

C661814

MODEL 700<sup>TM</sup> M24

Model **SWS** <sup>TM</sup>

Action

Barrel Length

Capacity

Order No. **5715**

\*Includes 1 in chamber.

*Remington*

**Remington**  
MODEL 700<sup>TM</sup> M24

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

**UPPONT**  
REGISTERED PATENT OFF.

SERIAL NO.  
C6611814

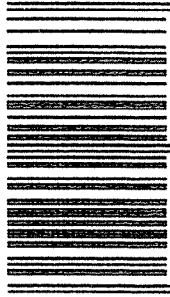
ORDER NO.  
5716

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

20

5716 C6611814

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # *C6611814*

| OP. #        | OP. NAME                                                       | READINGS | DATE           | INIT       |
|--------------|----------------------------------------------------------------|----------|----------------|------------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   | 3 28     | 91             | <i>RW</i>  |
| 600          | Proof                                                          | 3 28     | 91             | <i>RW</i>  |
| 607          | Check Headspace                                                | 3 28     | 91             | <i>RW</i>  |
| 610          | Dis-assemble Gun                                               | 3 28     | 91             | <i>RW</i>  |
| 612          | Magnaflux Barrel<br>Action                                     | APR      | 2 1991         | <i>K.R</i> |
|              | Magnaflux Bolt                                                 | APR      | 2 1991         | <i>"</i>   |
| 615          | Rollmark Caliber                                               | APR      | 2 1991         | <i>JS</i>  |
| 617          | Drill and Tap Sight Holes                                      | APR      | 5 1991         | <i>LB</i>  |
| 618          | Polish Barrel                                                  | APR      | 5 1991         | <i>LB</i>  |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | <i>4-9-91</i>  | <i>JS</i>  |
|              | Apply Coating (Bolt)                                           |          |                |            |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | <i>4/10/91</i> | <i>RW</i>  |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | <i>4/10/91</i> | <i>RW</i>  |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | <i>4/10/91</i> | <i>RW</i>  |
|              | D) Oil Firing Pin Ass'y                                        |          | <i>4/10/91</i> | <i>RW</i>  |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | <i>4/30/91</i> | <i>JS</i>  |

| op. #        | OP. NAME                                                    | READINGS |       |       |      |      | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|-------|-------|------|------|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 5        | 5     | 5     |      |      | 5/1/91  | SM   |
|              | G) Safety Off Force                                         | 3        | 3     | 3     |      |      | 5/1/91  | SM   |
|              | H) Trigger Pull Test & Retainability                        |          |       |       |      |      | 4/30/91 | SM   |
|              | I) Firing Pin Indent                                        | .0225    | .0225 | .0225 |      |      | 5/1/91  | SM   |
|              | J) Assemble Stock                                           |          |       |       |      |      | 5/1/91  | RW   |
|              | K) Assemble Swivel Studs                                    |          |       |       |      |      | 5-1-91  | D/H  |
|              | L) Attach Front and Rear Sight Assemblies                   |          |       |       |      |      | 5/1/91  | RW   |
|              | M) Iron Sight Alignment                                     |          |       |       |      |      | 5/1/91  | RW   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |       |       |      |      | 5/1/91  | RW   |
|              | O) Attach Scope to Rifle                                    |          |       |       |      |      | 5/1/91  | RW   |
|              | P) Detach & Attach Scope 20 Times                           |          |       |       |      |      | 5/1/91  | RW   |
|              |                                                             |          |       |       |      |      |         |      |
| 640          | Gallery Target & Test                                       |          |       |       |      |      | 5/1/91  | KT   |
|              | A) Time                                                     |          |       |       |      |      | "       | KT   |
|              | B) Malfunctions                                             |          |       |       |      |      | "       | KT   |
|              | C) Pierced Primers                                          |          |       |       |      |      | "       | KT   |
|              | D) Optical Clarity of Scope                                 |          |       |       |      |      | "       | KT   |
| 645          | Inspect for Live Ammo                                       |          |       |       |      |      | 5/1/91  | KT   |
| 655          | Final Inspection                                            |          |       |       |      |      |         |      |
|              | A) Headspace                                                |          |       |       |      |      | 5-1-91  | D/H  |
|              | B) Trigger Pull                                             | 2.35     | 2.26  | 2.29  | 2.30 | 2.30 | 5/1/91  | SM   |
|              | C) Function                                                 |          |       |       |      |      | 5-1-91  | D/H  |
| 660          | Pack                                                        |          |       |       |      |      | 6-19-91 | VF   |

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6611814

DATE 4/30/91

TESTER JL

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.24             | 2.26                     | 2.30                           | 2.35 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.23             | 2.37                     | 2.36                           | 2.26 |                                                                        |
| PULL #3 | 2.28             | 2.48                     | 2.38                           | 2.29 |                                                                        |
| PULL #4 | 2.25             | 2.42                     | 2.45                           | 2.30 |                                                                        |
| PULL #5 | 2.23             | 2.20                     | 2.40                           | 2.30 |                                                                        |
| TOTAL   |                  |                          |                                |      |                                                                        |
| AVG.    |                  |                          |                                |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.58             | 3.40                     |  |          |
| PULL #2 | 3.54             | 3.50                     |  |          |
| PULL #3 | 3.58             | 3.50                     |  |          |
| PULL #4 | 3.57             | 3.50                     |  |          |
| PULL #5 | 3.58             | 3.56                     |  |          |
| TOTAL   |                  |                          |  |          |
| AVG.    |                  |                          |  |          |

|         | 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 | 4.23             | 4.29                     |                                | 4.37                                 |
| PULL #2 | 4.27             | 4.39                     |                                | 4.40                                 |
| PULL #3 | 4.27             | 4.32                     |                                | 4.37                                 |
| PULL #4 | 4.29             | 4.30                     |                                | 4.40                                 |
| PULL #5 | 4.32             | 4.36                     |                                | 4.39                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # 06611814  
1 May 1991

CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| 0 TO | 1 | .229428 |
| 1 TO | 2 | .588623 |
| 1 TO | 3 | .189497 |
| 1 TO | 4 | .172699 |
| 1 TO | 5 | .147628 |

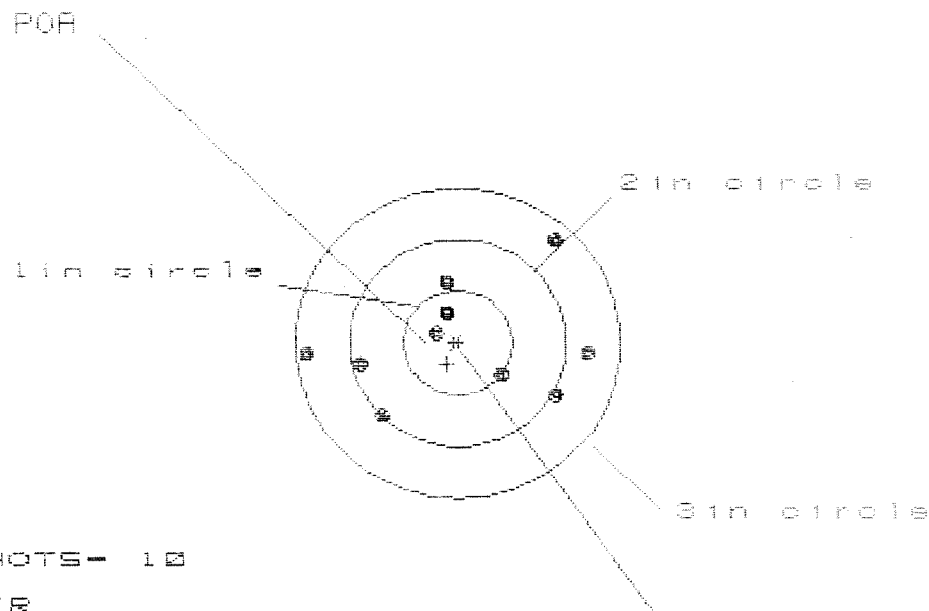
←----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0412  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .046  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0617531  
THE AMR FOR THIS RIFLE IS: .7864

1 May 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C8611814

## CENTERFIRE PATTERNS # 1



# OF SHOTS - 10

# IN CIR

1 in = 3

2 in = 6

3 in = 10

HS = 2.644

VS = 1.654

GS = 2.645

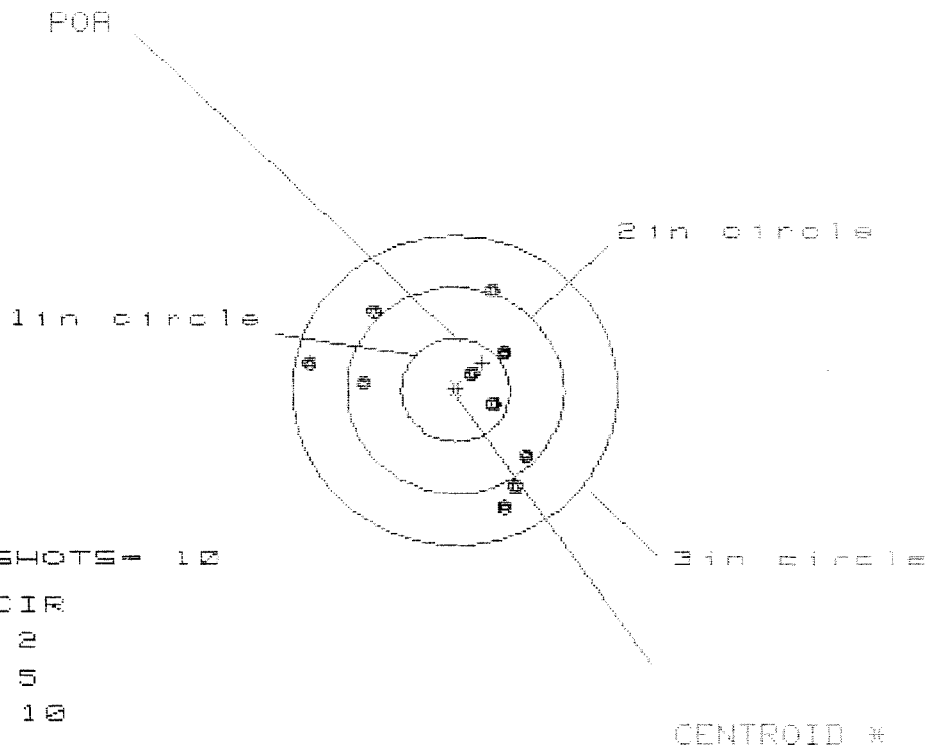
CENTROID \*

| PATTERN #                     | 1      | 2      | 3      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.207  | 1.047  | 1.138  |
| MINIMUM X                     | -1.437 | -1.015 | -0.924 |
| MAXIMUM Y                     | .993   | .976   | .677   |
| MINIMUM Y                     | -.661  | -.678  | -.556  |
| CENTROID X                    | .101   | .261   | .170   |
| CENTROID Y                    | .206   | .223   | .101   |
| POA TO CENTROID in.           | .229   | .343   | .198   |
| MIN RADIUS                    | .194   | .349   | .299   |
| MEAN RADIUS                   | .849   | .789   | .725   |
| MAX RADIUS                    | 1.445  | 1.214  | 1.138  |
| HORIZONTAL SPREAD             | 2.644  | 2.062  | 2.062  |
| VERTICAL SPREAD               | 1.654  | 1.654  | 1.233  |
| EXTREME SPREAD                | 2.645  | 2.291  | 2.064  |
| NUMBER IN ONE INCH CIRCLE =   | 3      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 6      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 10     |        |        |

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## CENTERFIRE PATTERNS # 2



# OF SHOTS - 10

# IN CIR

1in = 2

2in = 5

3in = 10

HS = 2.0009

VS = 2.163

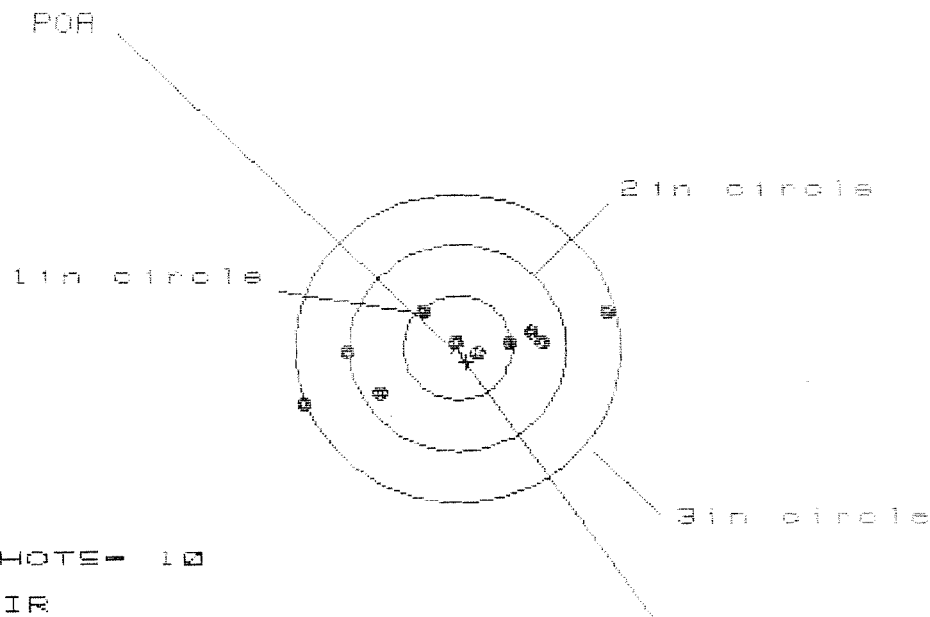
GS = 2.295

| PATTERN #                   | : | 2      |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | .644   | .493   | .530   |
| MINIMUM X                   | : | -1.365 | -1.027 | -.990  |
| MAXIMUM Y                   | : | 1.009  | 1.037  | .896   |
| MINIMUM Y                   | : | -1.154 | -1.126 | -1.013 |
| CENTROID X                  | : | -.248  | -.097  | -.134  |
| CENTROID Y                  | : | -.268  | -.296  | -.155  |
| POA TO CENTROID in.         | : | .365   | .311   | .205   |
| MIN RADIUS                  | : | .226   | .215   | .074   |
| MEAN RADIUS                 | : | .879   | .793   | .727   |
| MAX RADIUS                  | : | 1.388  | 1.190  | 1.105  |
| HORIZONTAL SPREAD           | : | 2.009  | 1.520  | 1.520  |
| VERTICAL SPREAD             | : | 2.163  | 2.163  | 1.909  |
| EXTREME SPREAD              | : | 2.295  | 2.267  | 2.114  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 5      |        |
| 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 = 2.842

VS = .840

GS = 2.964

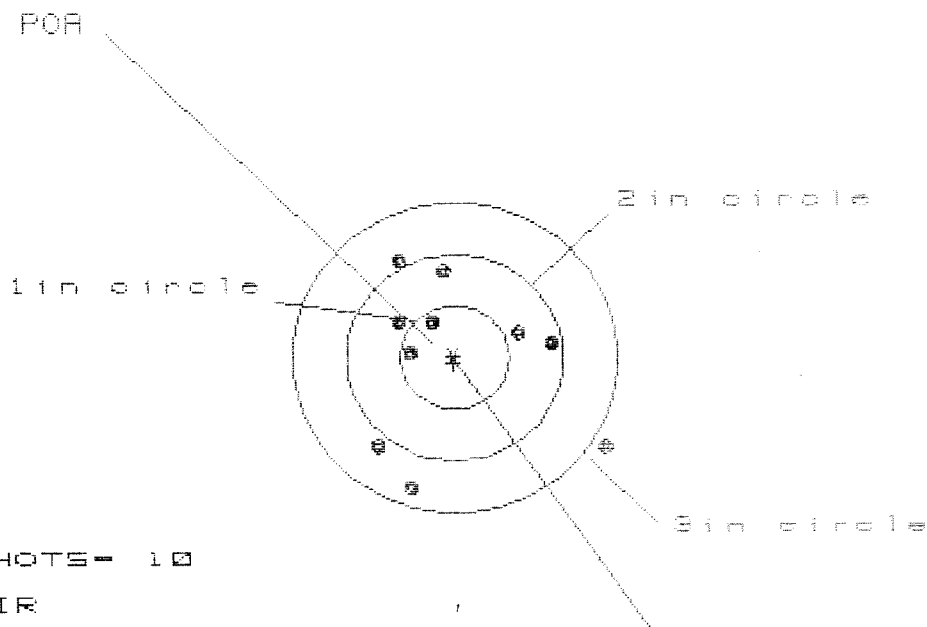
CENTROID #

| PATTERN #                     | 10     | 9      | 8      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.385  | 1.223  | .755   |
| MINIMUM X                     | -1.457 | -1.196 | -1.043 |
| MAXIMUM Y                     | .345   | .290   | .319   |
| MINIMUM Y                     | -.495  | -.460  | -.424  |
| CENTROID X                    | -.077  | .085   | -.068  |
| CENTROID Y                    | .141   | .196   | .160   |
| POA TO CENTROID in.           | .161   | .214   | .174   |
| MIN RADIUS                    | .106   | .134   | .100   |
| MEAN RADIUS                   | .765   | .655   | .583   |
| MAX RADIUS                    | 1.539  | 1.257  | 1.048  |
| HORIZONTAL SPREAD             | 2.842  | 2.419  | 1.798  |
| VERTICAL SPREAD               | .840   | .750   | .743   |
| EXTREME SPREAD                | 2.964  | 2.457  | 1.803  |
| 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= 2.195

VS= 2.148

GS= 2.612

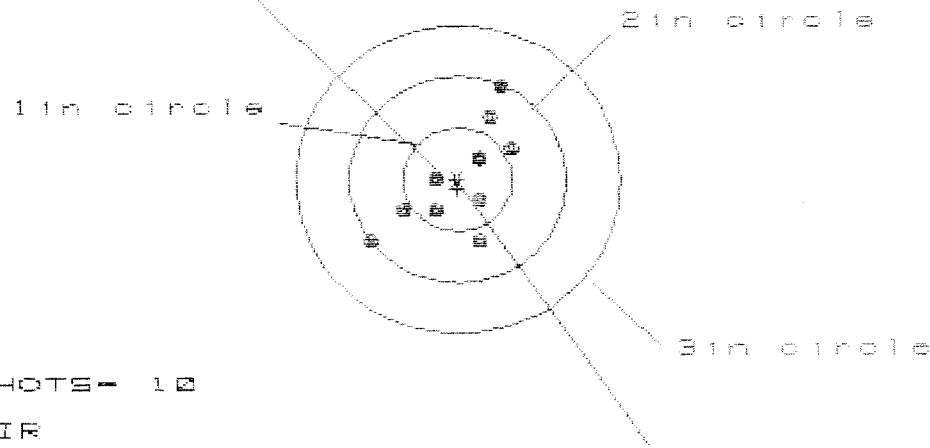
| PATTERN #                   | : | 4      |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.436  | 1.031  | 1.001  |
| MINIMUM X                   | : | -.759  | -.599  | -.629  |
| MAXIMUM Y                   | : | .940   | .846   | .683   |
| MINIMUM Y                   | : | -1.208 | -1.302 | -1.124 |
| CENTROID X                  | : | .012   | -.148  | -.119  |
| CENTROID Y                  | : | .056   | .152   | .315   |
| POA TO CENTROID in.         | : | .059   | .212   | .336   |
| MIN RADIUS                  | : | .378   | .209   | .166   |
| MEAN RADIUS                 | : | .897   | .762   | .657   |
| MAX RADIUS                  | : | 1.668  | 1.324  | 1.288  |
| HORIZONTAL SPREAD           | : | 2.195  | 1.630  | 1.630  |
| VERTICAL SPREAD             | : | 2.148  | 2.148  | 1.807  |
| EXTREME SPREAD              | : | 2.612  | 2.149  | 1.894  |
| 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



# OF SHOTS - 10

# IN CIR

1in = 4

2in = 10

3in = 10

HS = 1.241

VS = 1.493

GS = 1.859

CENTROID \*

| PATTERN #                   | 5     |
|-----------------------------|-------|
| SHOTS (BEST OF)             | 10    |
| MAXIMUM X                   | .467  |
| MINIMUM X                   | -.774 |
| MAXIMUM Y                   | .868  |
| MINIMUM Y                   | -.625 |
| CENTROID X                  | .086  |
| CENTROID Y                  | .093  |
| POB TO CENTROID in.         | .093  |
| MIN RADIUS                  | .175  |
| MEAN RADIUS                 | .542  |
| MAX RADIUS                  | .964  |
| HORIZONTAL SPREAD           | 1.241 |
| VERTICAL SPREAD             | 1.493 |
| EXTREME SPREAD              | 1.859 |
| NUMBER IN ONE INCH CIRCLE   | 4     |
| NUMBER IN TWO INCH CIRCLE   | 10    |
| NUMBER IN THREE INCH CIRCLE | 10    |