

C6636170

MODEL 700TM M24

Model **SWS** TM

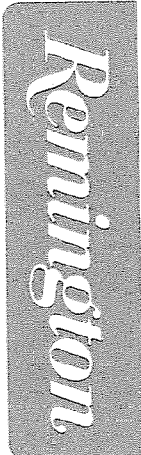
Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



Remington®

MODEL 700™ H24

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

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

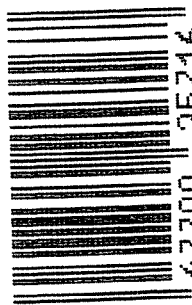
SERIAL NO.
C6636170

ORDER NO.
5716

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

5716 C6636170

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

Stock
Repaired

GUN SERIAL # C6636170

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		5/3/91	KJ
600	Proof		5/3/91	KJ
607	Check Headspace		5/3/91	KJ
610	Dis-assemble Gun		5/3/91	KJ
612	Magnaflux Barrel Action	5 6 0 1		KCR
	Magnaflux Bolt	5 6 9 1		KCR
615	Rollmark Caliber	1 5 6 9		G.S.
617	Drill and Tap Sight Holes	5 15 9 1		FB
618	Polish Barrel	5 15 9 1		WB
620	Apply Coatings (Barrel Action)		5-29-91	JS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		6/4/91	KJ
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/4/91	KJ
	C) Inspect Ejector Hole for Chamfer		6/4/91	KJ
	D) Oil Firing Pin Ass'y		4/4/91	KJ
	E) Adjust Trigger Pull to Min Setting and Stake		6-11-91	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			6-11-91	QU
	G) Safety Off Force	4	4	4			6-11-91	QU
	H) Trigger Pull Test & Retainability						6-11-91	QU
	I) Firing Pin Indent	.0225	.0215	.0215			6-11-91	QU
	J) Assemble Stock						6/11/91	KS
	K) Assemble Swivel Studs						6-13-91	A
	L) Attach Front and Rear Sight Assemblies						6/11/91	KS
	M) Iron Sight Alignment						6/11/91	KS
	N) Detach Front & Rear Sights & place in numbered container						6/11/91	KS
	O) Attach Scope to Rifle						6/11/91	KS
	P) Detach & Attach Scope 20 Times						6/11/91	KS
640	Gallery Target & Test						6/12/91	KS
	A) Time							KS
	B) Malfunctions							KS
	C) Pierced Primers							KS
	D) Optical Clarity of Scope							KS
645	Inspect for Live Ammo						6/12/91	KS
655	Final Inspection							
	A) Headspace						6-13-91	AC
	B) Trigger Pull	2.70	2.75	2.55	2.55	2.58	6-13-91	QU
	C) Function						6-13-91	K
660	Pack						6-20-91	NF

SWS TRIGGER PULL TEST

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

SERIAL NO. 06636170
DATE 6-11-91
TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.60	2.53	2.60	2.70	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.54	2.55	2.58	2.75	
PULL #3	2.52	2.55	2.56	2.55	
PULL #4	2.51	2.56	2.48	2.55	
PULL #5	2.52	2.58	2.55	2.58	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.23	3.44		
PULL #2	3.50	3.54		
PULL #3	3.55	3.53		
PULL #4	3.54	3.49		
PULL #5	3.48	3.50		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.21	4.29		4.35
PULL #2	4.30	4.32		4.23
PULL #3	4.36	4.34		4.39
PULL #4	4.44	4.33		4.38
PULL #5	4.30	4.33		4.39
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636170
12 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.109786
1 TO	2	.240753
1 TO	3	.0870919
1 TO	4	.145602
1 TO	5	.0687095

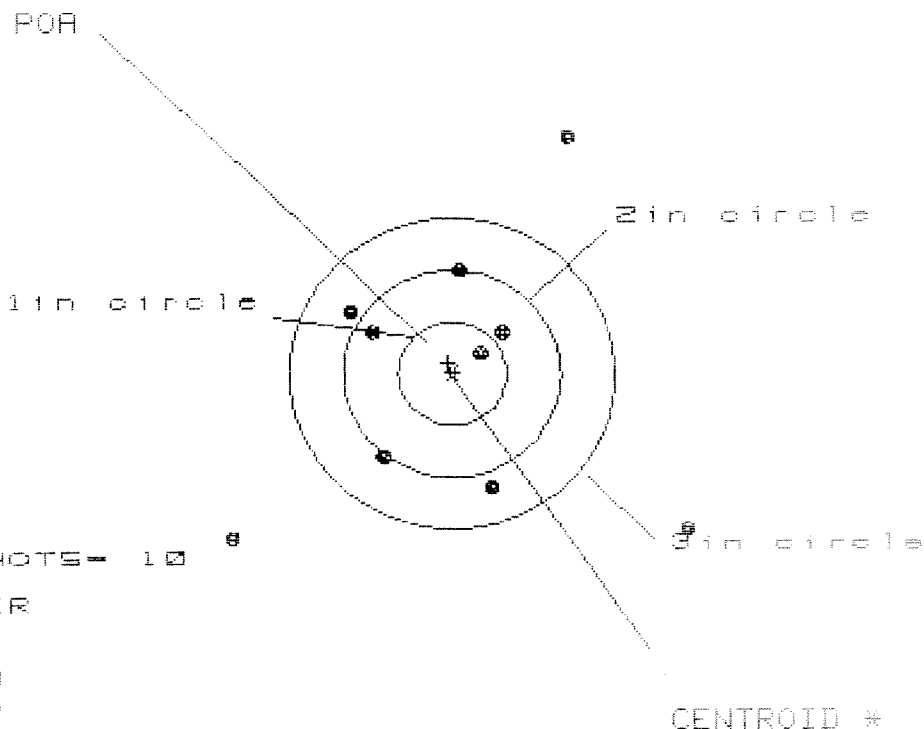
4 <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0266
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0312
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0854459
THE AMR FOR THIS RIFLE IS: 1.184

12 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6635170

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 7

HS= 4.190

VS= 3.912

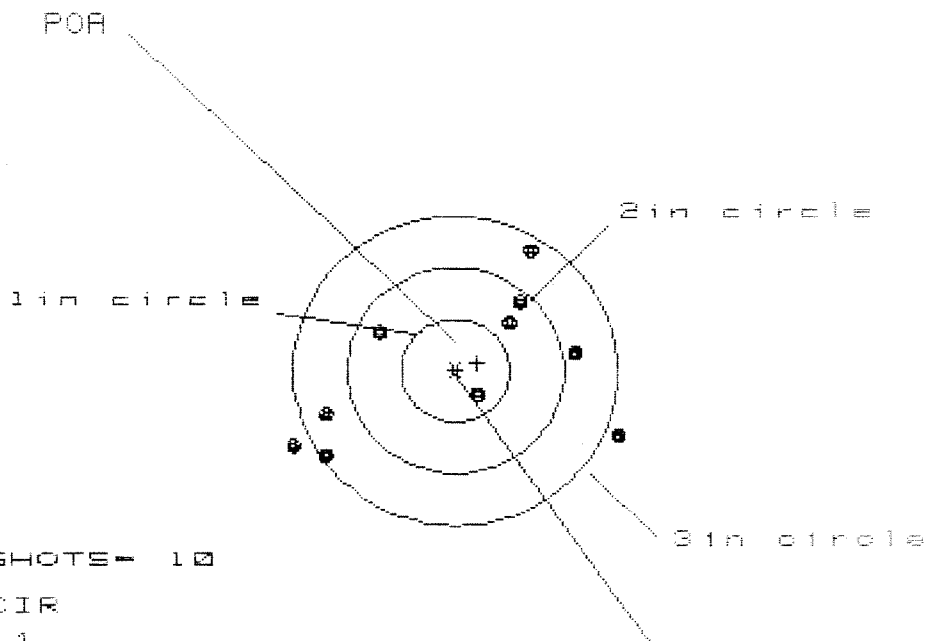
GS= 5.035

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.120	1.890	1.105
MINIMUM X	-2.070	-1.143	-0.907
MAXIMUM Y	2.301	2.122	1.909
MINIMUM Y	-1.611	-1.703	-1.462
CENTROID X	.038	.268	.032
CENTROID Y	-.103	.076	.289
POA TO CENTROID in.	.110	.279	.290
MIN RADIUS	.359	.070	.319
MEAN RADIUS	1.391	1.211	1.025
MAX RADIUS	2.623	2.544	2.206
HORIZONTAL SPREAD	4.190	3.033	2.012
VERTICAL SPREAD	3.912	3.825	3.372
EXTREME SPREAD	5.035	3.959	3.551
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	7		

12 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C0636170

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS= 3.010

VS= 1.966

CS= 3.011

CENTROID #

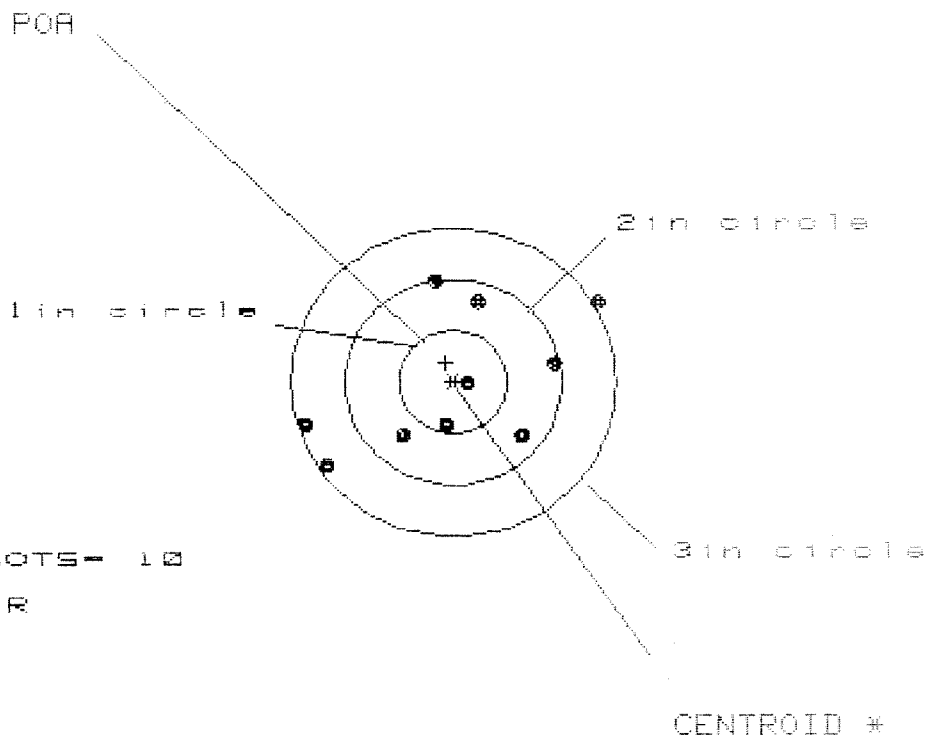
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.547	1.226	1.065
MINIMUM X	:	-1.463	-1.291	-1.214
MAXIMUM Y	:	1.184	1.109	1.086
MINIMUM Y	:	-.782	-.857	-.960
CENTROID X	:	-.201	-.373	-.211
CENTROID Y	:	-.074	.001	.104
POA TO CENTROID in.	:	.214	.373	.236
MIN RADIUS	:	.308	.484	.463
MEAN RADIUS	:	1.121	1.060	.970
MAX RADIUS	:	1.687	1.531	1.547
HORIZONTAL SPREAD	:	3.010	2.517	2.278
VERTICAL SPREAD	:	1.966	1.966	1.966
EXTREME SPREAD	:	3.011	2.924	2.773
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

12 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636170

CENTERFIRE PATTERNS

3



OF SHOTS- 10

IN CIR

1in - 2

2in - 6

3in - 9

HS= 2.740

VS= 1.818

GS= 2.993

CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.348	1.063	.908
MINIMUM X	:	-1.393	-1.243	-1.175
MAXIMUM Y	:	.993	1.075	1.028
MINIMUM Y	:	-.825	-.743	-.798
CENTROID X	:	.070	-.080	.075
CENTROID Y	:	-.184	-.266	-.219
POA TO CENTROID in.	:	.197	.278	.231
MIN RADIUS	:	.183	.304	.169
MEAN RADIUS	:	.928	.861	.779
MAX RADIUS	:	1.538	1.299	1.416
HORIZONTAL SPREAD	:	2.740	2.306	2.083
VERTICAL SPREAD	:	1.818	1.818	1.818
EXTREME SPREAD	:	2.993	2.392	2.310
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

12 Jun 1991

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CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 5

HS= 2.725

VS= 3.888

GS= 4.036

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X 1.047

.966

1.016

MINIMUM X -1.678

-1.759

-1.639

MAXIMUM Y 1.636

1.385

1.142

MINIMUM Y -2.252

-1.950

-.931

CENTROID X -.014

.067

-.053

CENTROID Y .033

.294

.527

POA TO CENTROID in. .036

.292

.530

MIN RADIUS .196

.427

.458

MEAN RADIUS 1.295

1.164

1.010

MAX RADIUS 2.368

2.176

1.645

HORIZONTAL SPREAD 2.725

2.725

2.655

VERTICAL SPREAD 3.888

3.335

2.073

EXTREME SPREAD 4.036

3.409

2.755

NUMBER IN ONE INCH CIRCLE = 1

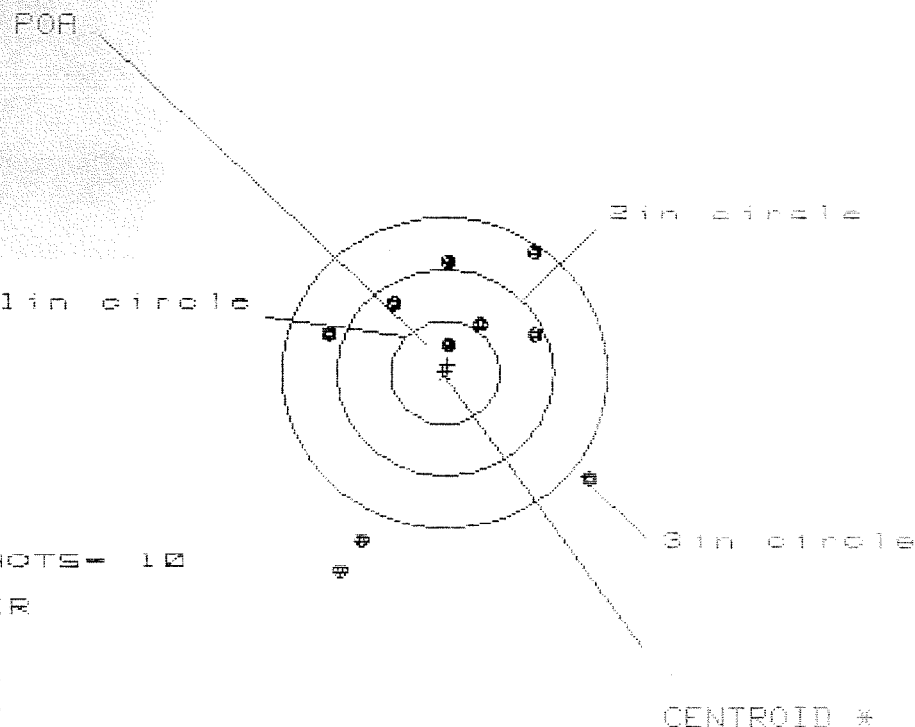
NUMBER IN TWO INCH CIRCLE = 3

NUMBER IN THREE INCH CIRCLE = 5

12 Jun 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 7

HS= 2.378

VS= 3.075

GS= 3.595

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.284	1.174	1.064
MINIMUM X	:	-1.094	-1.204	-1.314
MAXIMUM Y	:	1.191	.982	.752
MINIMUM Y	:	-1.884	-1.838	-1.424
CENTROID X	:	-.026	.084	.194
CENTROID Y	:	-.078	.131	.361
POA TO CENTROID in.	:	.082	.156	.410
MIN RADIUS	:	.306	.114	.099
MEAN RADIUS	:	1.186	.996	.802
MAX RADIUS	:	2.128	2.040	1.778
HORIZONTAL SPREAD	:	2.378	2.378	2.378
VERTICAL SPREAD	:	3.075	2.820	2.176
EXTREME SPREAD	:	3.595	3.266	2.763
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	