

06636279

MODEL 700™ M24

Model **SWS**™

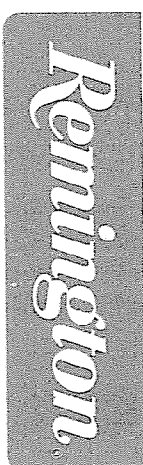
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Remington
 MODEL 700™ H24

VERY IMPORTANT:
 Instruction Book
 enclosed to assure
 safe use of this
 firearm.

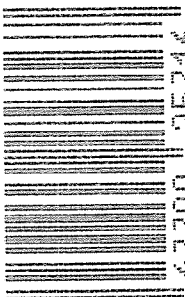
REG. U.S. PAT. & TM. OFF.

SERIAL NO.
 06606279

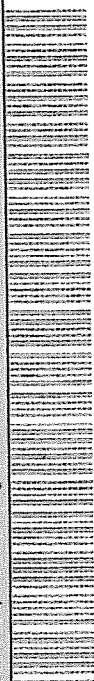
ORDER NO.
 5716

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

UPC



0 47700 25716 7



5716 06606279

GUN SERIAL # C6636279

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	6 27 9 1	RW
600	Proof		6 27 9 1	RW
607	Check Headspace		6 27 9 1	RW
610	Dis-assemble Gun		6 27 9 1	RW
612	Magnaflux Barrel Action		JUL 2 1991	KR
	Magnaflux Bolt		JUL 2 1991	KR
615	Rollmark Caliber		JUL 2 1991	28
617	Drill and Tap Sight Holes		JUL 2 1991	FB
618	Polish Barrel		JUL 7 1991	WB
620	Apply Coatings (Barrel Action)		7-12-91	TA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/23/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/23/91	RW
	C) Inspect Ejector Hole for Chamfer		7/23/91	RW
	D) Oil Firing Pin Ass'y		7/23/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		7-23-91 4	RW

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			7-29-91	YH
	G) Safety Off Force	4	4	4			7-29-91	YH
	H) Trigger Pull Test & Retainability						7-29-91	YH
	I) Firing Pin Indent	.021	.021	.021			7-29-91	YH
	J) Assemble Stock						7/30/91	RW
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies						7/30/91	RW
	M) Iron Sight Alignment						7/30/91	RW
	N) Detach Front & Rear Sights & place in numbered container						7/30/91	RW
	O) Attach Scope to Rifle						7/30/91	RW
	P) Detach & Attach Scope 20 Times						7/30/91	RW
640	Gallery Target & Test						7-30-91	NE
	A) Time						"	NE
	B) Malfunctions						"	NE
	C) Pierced Primers						"	NE
	D) Optical Clarity of Scope						"	NE
645	Inspect for Live Ammo						7-30-91	NE
655	Final Inspection							
	A) Headspace						8-30-91	AC
	B) Trigger Pull	2.57	2.58	2.60	2.59	2.60	8-5-91	YH
	C) Function						8-30-91	AC
660	Pack						9-17-91	DH

SWS TRIGGER PULL TEST

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

SERIAL NO C-6636279
DATE 7-29-91
TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.53	2.45	2.55	2.57	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.44	2.50	2.56	2.58	
PULL #3	2.50	2.46	2.40	2.60	
PULL #4	2.52	2.54	2.48	2.59	
PULL #5	2.47	2.49	2.46	2.60	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.42	3.44		
PULL #2	3.31	3.39		
PULL #3	3.40	3.38		
PULL #4	3.30	3.41		
PULL #5	3.29	3.40		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.42	4.39		4.41
PULL #2	4.35	4.41		4.39
PULL #3	4.13	4.41		4.44
PULL #4	4.30	4.41		4.42
PULL #5	4.38	4.28		4.39
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636279
30 Jul 1991

CENTROIDAL DISTANCES

0 TO 1	.170423
1 TO 2	.216372
1 TO 3	.152971
1 TO 4	.114481
1 TO 5	.21783

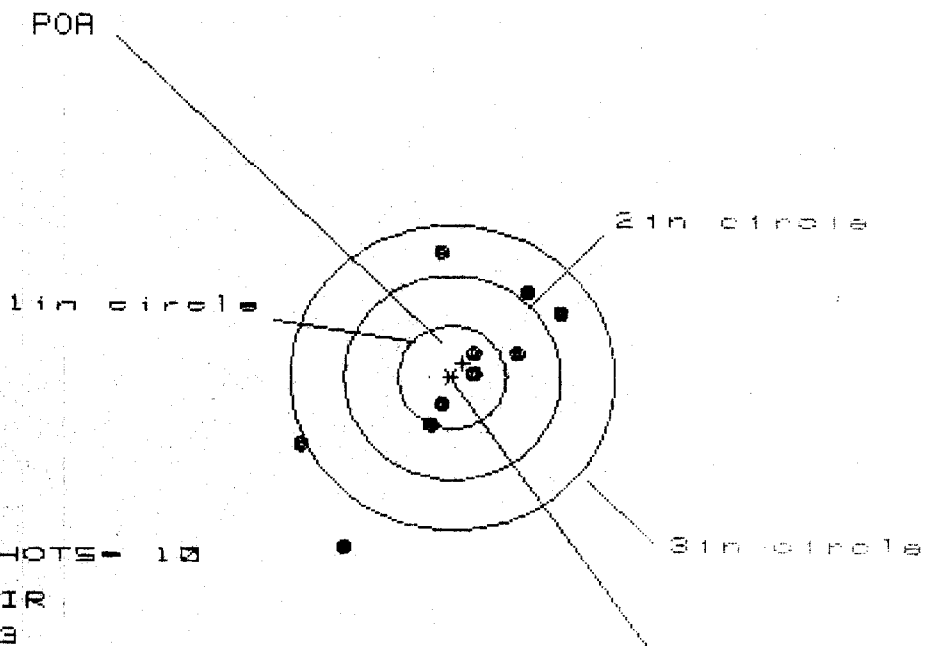
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1076
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0414
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .11529
THE ACP FOR THIS RIFLE IS: .9702

30 JUL 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C9836279

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 3

2in = 5

3in = 8

1in = 0.350

2in = 0.937

3in = 3.058

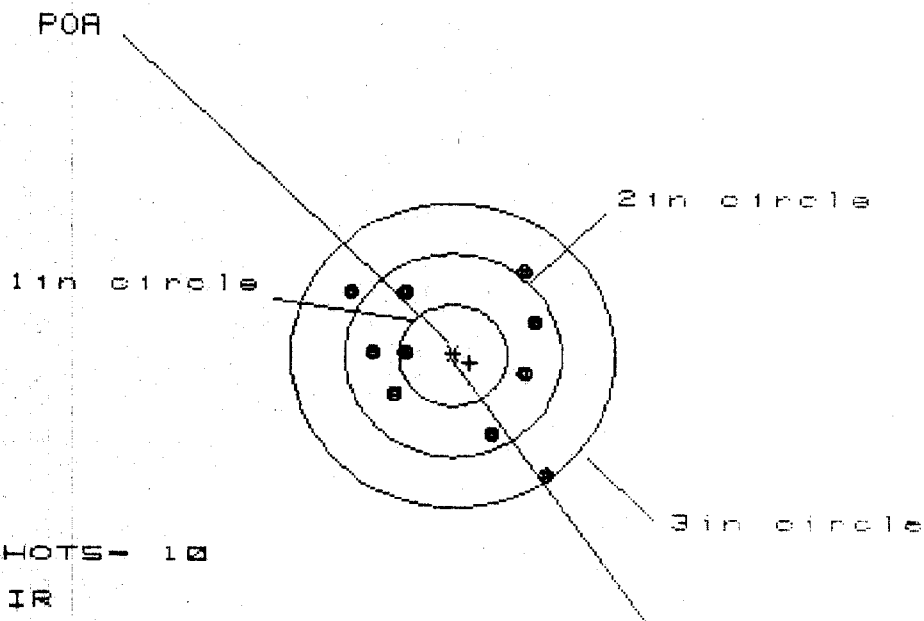
CENTROID *

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.991	.832	.699
MINIMUM X	:	-1.359	-1.468	-1.472
MAXIMUM Y	:	1.232	1.043	.936
MINIMUM Y	:	-1.705	-.854	-.764
CENTROID X	:	-.100	.009	.192
CENTROID Y	:	-.138	.051	.158
POA TO CENTROID in.	:	.171	.052	.249
MIN RADIUS	:	.228	.117	.104
MEAN RADIUS	:	.892	.738	.593
MAX RADIUS	:	1.965	1.698	1.025
HORIZONTAL SPREAD	:	2.350	2.350	1.171
VERTICAL SPREAD	:	2.937	1.897	1.700
DIAG SPREAD	:	3.058	2.675	1.701
SPREAD IN ONE INCH CIRCLE	=		3	
SPREAD IN TWO INCH CIRCLE	=		5	
SPREAD IN THREE INCH CIRCLE	=		8	

30 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08636279

CENTERFIRE PATTERNS # 2



OF SHOTS - 10
 # IN CIR
 1 1 1
 2 7
 3 10
 1 1.0000
 2 2.0000
 3 3.0000

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.837	.821	.712
MINIMUM X	:	-.969	-.876	-.755
MAXIMUM Y	:	.827	.694	.759
MINIMUM Y	:	-1.193	-.915	-.850
CENTROID X	:	-.156	-.249	-.140
CENTROID Y	:	.071	.204	.139
POA TO CENTROID in.	:	.172	.322	.197
MIN RADIUS	:	.461	.370	.473
MEAN RADIUS	:	.860	.776	.747
MAX RADIUS	:	1.457	1.017	.974
HORIZONTAL SPREAD	:	1.806	1.697	1.467
VERTICAL SPREAD	:	2.020	1.609	1.609
EXTREME SPREAD	:	2.580	1.920	1.690
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	10		

30 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6536273

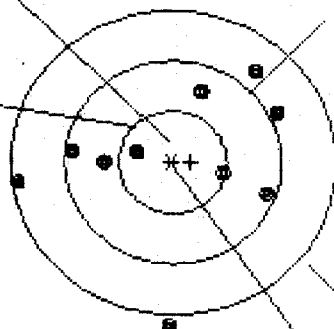
CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle



* OF SHOTS - 10

* IN CIR

1 in = 2

2 in = 6

3 in = 9

CENTROID *

HEI 2.383

VSI 2.444

CSI 2.576

PATTERN #

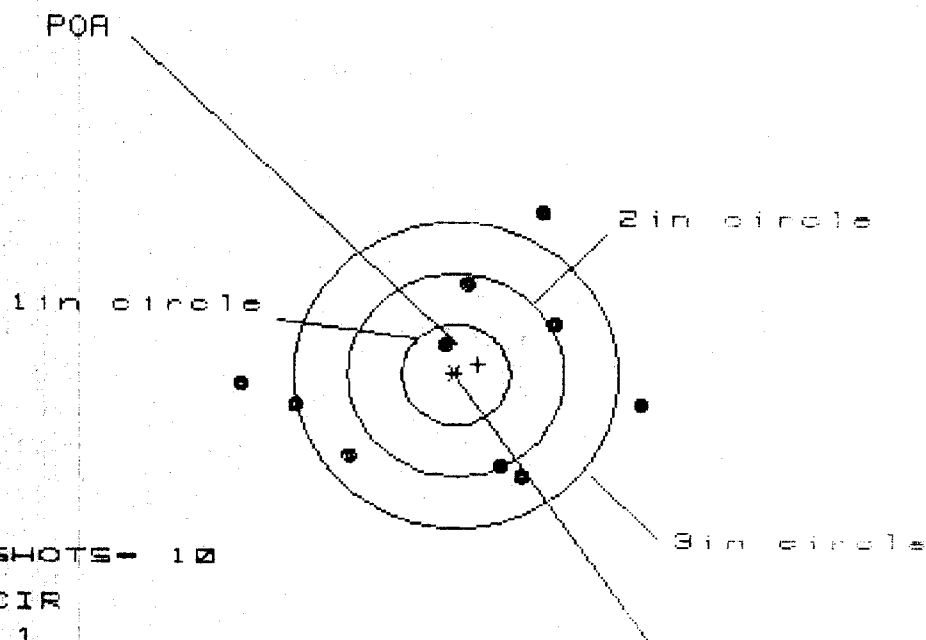
SHOTS (BEST OF)

	10	9	8
MAXIMUM X	.984	.977	.802
MINIMUM X	-1.393	-1.406	-1.105
MAXIMUM Y	.873	.698	.651
MINIMUM Y	-1.571	-.454	-.501
CENTROID X	-.166	-.159	.016
CENTROID Y	.000	.175	.222
POA TO CENTROID in.	.166	.237	.223
MIN RADIUS	.325	.345	.447
MEAN RADIUS	.921	.833	.741
MAX RADIUS	1.572	1.456	1.116
HORIZONTAL SPREAD	2.383	2.383	1.907
VERTICAL SPREAD	2.444	1.152	1.152
EXTREME SPREAD	2.576	2.475	1.947
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

30 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636279

CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 2

3 in = 6

HM = 3.720

VM = 2.561

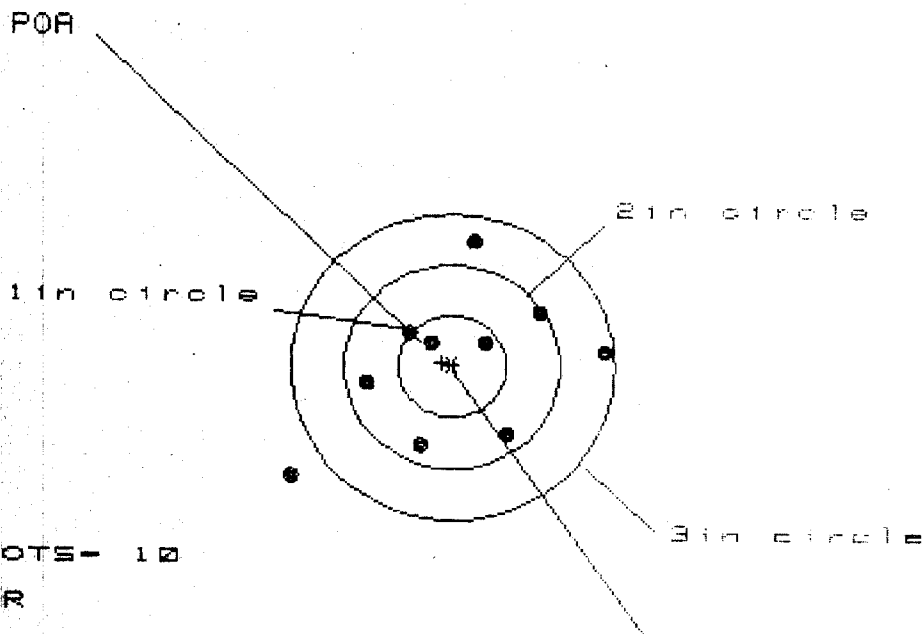
GM = 3.720

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.726	1.505	1.584
MINIMUM X	-1.994	-1.748	-1.669
MAXIMUM Y	1.614	1.602	1.087
MINIMUM Y	-.947	-.959	-.758
CENTROID X	-.209	.012	-.067
CENTROID Y	-.103	-.091	-.292
POA TO CENTROID in.	.233	.092	.299
MIN RADIUS	.370	.486	.600
MEAN RADIUS	1.282	1.186	1.113
MAX RADIUS	1.997	1.767	1.670
HORIZONTAL SPREAD	3.720	3.253	3.253
VERTICAL SPREAD	2.561	2.561	1.845
EXTREME SPREAD	3.728	3.254	3.254
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	6		

30 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08636279

CENTERFIRE PATTERNS # 5



OF SHOTS- 10
IN CIR
1" = 3
2" = 7
3" = 8
HS = 2.000
VS = 2.288
GS = 3.125

CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.363	1.194	.752
MINIMUM X	:	-1.525	-.966	-.817
MAXIMUM Y	:	1.216	1.097	1.097
MINIMUM Y	:	-1.072	-.882	-.882
CENTROID X	:	.093	.262	.113
CENTROID Y	:	-.037	.082	.082
POA TO CENTROID in.	:	.100	.275	.139
MIN RADIUS	:	.281	.174	.205
MEAN RADIUS	:	.896	.769	.700
MAX RADIUS	:	1.864	1.194	1.110
HORIZONTAL SPREAD	:	2.888	2.160	1.569
VERTICAL SPREAD	:	2.288	1.979	1.979
EXTREME SPREAD	:	3.125	2.181	2.029
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	8		

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636279
14 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.21496
1 TO	2	.213242
1 TO	3	.189897
1 TO	4	.190066
1 TO	5	.252733

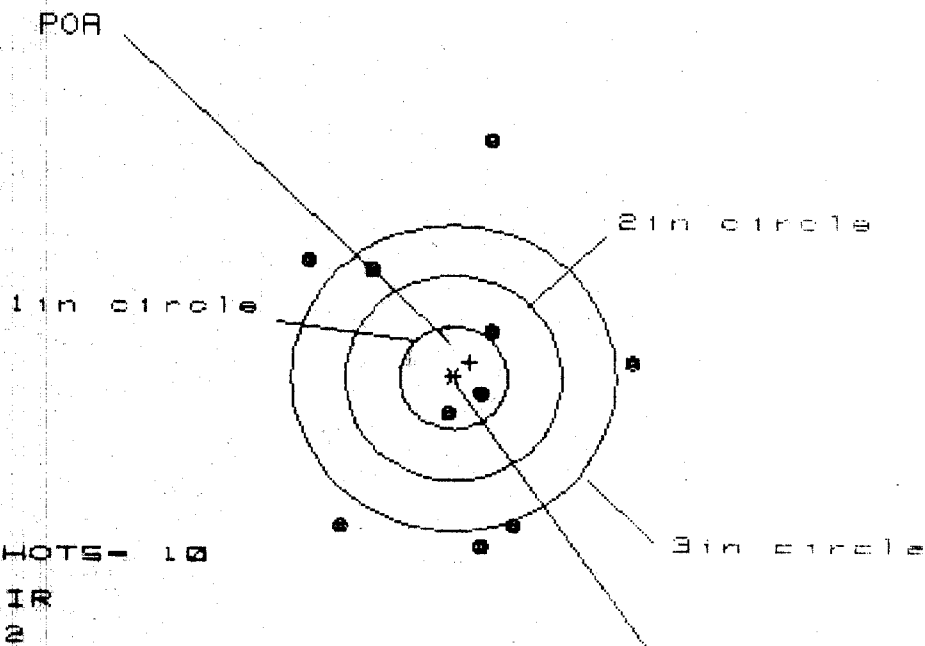
95 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0364
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0644
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .10776
THE AMR FOR THIS RIFLE IS: .913

14 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8635279.1

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 2

3 6

4

3.027

4.025

4.075

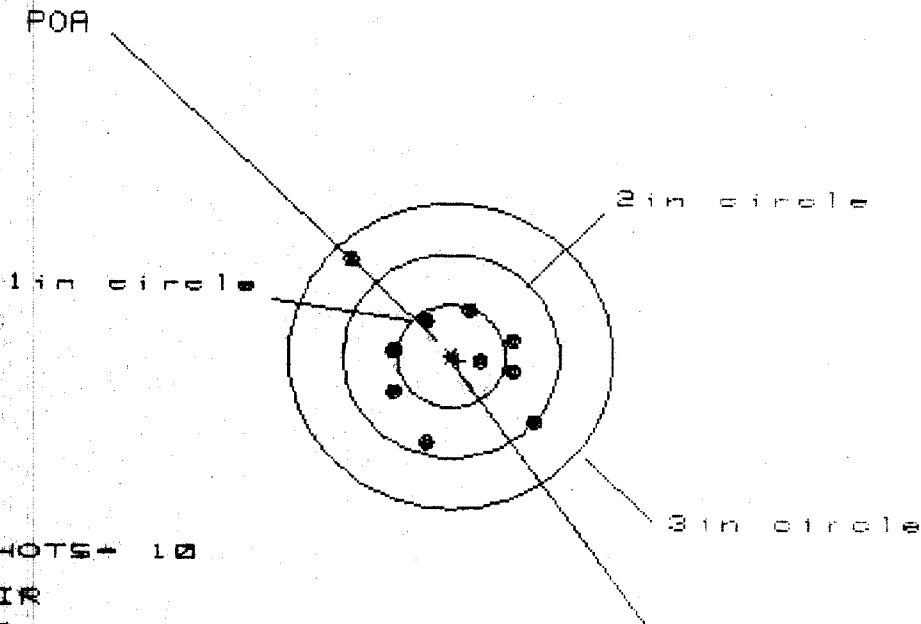
CENTROID *

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.651	1.694	1.563
MINIMUM X	:	-1.376	-1.333	-1.464
MAXIMUM Y	:	2.347	1.399	1.251
MINIMUM Y	:	-1.678	-1.417	-1.565
CENTROID X	:	-.152	-.195	-.064
CENTROID Y	:	-.152	-.413	-.265
POA TO CENTROID in.	:	.215	.457	.272
MIN RADIUS	:	.251	.053	.119
MEAN RADIUS	:	1.327	1.178	1.110
MAX RADIUS	:	2.379	1.933	1.926
HORIZONTAL SPREAD	:	3.027	3.027	3.027
VERTICAL SPREAD	:	4.025	2.816	2.816
EXTREME SPREAD	:	4.075	3.237	3.237
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		4	

14 Sep 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10
 # IN CIR
 1 in = 3
 2 in = 8
 3 in = 10
 ME = 1.659
 VE = 1.843
 GE = 2.353

CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.752	.651	.578
MINIMUM X	:	-.907	-.622	-.541
MAXIMUM Y	:	.976	.566	.493
MINIMUM Y	:	-.867	-.759	-.832
CENTROID X	:	-.068	.033	-.048
CENTROID Y	:	.044	-.064	.009
POA TO CENTROID in.	:	.081	.072	.049
MIN RADIUS	:	.297	.221	.279
MEAN RADIUS	:	.676	.594	.551
MAX RADIUS	:	1.333	.875	.869
HORIZONTAL SPREAD	:	1.659	1.273	1.119
VERTICAL SPREAD	:	1.843	1.325	1.325
EXTREME SPREAD	:	2.353	1.482	1.382
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

14 Sep 1991

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CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID *

* OF SHOTS- 10

* IN CIR

1 1 1 3

2 1 1 2

3 1 1 0

MEAN 2.438

VO 3.095

QS 3.461

PATTERN #

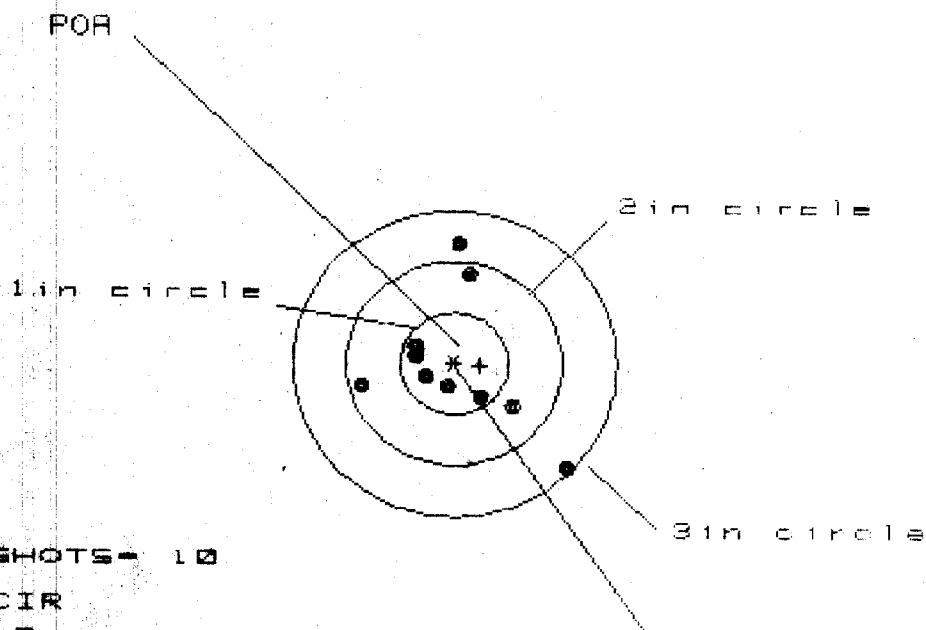
SHOTS (BEST OF)

	10	9	8
MAXIMUM X	1.450	1.516	.698
MINIMUM X	-.988	-.922	-.733
MAXIMUM Y	2.055	.554	.522
MINIMUM Y	-1.040	-.812	-.843
CENTROID X	-.058	-.124	-.313
CENTROID Y	.013	-.215	-.183
POA TO CENTROID in.	.059	.248	.363
MIN RADIUS	.234	.202	.357
MEAN RADIUS	.887	.722	.616
MAX RADIUS	2.139	1.537	1.097
HORIZONTAL SPREAD	2.438	2.438	1.431
VERTICAL SPREAD	3.095	1.366	1.366
EXTREME SPREAD	3.461	2.507	1.955
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	

14 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636279.1

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 5

2 in = 8

3 in = 10

ME = 1.851

VS = 2.262

CS = 2.452

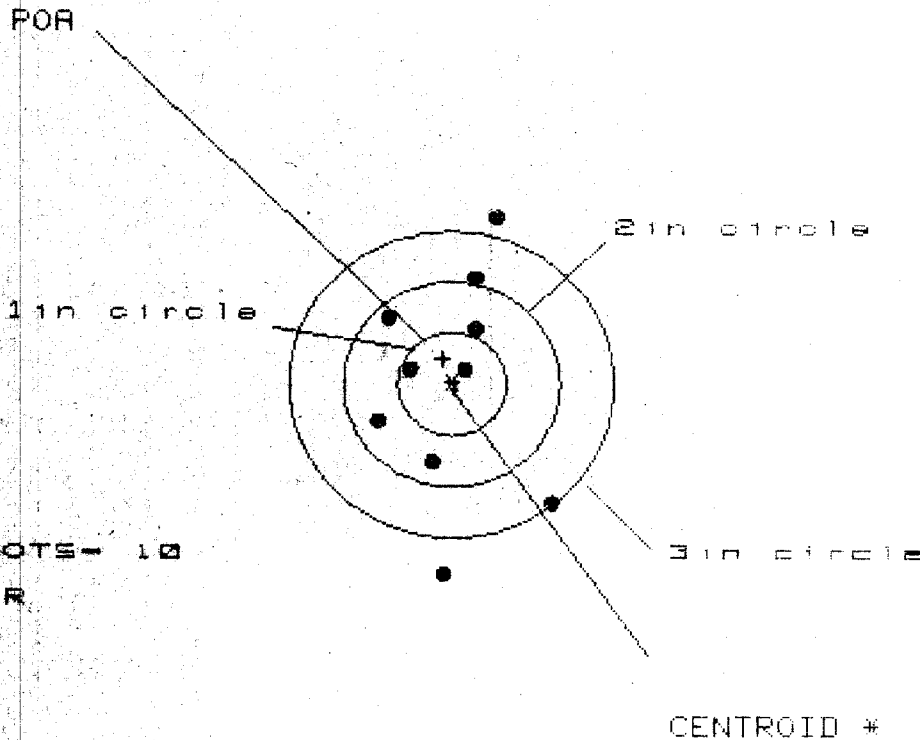
CENTROID *

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.988	.659	.678
MINIMUM X	:	-.873	-.763	-.744
MAXIMUM Y	:	1.202	1.084	.920
MINIMUM Y	:	-1.060	-.515	-.380
CENTROID X	:	-.237	-.347	-.366
CENTROID Y	:	.018	.136	.001
POA TO CENTROID in.	:	.238	.373	.366
MIN RADIUS	:	.260	.218	.171
MEAN RADIUS	:	.691	.594	.498
MAX RADIUS	:	1.449	1.094	.951
HORIZONTAL SPREAD	:	1.861	1.422	1.422
VERTICAL SPREAD	:	2.262	1.599	1.300
EXTREME SPREAD	:	2.452	1.686	1.491
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

14 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08636279.1

CENTERFIRE PATTERNS # 5



OF SHOTS - 10
IN CIR
1 1 2
2 1 6
3 1 8
MEAN 1.526
VST 3.557
GST 3.599

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.900	.888	.942
MINIMUM X	:	-.726	-.738	-.684
MAXIMUM Y	:	1.681	1.473	1.027
MINIMUM Y	:	-1.875	-1.397	-1.211
CENTROID X	:	.083	.095	.041
CENTROID Y	:	-.245	-.037	-.221
POA TO CENTROID in.	:	.259	.102	.225
MIN RADIUS	:	.223	.124	.234
MEAN RADIUS	:	.984	.843	.770
MAX RADIUS	:	1.879	1.655	1.535
HORIZONTAL SPREAD	:	1.626	1.626	1.626
VERTICAL SPREAD	:	3.557	2.870	2.240
EXTREME SPREAD	:	3.599	2.906	2.340
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	