

C6523306

MODEL 700™ M24

Model SWS™

Action

Barrel Length

Capacity

Order No. 5716

\*Includes 1 in chamber.

*Remington*



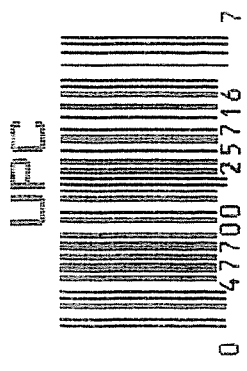

VERY IMPORTANT:  
Instruction Book  
enclosed to assure  
safe use of this  
firearm.

MODEL 700™ H24

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

SERIAL NO.  
C6523306

ORDER NO.  
5716



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523306

| OP. #        | OP. NAME                                                       | READINGS | DATE     | INIT |
|--------------|----------------------------------------------------------------|----------|----------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   | 10 3     | 90       | RW   |
| 600          | Proof                                                          | 10 3     | 90       | RW   |
| 607          | Check Headspace                                                | 10 3     | 90       | RW   |
| 610          | Dis-assemble Gun                                               | 10 3     | 90       | RW   |
| 612          | Magnaflux Barrel<br>Action                                     |          | 10/11/90 | KR   |
|              | Magnaflux Bolt                                                 |          | 10/11/90 | KR   |
| 615          | Rollmark Caliber                                               |          | 10/11/90 | GB   |
| 617          | Drill and Tap Sight Holes                                      |          | 10/11/90 | FB   |
| 618          | Polish Barrel RWB                                              |          | 10/12/90 | WB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 10-13-90 | TH   |
|              | Apply Coating (Bolt)                                           |          | 10-13-90 | TH   |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 10/22/90 | RW   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 10/22/90 | RW   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 10/22/90 | RW   |
|              | D) Oil Firing Pin Ass'y                                        |          | 10/22/90 | RW   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 11/2/90  | GB   |

| op. #        | OP. NAME                                                    | READINGS |       |       |      |      | DATE     | INIT |
|--------------|-------------------------------------------------------------|----------|-------|-------|------|------|----------|------|
| 625<br>cont. | F) Safety On Force                                          | 4 1/2    | 4 1/2 | 4 1/2 |      |      | 11/9/90  | GS   |
|              | G) Safety Off Force                                         | 3 1/2    | 3 1/2 | 3 1/2 |      |      | 11/9/90  | GS   |
|              | H) Trigger Pull Test & Retainability                        |          |       |       |      |      | 11/9/90  | GS   |
|              | I) Firing Pin Indent                                        | .021     | .021  | .021  |      |      | 11/9/90  | GS   |
|              | J) Assemble Stock                                           |          |       |       |      |      | 11/14/90 | RW   |
|              | K) Assemble Swivel Studs                                    |          |       |       |      |      | 11-17-90 | D/H  |
|              | L) Attach Front and Rear Sight Assemblies                   |          |       |       |      |      | 11/14/90 | RW   |
|              | M) Iron Sight Alignment                                     |          |       |       |      |      | 11/14/90 | RW   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |       |       |      |      | 11/14/90 | RW   |
|              | O) Attach Scope to Rifle                                    |          |       |       |      |      | 11/14/90 | RW   |
|              | P) Detach & Attach Scope 20 Times                           |          |       |       |      |      | 11/14/90 | RW   |
| 640          | Gallery Target & Test                                       |          |       |       |      |      | 11-15-90 | AC   |
|              | A) Time                                                     |          |       |       |      |      | 11-15-90 | AC   |
|              | B) Malfunctions                                             |          |       |       |      |      | 11-15-90 | AC   |
|              | C) Pierced Primers                                          |          |       |       |      |      | 11-15-90 | AC   |
|              | D) Optical Clarity of Scope                                 |          |       |       |      |      | 11-15-90 | AC   |
| 645          | Inspect for Live Ammo                                       |          |       |       |      |      | 11-15-90 | AC   |
| 655          | Final Inspection                                            |          |       |       |      |      |          |      |
|              | A) Headspace                                                |          |       |       |      |      | 11-19-90 | D/H  |
|              | B) Trigger Pull                                             | 2.54     | 2.52  | 2.57  | 2.55 | 2.55 | 11-19-90 | D/H  |
|              | C) Function                                                 |          |       |       |      |      | 11-19-90 | D/H  |
| 660          | Pack                                                        |          |       |       |      |      | 12-17-90 | D/H  |

SWS TRIGGER PULL TEST

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

SERIAL NO. C6 523306  
DATE 9/16/90  
TESTER Q28

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 227              | 228                      | 232                            | 2.54 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 226              | 221                      | 241                            | 2.52 |                                                                        |
| PULL #3 | 220              | 238                      | 231                            | 2.57 |                                                                        |
| PULL #4 | 218              | 230                      | 236                            | 2.55 |                                                                        |
| PULL #5 | 216              | 228                      | 235                            | 2.55 |                                                                        |
| TOTAL   |                  |                          |                                |      |                                                                        |
| AVG.    |                  |                          |                                |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 336              | 340                      |  |          |
| PULL #2 | 328              | 334                      |  |          |
| PULL #3 | 330              | 329                      |  |          |
| PULL #4 | 330              | 331                      |  |          |
| PULL #5 | 327              | 332                      |  |          |
| 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 | 403              | 405                      |                                | 4.09                                 |
| PULL #2 | 401              | 414                      |                                | 4.15                                 |
| PULL #3 | 396              | 413                      |                                | 4.19                                 |
| PULL #4 | 399              | 410                      |                                | 4.19                                 |
| PULL #5 | 400              | 410                      |                                | 4.18                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # 06523306  
15 Nov 1990

CENTROIDAL DISTANCES

|      |   |          |
|------|---|----------|
| 0 TO | 1 | .0284605 |
| 1 TO | 2 | .150153  |
| 1 TO | 3 | .353375  |
| 1 TO | 4 | .303028  |
| 1 TO | 5 | .159113  |

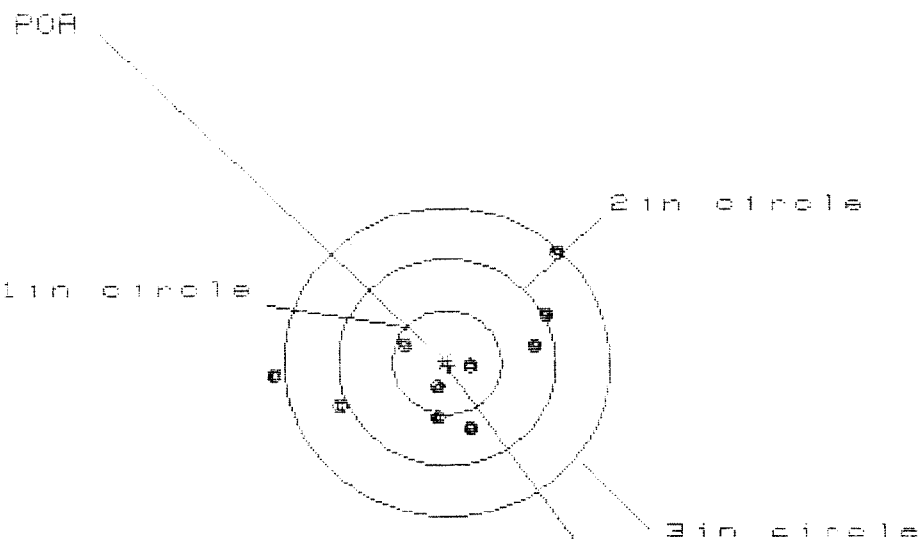
 ----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0824  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0246  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0356  
THE AMR FOR THIS RIFLE IS: .8058

15 Nov 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/C8523386

# CENTERFIRE PATTERNS # 1



# OF SHOTS= 10

# IN CIR

1in = 3

2in = 6

3in = 9

HS= 2.660

VS= 1.619

GS= 2.986

CENTROID #

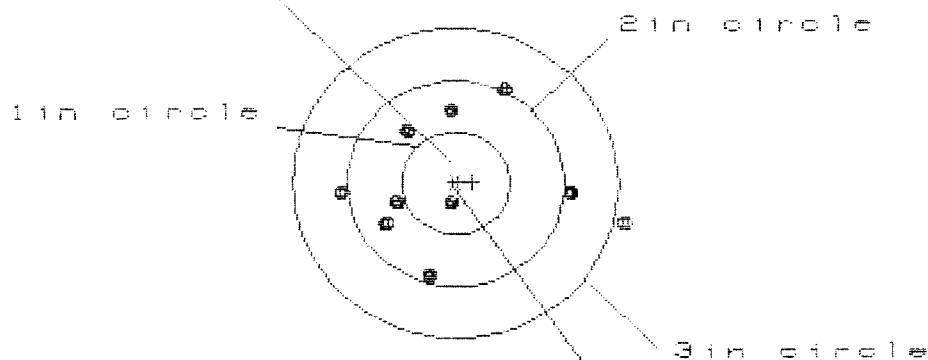
|                             |   |        |        |        |
|-----------------------------|---|--------|--------|--------|
| PATTERN #                   | : | 1      |        |        |
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.042  | .862   | .857   |
| MINIMUM X                   | : | -1.618 | -1.157 | -1.049 |
| MAXIMUM Y                   | : | 1.040  | 1.026  | .629   |
| MINIMUM Y                   | : | -.579  | -.593  | -.465  |
| CENTROID X                  | : | -.009  | .171   | .063   |
| CENTROID Y                  | : | .027   | .041   | -.087  |
| POA TO CENTROID in.         | : | .028   | .176   | .107   |
| MIN RADIUS                  | : | .235   | .071   | .180   |
| MEAN RADIUS                 | : | .799   | .696   | .590   |
| MAX RADIUS                  | : | 1.623  | 1.340  | 1.093  |
| HORIZONTAL SPREAD           | : | 2.660  | 2.019  | 1.905  |
| VERTICAL SPREAD             | : | 1.619  | 1.619  | 1.094  |
| EXTREME SPREAD              | : | 2.986  | 2.492  | 2.123  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 3      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 6      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |        |

15 Nov 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/06523306

# CENTERFIRE PATTERNS # 2

POB



# OF SHOTS- 10

# IN CIR

1in = 1

2in = 6

3in = 9

HS= 2.607

VS= 1.781

GS= 2.616

CENTROID #

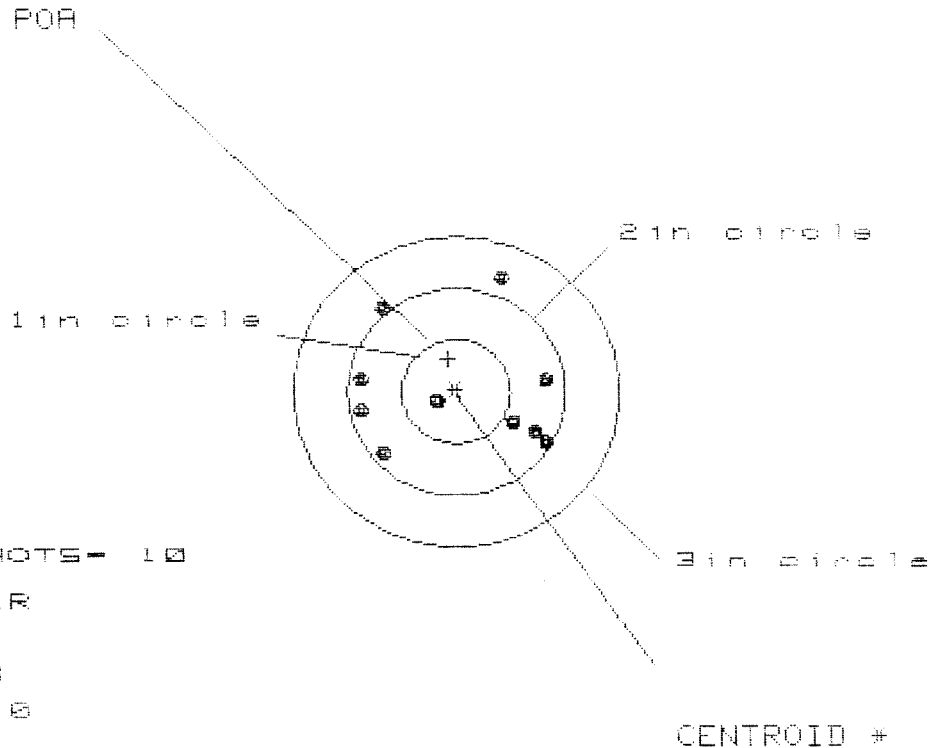
|                             |   |        |       |       |
|-----------------------------|---|--------|-------|-------|
| PATTERN #                   | : | 2      |       |       |
| SHOTS (BEST OF)             | : | 10     | 9     | 8     |
| MAXIMUM X                   | : | 1.535  | 1.244 | .740  |
| MINIMUM X                   | : | -1.072 | -.901 | -.745 |
| MAXIMUM Y                   | : | .942   | .904  | .885  |
| MINIMUM Y                   | : | -.839  | -.877 | -.896 |
| CENTROID X                  | : | -.154  | -.324 | -.480 |
| CENTROID Y                  | : | -.012  | .026  | .045  |
| POB TO CENTROID in.         | : | .154   | .325  | .482  |
| MIN RADIUS                  | : | .153   | .237  | .359  |
| MEAN RADIUS                 | : | .859   | .752  | .668  |
| MAX RADIUS                  | : | 1.574  | 1.253 | 1.154 |
| HORIZONTAL SPREAD           | : | 2.607  | 2.145 | 1.485 |
| VERTICAL SPREAD             | : | 1.781  | 1.781 | 1.781 |
| EXTREME SPREAD              | : | 2.616  | 2.145 | 1.901 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 1     |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 6     |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 9     |       |



15 Nov 1988

FILE:/PATTERNING/CENTERFIRE\_PATT/C8523306

# CENTERFIRE PATTERNS # 3



# OF SHOTS- 10

# IN CIR

1in = 1

2in = 6

3in = 10

HS= 1.763

VS= 1.660

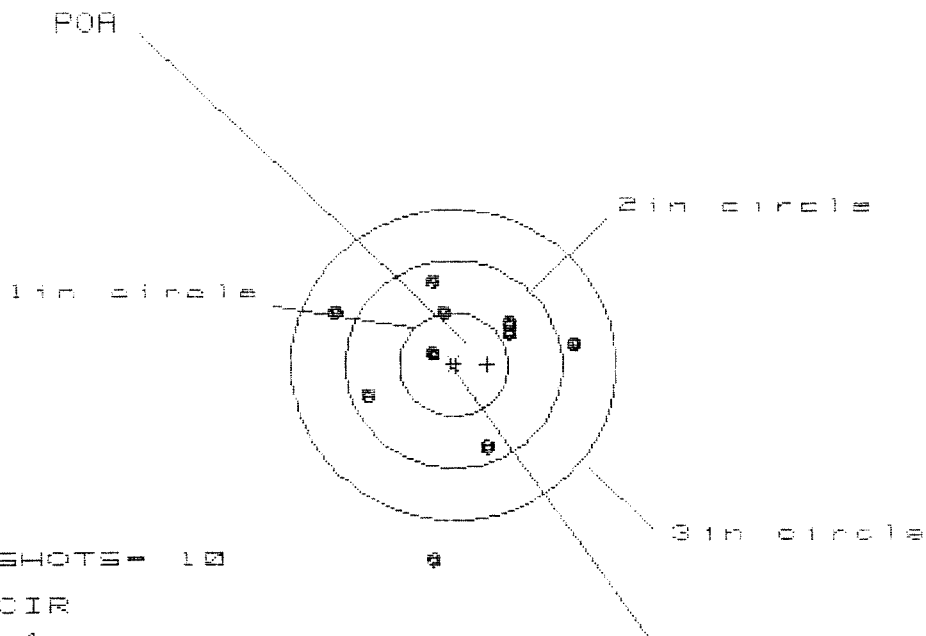
GS= 1.950

| PATTERN #                   | 3     |
|-----------------------------|-------|
| SHOTS (BEST OF)             | 10    |
| MAXIMUM X                   | .869  |
| MINIMUM X                   | -.894 |
| MAXIMUM Y                   | 1.070 |
| MINIMUM Y                   | -.590 |
| CENTROID X                  | .076  |
| CENTROID Y                  | -.316 |
| POA TO CENTROID in.         | .325  |
| MIN RADIUS                  | .207  |
| MEAN RADIUS                 | .828  |
| MAX RADIUS                  | 1.139 |
| HORIZONTAL SPREAD           | 1.763 |
| VERTICAL SPREAD             | 1.660 |
| EXTREME SPREAD              | 1.950 |
| NUMBER IN ONE INCH CIRCLE   | = 1   |
| NUMBER IN TWO INCH CIRCLE   | = 6   |
| NUMBER IN THREE INCH CIRCLE | = 10  |

15 Nov 1990

FILE:/PATTERNING/CENTERFIRE\_PATT/C8523306

# CENTERFIRE PATTERNS # 4



# OF SHOTS- 10

# IN CIR

1 in = 1

2 in = 7

3 in = 9

HS= 2.268

VS= 2.656

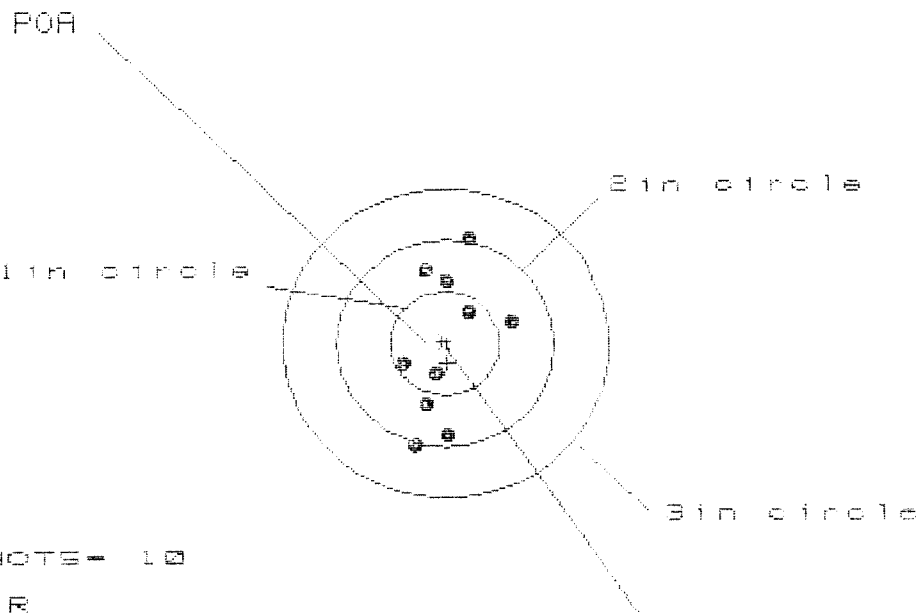
GS= 2.656

| PATTERN #                   | : | 4      |        |       |
|-----------------------------|---|--------|--------|-------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | 1.151  | 1.133  | .992  |
| MINIMUM X                   | : | -1.117 | -1.135 | -.946 |
| MAXIMUM Y                   | : | .791   | .583   | .617  |
| MINIMUM Y                   | : | -1.865 | -.973  | -.939 |
| CENTROID X                  | : | -.310  | -.292  | -.151 |
| CENTROID Y                  | : | -.008  | .200   | .166  |
| POA TO CENTROID in.         | : | .310   | .354   | .324  |
| MIN RADIUS                  | : | .196   | .175   | .304  |
| MEAN RADIUS                 | : | .869   | .709   | .648  |
| MAX RADIUS                  | : | 1.872  | 1.166  | 1.034 |
| HORIZONTAL SPREAD           | : | 2.268  | 2.268  | 1.938 |
| VERTICAL SPREAD             | : | 2.656  | 1.556  | 1.556 |
| EXTREME SPREAD              | : | 2.656  | 2.282  | 1.998 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 1      |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 7      |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |       |

15 Nov 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/08523388

# CENTERFIRE PATTERNS # 5



# OF SHOTS- 10

# IN CIR

1in = 3

2in = 8

3in = 10

HSI = 1.033

VS = 2.016

GS = 2.078

CENTROID #

| PATTERN #                   | : | 5     |       |       |
|-----------------------------|---|-------|-------|-------|
| SHOTS (BEST OF)             | : | 10    | 9     | 8     |
| MAXIMUM X                   | : | .601  | .623  | .589  |
| MINIMUM X                   | : | -.432 | -.410 | -.444 |
| MAXIMUM Y                   | : | 1.028 | .874  | .764  |
| MINIMUM Y                   | : | -.988 | -.874 | -.842 |
| CENTROID X                  | : | -.015 | -.037 | -.003 |
| CENTROID Y                  | : | .186  | .072  | .182  |
| POA TO CENTROID in.         | : | .187  | .081  | .182  |
| MIN RADIUS                  | : | .292  | .176  | .289  |
| MEAN RADIUS                 | : | .675  | .621  | .584  |
| MAX RADIUS                  | : | 1.048 | .917  | .842  |
| HORIZONTAL SPREAD           | : | 1.033 | 1.033 | 1.033 |
| VERTICAL SPREAD             | : | 2.016 | 1.748 | 1.606 |
| EXTREME SPREAD              | : | 2.078 | 1.755 | 1.617 |
| NUMBER IN ONE INCH CIRCLE   | = |       | 3     |       |
| NUMBER IN TWO INCH CIRCLE   | = |       | 8     |       |
| NUMBER IN THREE INCH CIRCLE | = |       | 10    |       |