

06636327

MODEL 700™ N24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington[®]

MODEL 700TM M24

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.

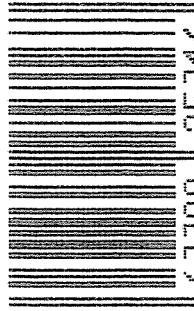
DUPONT
REG. U.S. PAT. & TM. OFF.

SERIAL NO.
C6636327

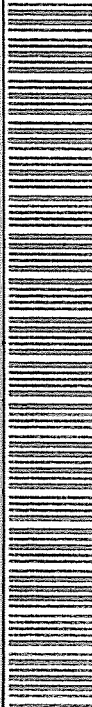
ORDER NO.
5715

20

UPC



0 47700 25716 7



5715 C6636327

GUN SERIAL #

C6636327

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		5/3/91	KS
600	Proof		5/3/91	KS
607	Check Headspace		5/3/91	KS
610	Dis-assemble Gun		5/3/91	KS
612	Magnaflux Barrel Action		JUL 2 1991	KR
	Magnaflux Bolt		JUL 2 1991	KR
615	Rollmark Caliber		JUL 2 1991	KR
617	Drill and Tap Sight Holes		JUL 2 1991	LB
618	Polish Barrel		JUL 7 1991	WB
620	Apply Coatings (Barrel Action)		8/6/91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/15/91	JA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/15/91	JA
	C) Inspect Ejector Hole for Chamfer		8/15/91	JA
	D) Oil Firing Pin Ass'y		8/15/91	JA
	E) Adjust Trigger Pull to Min Setting and Stake		8/19/91	JA

Op.	BARREL - MARK 0033063	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			8-19-91	D/H
	G) Safety Off Force	2	2	2			8-19-91	D/H
	H) Trigger Pull Test & Retainability						8-19/91	SH
	I) Firing Pin Indent	.021	.020	.022			8-19-91	D/H
	J) Assemble Stock						8/19/91	KK
	K) Assemble Swivel Studs						8/22/91	SH
	L) Attach Front and Rear Sight Assemblies						8/19/91	SH
	M) Iron Sight Alignment						8/19/91	SH
	N) Detach Front & Rear Sights & place in numbered container						8/19/91	SH
	O) Attach Scope to Rifle						8/19/91	SH
	P) Detach & Attach Scope 20 Times						8/19/91	SH
640	Gallery Target & Test						8-20-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						8-20-91	NF
655	Final Inspection							
	A) Headspace						8/22/91	SH
	B) Trigger Pull	287	289	289	281	289	8-21-91	D/H
	C) Function						8/22/91	SH
660	Pack						9-19-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6636327

DATE 8-19-91

TESTER JH.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.57	2.52	2.45	287	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.58	2.49	2.48	289	
PULL #3	2.55	2.51	2.55	289	
PULL #4	2.51	2.49	2.50	281	
PULL #5	2.49	2.50	2.44	289	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.22	3.30		
PULL #2	3.23	3.28		
PULL #3	3.22	3.27		
PULL #4	3.19	3.34		
PULL #5	3.33	3.32		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.46	4.54		4.54
PULL #2	4.50	4.52		4.62
PULL #3	4.49	4.53		4.60
PULL #4	4.52	4.55		4.61
PULL #5	4.53	4.55		4.29
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636327
23 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.116726
1 TO	2	.193052
1 TO	3	.156349
1 TO	4	.0206155
1 TO	5	.377308

5.8" <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0458
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .076
THE RESULTING AVERAGE PCI RADIUS FOR THIS RIFLE IS: .0887335
THE AMR FOR THIS RIFLE IS: .9626

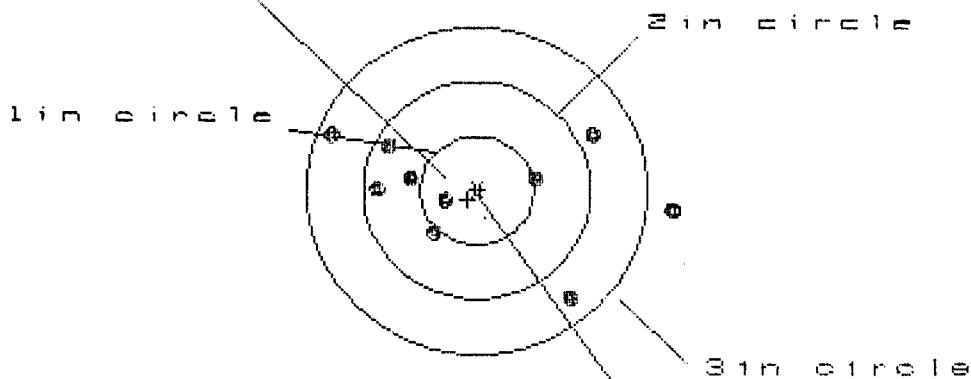
23 Aug 1991

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CENTERFIRE PATTERNS

1

POA



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 3.022

VS= 1.551

GS= 3.098

PATTERN #

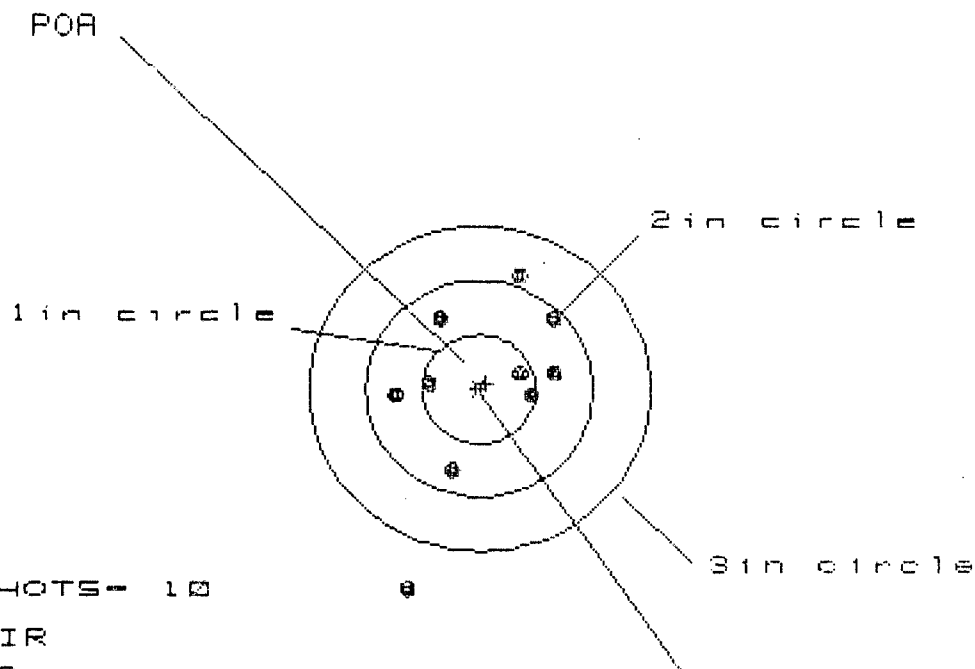
1

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.768	1.186	1.054
MINIMUM X	-1.254	-1.057	-.794
MAXIMUM Y	.530	.513	.516
MINIMUM Y	-1.021	-1.038	-.974
CENTROID X	.080	-.117	.015
CENTROID Y	.085	.102	.037
POA TO CENTROID in.	.116	.155	.040
MIN RADIUS	.311	.153	.236
MEAN RADIUS	.929	.781	.753
MAX RADIUS	1.775	1.445	1.308
HORIZONTAL SPREAD	3.022	2.243	1.848
VERTICAL SPREAD	1.551	1.551	1.489
EXTREME SPREAD	3.098	2.581	2.146
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

23 Aug 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 8

3 in = 9

HS = 1.421

VS = 2.952

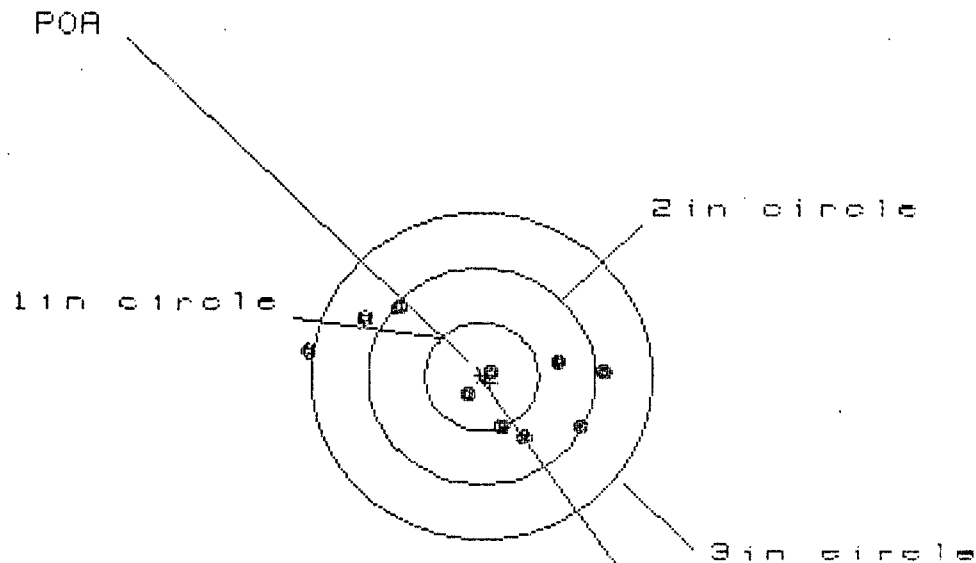
GS = 3.135

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.659	.584	.622
MINIMUM X	:	-.762	-.837	-.799
MAXIMUM Y	:	1.093	.886	.594
MINIMUM Y	:	-1.859	-.990	-.879
CENTROID X	:	-.058	.017	-.021
CENTROID Y	:	-.050	.157	.046
POA TO CENTROID in.	:	.077	.157	.050
MIN RADIUS	:	.425	.306	.356
MEAN RADIUS	:	.839	.679	.645
MAX RADIUS	:	1.978	1.031	.914
HORIZONTAL SPREAD	:	1.421	1.421	1.421
VERTICAL SPREAD	:	2.952	1.876	1.473
EXTREME SPREAD	:	3.135	1.967	1.711
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 5

3 in = 9

HS= 2.647

VS= 1.253

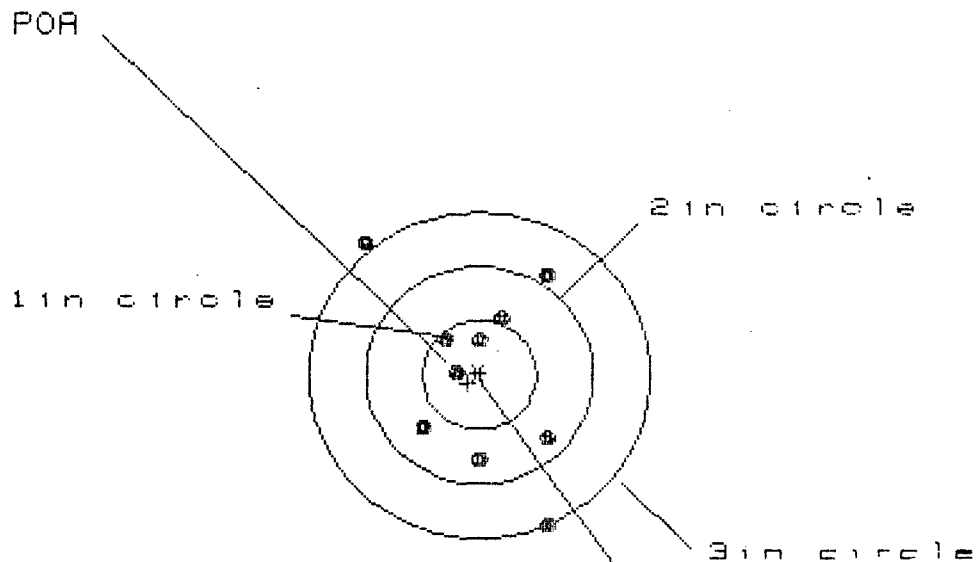
GS= 2.655

PATTERN #	:	3	3	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.109	.938	.791
MINIMUM X	:	-1.538	-1.171	-.995
MAXIMUM Y	:	.649	.679	.752
MINIMUM Y	:	-.604	-.574	-.501
CENTROID X	:	-.074	.096	.243
CENTROID Y	:	.058	.028	-.045
POA TO CENTROID in.	:	.094	.101	.247
MIN RADIUS	:	.116	.091	.251
MEAN RADIUS	:	.798	.685	.595
MAX RADIUS	:	1.561	1.310	1.247
HORIZONTAL SPREAD	:	2.647	2.109	1.786
VERTICAL SPREAD	:	1.253	1.253	1.253
EXTREME SPREAD	:	2.655	2.181	1.958
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	9		

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 7

3 in = 8

HS = 1.652

VS = 2.562

GS = 3.048

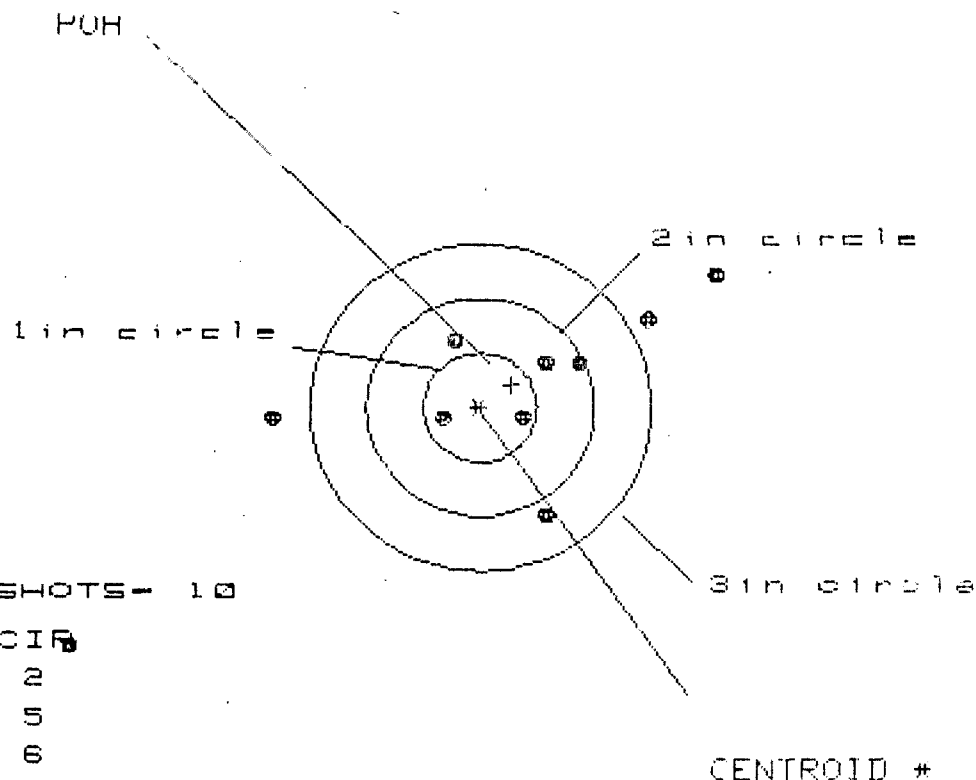
CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.650	.538	.522
MINIMUM X	:	-1.002	-.569	-.501
MAXIMUM Y	:	1.175	1.067	.910
MINIMUM Y	:	-1.387	-1.257	-.830
CENTROID X	:	.099	.211	.143
CENTROID Y	:	.077	-.053	.104
POA TO CENTROID in.	:	.126	.217	.177
MIN RADIUS	:	.217	.354	.263
MEAN RADIUS	:	.797	.732	.613
MAX RADIUS	:	1.544	1.367	1.048
HORIZONTAL SPREAD	:	1.652	1.107	1.023
VERTICAL SPREAD	:	2.562	2.324	1.740
EXTREME SPREAD	:	3.048	2.326	1.832
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	8		

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 6

HS= 5.700

VS= 3.410

GS= 6.642

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.060	1.655	1.258
MINIMUM X	-3.640	-2.270	-2.063
MAXIMUM Y	1.180	.933	.720
MINIMUM Y	-2.330	-1.251	-1.135
CENTROID X	-.276	.129	-.078
CENTROID Y	-.210	.037	-.079
POA TO CENTROID in.	.347	.134	.111
MIN RADIUS	.338	.280	.339
MEAN RADIUS	1.450	1.037	.937
MAX RADIUS	4.269	2.288	2.070
HORIZONTAL SPREAD	5.700	3.925	3.321
VERTICAL SPREAD	3.410	2.184	1.855
EXTREME SPREAD	6.642	4.112	3.440
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	6		