

C6636081

MODEL 700™ M24

Model SWS™

Action

Barrel Length

Capacity

Order No. 5715

*Includes 1 in chamber.

Remington




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

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

MODEL 700™ H24

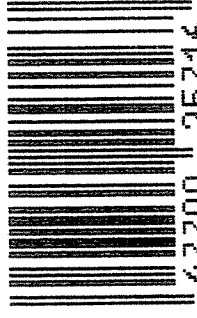
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

SERIAL NO.
C6636081

ORDER NO.
5716

LPC



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5716 C6636081

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636081

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 8 91		RW
600	Proof	4 8 91		RW
607	Check Headspace	4 8 91		RW
610	Dis-assemble Gun	4 8 91		RW
612	Magnaflux Barrel Action		APR 9 1991	KR
	Magnaflux Bolt		APR 9 1991	LC
615	Rollmark Caliber		APR 9 1991	LS
617	Drill and Tap Sight Holes		APR 19 1991	LB
618	Polish Barrel		APR 19 1991	WB
620	Apply Coatings (Barrel Action)		5-10-91	JA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		5/14/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/14/91	RW
	C) Inspect Ejector Hole for Chamfer		5/14/91	RW
	D) Oil Firing Pin Ass'y		5/14/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		6-10-91	RL

Op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			6-10-91	JK
	G) Safety Off Force	4	4	4			6-10-91	JK
	H) Trigger Pull Test & Retainability						6-10-91	JK
	I) Firing Pin Indent	.020	.0205	.0205			6-10-91	JK
	J) Assemble Stock						6/11/91	RW
	K) Assemble Swivel Studs						6-13-91	A
	L) Attach Front and Rear Sight Assemblies						6/11/91	RW
	M) Iron Sight Alignment						6/11/91	RW
	N) Detach Front & Rear Sights & place in numbered container						6/14/91	RW
	O) Attach Scope to Rifle						6/11/91	RW
	P) Detach & Attach Scope 20 Times						6/14/91	RW
640	Gallery Target & Test						6-11-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						6-11-91	AF
655	Final Inspection							
	A) Headspace						6-13-91	A
	B) Trigger Pull	2.15	2.20	2.15	2.16	2.18	6-13-91	JK
	C) Function						6-13-91	AE
660	Pack						6-19-91	AF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C6636081

DATE 6-10-91

TESTER RL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.32	2.25	2.15	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.29	2.13	2.30	2.20	
PULL #3	2.32	2.19	2.44	2.15	
PULL #4	2.27	2.23	2.20	2.16	
PULL #5	2.37	2.23	2.19	2.18	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.37	3.32		
PULL #2	3.26	3.35		
PULL #3	3.14	3.35		
PULL #4	3.17	3.36		
PULL #5	3.39	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	4.51	4.33		4.39
PULL #2	4.28	4.32		4.18
PULL #3	4.34	4.19		4.33
PULL #4	4.33	4.34		4.23
PULL #5	4.36	4.42		4.18
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636081
12 Jun 1991

CENTROIDAL DISTANCES

0 TO 1	.559032
1 TO 2	.634962
1 TO 3	.631367
1 TO 4	.63742
1 TO 5	.195576

$\frac{1}{3}$ $\frac{1}{3}$ <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0024
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1704
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .170417

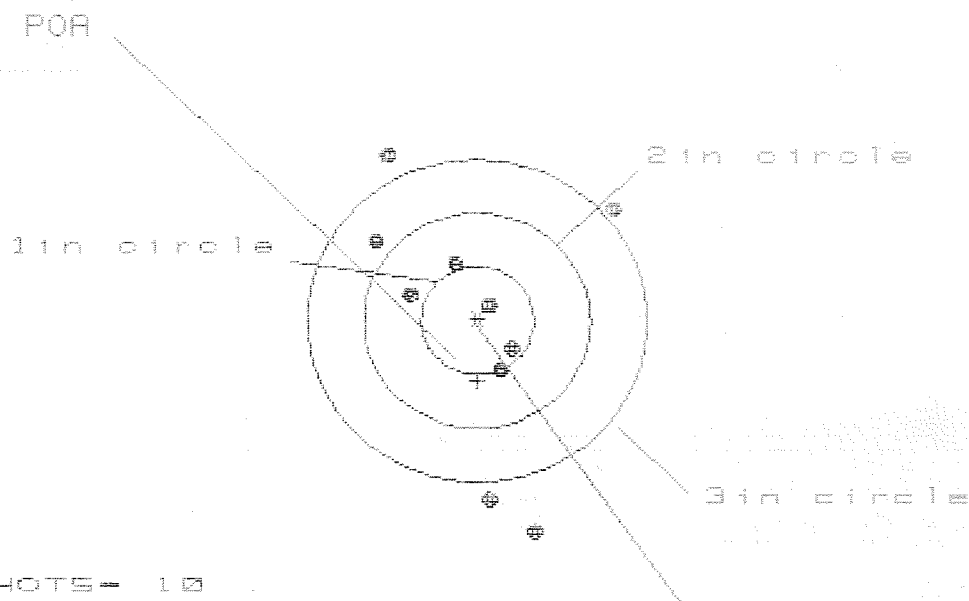
THE AMR FOR THIS RIFLE IS: 1.144

11 Jun 1991

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CENTERFIRE PATTERNS

1



OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 6

HS = 2.094

VS = 3.574

GS = 3.791

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.226	1.280	1.190
MINIMUM X	-0.868	-0.814	-0.904
MAXIMUM Y	1.587	1.366	1.018
MINIMUM Y	-1.987	-1.906	-1.735
CENTROID X	-0.006	-0.060	.030
CENTROID Y	.559	.780	.609
POA TO CENTROID in.	.559	.782	.610
MIN RADIUS	.238	.202	.176
MEAN RADIUS	1.064	.933	.847
MAX RADIUS	2.046	1.912	1.736
HORIZONTAL SPREAD	2.094	2.094	2.094
VERTICAL SPREAD	3.574	3.272	2.753
EXTREME SPREAD	3.791	3.386	2.977
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	6		

11 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66360B1

CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 5

HS= 3.289

VS= 4.323

GS= 4.375

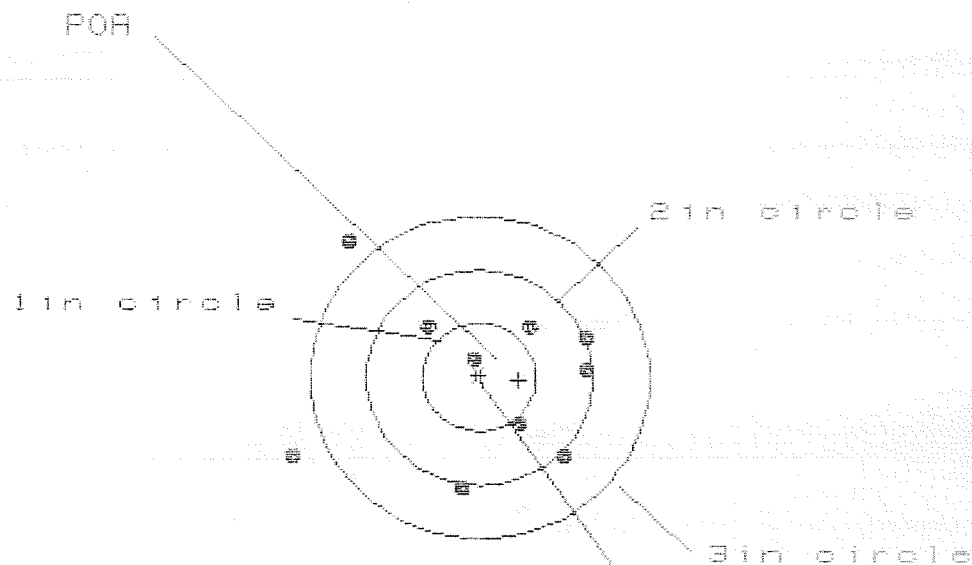
PATTERN #	2	3	4
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.842	1.936	1.971
MINIMUM X	-1.447	-1.353	-1.318
MAXIMUM Y	1.957	1.694	1.630
MINIMUM Y	-2.366	-1.999	-1.787
CENTROID X	.213	.119	.084
CENTROID Y	-.037	.226	.014
POA TO CENTROID in.	.216	.255	.086
MIN RADIUS	.166	.219	.028
MEAN RADIUS	1.431	1.314	1.204
MAX RADIUS	2.514	2.065	2.034
HORIZONTAL SPREAD	3.289	3.289	3.289
VERTICAL SPREAD	4.323	2.693	2.417
EXTREME SPREAD	4.375	3.346	3.346
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	5		

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FILE:/PATTERNING/CENTERFIRE_PATT/C8636081

CENTERFIRE PATTERNS

3



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 2.653

VS= 2.302

GS= 2.874

CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.982	.796	.627
MINIMUM X	:	-1.671	-1.357	-.815
MAXIMUM Y	:	1.292	1.211	.576
MINIMUM Y	:	-1.010	-1.091	-.940
CENTROID X	:	-.346	-.160	.009
CENTROID Y	:	.027	.108	-.043
POA TO CENTROID in.	:	.347	.193	.044
MIN RADIUS	:	.210	.283	.386
MEAN RADIUS	:	.983	.858	.716
MAX RADIUS	:	1.825	1.818	1.065
HORIZONTAL SPREAD	:	2.653	2.153	1.442
VERTICAL SPREAD	:	2.302	2.302	1.516
EXTREME SPREAD	:	2.874	2.811	1.784
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS= 1.189

VS= 2.978

GS= 3.184

PATTERN #

4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.644	.675	.721
MINIMUM X	-.545	-.473	-.427
MAXIMUM Y	1.169	.968	.773
MINIMUM Y	-1.809	-1.558	-1.532
CENTROID X	.142	.070	.024
CENTROID Y	-.061	.140	.335
POA TO CENTROID in.	.154	.157	.336
MIN RADIUS	.111	.167	.274
MEAN RADIUS	.993	.838	.712
MAX RADIUS	1.928	1.602	1.532
HORIZONTAL SPREAD	1.189	1.148	1.148
VERTICAL SPREAD	2.978	2.526	2.305
EXTREME SPREAD	3.184	2.645	2.352
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
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 = 0

2 in = 4

3 in = 7

HS= 3.055

VS= 3.480

GS= 3.501

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	-2.025	.903	.953
MINIMUM X	:	-1.030	-.805	-.755
MAXIMUM Y	:	1.856	1.823	1.405
MINIMUM Y	:	-1.624	-1.657	-1.430
CENTROID X	:	.009	-.216	-.266
CENTROID Y	:	.364	.397	.170
POA TO CENTROID in.	:	.364	.453	.316
MIN RADIUS	:	.541	.314	.360
MEAN RADIUS	:	1.247	1.095	.981
MAX RADIUS	:	2.048	1.866	1.698
HORIZONTAL SPREAD	:	3.055	1.708	1.708
VERTICAL SPREAD	:	3.480	3.480	2.835
EXTREME SPREAD	:	3.501	3.501	2.971
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	