

C6498764

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

\*Includes 1 in chamber.

*Remington*

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6498764

| OP. #     | OP. NAME                                                 | READINGS | DATE    | INIT |
|-----------|----------------------------------------------------------|----------|---------|------|
| 575 & 580 | Assemble Action and Stock                                | 5 9      | 90      | RW   |
| 600       | Proof                                                    | 5 9      | 90      | RW   |
| 607       | Check Headspace                                          | 9        | 90      | RW   |
| 610       | Dis-assemble Gun                                         | 2        | 90      | RW   |
| 612       | Magnaflux Barrel Action                                  | 5-15-90  |         | KER  |
|           | Magnaflux Bolt                                           | 5-15-90  |         | KER  |
| 615       | Rollmark Caliber                                         | 5-15-90  |         | GS   |
| 617       | Drill and Tap Sight Holes                                |          | 5/17/90 | LB   |
| 618       | Polish Barrel RB                                         |          | 5/17/90 | WB   |
| 620       | Apply Coatings (Barrel Action)                           |          | 5-85-90 | TA   |
|           | Apply Coating (Bolt)                                     |          |         | TA   |
| 625       | Final Assembly                                           |          |         |      |
|           | A) Clean inside of Bolt Assembly                         |          | 6/12/90 | RW   |
|           | B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head |          | 6/12/90 | RW   |
|           | C) Inspect Ejector Hole for Chamfer                      |          | 6/12/90 | RW   |
|           | D) Oil Firing Pin Ass'y                                  |          | 6/12/90 | RW   |
|           | E) Adjust Trigger Pull to Min Setting and Stake          |          | 8/23/90 | JU   |

| op. #        | OP. NAME                                                    | READINGS |       |       |      |      | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|-------|-------|------|------|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 5        | 5     | 5     |      |      | 7/24/90 | RL   |
|              | G) Safety Off Force                                         | 3        | 3     | 3     |      |      | 7/24/90 | RL   |
|              | H) Trigger Pull Test & Retainability                        |          |       |       |      |      | 8/23/90 | RL   |
|              | I) Firing Pin Indent                                        | .023     | .0235 | .0235 |      |      | 7/24/90 | RL   |
|              | J) Assemble Stock                                           |          |       |       |      |      | 8/1/90  | RW   |
|              | K) Assemble Swivel Studs                                    |          |       |       |      |      | 8/29/90 | RL   |
|              | L) Attach Front and Rear Sight Assemblies                   |          |       |       |      |      | 8/1/90  | RW   |
|              | M) Iron Sight Alignment                                     |          |       |       |      |      | 8/1/90  | RW   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |       |       |      |      | 8/1/90  | RW   |
|              | O) Attach Scope to Rifle                                    |          |       |       |      |      | 8/1/90  | RW   |
|              | P) Detach & Attach Scope 20 Times                           |          |       |       |      |      | 8/1/90  | RW   |
| 640          | Gallery Target & Test                                       |          |       |       |      |      | 8-6-90  | KJ   |
|              | A) Time                                                     |          |       |       |      |      |         | KJ   |
|              | B) Malfunctions                                             |          |       |       |      |      |         | KJ   |
|              | C) Pierced Primers                                          |          |       |       |      |      |         | KJ   |
|              | D) Optical Clarity of Scope                                 |          |       |       |      |      |         | KJ   |
| 645          | Inspect for Live Ammo                                       |          |       |       |      |      | 8-6-90  | KJ   |
| 655          | Final Inspection                                            |          |       |       |      |      | 8/29/90 | RL   |
|              | A) Headspace                                                |          |       |       |      |      | 8/23/90 | RL   |
|              | B) Trigger Pull                                             | 2.31     | 2.35  | 2.19  | 2.22 | 2.27 | 8/23/90 | RL   |
|              | C) Function                                                 |          |       |       |      |      | 9/10/90 | RL   |
| 660          | Pack                                                        |          |       |       |      |      | 9/20/90 | RL   |

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

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

SERIAL NO. C6498764

DATE 8/23/90

TESTER JH

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |       | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|-------|------------------------------------------------------------------------|
| PULL #1 | 2.47             | 2.19                     | 2.29                           | 2.31  | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.50             | 2.19                     | 2.12                           | 2.35  |                                                                        |
| PULL #3 | 2.34             | 2.29                     | 2.09                           | 2.19  |                                                                        |
| PULL #4 | 2.26             | 2.32                     | 2.04                           | 2.22  |                                                                        |
| PULL #5 | 2.23             | 2.21                     | 2.10                           | 2.27  |                                                                        |
| TOTAL   | 11.80            | 11.20                    | 10.69                          | 11.34 |                                                                        |
| AVG.    | 2.36             | 2.24                     | 2.138                          | 2.268 |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.15             | 3.24                     |  |          |
| PULL #2 | 3.39             | 3.38                     |  |          |
| PULL #3 | 3.48             | 3.32                     |  |          |
| PULL #4 | 3.43             | 3.30                     |  |          |
| PULL #5 | 3.32             | 3.23                     |  |          |
| TOTAL   | 16.77            | 16.52                    |  |          |
| AVG.    | 3.354            | 3.304                    |  |          |

|         | 4.00#<br>INITIAL | 4.00# AFTER<br>20 CYCLES | MAX SETTING<br>GREATER THAN 4# | RESET TO 4# FOR<br>TARGET & ACCURACY |
|---------|------------------|--------------------------|--------------------------------|--------------------------------------|
| PULL #1 | 4.22             | 4.21                     |                                | 4.18                                 |
| PULL #2 | 4.19             | 4.20                     |                                | 4.23                                 |
| PULL #3 | 4.21             | 4.24                     |                                | 4.26                                 |
| PULL #4 | 4.24             | 4.21                     |                                | 4.20                                 |
| PULL #5 | 4.21             | 4.22                     |                                | 4.22                                 |
| TOTAL   | 21.07            | 21.08                    |                                | 21.09                                |
| AVG.    | 4.214            | 4.216                    |                                | 4.218                                |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6498764  
7 Aug 1990

CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| 0 TO | 1 | .168716 |
| 1 TO | 2 | .705839 |
| 1 TO | 3 | .94066  |
| 1 TO | 4 | .46964  |
| 1 TO | 5 | .166373 |

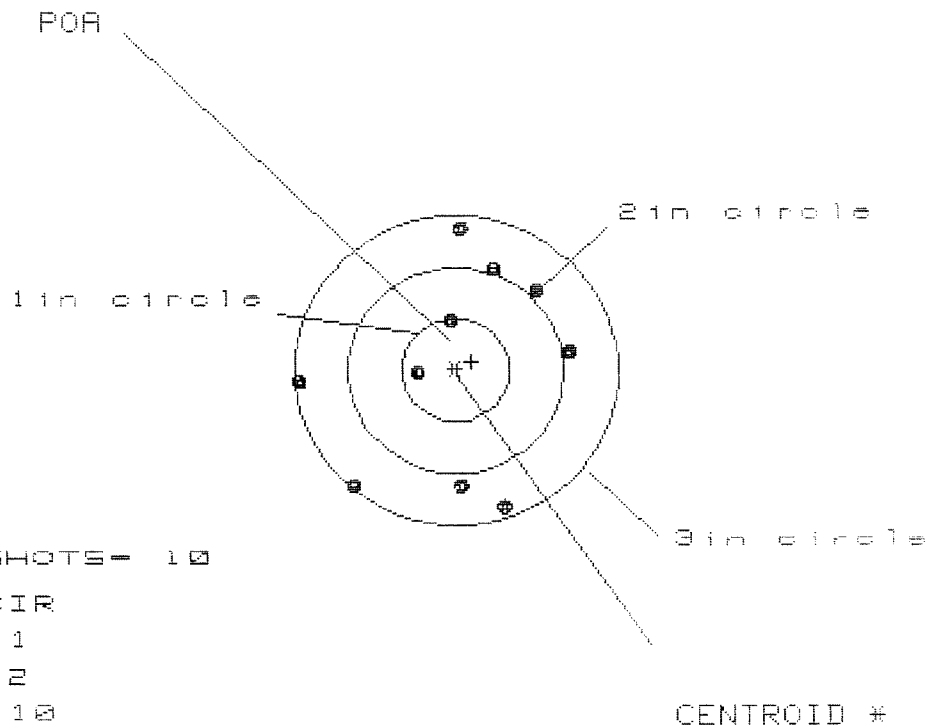
$\bar{B}_{42}^3$  <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2212  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0126  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .221559  
THE AMR FOR THIS RIFLE IS: .982

6 Aug 1988

FILE:/PATTERNING/CENTERFIRE\_PATT/C643B764

# CENTERFIRE PATTERNS # 1



# OF SHOTS- 10

# IN CIR

1in = 1

2in = 2

3in = 10

HS= 2.519

VS= 2.769

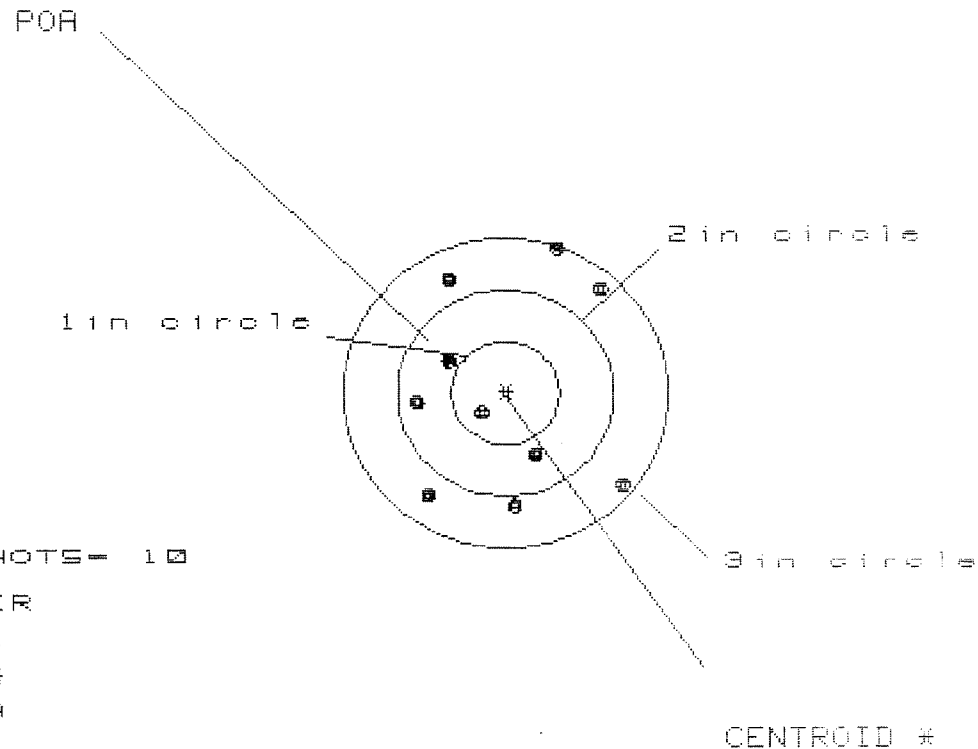
GS= 2.796

| PATTERN #                     | : | 1      | 9      | 8      |
|-------------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)               | : | 10     | 9      | 8      |
| MAXIMUM X                     | : | 1.078  | .972   | .779   |
| MINIMUM X                     | : | -1.441 | -1.547 | -.637  |
| MAXIMUM Y                     | : | 1.403  | 1.277  | 1.252  |
| MINIMUM Y                     | : | -1.366 | -1.492 | -1.517 |
| CENTROID X                    | : | -.148  | -.042  | .151   |
| CENTROID Y                    | : | -.081  | .045   | .070   |
| FOR TO CENTROID in.           | : | .168   | .062   | .166   |
| MIN RADIUS                    | : | .341   | .427   | .519   |
| MEAN RADIUS                   | : | 1.095  | 1.033  | .955   |
| MAX RADIUS                    | : | 1.474  | 1.560  | 1.525  |
| HORIZONTAL SPREAD             | : | 2.519  | 2.519  | 1.416  |
| VERTICAL SPREAD               | : | 2.769  | 2.769  | 2.769  |
| EXTREME SPREAD                | : | 2.796  | 2.796  | 2.796  |
| NUMBER IN ONE INCH CIRCLE =   | : | 1      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | : | 2      |        |        |
| NUMBER IN THREE INCH CIRCLE = | : | 10     |        |        |

6 Aug 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/C6498764

# CENTERFIRE PATTERNS # 2



# OF SHOTS = 10

# IN CIR

1 in = 1

2 in = 4

3 in = 9

HS = 1.933

VS = 2.505

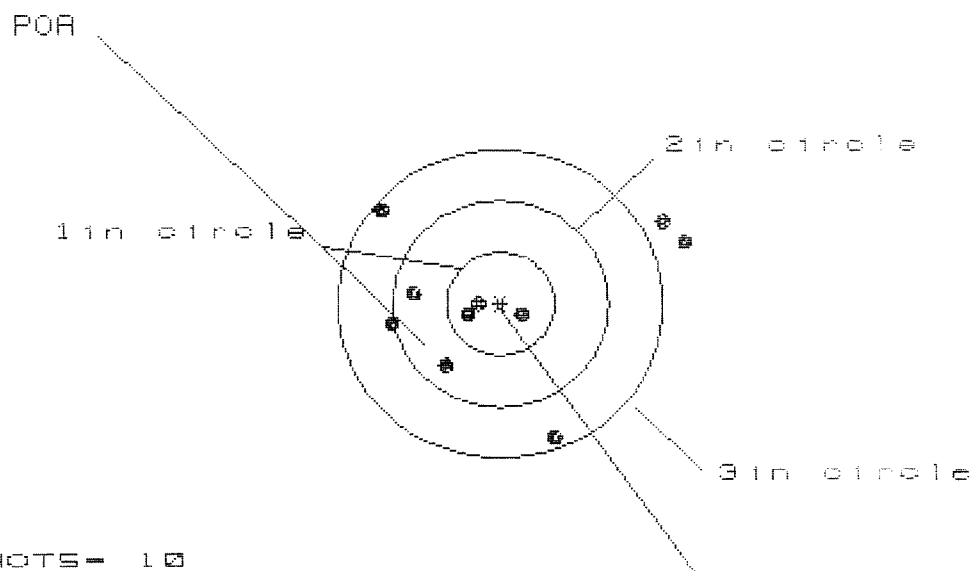
GS = 2.753

|                             |   |        |       |       |
|-----------------------------|---|--------|-------|-------|
| PATTERN #                   | : | 2      |       |       |
| SHOTS (BEST OF)             | : | 10     | 9     | 8     |
| MAXIMUM X                   | : | 1.118  | 1.176 | 1.131 |
| MINIMUM X                   | : | -.815  | -.757 | -.610 |
| MAXIMUM Y                   | : | 1.441  | 1.282 | 1.187 |
| MINIMUM Y                   | : | -1.065 | -.904 | -.999 |
| CENTROID X                  | : | .520   | .462  | .315  |
| CENTROID Y                  | : | -.309  | -.470 | -.375 |
| POA TO CENTROID in.         | : | .605   | .659  | .490  |
| MIN RADIUS                  | : | .300   | .194  | .108  |
| MEAN RADIUS                 | : | 1.036  | .945  | .860  |
| MAX RADIUS                  | : | 1.532  | 1.544 | 1.574 |
| HORIZONTAL SPREAD           | : | 1.933  | 1.933 | 1.741 |
| VERTICAL SPREAD             | : | 2.505  | 2.186 | 2.186 |
| EXTREME SPREAD              | : | 2.753  | 2.638 | 2.634 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 1     |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 4     |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 9     |       |

6 Aug 1990

FILE:/PATTERNING/CENTERFIRE\_PATT/CB43B764

# CENTERFIRE PATTERNS # 3



# OF SHOTS- 10

# IN CIR

1 in = 3

2 in = 6

3 in = 8

HS= 2.838

VS= 2.201

GS= 2.854

CENTROID \*

| PATTERN #                     | : | 3      |        |        |
|-------------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)               | : | 10     | 9      | 8      |
| MAXIMUM X                     | : | 1.743  | 1.691  | .892   |
| MINIMUM X                     | : | -1.095 | -.901  | -.690  |
| MAXIMUM Y                     | : | .892   | .958   | 1.063  |
| MINIMUM Y                     | : | -1.309 | -1.243 | -1.138 |
| CENTROID X                    | : | .503   | .309   | .098   |
| CENTROID Y                    | : | .598   | .532   | .427   |
| POA TO CENTROID in.           | : | .781   | .616   | .438   |
| MIN RADIUS                    | : | .238   | .064   | .129   |
| MEAN RADIUS                   | : | .976   | .808   | .648   |
| MAX RADIUS                    | : | 1.841  | 1.888  | 1.447  |
| HORIZONTAL SPREAD             | : | 2.838  | 2.592  | 1.582  |
| VERTICAL SPREAD               | : | 2.201  | 2.201  | 2.201  |
| EXTREME SPREAD                | : | 2.854  | 2.711  | 2.711  |
| NUMBER IN ONE INCH CIRCLE =   |   |        | 3      |        |
| NUMBER IN TWO INCH CIRCLE =   |   |        | 6      |        |
| NUMBER IN THREE INCH CIRCLE = |   |        | 8      |        |



6 Aug 1988

FILE:/PATTERNING/CENTERFIRE\_PATT/C6498764

# CENTERFIRE PATTERNS

# 4

POA

1 in circle

2 in circle

3 in circle

CENTROID \*

# OF SHOTS - 10

# IN CIR

1 in = 1

2 in = 3

3 in = 8

HS = 3.232

VS = 2.100

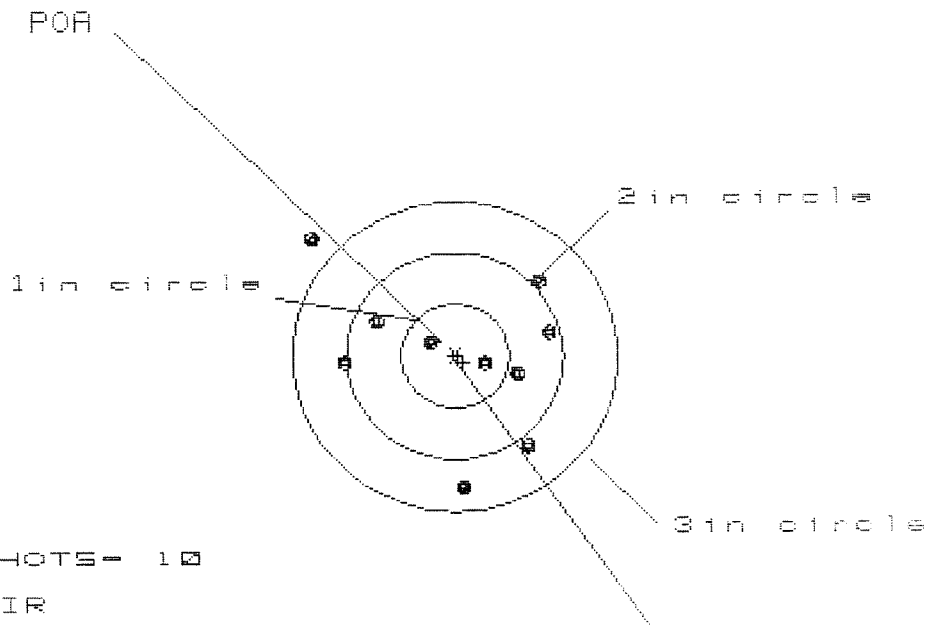
GS = 3.247

|                             |   |        |       |       |
|-----------------------------|---|--------|-------|-------|
| PATTERN #                   | : | 4      |       |       |
| SHOTS (BEST OF)             | : | 10     | 9     | 8     |
| MAXIMUM X                   | : | 2.074  | 1.517 | 1.644 |
| MINIMUM X                   | : | -1.158 | -.928 | -.738 |
| MAXIMUM Y                   | : | 1.170  | 1.200 | 1.295 |
| MINIMUM Y                   | : | -.930  | -.900 | -.805 |
| CENTROID X                  | : | .303   | .073  | -.117 |
| CENTROID Y                  | : | -.212  | -.242 | -.337 |
| POA TO CENTROID in.         | : | .370   | .253  | .356  |
| MIN RADIUS                  | : | .490   | .286  | .113  |
| MEAN RADIUS                 | : | 1.176  | 1.001 | .844  |
| MAX RADIUS                  | : | 2.091  | 1.695 | 1.787 |
| HORIZONTAL SPREAD           | : | 3.232  | 2.445 | 2.382 |
| VERTICAL SPREAD             | : | 2.100  | 2.100 | 2.100 |
| EXTREME SPREAD              | : | 3.247  | 2.632 | 2.506 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 1     |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 3     |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 9     |       |

6 Aug 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/CS438764

# CENTERFIRE PATTERNS # 5



# OF SHOTS - 10

# IN CIR

1 in = 2

2 in = 5

3 in = 8

HS = 2.163

VS = 2.418

GS = 2.872

|                             |   |        |        |        |
|-----------------------------|---|--------|--------|--------|
| PATTERN #                   | : | 5      |        |        |
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | .837   | .690   | .681   |
| MINIMUM X                   | : | -1.326 | -1.221 | -1.230 |
| MAXIMUM Y                   | : | 1.133  | .831   | .686   |
| MINIMUM Y                   | : | -1.285 | -1.159 | -.918  |
| CENTROID X                  | : | -.072  | .075   | .084   |
| CENTROID Y                  | : | .067   | -.059  | .086   |
| POA TO CENTROID in.         | : | .098   | .096   | .120   |
| MIN RADIUS                  | : | .257   | .168   | .169   |
| MEAN RADIUS                 | : | .913   | .798   | .736   |
| MAX RADIUS                  | : | 1.744  | 1.223  | 1.232  |
| HORIZONTAL SPREAD           | : | 2.163  | 1.911  | 1.911  |
| VERTICAL SPREAD             | : | 2.418  | 1.990  | 1.605  |
| EXTREME SPREAD              | : | 2.872  | 2.112  | 2.004  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 5      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |        |

# Remington®



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

MODEL 700™ H24

SERIAL NO.  
C6498764

ORDER NO.  
5716

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

01



5716 C6498764



UPC