

C6636247

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

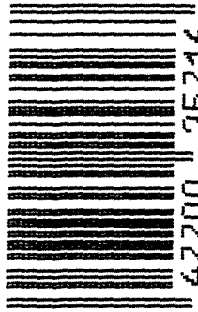
Remington

Remington®  REG. U.S. PAT. & TM. OFF.		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700™ H24		SERIAL NO. C6636247
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.		ORDER NO. 5716



5716 C6636247

UPC



0 47700 25716 7

GUN SERIAL #

C6636247

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 30 91		RW
600	Proof	4 30 91		RW
607	Check Headspace	4 30 91		RW
610	Dis-assemble Gun	4 30 91		RW
612	Magnaflux Barrel Action	5 6 91		KCK
	Magnaflux Bolt	5 6 91		KCK
615	Rollmark Caliber	5 6 91		CS
617	Drill and Tap Sight Holes	5 10 91		WB
618	Polish Barrel	5 10 91		WB
620	Apply Coatings (Barrel Action)		5/30/91	
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		5/30/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/91	RW
	C) Inspect Ejector Hole for Chamfer		5/30/91	RW
	D) Oil Firing Pin Ass'y		5/30/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		6-6-91	JH

Op. #	Op. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			6-6-91	JU
	G) Safety Off Force	3	3	3			6-6-91	JU
	H) Trigger Pull Test & Retainability						6-6-91	JU
	I) Firing Pin Indent	.022	.0215	.0215			6-6-91	JU
	J) Assemble Stock						6/6/91	RW
	K) Assemble Swivel Studs						6-14-91	JU
	L) Attach Front and Rear Sight Assemblies						6/6/91	RW
	M) Iron Sight Alignment						6/6/91	RW
	N) Detach Front & Rear Sights & place in numbered container						6/6/91	RW
	O) Attach Scope to Rifle						6/6/91	RW
	P) Detach & Attach Scope 20 Times						6/6/91	RW
640	Gallery Target & Test						6-6-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						6-6-91	NF
655	Final Inspection							
	A) Headspace						6-14-91	JU
	B) Trigger Pull	2.70	2.79	2.77	2.77	2.76	6-13-91	JU
	C) Function						6-14-91	JU
660	Pack						6-19-91	NF

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6636247

DATE 6-6-91

TESTER JH.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.32	2.40	2.70	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.28	2.22	2.38	2.79	
PULL #3	2.42	2.25	2.41	2.77	
PULL #4	2.37	2.60	2.38	2.77	
PULL #5	2.38	2.37	2.30	2.76	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.50	3.41		
PULL #2	3.39	3.51		
PULL #3	3.50	3.51		
PULL #4	3.37	3.51		
PULL #5	3.50	3.16		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.48	4.45		4.16
PULL #2	4.45	4.49		4.53
PULL #3	4.40	4.53		4.59
PULL #4	4.40	4.55		4.59
PULL #5	4.37	4.44		4.61
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636247
6 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.37392
1 TO	2	.419672
1 TO	3	.145671
1 TO	4	.519477
1 TO	5	.214898

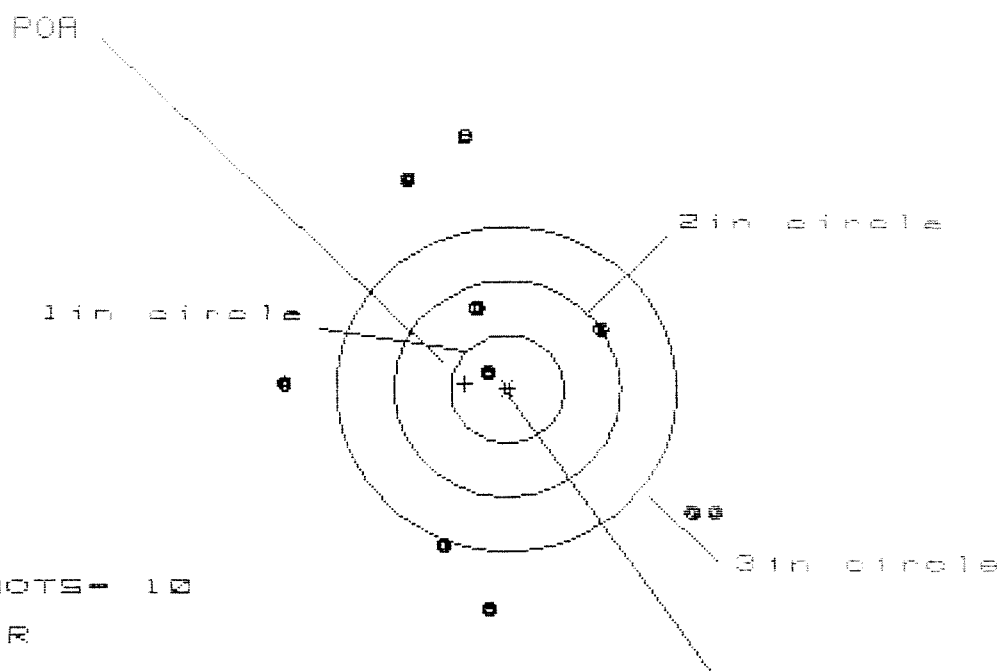
~~751~~ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1246
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0038
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .124658
THE AMR FOR THIS RIFLE IS: 1.158

6 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08636247

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 1

2in = 2

3in = 3

HS = 3.814

VS = 4.386

GS = 4.390

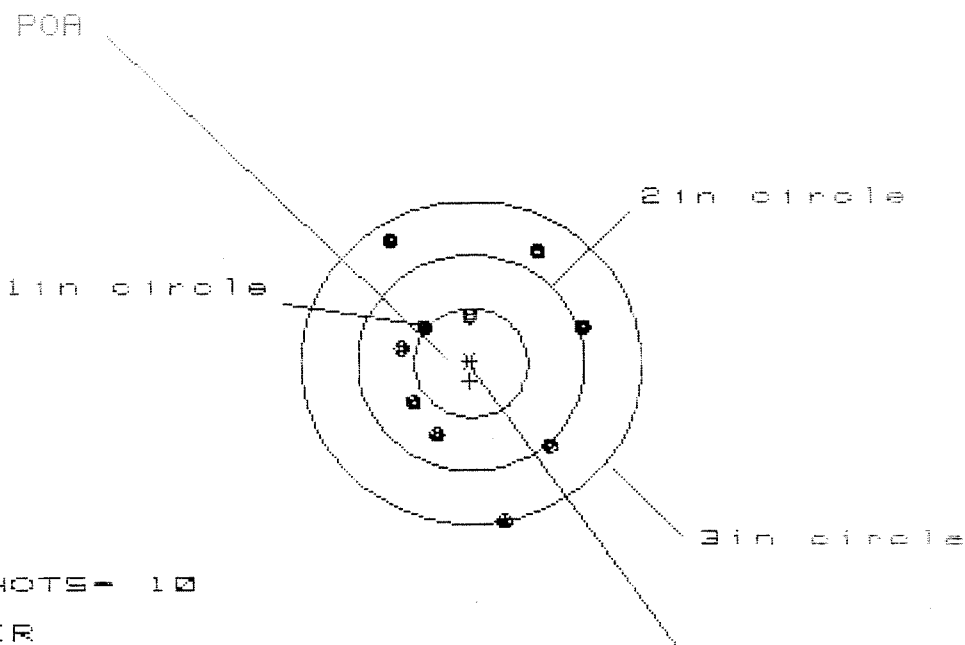
CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.832	1.794	1.770
MINIMUM X	:	-1.982	-2.020	-1.796
MAXIMUM Y	:	2.320	2.212	2.100
MINIMUM Y	:	-2.066	-1.808	-1.920
CENTROID X	:	.370	.408	.183
CENTROID Y	:	-.054	-.312	-.200
POA TO CENTROID in.	:	.374	.513	.272
MIN RADIUS	:	.218	.454	.302
MEAN RADIUS	:	1.629	1.565	1.480
MAX RADIUS	:	2.344	2.373	2.194
HORIZONTAL SPREAD	:	3.814	3.814	3.566
VERTICAL SPREAD	:	4.386	4.020	4.020
EXTREME SPREAD	:	4.390	4.082	4.075
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	2		
NUMBER IN THREE INCH CIRCLE	=	3		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 1.708

VS= 2.592

GS= 2.788

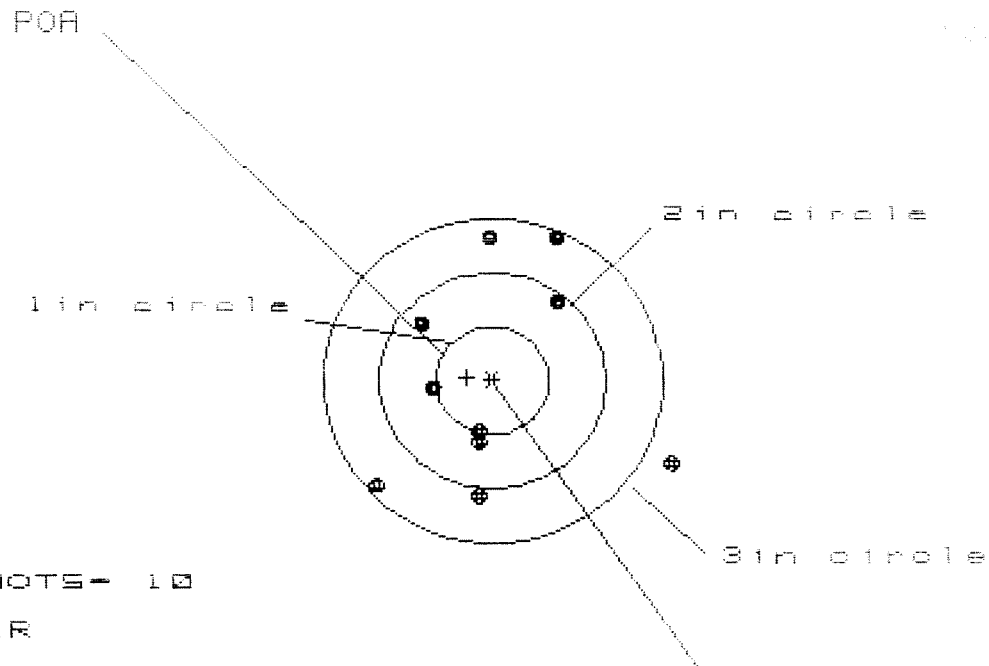
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.987	1.021	.935
MINIMUM X	:	-.721	-.687	-.624
MAXIMUM Y	:	1.118	.954	.985
MINIMUM Y	:	-1.474	-.914	-.795
CENTROID X	:	.012	-.022	.063
CENTROID Y	:	.165	.329	.210
POA TO CENTROID in.	:	.166	.330	.219
MIN RADIUS	:	.419	.258	.377
MEAN RADIUS	:	.901	.808	.774
MAX RADIUS	:	1.506	1.175	1.108
HORIZONTAL SPREAD	:	1.708	1.708	1.559
VERTICAL SPREAD	:	2.592	1.868	1.780
EXTREME SPREAD	:	2.788	2.327	1.953
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 2.593

VS= 2.391

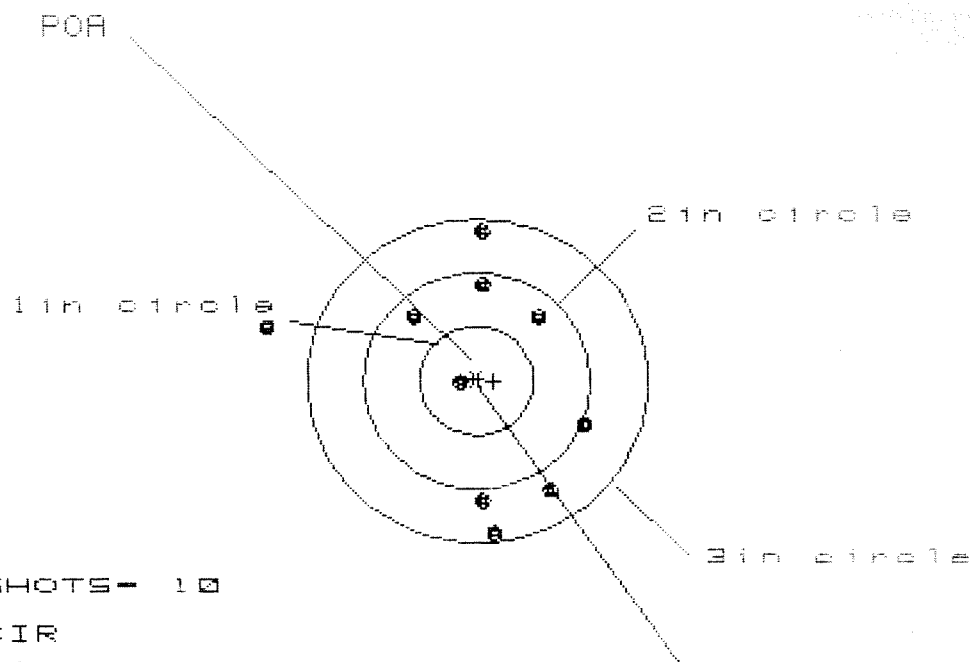
GS= 2.789

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	9
MAXIMUM X	:	1.530	.766	.810
MINIMUM X	:	-1.063	-.893	-.798
MAXIMUM Y	:	1.310	1.221	1.372
MINIMUM Y	:	-1.081	-1.170	-1.019
CENTROID X	:	.226	.056	-.039
CENTROID Y	:	-.032	.057	-.094
POA TO CENTROID in.	:	.228	.080	.102
MIN RADIUS	:	.461	.378	.259
MEAN RADIUS	:	1.025	.927	.826
MAX RADIUS	:	1.725	1.429	1.386
HORIZONTAL SPREAD	:	2.593	1.659	1.616
VERTICAL SPREAD	:	2.391	2.391	2.391
EXTREME SPREAD	:	2.789	2.789	2.465
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			9	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 9

HS= 2.795

VS= 2.804

GS= 2.959

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.975	.773	.760
MINIMUM X	:	-1.820	-.803	-.816
MAXIMUM Y	:	1.407	1.467	1.123
MINIMUM Y	:	-1.397	-1.337	-1.153
CENTROID X	:	-.146	.056	.069
CENTROID Y	:	.006	-.054	-.238
POA TO CENTROID in.	:	.147	.078	.248
MIN RADIUS	:	.135	.326	.388
MEAN RADIUS	:	1.080	.985	.916
MAX RADIUS	:	1.898	1.471	1.183
HORIZONTAL SPREAD	:	2.795	1.576	1.576
VERTICAL SPREAD	:	2.804	2.804	2.276
EXTREME SPREAD	:	2.959	2.806	2.281
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			4	
NUMBER IN THREE INCH CIRCLE =			9	

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CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 1

2 in = 4

3 in = 7

HS = 3.230

VS = 3.124

GS = 3.493

CENTROID #

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.740	1.574	1.563
MINIMUM X	:	-1.490	-1.183	-1.195
MAXIMUM Y	:	1.827	1.682	.759
MINIMUM Y	:	-1.297	-1.086	-.875
CENTROID X	:	.161	.327	.339
CENTROID Y	:	-.104	.041	-.170
POA TO CENTROID in.	:	.192	.329	.379
MIN RADIUS	:	.495	.573	.656
MEAN RADIUS	:	1.157	1.058	.969
MAX RADIUS	:	1.976	1.685	1.563
HORIZONTAL SPREAD	:	3.230	2.757	2.757
VERTICAL SPREAD	:	3.124	2.768	1.634
EXTREME SPREAD	:	3.493	2.840	2.783
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	7		