

C6225301

MODEL 700<sup>TM</sup> M24

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

Action

Barrel Length

Capacity

Order No. **5716**

\* Includes 1 in chamber.

*Remington*

111  
5000 10 12 1997

**Remington**<sup>®</sup>



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

**MODEL 700<sup>TM</sup> H24**

SERIAL NO.  
**C6225301**

ORDER NO.  
**5716**

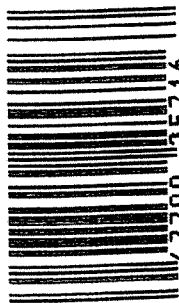
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MADE IN ILION, N.Y., U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



5716 C6225301

UPC



0 47700 25716 7

RC-32  
Replace

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225301

| OP. #     | OP. NAME                                                 | READINGS                            | DATE     | INIT |
|-----------|----------------------------------------------------------|-------------------------------------|----------|------|
| 575 & 580 | Assemble Action and Stock                                | <div>QUALITY</div> <div>AUDIT</div> | 12-20 89 | RW   |
| 600       | Proof                                                    |                                     | 12-20 89 | A    |
| 607       | Check Headspace                                          |                                     | 12-20 89 | A    |
| 610       | Dis-assemble Gun                                         |                                     | 12-20 89 | RW   |
| 612       | Magnaflux Barrel Action                                  |                                     | 1-5-90   | KCR  |
|           | Magnaflux Bolt                                           |                                     | 1-5-90   |      |
| 615       | Rollmark Caliber                                         |                                     | 1/8/90   | GS   |
| 617       | Drill and Tap Sight Holes                                |                                     | 1/10/90  | FB   |
| 618       | Polish Barrel RB                                         |                                     | 1/10/90  | WB   |
| 620       | Apply Coatings (Barrel Action)                           |                                     | 1-15-90  | PA   |
|           | Apply Coating (Bolt)                                     |                                     |          | P    |
| 625       | Final Assembly                                           |                                     | 2/1/90   | WB   |
|           | A) Clean inside of Bolt Assembly                         |                                     | 1/16/90  |      |
|           | B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head |                                     | 1/16/90  | RW   |
|           | C) Inspect Ejector Hole for Chamfer                      |                                     | 1/16/90  | RW   |
|           | D) Oil Firing Pin Ass'y                                  |                                     | 1/16/90  | RW   |
|           | E) Adjust Trigger Pull to Min Setting and Stake          |                                     | 1/16/90  | AS   |

| op. #        | OP. NAME                                                    | READINGS |      |       | DATE      | INIT |
|--------------|-------------------------------------------------------------|----------|------|-------|-----------|------|
| 625<br>cont. | F) Safety On Force                                          | 5        | 5    | 5     | 1-16-90   | JL   |
|              | G) Safety Off Force                                         | 5        | 3    | 3     | 1-16-90   | JL   |
|              | H) Trigger Pull Test & Retainability                        |          |      |       | 16 MAR 90 | JL   |
|              | I) Firing Pin Indent                                        | .020     | .021 | .0205 | 1-16-90   | JL   |
|              | J) Assemble Stock                                           |          |      |       | 3/15/90   | RW   |
|              | K) Assemble Swivel Studs                                    |          |      |       | 16 MAR 90 | JL   |
|              | L) Attach Front and Rear Sight Assemblies                   |          |      |       | 3/15/90   | RW   |
|              | M) Iron Sight Alignment                                     |          |      |       | 3/15/90   | RW   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |      |       | 3/15/90   | RW   |
|              | O) Attach Scope to Rifle                                    |          |      |       | 15 MAR 90 | JL   |
|              | P) Detach & Attach Scope 20 Times                           |          |      |       | 15 MAR 90 | JL   |
| 640          | Gallery Target & Test                                       |          |      |       | 3-15-90   | A    |
|              | A) Time                                                     |          |      |       | "         | A    |
|              | B) Malfunctions                                             |          |      |       | "         | A    |
|              | C) Pierced Primers                                          |          |      |       | "         | A    |
|              | D) Optical Clarity of Scope                                 |          |      |       | "         | A    |
| 645          | Inspect for Live Ammo                                       |          |      |       | 3-15-90   | A    |
| 655          | Final Inspection                                            |          |      |       | 16 MAR 90 | JL   |
|              | A) Headspace                                                |          |      |       | 16 MAR 90 | JL   |
|              | B) Trigger Pull                                             | 278      | 280  | 279   | 16 MAR 90 | JL   |
|              | C) Function                                                 |          |      |       | 16 MAR 90 | JL   |
| 660          | Pack                                                        |          |      |       | 19 MAR 90 | JL   |

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6225301

DATE 16 Jan 90

TESTER JES

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |       | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|-------|------------------------------------------------------------------------|
| PULL #1 | 2.45             | 2.42                     | 2.52                           | 2.78  | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.44             | 2.53                     | 2.51                           | 2.80  |                                                                        |
| PULL #3 | 2.45             | 2.31                     | 2.49                           | 2.79  |                                                                        |
| PULL #4 | 2.34             | 2.47                     | 2.49                           | 2.77  |                                                                        |
| PULL #5 | 2.49             | 2.33                     | 2.58                           | 2.79  |                                                                        |
| TOTAL   | 1217             | 1206                     | 1259                           | 1391  |                                                                        |
| AVG.    | 2.434            | 2.412                    | 2.518                          | 2.782 |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.02             | 2.86                     |  |          |
| PULL #2 | 2.87             | 2.90                     |  |          |
| PULL #3 | 2.99             | 2.89                     |  |          |
| PULL #4 | 3.05             | 2.89                     |  |          |
| PULL #5 | 2.91             | 2.85                     |  |          |
| TOTAL   | 1484             | 1439                     |  |          |
| AVG.    | 2.968            | 2.878                    |  |          |

|         | 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 | 3.96             | 3.89                     |                                | 3.90                                 |
| PULL #2 | 3.94             | 3.89                     |                                | 4.08                                 |
| PULL #3 | 3.97             | 3.87                     |                                | 3.84                                 |
| PULL #4 | 3.95             | 3.81                     |                                | 4.09                                 |
| PULL #5 | 3.93             | 3.84                     |                                | 4.10                                 |
| TOTAL   | 1975             | 1930                     |                                | 2001                                 |
| AVG.    | 3.95             | 3.86                     |                                | 4.002                                |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6225301  
15 Mar 1990

CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| 0 TO | 1 | .388171 |
| 1 TO | 2 | .437321 |
| 1 TO | 3 | .402826 |
| 1 TO | 4 | .41389  |
| 1 TO | 5 | .839849 |

$z_j^5$  <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .08  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0754  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .109933  
THE AMR FOR THIS RIFLE IS: .9234

15 Mar 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/C8225381

# CENTERFIRE PATTERNS

# 1

POA

1in circle

2in circle

2in circle

# OF SHOTS = 10

# IN CIR

1in = 1

2in = 6

3in = 10

HS = 1.826

VS = 1.972

GS = 2.281

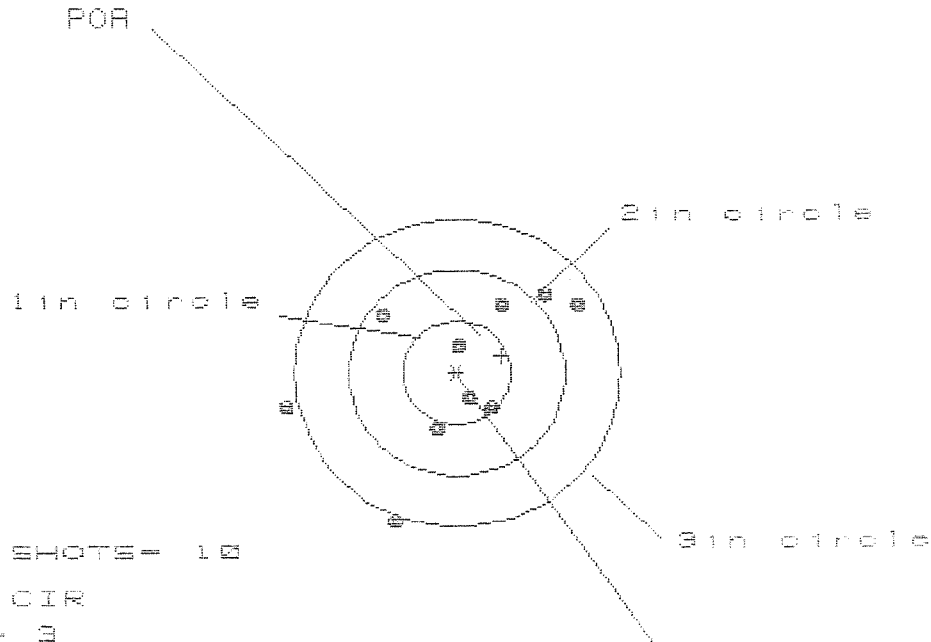
CENTROID #

| PATTERN #                     | 1     | 2     | 3     |
|-------------------------------|-------|-------|-------|
| SHOTS (BEST OF)               | 10    | 9     | 8     |
| MAXIMUM X                     | 1.049 | .963  | .687  |
| MINIMUM X                     | -.777 | -.822 | -.782 |
| MAXIMUM Y                     | 1.013 | .906  | .848  |
| MINIMUM Y                     | -.959 | -.924 | -.982 |
| CENTROID X                    | -.041 | .045  | -.075 |
| CENTROID Y                    | -.386 | -.279 | -.221 |
| POA TO CENTROID in.           | .388  | .283  | .233  |
| MIN RADIUS                    | .192  | .243  | .343  |
| MEAN RADIUS                   | .848  | .797  | .764  |
| MAX RADIUS                    | 1.234 | 1.116 | 1.105 |
| HORIZONTAL SPREAD             | 1.826 | 1.785 | 1.389 |
| VERTICAL SPREAD               | 1.972 | 1.830 | 1.830 |
| EXTREME SPREAD                | 2.281 | 2.024 | 2.024 |
| NUMBER IN ONE INCH CIRCLE =   | 1     |       |       |
| NUMBER IN TWO INCH CIRCLE =   | 6     |       |       |
| NUMBER IN THREE INCH CIRCLE = | 10    |       |       |

15 Mar 1980

FILE:/PATTERNING/CENTERFIRE\_PATT/CS225381

# CENTERFIRE PATTERNS # 2



# OF SHOTS= 10

# IN CIR

1 in = 3

2 in = 6

3 in = 8

HS= 2.713

VS= 2.113

GS= 2.904

CENTROID #

| PATTERN #                     | 2      | 9      | 8     |
|-------------------------------|--------|--------|-------|
| SHOTS (BEST OF)               | 10     | 9      | 8     |
| MAXIMUM X                     | 1.131  | .955   | .861  |
| MINIMUM X                     | -1.582 | -.816  | -.910 |
| MAXIMUM Y                     | .716   | .678   | .499  |
| MINIMUM Y                     | -1.397 | -1.435 | -.770 |
| CENTROID X                    | -.416  | -.240  | -.146 |
| CENTROID Y                    | -.161  | -.123  | .056  |
| POA TO CENTROID in.           | .446   | .270   | .156  |
| MIN RADIUS                    | .293   | .286   | .240  |
| MEAN RADIUS                   | .885   | .783   | .669  |
| MAX RADIUS                    | 1.618  | 1.620  | .987  |
| HORIZONTAL SPREAD             | 2.713  | 1.771  | 1.771 |
| VERTICAL SPREAD               | 2.113  | 2.113  | 1.269 |
| EXTREME SPREAD                | 2.904  | 2.705  | 1.819 |
| NUMBER IN ONE INCH CIRCLE =   | 3      |        |       |
| NUMBER IN TWO INCH CIRCLE =   | 6      |        |       |
| NUMBER IN THREE INCH CIRCLE = | 8      |        |       |

15 Mar 1999

FILE:/PATTERNING/CENTERFIRE\_PATT/C8225301

# CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID \*

# OF SHOTS = 10

# IN CIR

1in = 0

2in = 6

3in = 7

HS = 2.055

VS = 3.112

GS = 3.365

PATTERN #

3

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.862

.729

.818

MINIMUM X

-1.193

-.971

-.882

MAXIMUM Y

1.619

1.477

1.272

MINIMUM Y

-1.492

-1.635

-1.196

CENTROID X

.197

.330

.241

CENTROID Y

-.061

.082

.287

POA TO CENTROID in.

.206

.340

.375

MIN RADIUS

.784

.623

.496

MEAN RADIUS

1.144

1.044

.927

MAX RADIUS

1.754

1.781

1.362

HORIZONTAL SPREAD

2.055

1.700

1.700

VERTICAL SPREAD

3.112

3.112

2.468

EXTREME SPREAD

3.365

3.365

2.469

NUMBER IN ONE INCH CIRCLE =

0

NUMBER IN TWO INCH CIRCLE =

6

NUMBER IN THREE INCH CIRCLE =

7

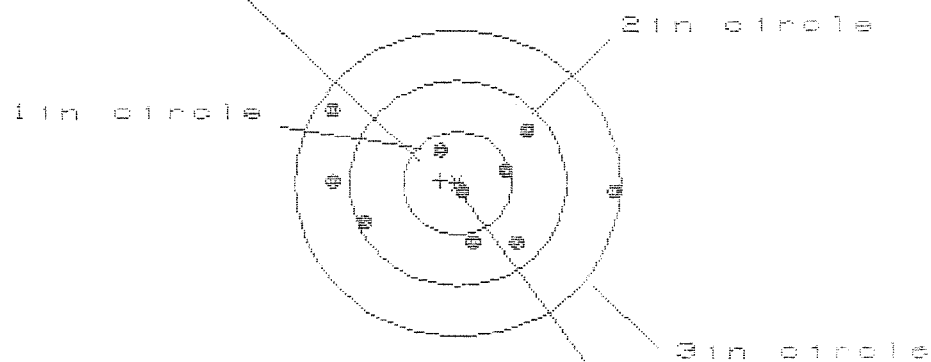
15 Mar 1998

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# CENTERFIRE PATTERNS

# 4

POA



# OF SHOTS - 10

# IN CIR

1 in = 3

2 in = 7

3 in = 10

HS = 2.521

VS = 1.384

GS = 2.731

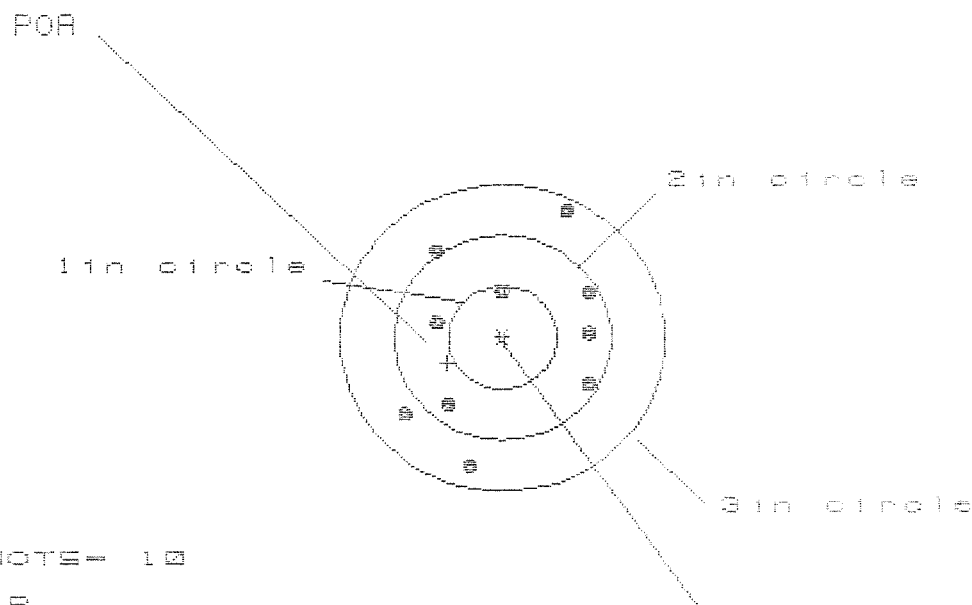
CENTROID \*

| PATTERN #                     | 4      |
|-------------------------------|--------|
| SHOTS (BEST OF)               | 10     |
| MAXIMUM X                     | 1.475  |
| MINIMUM X                     | -1.146 |
| MAXIMUM Y                     | .771   |
| MINIMUM Y                     | -.613  |
| CENTROID X                    | .156   |
| CENTROID Y                    | -.022  |
| POA TO CENTROID in.           | .158   |
| MIN RADIUS                    | .068   |
| MEAN RADIUS                   | .798   |
| MAX RADIUS                    | 1.477  |
| HORIZONTAL SPREAD             | 2.621  |
| VERTICAL SPREAD               | 1.384  |
| EXTREME SPREAD                | 2.731  |
| NUMBER IN ONE INCH CIRCLE =   | 3      |
| NUMBER IN TWO INCH CIRCLE =   | 7      |
| NUMBER IN THREE INCH CIRCLE = | 10     |

15 Mar 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/C8225801

# CENTERFIRE PATTERNS # 5



# OF SHOTS = 10

# IN CIR

1in = 1

2in = 6

3in = 10

HS = 1.777

VS = 2.440

GS = 2.617

CENTROID \*

| PATTERN #                     | 1      | 5      | 8     |
|-------------------------------|--------|--------|-------|
| SHOTS (BEST OF)               | 10     | 9      | 8     |
| MAXIMUM X                     | .832   | .901   | .869  |
| MINIMUM X                     | -.941  | -.872  | -.904 |
| MAXIMUM Y                     | 1.202  | .966   | .828  |
| MINIMUM Y                     | -1.238 | -1.105 | -.716 |
| CENTROID X                    | .504   | .435   | .467  |
| CENTROID Y                    | .253   | .119   | .257  |
| POA TO CENTROID in.           | .564   | .451   | .593  |
| MIN RADIUS                    | .494   | .602   | .489  |
| MEAN RADIUS                   | .942   | .893   | .847  |
| MAX RADIUS                    | 1.353  | 1.134  | 1.153 |
| HORIZONTAL SPREAD             | 1.773  | 1.773  | 1.773 |
| VERTICAL SPREAD               | 2.440  | 2.071  | 1.544 |
| EXTREME SPREAD                | 2.617  | 2.130  | 2.130 |
| NUMBER IN ONE INCH CIRCLE =   | 1      | 1      | 1     |
| NUMBER IN TWO INCH CIRCLE =   | 6      | 6      | 6     |
| NUMBER IN THREE INCH CIRCLE = | 10     | 10     | 10    |