

C6636104

MODEL 700™ M24

Model **SWS**™

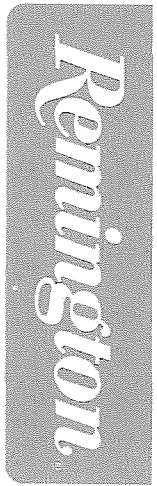
Action

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.
C6636104

ORDER NO.
5716

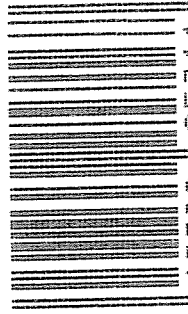
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



5716 C6636104

UPC



0 47700 25716 7

GUN SERIAL #

C6636104

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		4/23/91	K.S.
600	Proof		4/23/91	K.S.
607	Check Headspace		4/23/91	K.S.
610	Dis-assemble Gun		4/23/91	K.S.
612	Magnaflux Barrel Action	5 8 9 1		Kcd
	Magnaflux Bolt	5 8 9 1		Kcd
615	Rollmark Caliber	5 8 9 1		CS.
617	Drill and Tap Sight Holes	5 15 9 1		LB
618	Polish Barrel	5 15 9 1		wrb
620	Apply Coatings (Barrel Action)		5-31-91	JA
	Apply Coating (Bolt)		5-31-91	JA
625	Final Assembly A) Clean inside of Bolt Assembly		7/15/91	KH
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/15/91	KH
	C) Inspect Ejector Hole for Chamfer		7/15/91	KH
	D) Oil Firing Pin Ass'y		7/15/91	KH
	E) Adjust Trigger Pull to Min Setting and Stake		7-17-91	JH

Op. #	Op. NAME	READINGS					DATE	INITIALS
625 cont.	F) Safety On Force	6	6	6			7-17-91	SL
	G) Safety Off Force	4	4	4			7-17-91	SL
	H) Trigger Pull Test & Retainability						7-17-91	SL
	I) Firing Pin Indent	.023	.023	.023			7-17-91	SL
	J) Assemble Stock						7-18-91	KS
	K) Assemble Swivel Studs						7-18-91	1/H
	L) Attach Front and Rear Sight Assemblies						7-18-91	KS
	M) Iron Sight Alignment						7-18-91	KS
	N) Detach Front & Rear Sights & place in numbered container						7-18-91	KS
	O) Attach Scope to Rifle						7-18-91	KS
	P) Detach & Attach Scope 20 Times						7-18-91	KS
640	Gallery Target & Test						7-24-91	1/F
	A) Time						"	1/F
	B) Malfunctions						"	1/F
	C) Pierced Primers						"	1/F
	D) Optical Clarity of Scope						"	1/F
645	Inspect for Live Ammo						7-24-91	1/F
655	Final Inspection							
	A) Headspace						7-26-91	1/H
	B) Trigger Pull	2.22	2.20	2.30	2.25	2.27	7-26-91	SL
	C) Function						7-26-91	1/H
660	Pack						9-18-91	1/F

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6636104

DATE 7-17-91

TESTER SM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.28	2.40	2.44	2.22	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.33	2.38	2.40	2.20	
PULL #3	2.31	2.41	2.44	2.30	
PULL #4	2.38	2.41	2.41	2.25	
PULL #5	2.47	2.36	2.48	2.27	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.35	3.20		
PULL #2	3.29	3.53		
PULL #3	3.20	3.48		
PULL #4	3.12	3.51		
PULL #5	3.15	3.49		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.24	4.15		4.32
PULL #2	4.30	4.32		4.26
PULL #3	4.28	4.27		4.24
PULL #4	4.26	4.23		4.20
PULL #5	4.30	4.15		4.26
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636104
24 Jul 1991

CENTROIDAL DISTANCES

0 TO	1	.0960833
1 TO	2	.257934
1 TO	3	.213021
1 TO	4	.468386
1 TO	5	.087023

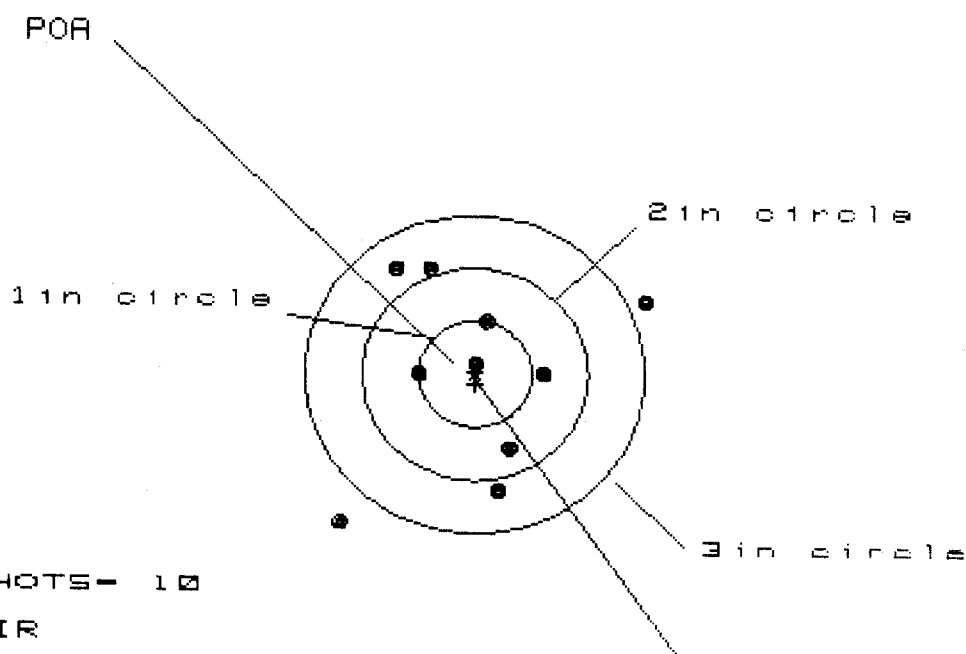
$\frac{5}{4}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: $-.017$
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: $-.019$
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: $.0254951$
THE AMR FOR THIS RIFLE IS: $.931$

24 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636184

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 2.707

VS= 2.396

GS= 3.396

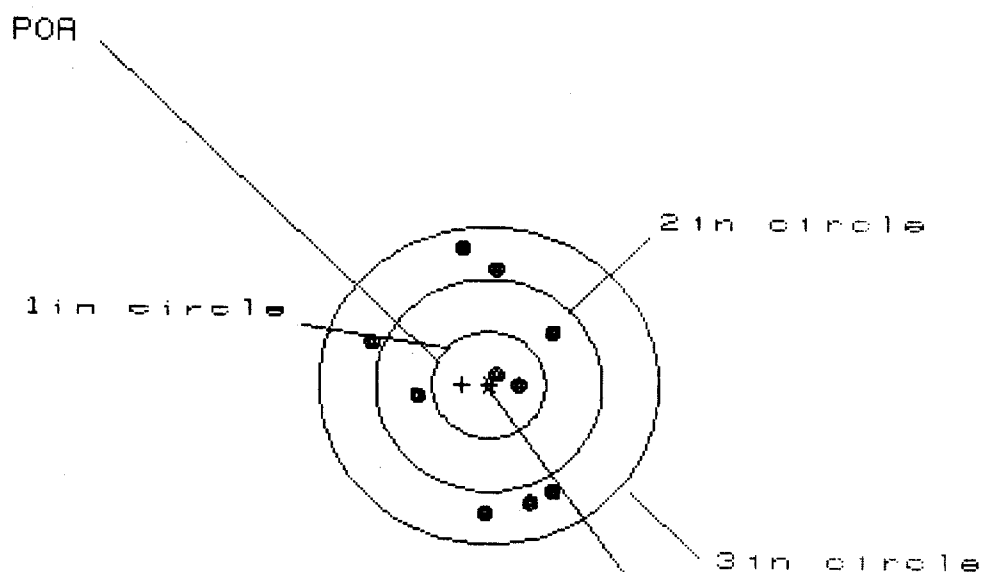
CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.525	1.393	.636
MINIMUM X	:	-1.182	-.856	-.681
MAXIMUM Y	:	1.006	.852	.915
MINIMUM Y	:	-1.390	-1.269	-1.206
CENTROID X	:	-.004	.128	-.047
CENTROID Y	:	.096	.250	.187
POA TO CENTROID in.	:	.096	.281	.192
MIN RADIUS	:	.075	.133	.076
MEAN RADIUS	:	.948	.839	.741
MAX RADIUS	:	1.824	1.483	1.239
HORIZONTAL SPREAD	:	2.707	2.249	1.317
VERTICAL SPREAD	:	2.396	2.121	2.121
EXTREME SPREAD	:	3.396	2.331	2.331
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			8	

24 Jul 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 2

2in = 4

3in = 10

HS= 1.573

VS= 2.453

GS= 2.457

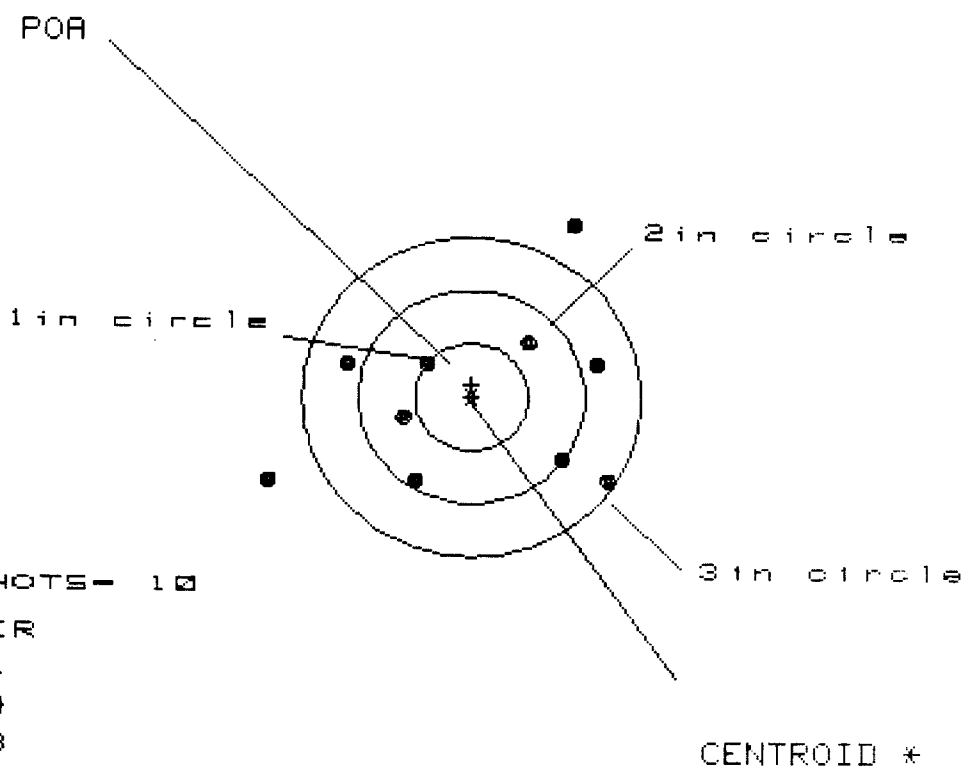
CENTROID *

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.566	.545	.611
MINIMUM X	:	-1.007	-1.028	-.960
MAXIMUM Y	:	1.284	1.268	1.157
MINIMUM Y	:	-1.169	-1.027	-1.137
CENTROID X	:	.235	.256	.188
CENTROID Y	:	-.001	-.143	-.032
POA TO CENTROID in.	:	.235	.294	.191
MIN RADIUS	:	.106	.243	.156
MEAN RADIUS	:	.881	.839	.800
MAX RADIUS	:	1.298	1.268	1.160
HORIZONTAL SPREAD	:	1.573	1.573	1.571
VERTICAL SPREAD	:	2.453	2.295	2.295
EXTREME SPREAD	:	2.457	2.296	2.296
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in - 1

2 in - 4

3 in - 5

HS- 3.013

VS- 2.409

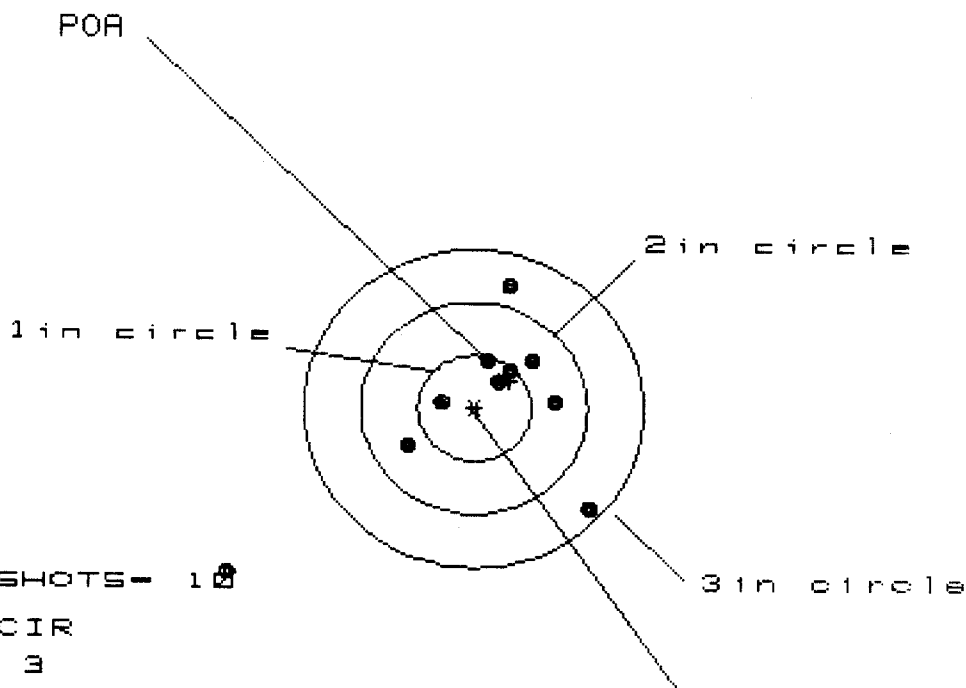
GS- 3.587

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.179	.975	1.060
MINIMUM X	:	-1.834	-1.294	-1.209
MAXIMUM Y	:	1.612	1.531	.637
MINIMUM Y	:	-.797	-.878	-.687
CENTROID X	:	-.001	.203	.118
CENTROID Y	:	-.117	-.036	-.227
POA TO CENTROID in.	:	.117	.206	.256
MIN RADIUS	:	.478	.517	.639
MEAN RADIUS	:	1.124	1.024	.933
MAX RADIUS	:	1.976	1.673	1.269
HORIZONTAL SPREAD	:	3.013	2.269	2.269
VERTICAL SPREAD	:	2.409	2.409	1.324
EXTREME SPREAD	:	3.587	2.793	2.509
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 3.194

VS= 2.676

GS= 3.629

CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.019	.778	.543
MINIMUM X	:	-2.175	-.808	-.711
MAXIMUM Y	:	1.173	1.006	.870
MINIMUM Y	:	-1.503	-1.091	-.659
CENTROID X	:	-.313	-.072	-.169
CENTROID Y	:	-.256	-.089	.047
POA TO CENTROID in.	:	.405	.115	.175
MIN RADIUS	:	.304	.088	.084
MEAN RADIUS	:	.883	.595	.476
MAX RADIUS	:	2.643	1.339	.970
HORIZONTAL SPREAD	:	3.194	1.586	1.254
VERTICAL SPREAD	:	2.676	2.097	1.529
EXTREME SPREAD	:	3.629	2.225	1.746
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			9	

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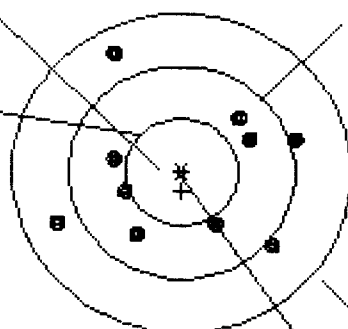
CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 10

HS= 2.026

VS= 1.729

GS= 2.232

CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.952	.882	.740
MINIMUM X	:	-1.074	-1.144	-.833
MAXIMUM Y	:	1.086	.678	.634
MINIMUM Y	:	-.643	-.522	-.566
CENTROID X	:	-.002	.068	.210
CENTROID Y	:	.183	.062	.106
POA TO CENTROID in.	:	.183	.092	.236
MIN RADIUS	:	.496	.443	.413
MEAN RADIUS	:	.819	.758	.692
MAX RADIUS	:	1.254	1.196	.846
HORIZONTAL SPREAD	:	2.026	2.026	1.573
VERTICAL SPREAD	:	1.729	1.200	1.200
EXTREME SPREAD	:	2.232	2.166	1.589
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	10		