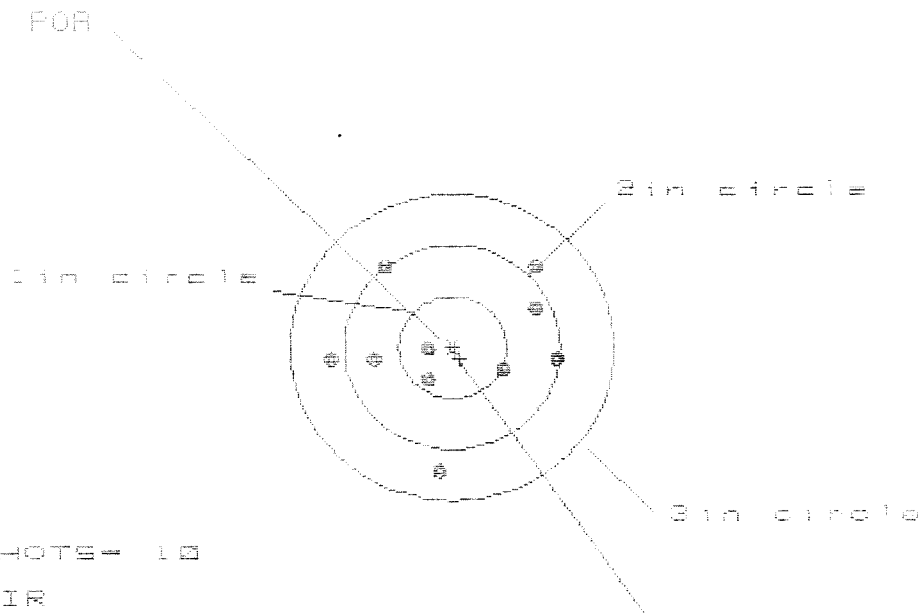
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.792	.700	.655
MINIMUM X	:	-.829	-.825	-.870
MAXIMUM Y	:	.904	.581	.472
MINIMUM Y	:	-.972	-.871	-.682
CENTROID X	:	-.186	-.094	-.049
CENTROID Y	:	-.017	-.118	-.009
POA TO CENTROID in.	:	.187	.150	.050
MIN RADIUS	:	.435	.377	.293
MEAN RADIUS	:	.755	.688	.630
MAX RADIUS	:	1.227	.994	1.093
HORIZONTAL SPREAD	:	1.621	1.525	1.525
VERTICAL SPREAD	:	1.876	1.452	1.134
EXTREME SPREAD	:	1.983	1.737	1.737
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

20 Feb 1988

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CENTERFIRE PATTERNS

4



OF SHOTS = 10

IN CIR

1in = 2

2in = 6

3in = 10

HS = 2.0000

VS = 2.0023

CS = 2.211

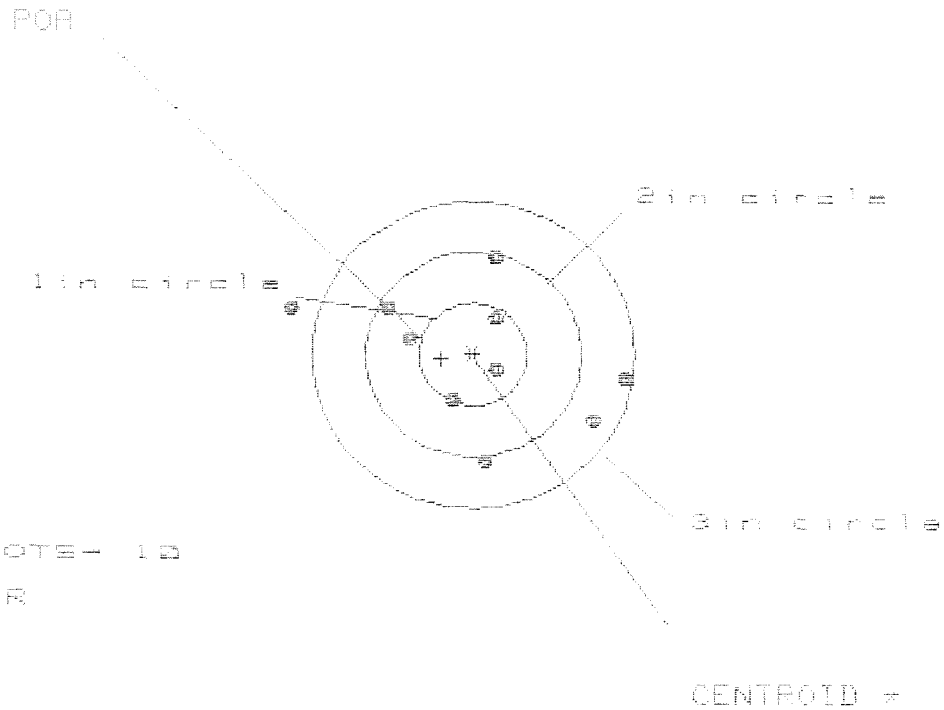
CENTROID *

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.999	.988	1.087
MINIMUM X	-1.099	-1.110	-1.011
MAXIMUM Y	.798	.662	.705
MINIMUM Y	-1.225	-1.400	-1.317
CENTROID X	-.071	-.060	-.159
CENTROID Y	.110	.246	.163
POA TO CENTROID in.	.130	.253	.228
MIN RADIUS	.250	.277	.160
MEAN RADIUS	.811	.767	.707
MAX RADIUS	1.228	1.134	1.099
HORIZONTAL SPREAD	2.098	2.098	2.098
VERTICAL SPREAD	2.023	1.062	1.022
EXTREME SPREAD	2.211	2.098	2.098
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

26 Feb 1998

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 5

3 in = 9

HS= 3.013

VS= 2.063

GS= 3.076

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.363	1.189	1.101
MINIMUM X	:	-1.653	-1.928	-1.781
MAXIMUM Y	:	.979	1.006	1.067
MINIMUM Y	:	-1.084	-1.037	-1.056
CENTROID X	:	.292	.475	.328
CENTROID Y	:	.042	-.005	.014
POA TO CENTROID in.	:	.295	.475	.328
MIN RADIUS	:	.277	.100	.232
MEAN RADIUS	:	.916	.816	.759
MAX RADIUS	:	1.703	1.189	1.249
HORIZONTAL SPREAD	:	3.013	2.108	1.862
VERTICAL SPREAD	:	2.063	2.063	2.063
EXTREME SPREAD	:	3.076	2.199	2.153
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			9	