

C6636136

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington




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

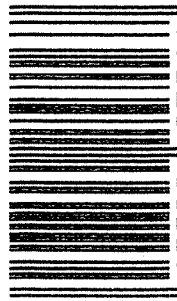
MODEL 700TM H24

SERIAL NO.
C6636136

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 C6636136

CONTRACT # DAAA21-87-C-0086

Stock
Repaired

GUN SERIAL #

C6636136

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		5/1/91	KS
600	Proof		5/1/91	KS
607	Check Headspace		5/1/91	KS
610	Dis-assemble Gun		5/1/91	KS
612	Magnaflux Barrel Action	5 8	9 1	KCR
	Magnaflux Bolt	5 8	9 1	KCR
615	Rollmark Caliber	5 8	9 1	GS
617	Drill and Tap Sight Holes	5 15	9 1	LB
618	Polish Barrel	5 15	9 1	LB
620	Apply Coatings (Barrel Action)		5-31-91	TS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		6-6-91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6-6-91	KS
	C) Inspect Ejector Hole for Chamfer		6-6-91	KS
	D) Oil Firing Pin Ass'y		6-6-91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		6-7-91	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			6-7-91	JH
	G) Safety Off Force	4	4	4			6-7-91	JH
	H) Trigger Pull Test & Retainability						6-7-91	JH
	I) Firing Pin Indent	.020	.0225	.022			6-7-91	JH
	J) Assemble Stock						6/10/91	KS
	K) Assemble Swivel Studs						6-12-91	K
	L) Attach Front and Rear Sight Assemblies						6/10/91	KS
	M) Iron Sight Alignment						6/10/91	KS
	N) Detach Front & Rear Sights & place in numbered container						6/10/91	KS
	O) Attach Scope to Rifle						6/10/91	KS
	P) Detach & Attach Scope 20 Times						6/10/91	KS
640	Gallery Target & Test						6-11-91	DH
	A) Time						6-11-91	DH
	B) Malfunctions						6-11-91	DH
	C) Pierced Primers						6-11-91	DH
	D) Optical Clarity of Scope						6-11-91	DH
645	Inspect for Live Ammo						6-11-91	DH
655	Final Inspection							
	A) Headspace						6-12-91	K
	B) Trigger Pull	2.37	2.18	2.17	2.22	2.17	6-12-91	JH
	C) Function						6-12-91	K
660	Pack						6-20-91	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-6636136

DATE 6-7-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.47	2.57	2.59	2.37	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.53	2.45	2.46	2.18	
PULL #3	2.52	2.47	2.49	2.17	
PULL #4	2.48	2.58	2.52	2.22	
PULL #5	2.47	2.60	2.50	2.17	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.70	3.77		
PULL #2	3.50	3.46		
PULL #3	3.60	3.75		
PULL #4	3.35	3.33		
PULL #5	3.70	3.45		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.30	4.20		4.48
PULL #2	4.41	4.45		4.48
PULL #3	4.34	4.47		4.33
PULL #4	4.44	4.40		4.21
PULL #5	4.46	4.44		4.15
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636136
11 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.344606
1 TO	2	.492919
1 TO	3	.526305
1 TO	4	.410079
1 TO	5	.130465

$\frac{2}{5}$ <----POA

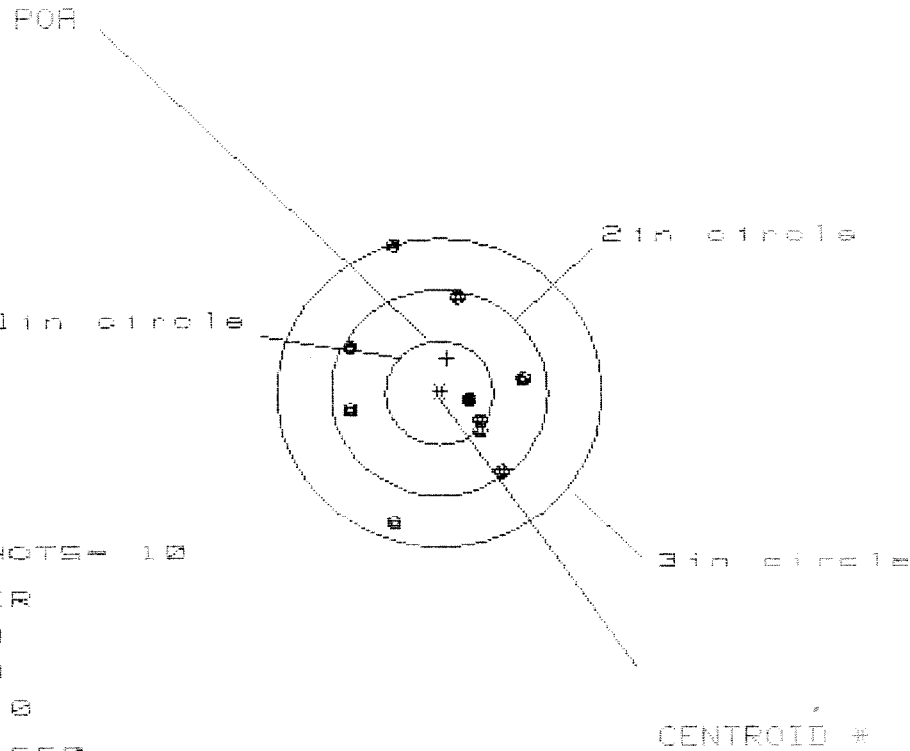
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0924
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1066
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .141072

THE AMR FOR THIS RIFLE IS: .8706

11 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636136

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 3

2in = 8

3in = 10

HS = 1.650

VS = 2.655

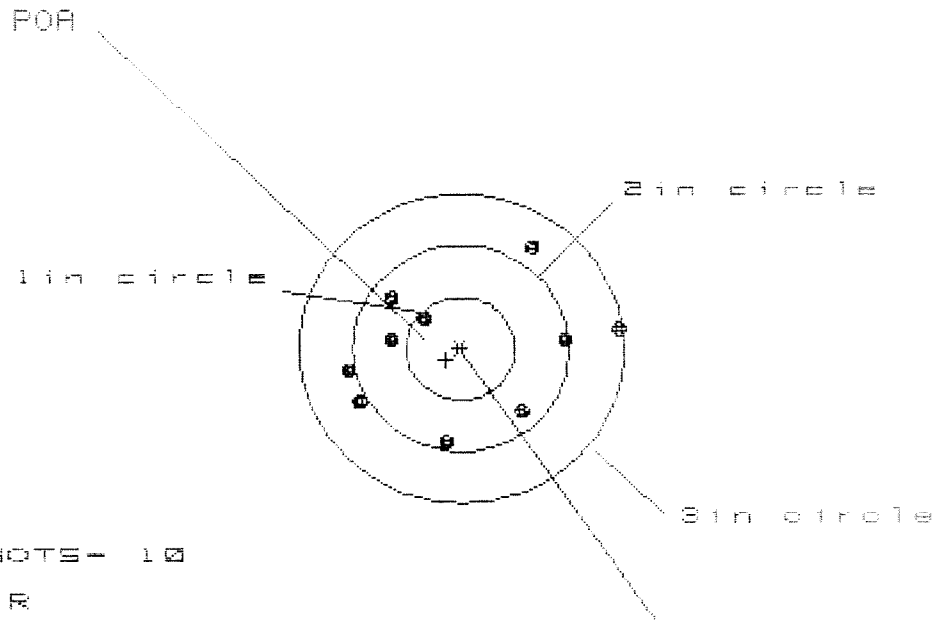
GS = 2.655

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.790	.738	.679
MINIMUM X	-.870	-.922	-.981
MAXIMUM Y	1.388	1.075	.936
MINIMUM Y	-1.267	-1.113	-.748
CENTROID X	-.072	-.020	.039
CENTROID Y	-.337	-.491	-.352
POA TO CENTROID in.	.344	.491	.354
MIN RADIUS	.251	.200	.143
MEAN RADIUS	.851	.751	.680
MAX RADIUS	1.465	1.209	1.028
HORIZONTAL SPREAD	1.660	1.660	1.660
VERTICAL SPREAD	2.655	2.188	1.684
EXTREME SPREAD	2.655	2.279	1.826
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

11 Jun 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 6

3 in = 10

HS= 2.504

VS= 1.859

GS= 2.537

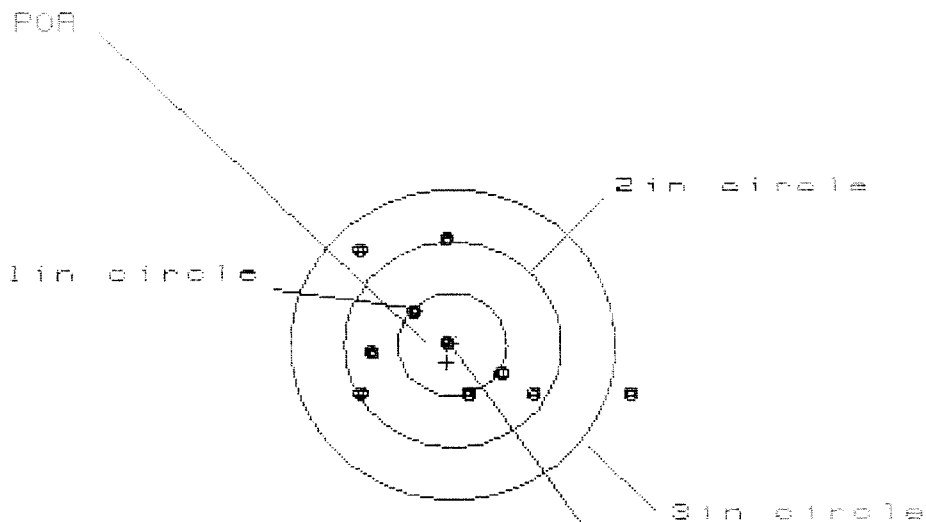
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.425	1.136	1.245
MINIMUM X	:	-1.079	-.921	-.813
MAXIMUM Y	:	.966	.991	.680
MINIMUM Y	:	-.894	-.868	-.744
CENTROID X	:	.140	-.018	-.126
CENTROID Y	:	.108	.023	-.041
POA TO CENTROID in.	:	.177	.085	.133
MIN RADIUS	:	.404	.323	.411
MEAN RADIUS	:	.939	.851	.773
MAX RADIUS	:	1.444	1.316	1.274
HORIZONTAL SPREAD	:	2.504	2.057	2.057
VERTICAL SPREAD	:	1.859	1.859	1.424
EXTREME SPREAD	:	2.537	2.227	2.078
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 3

2in = 7

3in = 9

HS = 2.524

VS = 1.571

GS = 2.921

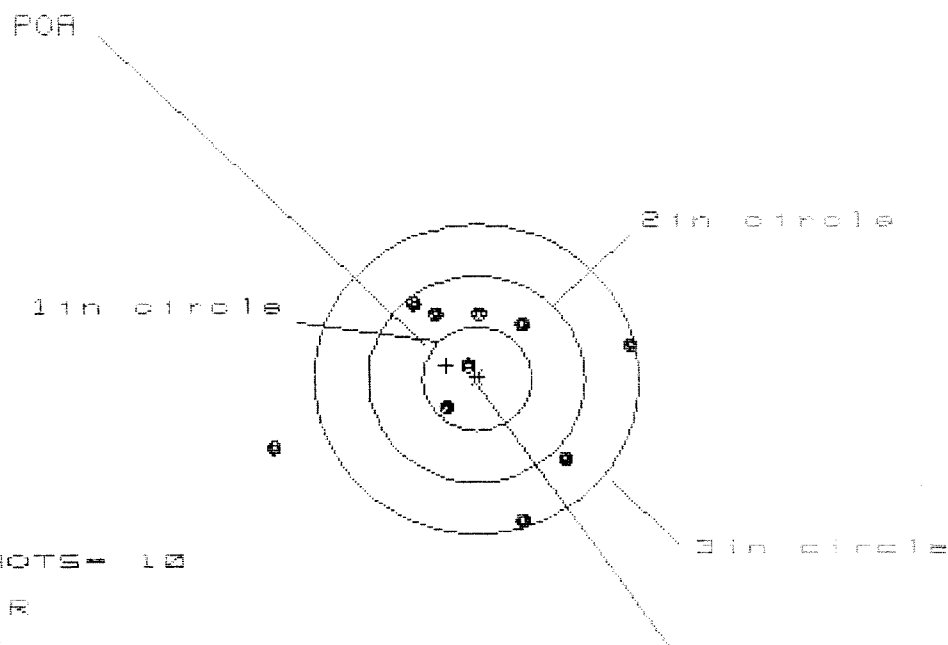
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.637	.879	.791
MINIMUM X	:	-.887	-.705	-.728
MAXIMUM Y	:	1.050	.994	1.108
MINIMUM Y	:	-.521	-.577	-.463
CENTROID X	:	.054	-.128	-.040
CENTROID Y	:	.174	.230	.116
POA TO CENTROID in.	:	.182	.263	.123
MIN RADIUS	:	.045	.147	.098
MEAN RADIUS	:	.814	.707	.635
MAX RADIUS	:	1.713	1.150	1.108
HORIZONTAL SPREAD	:	2.524	1.584	1.519
VERTICAL SPREAD	:	1.571	1.571	1.571
EXTREME SPREAD	:	2.921	2.129	1.736
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 2

2in = 6

3in = 9

HS = 3.254

VS = 2.085

GS = 3.423

CENTROID #

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.413	1.209	.791
MINIMUM X	-1.841	-.795	-.644
MAXIMUM Y	.759	.682	.719
MINIMUM Y	-1.326	-1.403	-1.366
CENTROID X	.282	.486	.335
CENTROID Y	-.130	-.053	-.090
POA TO CENTROID in.	.310	.489	.347
MIN RADIUS	.193	.302	.191
MEAN RADIUS	.955	.839	.761
MAX RADIUS	1.966	1.424	1.422
HORIZONTAL SPREAD	3.254	2.004	1.435
VERTICAL SPREAD	2.085	2.085	2.085
EXTREME SPREAD	3.423	2.330	2.330
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS # 5

POB

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

HS = 1.777

VS = 2.215

GS = 2.546

CENTROID *

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.811	.704	.739
MINIMUM X	-.966	-.860	-.825
MAXIMUM Y	1.071	1.184	1.055
MINIMUM Y	-1.143	-1.031	-.725
CENTROID X	.058	.165	.130
CENTROID Y	-.348	-.460	-.331
POB TO CENTROID in.	.352	.489	.356
MIN RADIUS	.144	.170	.072
MEAN RADIUS	.794	.719	.665
MAX RADIUS	1.399	1.250	1.117
HORIZONTAL SPREAD	1.777	1.564	1.564
VERTICAL SPREAD	2.215	2.215	1.780
EXTREME SPREAD	2.546	2.318	1.925
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		