

C6636168

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.

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

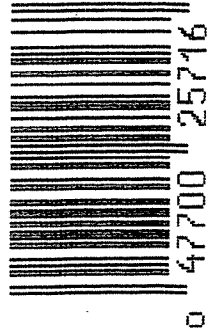
MODEL 700™ H24

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

SERIAL NO.
C6636168

ORDER NO.
5716

UPC



5716 C6636168

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636168

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		5/3/91	K.S.
600	Proof		5/3/91	K.S.
607	Check Headspace		5/3/91	K.S.
610	Dis-assemble Gun		5/3/91	K.S.
612	Magnaflux Barrel Action	5 6 0 1		KCR
	Magnaflux Bolt	5 6 9 1		KCR
615	Rollmark Caliber	5 6 9 1		C.B.
617	Drill and Tap Sight Holes	5 15 9 1		K.B.
618	Polish Barrel	5 15 9 1		W.B.
620	Apply Coatings (Barrel Action)		5-29-91	JA
	Apply Coating (Bolt)		5	
625	Final Assembly			
	A) Clean inside of Bolt Assembly		4/4/91	K.S.
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/4/91	K.S.
	C) Inspect Ejector Hole for Chamfer		4/4/91	K.S.
	D) Oil Firing Pin Ass'y		4/4/91	K.S.
	E) Adjust Trigger Pull to Min Setting and Stake		4/5/91	Off

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			6-5-91	JH
	G) Safety Off Force	4	4	4			6-5-91	JH
	H) Trigger Pull Test & Retainability						6-5-91	JH
	I) Firing Pin Indent	.0215	.0225	.0225			6-5-91	JH
	J) Assemble Stock						6/5/91	KS
	K) Assemble Swivel Studs						6-14-91	JH
	L) Attach Front and Rear Sight Assemblies						6/5/91	KS
	M) Iron Sight Alignment						6/5/91	KS
	N) Detach Front & Rear Sights & place in numbered container						6/5/91	KS
	O) Attach Scope to Rifle						6/6/91	KS
	P) Detach & Attach Scope 20 Times						6/6/91	KS
640	Gallery Target & Test						6/6/91	KT
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	KT
645	Inspect for Live Ammo						6/6/91	KT
655	Final Inspection							
	A) Headspace						6-14-91	JH
	B) Trigger Pull	2.68	2.70	2.74	2.69	2.70	6-13-91	JH
	C) Function						6-14-91	JH
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. C6636168
DATE 6-5-91
TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.45	2.40	2.68	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.33	2.46	2.51	2.70	
PULL #3	2.22	2.47	2.53	2.74	
PULL #4	2.41	2.22	2.28	2.69	
PULL #5	2.21	2.50	2.38	2.70	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.54	3.45		
PULL #2	3.31	3.38		
PULL #3	3.46	3.50		
PULL #4	3.34	3.53		
PULL #5	3.35	3.27		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.55	4.58		4.39
PULL #2	4.34	4.51		4.48
PULL #3	4.31	4.49		4.27
PULL #4	4.44	4.43		4.34
PULL #5	4.46	4.39		4.33
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636168
6 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.356183
1 TO	2	.653946
1 TO	3	.685555
1 TO	4	.440409
1 TO	5	.349006

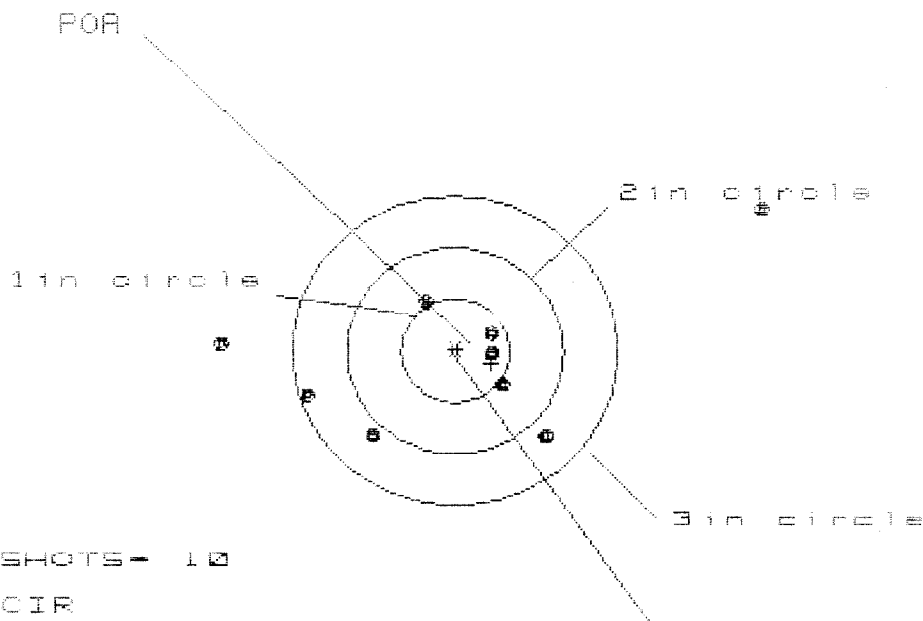
19
3 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0406
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.118
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .124789
THE AMR FOR THIS RIFLE IS: 1.073

6 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C88351B8

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 8

HS= 4.945

VS= 2.197

GS= 5.110

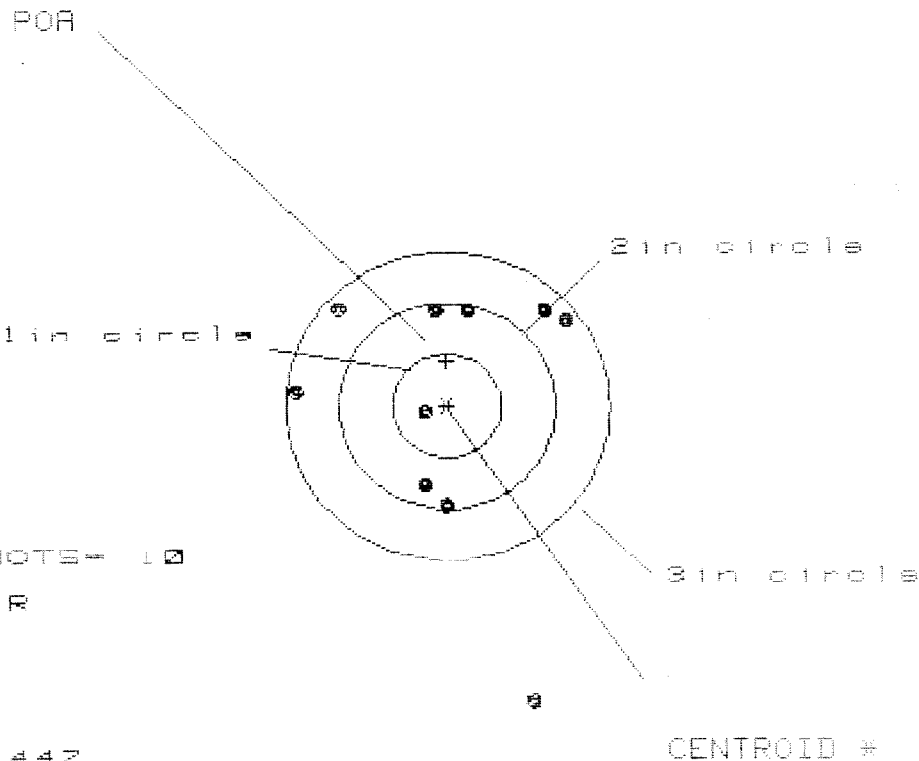
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.808	1.171	.943
MINIMUM X	-2.137	-1.825	-1.240
MAXIMUM Y	1.351	.621	.647
MINIMUM Y	-.846	-.696	-.670
CENTROID X	-.335	-.647	-.419
CENTROID Y	.121	-.029	-.055
POA TO CENTROID in.	.356	.648	.422
MIN RADIUS	.343	.587	.488
MEAN RADIUS	1.132	.940	.780
MAX RADIUS	3.116	1.837	1.271
HORIZONTAL SPREAD	4.945	2.996	2.183
VERTICAL SPREAD	2.197	1.317	1.317
EXTREME SPREAD	5.110	3.130	2.218
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

8 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08636168

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS= 2.447

VS= 3.843

CS= 4.265

CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.873	1.163	1.044
MINIMUM X	:	-1.374	-1.284	-1.483
MAXIMUM Y	:	.986	.668	.725
MINIMUM Y	:	-2.857	-1.320	-1.236
CENTROID X	:	.006	-.084	.035
CENTROID Y	:	-.437	-.119	-.283
POA TO CENTROID in.	:	.437	.146	.286
MIN RADIUS	:	.193	.409	.376
MEAN RADIUS	:	1.232	1.001	.975
MAX RADIUS	:	2.969	1.321	1.485
HORIZONTAL SPREAD	:	2.447	2.447	2.447
VERTICAL SPREAD	:	3.843	1.988	1.961
EXTREME SPREAD	:	4.265	2.528	2.528
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

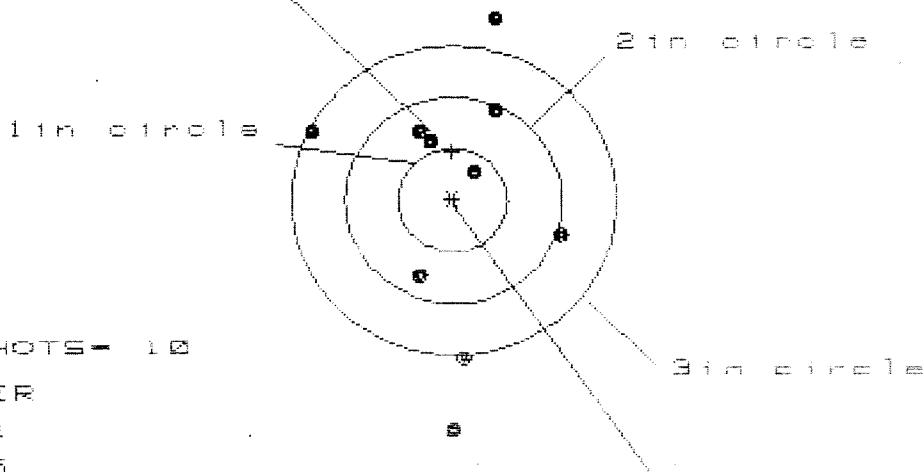
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CENTERFIRE PATTERNS

3

POA



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 2.250

VS= 4.041

GS= 4.057

CENTROID *

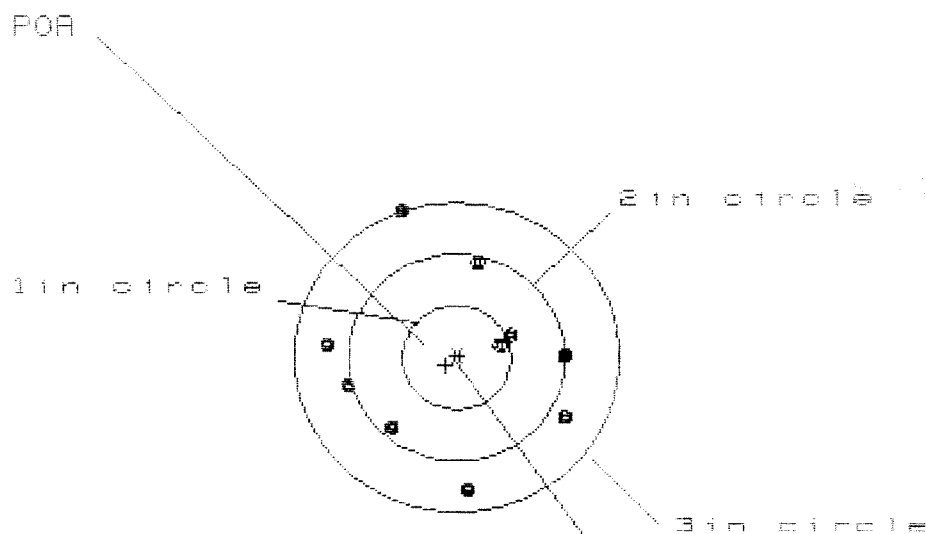
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.970	.972	1.021
MINIMUM X	:	-1.280	-1.278	-1.229
MAXIMUM Y	:	1.765	1.512	.798
MINIMUM Y	:	-2.276	-1.732	-1.543
CENTROID X	:	.009	.007	-.042
CENTROID Y	:	-.472	-.219	-.408
POA TO CENTROID in.	:	.472	.219	.410
MIN RADIUS	:	.366	.224	.354
MEAN RADIUS	:	1.154	.966	.920
MAX RADIUS	:	2.276	1.738	1.555
HORIZONTAL SPREAD	:	2.250	2.250	2.250
VERTICAL SPREAD	:	4.041	3.244	2.341
EXTREME SPREAD	:	4.057	3.253	2.541
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



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 10

HS= 2.216

VS= 2.664

GS= 2.733

CENTROID #

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.023	.971	.981
MINIMUM X	-1.193	-1.245	-1.235
MAXIMUM Y	1.396	1.047	.908
MINIMUM Y	-1.268	-1.113	-.653
CENTROID X	.103	.155	.145
CENTROID Y	.075	-.080	.059
POA TO CENTROID in.	.128	.175	.156
MIN RADIUS	.428	.457	.394
MEAN RADIUS	.991	.928	.809
MAX RADIUS	1.473	1.280	1.245
HORIZONTAL SPREAD	2.216	2.216	2.216
VERTICAL SPREAD	2.664	2.160	1.561
EXTREME SPREAD	2.733	2.248	2.248
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	10		

8 Jun 1991

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CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 10

HS = 1.843

VS = 2.546

GS = 2.626

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.888	.889	.820
MINIMUM X	:	-1.063	-1.054	-1.123
MAXIMUM Y	:	1.433	.773	.654
MINIMUM Y	:	-1.113	-.954	-.544
CENTROID X	:	.014	.005	.075
CENTROID Y	:	.123	-.036	.083
POA TO CENTROID in.	:	.124	.037	.111
MIN RADIUS	:	.403	.257	.332
MEAN RADIUS	:	.857	.758	.722
MAX RADIUS	:	1.435	1.281	1.278
HORIZONTAL SPREAD	:	1.943	1.943	1.943
VERTICAL SPREAD	:	2.546	1.727	1.198
EXTREME SPREAD	:	2.626	2.077	2.077
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	