

C6522152

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

\*Includes 1 in chamber.

*Remington*

*Smead*®

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522162

| OP. #     | OP. NAME                                                 | READINGS | DATE    | INIT |
|-----------|----------------------------------------------------------|----------|---------|------|
| 575 & 580 | Assemble Action and Stock                                | 8 2      | 90      | RW   |
| 600       | Proof                                                    | 8 2      | 90      | RW   |
| 607       | Check Headspace                                          | 8 2      | 90      | RW   |
| 610       | Dis-assemble Gun                                         | 8 2      | 90      | RW   |
| 612       | Magnaflux Barrel Action                                  |          | 8/7/90  | KR   |
|           | Magnaflux Bolt                                           |          | 8/7/90  | KR   |
| 615       | Rollmark Caliber                                         |          | 8/7/90  | GL   |
| 617       | Drill and Tap Sight Holes                                |          | 8/10/90 | LB   |
| 618       | Polish Barrel RW                                         |          | 8/14/90 | WB   |
| 620       | Apply Coatings (Barrel Action)                           |          | 8/24/90 | TSR  |
|           | Apply Coating (Bolt)                                     |          |         |      |
| 625       | Final Assembly                                           |          |         |      |
|           | A) Clean inside of Bolt Assembly                         |          | 8/27/90 | RW   |
|           | B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head |          | 8/27/90 | RW   |
|           | C) Inspect Ejector Hole for Chamfer                      |          | 8/27/90 | RW   |
|           | D) Oil Firing Pin Ass'y                                  |          | 8/27/90 | RW   |
|           | E) Adjust Trigger Pull to Min Setting and Stake          |          | 8/30/90 | XL   |

| op. #        | OP. NAME                                                    | READINGS |       |       |     |     | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|-------|-------|-----|-----|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 4 1/4    | 4 1/4 | 4 1/4 |     |     | 8/30/90 | CS   |
|              | G) Safety Off Force                                         | 2 1/2    | 2 1/2 | 2 1/2 |     |     | 8/30/90 | CS   |
|              | H) Trigger Pull Test & Retainability                        |          |       |       |     |     | 8/30/90 | MF   |
|              | I) Firing Pin Indent                                        | .0225    | .0225 | .0225 |     |     | 8/30/90 | CS   |
|              | J) Assemble Stock                                           |          |       |       |     |     | 9/4/90  | Ru   |
|              | K) Assemble Swivel Studs                                    |          |       |       |     |     | 9/4/90  | 928  |
|              | L) Attach Front and Rear Sight Assemblies                   |          |       |       |     |     | 9/4/90  | Ru   |
|              | M) Iron Sight Alignment                                     |          |       |       |     |     | 9/4/90  | Ru   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |       |       |     |     | 9/4/90  | Ru   |
|              | O) Attach Scope to Rifle                                    |          |       |       |     |     | 9/4/90  | Ru   |
|              | P) Detach & Attach Scope 20 Times                           |          |       |       |     |     | 9/4/90  | Ru   |
| 640          | Gallery Target & Test                                       |          |       |       |     |     | 9/7/90  | AF   |
|              | A) Time                                                     |          |       |       |     |     | 9/7/90  | AF   |
|              | B) Malfunctions                                             |          |       |       |     |     | 9/7/90  | AF   |
|              | C) Pierced Primers                                          |          |       |       |     |     | 9/7/90  | AF   |
|              | D) Optical Clarity of Scope                                 |          |       |       |     |     | 9/7/90  | AF   |
| 645          | Inspect for Live Ammo                                       |          |       |       |     |     | 9/7/90  | AF   |
| 655          | Final Inspection                                            |          |       |       |     |     |         |      |
|              | A) Headspace                                                |          |       |       |     |     | 9/9/90  | 928  |
|              | B) Trigger Pull                                             | 239      | 243   | 234   | 244 | 247 | 9/9/90  | 928  |
|              | C) Function                                                 |          |       |       |     |     | 9/9/90  | 928  |
| 660          | Pack                                                        |          |       |       |     |     | 9/24/90 | AF   |

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

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

SERIAL NO. C6522162

DATE 8/30/98

TESTER JH

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |     | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|-----|------------------------------------------------------------------------|
| PULL #1 | 2.29             | 2.25                     | 2.11                           | 239 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.25             | 2.19                     | 2.33                           | 243 |                                                                        |
| PULL #3 | 2.24             | 2.23                     | 2.27                           | 234 |                                                                        |
| PULL #4 | 2.25             | 2.28                     | 2.27                           | 244 |                                                                        |
| PULL #5 | 2.27             | 2.34                     | 2.35                           | 247 |                                                                        |
| TOTAL   | 11.30            | 11.29                    | 11.33                          |     |                                                                        |
| AVG.    | 2.26             | 2.258                    | 2.266                          |     |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.16             | 3.43                     |  |          |
| PULL #2 | 3.28             | 3.43                     |  |          |
| PULL #3 | 3.35             | 3.43                     |  |          |
| PULL #4 | 3.38             | 3.49                     |  |          |
| PULL #5 | 3.44             | 3.50                     |  |          |
| TOTAL   | 16.61            | 17.28                    |  |          |
| AVG.    | 3.322            | 3.455                    |  |          |

|         | 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 | 4.48             | 4.38                     |                                | 4.08                                 |
| PULL #2 | 4.30             | 4.25                     |                                | 4.33                                 |
| PULL #3 | 4.28             | 4.30                     |                                | 4.28                                 |
| PULL #4 | 4.31             | 4.23                     |                                | 4.06                                 |
| PULL #5 | 4.33             | 4.31                     |                                | 4.25                                 |
| TOTAL   | 21.70            | 21.47                    |                                | 21.00                                |
| AVG.    | 4.34             | 4.294                    |                                | 4.2                                  |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6522162  
7 Sep 1990

CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| 0 TO | 1 | .38764  |
| 1 TO | 2 | .524141 |
| 1 TO | 3 | .485619 |
| 1 TO | 4 | .654618 |
| 1 TO | 5 | .5114   |

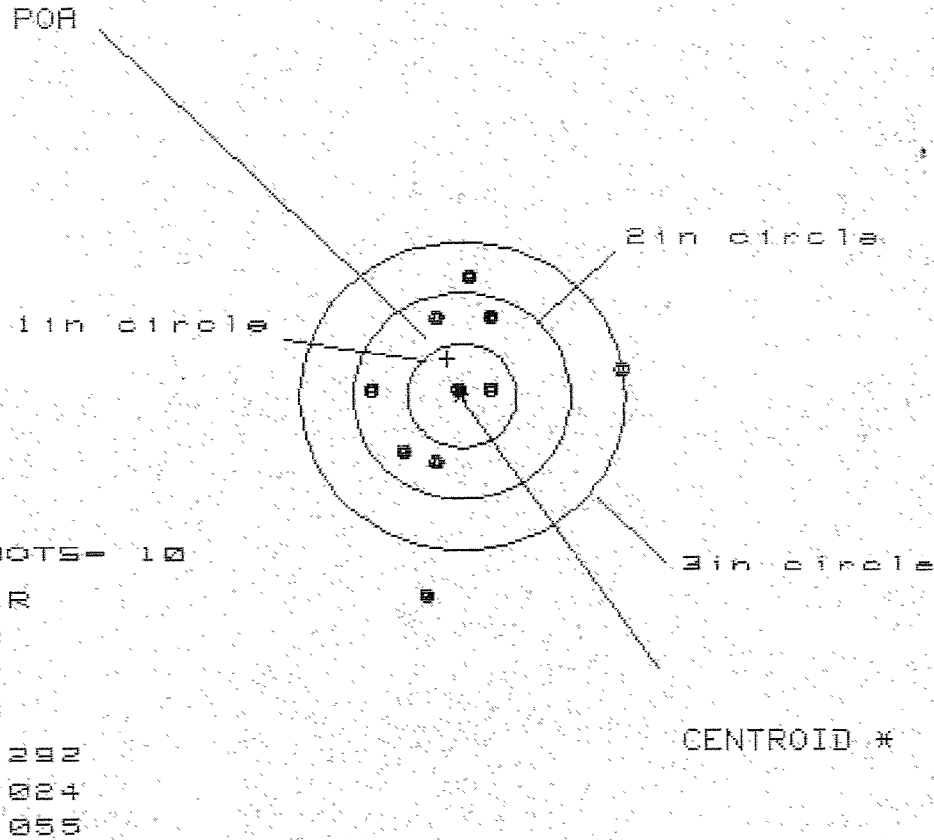
1 <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .009  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0514  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .052182  
THE AMR FOR THIS RIFLE IS: .864

7 Sep 1938

FILE: PATTERNING/CENTERFIRE\_PATT/08522162

# CENTERFIRE PATTERNS # 1

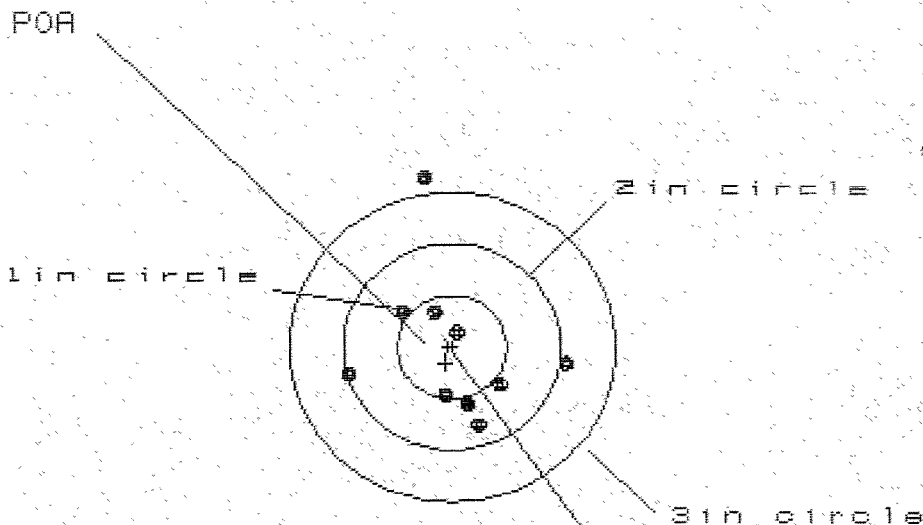


| PATTERN #                     | 1      | 9     | 8     |
|-------------------------------|--------|-------|-------|
| SHOTS (BEST OF)               | 10     | 9     | 8     |
| MAXIMUM X                     | 1.498  | 1.457 | .434  |
| MINIMUM X                     | -.794  | -.835 | -.652 |
| MAXIMUM Y                     | 1.127  | .916  | .921  |
| MINIMUM Y                     | -1.897 | -.816 | -.811 |
| CENTROID X                    | .136   | .177  | -.006 |
| CENTROID Y                    | -.363  | -.152 | -.157 |
| POA TO CENTROID in.           | .387   | .233  | .157  |
| MIN RADIUS                    | .053   | .176  | .198  |
| DEAN RADIUS                   | .865   | .737  | .639  |
| MAX RADIUS                    | 1.932  | 1.458 | .945  |
| HORIZONTAL SPREAD             | 2.292  | 2.292 | 1.087 |
| VERTICAL SPREAD               | 3.024  | 1.732 | 1.732 |
| EXTREME SPREAD                | 3.055  | 2.296 | 1.761 |
| NUMBER IN ONE INCH CIRCLE =   | 2      |       |       |
| NUMBER IN TWO INCH CIRCLE =   | 7      |       |       |
| NUMBER IN THREE INCH CIRCLE = | 8      |       |       |

7 Sep 1980

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# CENTERFIRE PATTERNS # 2



# OF SHOTS- 10

# IN CIR

1 in = 3

2 in = 8

3 in = 9

HS= 2.021

VS= 2.369

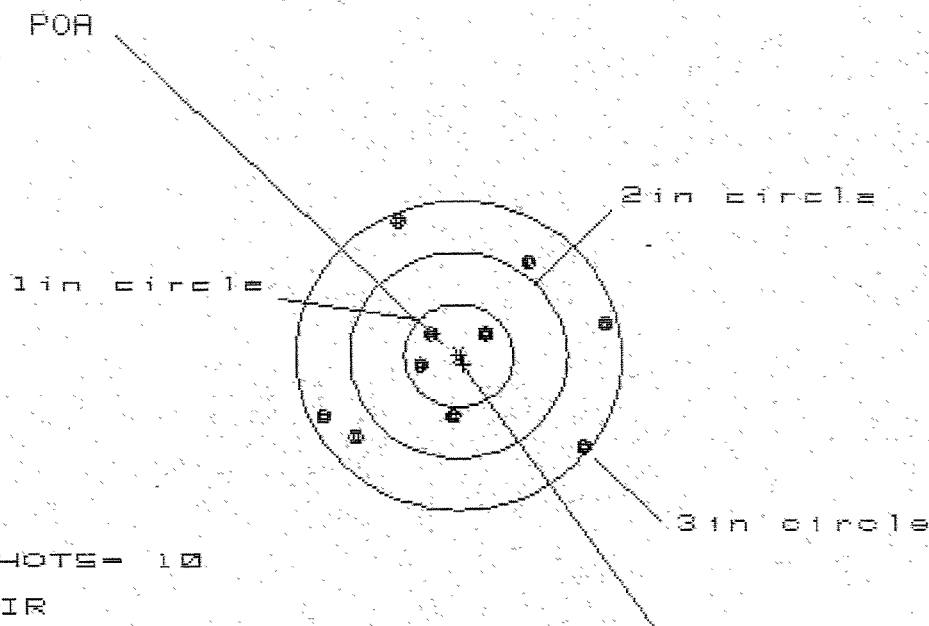
GS= 2.419

| PATTERN #                   | 2      |
|-----------------------------|--------|
| SHOTS (BEST OF)             | 10     |
| MAXIMUM X                   | 1.046  |
| MINIMUM X                   | -0.975 |
| MAXIMUM Y                   | 1.614  |
| MINIMUM Y                   | -0.755 |
| CENTROID X                  | 0.056  |
| CENTROID Y                  | 0.155  |
| POA TO CENTROID in.         | 0.165  |
| MIN RADIUS                  | 0.170  |
| PERC RADIUS                 | 0.720  |
| MAX RADIUS                  | 1.631  |
| HORIZONTAL SPREAD           | 2.021  |
| VERTICAL SPREAD             | 2.369  |
| EXTREME SPREAD              | 2.419  |
| KINZER IN ONE INCH CIRCLE   | 3      |
| KINZER IN TWO INCH CIRCLE   | 8      |
| KINZER IN THREE INCH CIRCLE | 9      |

7 Sep 1998

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# CENTERFIRE PATTERNS # 3



# OF SHOTS= 10

# IN CIR

1in = 3

2in = 4

3in = 10

HS= 2.571

VS= 2.206

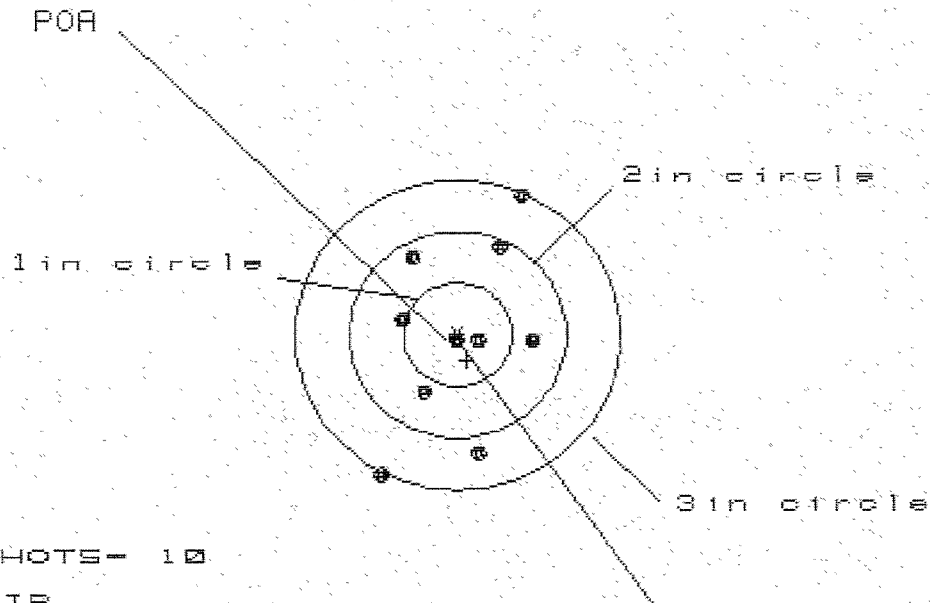
GS= 2.775

|                             |   |        |        |        |
|-----------------------------|---|--------|--------|--------|
| PATTERN #                   | : | 3      |        |        |
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.301  | 1.432  | 1.386  |
| MINIMUM X                   | : | -1.270 | -1.139 | -1.185 |
| MAXIMUM Y                   | : | 1.310  | 1.210  | .927   |
| MINIMUM Y                   | : | -.896  | -.919  | -.768  |
| CENTROID X                  | : | -.049  | -.180  | -.134  |
| CENTROID Y                  | : | .086   | .186   | .035   |
| POA TO CENTROID in.         | : | .099   | .259   | .138   |
| MIN RADIUS                  | : | .315   | .200   | .268   |
| MEAN RADIUS                 | : | .962   | .885   | .832   |
| MAX RADIUS                  | : | 1.483  | 1.455  | 1.445  |
| HORIZONTAL SPREAD           | : | 2.571  | 2.571  | 2.571  |
| VERTICAL SPREAD             | : | 2.206  | 2.129  | 1.695  |
| EXTREME SPREAD              | : | 2.775  | 2.726  | 2.726  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 3      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 4      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 10     |        |

7 Sep 1998

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# CENTERFIRE PATTERNS # 4



# OF SHOTS- 10

# IN CIR

1 in = 2

2 in = 7

3 in = 10

HS= 1.388

VS= 2.612

GS= 2.902

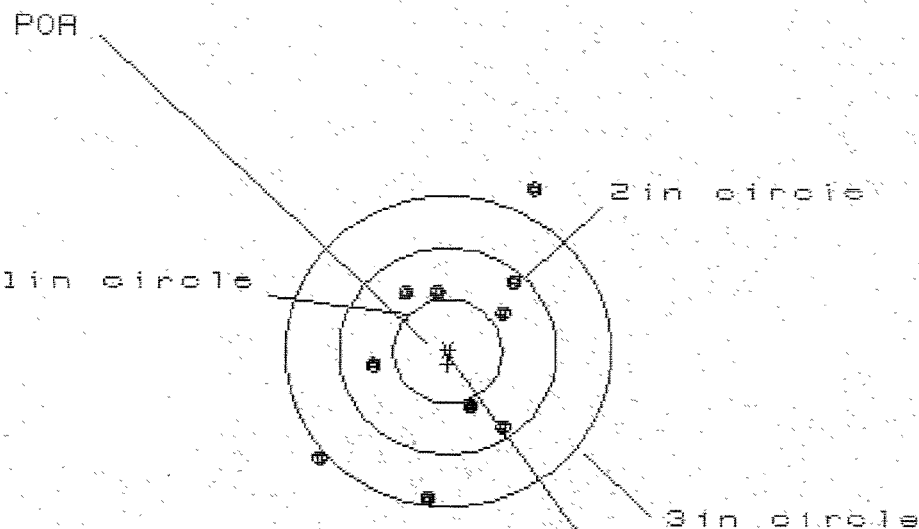
CENTROID \*

|                             |   |        |        |        |
|-----------------------------|---|--------|--------|--------|
| PATTERN #                   | : | 4      |        |        |
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | .725   | .651   | .717   |
| MINIMUM X                   | : | -.663  | -.615  | -.549  |
| MAXIMUM Y                   | : | 1.306  | 1.160  | .861   |
| MINIMUM Y                   | : | -1.306 | -1.248 | -1.103 |
| CENTROID X                  | : | -.091  | -.017  | -.083  |
| CENTROID Y                  | : | .251   | .396   | .251   |
| POA TO CENTROID in.         | : | .266   | .396   | .264   |
| MIN RADIUS                  | : | .089   | .178   | .095   |
| MEAN RADIUS                 | : | .803   | .739   | .641   |
| MAX RADIUS                  | : | 1.465  | 1.274  | 1.111  |
| HORIZONTAL SPREAD           | : | 1.388  | 1.266  | 1.266  |
| VERTICAL SPREAD             | : | 2.612  | 2.408  | 1.964  |
| EXTREME SPREAD              | : | 2.902  | 2.452  | 1.979  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 7      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 10     |        |

7 Sep 1998

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# CENTERFIRE PATTERNS # 5



# OF SHOTS= 10

# IN CIR

1 in = 0

2 in = 7

3 in = 8

HS= 2.005

VS= 3.065

GS= 3.271

CENTROID #

| PATTERN #                     | 5      | 9      | 8      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | .780   | .681   | .539   |
| MINIMUM X                     | -1.225 | -1.139 | -.716  |
| MAXIMUM Y                     | 1.591  | .841   | .739   |
| MINIMUM Y                     | -1.474 | -1.297 | -1.399 |
| CENTROID X                    | -.007  | -.093  | .049   |
| CENTROID Y                    | .128   | -.049  | .053   |
| POA TO CENTROID in.           | .128   | .106   | .072   |
| MIN RADIUS                    | .541   | .449   | .449   |
| MEAN RADIUS                   | .970   | .885   | .795   |
| MAX RADIUS                    | 1.772  | 1.401  | 1.425  |
| HORIZONTAL SPREAD             | 2.005  | 1.820  | 1.255  |
| VERTICAL SPREAD               | 3.065  | 2.138  | 2.138  |
| EXTREME SPREAD                | 3.271  | 2.462  | 2.286  |
| NUMBER IN ONE INCH CIRCLE =   | 0      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 7      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 8      |        |        |

**Remington**<sup>®</sup> **DUPONT**  
REG. U.S. PAT. & TM. OFF.

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

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

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

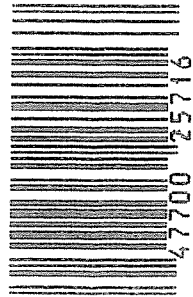
**SERIAL NO.**  
 C6522162

**ORDER NO.**  
 5715



5715 C6522162

UPC



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