

C6594563

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

\*Includes 1 in chamber.

*Remington*™

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

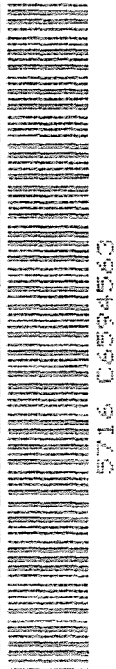
**MODEL 700<sup>™</sup> H24**

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

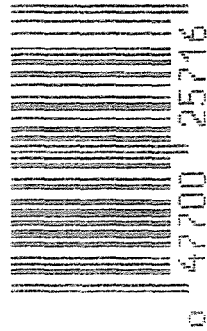
VERY IMPORTANT:  
 Instruction Book  
 enclosed to assure  
 safe use of this  
 firearm.

**SERIAL NO.**  
 C6594563

**ORDER NO.**  
 5716



LPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6594563

| OP. #        | OP. NAME                                                       | READINGS | DATE     | INIT      |
|--------------|----------------------------------------------------------------|----------|----------|-----------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   |          | 10/30/90 | Kd        |
| 600          | Proof                                                          |          | 10/30/90 | Kd        |
| 607          | Check Headspace                                                |          | 10/30/90 | Kd        |
| 610          | Dis-assemble Gun                                               |          | 10/30/90 | Kd        |
| 612          | Magnaflux Barrel<br>Action                                     |          | 11/1/90  | KCR       |
|              | Magnaflux Bolt                                                 |          | 11/1/90  | KCR       |
| 615          | Rollmark Caliber                                               |          | 11/1/90  | GS        |
| 617          | Drill and Tap Sight Holes                                      |          | 11/6/90  | FB        |
| 618          | Polish Barrel <i>RB</i>                                        |          | 11/7/90  | WB        |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 11-26-90 | <i>JA</i> |
|              | Apply Coating (Bolt)                                           |          |          |           |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 12/28/90 | K.S.      |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 12/28/90 | K.S.      |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 12/28/90 | K.S.      |
|              | D) Oil Firing Pin Ass'y                                        |          | 12/28/90 | K.S.      |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 1-7-91   | D/H       |

| op. #        | OP. NAME                                                    | READINGS |      |      |      |      | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|------|------|------|------|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 3.75     | 3.75 | 3.50 |      |      | 1/2/91  | KF   |
|              | G) Safety Off Force                                         | 2.25     | 2.25 | 2.25 |      |      | 1/2/91  | KT   |
|              | H) Trigger Pull Test & Retainability                        |          |      |      |      |      | 1-7-91  | DH   |
|              | I) Firing Pin Indent                                        | .022     | .022 | .021 |      |      | 1/2/91  | KT   |
|              | J) Assemble Stock                                           |          |      |      |      |      | 1/15/91 | KF   |
|              | K) Assemble Swivel Studs                                    |          |      |      |      |      | 1-17-91 | JK   |
|              | L) Attach Front and Rear Sight Assemblies                   |          |      |      |      |      | 1/15/91 | KF   |
|              | M) Iron Sight Alignment                                     |          |      |      |      |      | 1/15/91 | KF   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |      |      |      |      | 1/15/91 | KF   |
|              | O) Attach Scope to Rifle                                    |          |      |      |      |      | 1/15/91 | KF   |
|              | P) Detach & Attach Scope 20 Times                           |          |      |      |      |      | 1/15/91 | KF   |
| 640          | Gallery Target & Test                                       |          |      |      |      |      | 1-16-91 | DH   |
|              | A) Time                                                     |          |      |      |      |      | 1-16-91 | DH   |
|              | B) Malfunctions                                             |          |      |      |      |      | 1-16-91 | DH   |
|              | C) Pierced Primers                                          |          |      |      |      |      | 1-16-91 | DH   |
|              | D) Optical Clarity of Scope                                 |          |      |      |      |      | 1-16-91 | DH   |
| 645          | Inspect for Live Ammo                                       |          |      |      |      |      | 1-16-91 | DH   |
| 655          | Final Inspection                                            |          |      |      |      |      |         |      |
|              | A) Headspace                                                |          |      |      |      |      | 1-17-91 | JK   |
|              | B) Trigger Pull                                             | 2.36     | 2.36 | 2.34 | 2.30 | 2.33 | 1-17-91 | JK   |
|              | C) Function                                                 |          |      |      |      |      | 1-17-91 | JK   |
| 660          | Pack                                                        |          |      |      |      |      | 3-19-91 | NF   |

SWS TRIGGER PULL TEST

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

SERIAL NO. CG594563

DATE 1-4-91

TESTER DH

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.57             | 2.47                     | 2.33                           | 2.36 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.52             | 2.24                     | 2.33                           | 2.36 |                                                                        |
| PULL #3 | 2.59             | 2.20                     | 2.06                           | 2.34 |                                                                        |
| PULL #4 | 2.59             | 2.28                     | 2.05                           | 2.30 |                                                                        |
| PULL #5 | 2.47             | 2.69                     | 2.25                           | 2.33 |                                                                        |
| TOTAL   | 12.74            | 11.88                    | 11.02                          |      |                                                                        |
| AVG.    | 2.54             | 2.37                     | 2.20                           |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.76             | 3.78                     |  |          |
| PULL #2 | 3.39             | 3.35                     |  |          |
| PULL #3 | 3.10             | 3.14                     |  |          |
| PULL #4 | 3.00             | 3.15                     |  |          |
| PULL #5 | 3.36             | 3.31                     |  |          |
| TOTAL   | 16.01            | 16.13                    |  |          |
| AVG.    | 3.20             | 3.22                     |  |          |

|         | 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 | 4.46             | 4.42                     |                                | 4.39                                 |
| PULL #2 | 4.61             | 4.43                     |                                | 4.23                                 |
| PULL #3 | 4.49             | 4.45                     |                                | 4.09                                 |
| PULL #4 | 4.41             | 4.44                     |                                | 4.38                                 |
| PULL #5 | 4.33             | 4.46                     |                                | 4.22                                 |
| TOTAL   | 22.30            | 22.20                    |                                | 21.31                                |
| AVG.    | 4.46             | 4.44                     |                                | 4.26                                 |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6594563  
17 Jan 1991

CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| 0 TO | 1 | .446992 |
| 1 TO | 2 | .331879 |
| 1 TO | 3 | .327674 |
| 1 TO | 4 | .645914 |
| 1 TO | 5 | .571347 |

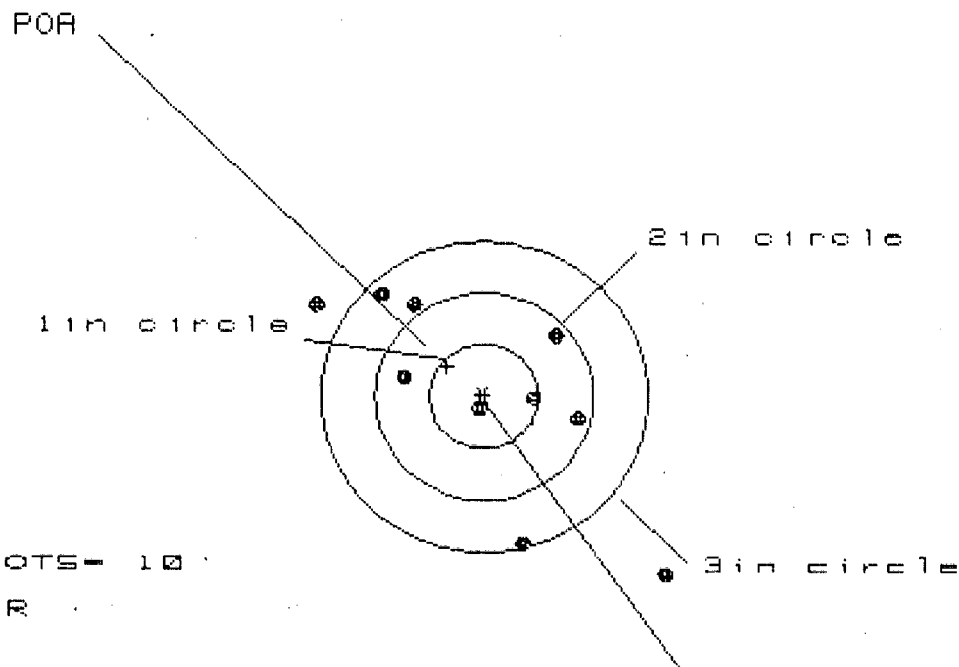
Sub 2 ←----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .207  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .017  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .207697  
  
THE AMR FOR THIS RIFLE IS: .9784

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FILE:/PATTERNING/CENTERFIRE\_PATT/C6594563

# CENTERFIRE PATTERNS # 1



# OF SHOTS- 10

# IN CIR

1in = 2

2in = 5

3in = 8

HS= 3.228

VS= 2.688

GS= 4.146

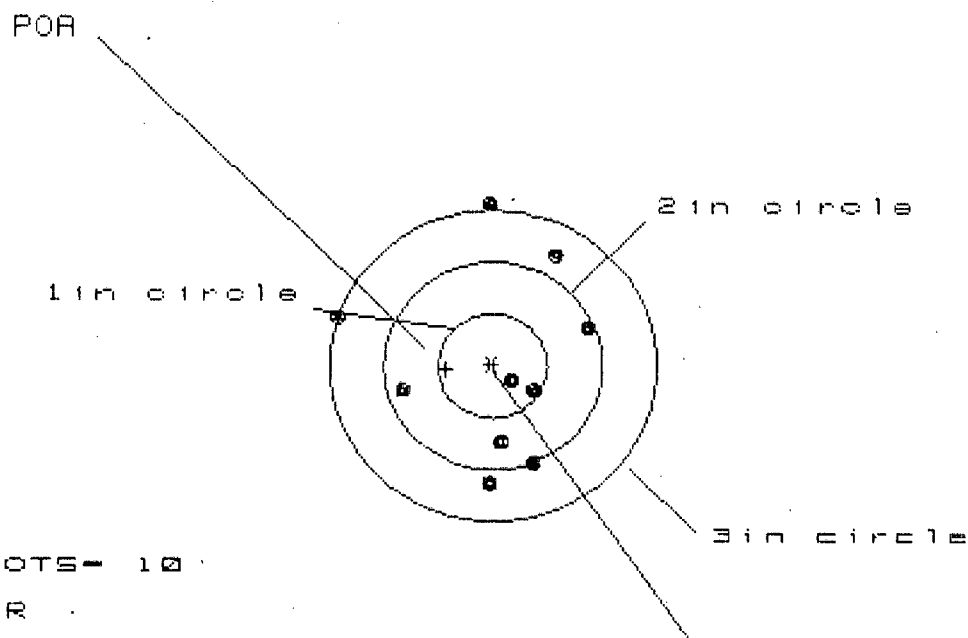
CENTROID #

|                               |   |        |        |        |
|-------------------------------|---|--------|--------|--------|
| PATTERN #                     | : | 1      |        |        |
| SHOTS (BEST OF)               | : | 10     | 9      | 8      |
| MAXIMUM X                     | : | 1.648  | 1.024  | .849   |
| MINIMUM X                     | : | -1.580 | -1.396 | -.925  |
| MAXIMUM Y                     | : | .941   | .747   | .830   |
| MINIMUM Y                     | : | -1.747 | -1.595 | -1.512 |
| CENTROID X                    | : | .341   | .157   | .332   |
| CENTROID Y                    | : | -.289  | -.095  | -.178  |
| POA TO CENTROID in.           | : | .447   | .184   | .377   |
| MIN RADIUS                    | : | .095   | .309   | .198   |
| MEAN RADIUS                   | : | 1.111  | .962   | .865   |
| MAX RADIUS                    | : | 2.402  | 1.690  | 1.560  |
| HORIZONTAL SPREAD             | : | 3.228  | 2.420  | 1.774  |
| VERTICAL SPREAD               | : | 2.688  | 2.342  | 2.342  |
| EXTREME SPREAD                | : | 4.146  | 2.985  | 2.683  |
| NUMBER IN ONE INCH CIRCLE =   |   |        | 2      |        |
| NUMBER IN TWO INCH CIRCLE =   |   |        | 5      |        |
| NUMBER IN THREE INCH CIRCLE = |   |        | 8      |        |

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# CENTERFIRE PATTERNS # 2



# OF SHOTS- 10

# IN CIR

1 in - 2

2 in - 5

3 in - 9

HS- 2.273

VS- 2.662

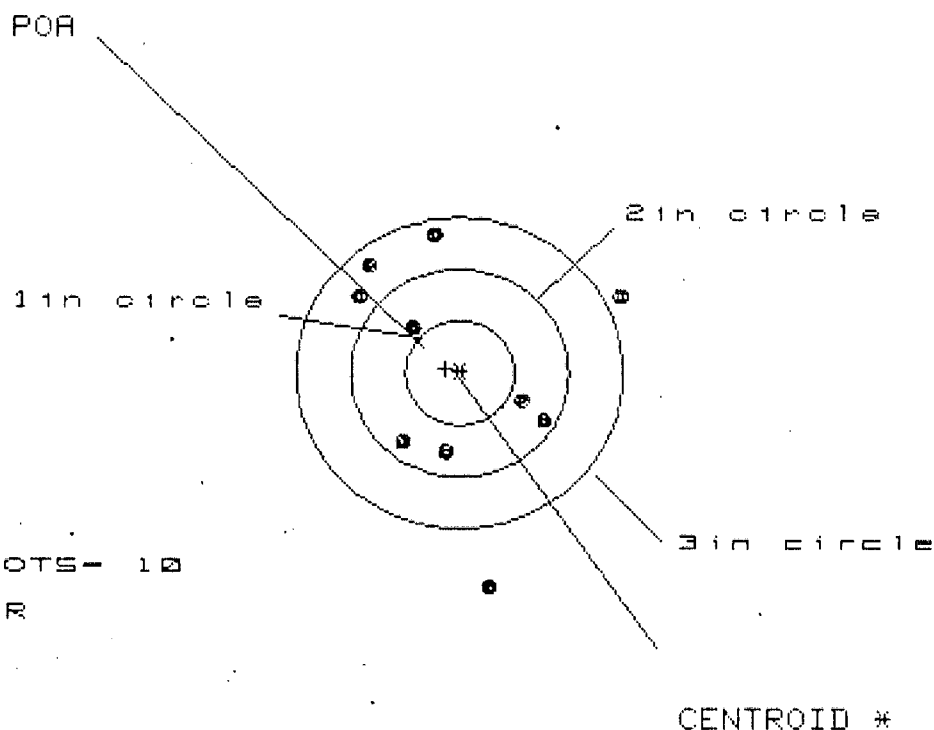
GS- 2.662

|                               |   |        |        |        |
|-------------------------------|---|--------|--------|--------|
| PATTERN #                     | : | 2      |        |        |
| SHOTS (BEST OF)               | : | 10     | 9      | 8      |
| MAXIMUM X                     | : | .848   | .844   | .665   |
| MINIMUM X                     | : | -1.425 | -1.429 | -1.010 |
| MAXIMUM Y                     | : | 1.578  | 1.218  | 1.298  |
| MINIMUM Y                     | : | -1.084 | -.909  | -.829  |
| CENTROID X                    | : | .429   | .433   | .612   |
| CENTROID Y                    | : | .031   | -.144  | -.224  |
| POA TO CENTROID in.           | : | .430   | .457   | .652   |
| MIN RADIUS                    | : | .192   | .159   | .141   |
| MEAN RADIUS                   | : | .951   | .841   | .705   |
| MAX RADIUS                    | : | 1.579  | 1.564  | 1.350  |
| HORIZONTAL SPREAD             | : | 2.273  | 2.273  | 1.675  |
| VERTICAL SPREAD               | : | 2.662  | 2.127  | 2.127  |
| EXTREME SPREAD                | : | 2.662  | 2.276  | 2.200  |
| NUMBER IN ONE INCH CIRCLE =   |   |        | 2      |        |
| NUMBER IN TWO INCH CIRCLE =   |   |        | 5      |        |
| NUMBER IN THREE INCH CIRCLE = |   |        | 9      |        |

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# CENTERFIRE PATTERNS # 3



# OF SHOTS- 10

# IN CIR

1in = 0

2in = 5

3in = 8

HS= 2.421

VS= 3.416

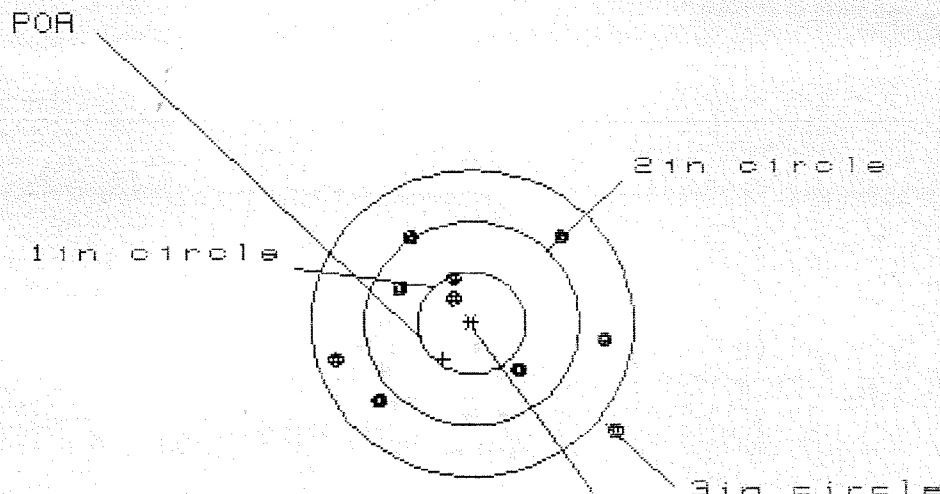
GS= 3.453

|                             |   |        |        |       |
|-----------------------------|---|--------|--------|-------|
| PATTERN #                   | : | 3      |        |       |
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | 1.456  | 1.492  | 1.039 |
| MINIMUM X                   | : | -.965  | -.929  | -.743 |
| MAXIMUM Y                   | : | 1.313  | 1.079  | 1.140 |
| MINIMUM Y                   | : | -2.103 | -1.029 | -.968 |
| CENTROID X                  | : | .128   | .092   | -.094 |
| CENTROID Y                  | : | -.040  | .194   | .133  |
| POA TO CENTROID in.         | : | .134   | .215   | .163  |
| MIN RADIUS                  | : | .585   | .454   | .326  |
| MEAN RADIUS                 | : | 1.151  | 1.031  | .936  |
| MAX RADIUS                  | : | 2.127  | 1.571  | 1.221 |
| HORIZONTAL SPREAD           | : | 2.421  | 2.421  | 1.782 |
| VERTICAL SPREAD             | : | 3.416  | 2.108  | 2.108 |
| EXTREME SPREAD              | : | 3.453  | 2.477  | 2.248 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 0      |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 5      |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 8      |       |

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# CENTERFIRE PATTERNS # 4



# OF SHOTS - 10

# IN CIR

1in = 1

2in = 4

3in = 9

HS = 2.662

VS = 1.845

GS = 2.745

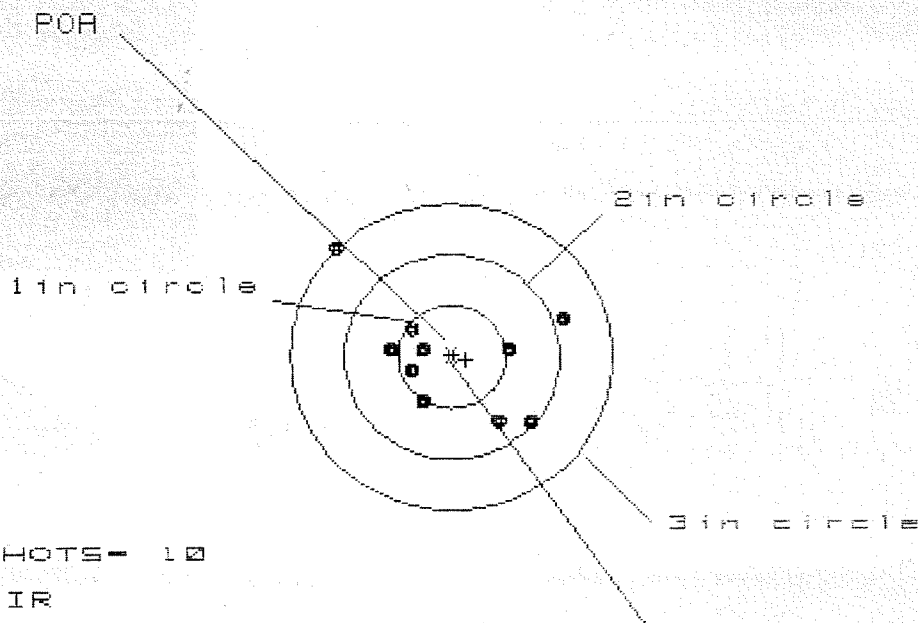
CENTROID \*

|                             |   |        |        |       |
|-----------------------------|---|--------|--------|-------|
| PATTERN #                   | : | 4      |        |       |
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | 1.362  | 1.407  | 1.264 |
| MINIMUM X                   | : | -1.300 | -1.149 | -.869 |
| MAXIMUM Y                   | : | .832   | .719   | .662  |
| MINIMUM Y                   | : | -1.013 | -.832  | -.889 |
| CENTROID X                  | : | .270   | .119   | .262  |
| CENTROID Y                  | : | .353   | .466   | .523  |
| POA TO CENTROID in.         | : | .445   | .481   | .585  |
| MIN RADIUS                  | : | .321   | .142   | .219  |
| MEAN RADIUS                 | : | .984   | .856   | .815  |
| MAX RADIUS                  | : | 1.697  | 1.430  | 1.301 |
| HORIZONTAL SPREAD           | : | 2.662  | 2.556  | 2.133 |
| VERTICAL SPREAD             | : | 1.845  | 1.551  | 1.551 |
| EXTREME SPREAD              | : | 2.745  | 2.564  | 2.314 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 1      |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 4      |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |       |

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# CENTERFIRE PATTERNS # 5



# OF SHOTS- 10

# IN CIR

1in = 4

2in = 8

3in = 10

HS= 2.060

VS= 1.731

GS= 2.438

CENTROID \*

| PATTERN #                     | 5      |       |       |
|-------------------------------|--------|-------|-------|
| SHOTS (BEST OF)               | 10     | 9     | 8     |
| MAXIMUM X                     | 1.034  | .920  | .692  |
| MINIMUM X                     | -1.026 | -.655 | -.540 |
| MAXIMUM Y                     | 1.068  | .444  | .439  |
| MINIMUM Y                     | -.663  | -.545 | -.489 |
| CENTROID X                    | -.133  | -.019 | -.134 |
| CENTROID Y                    | .030   | -.088 | -.144 |
| POA TO CENTROID in.           | .136   | .090  | .197  |
| MIN RADIUS                    | .253   | .411  | .330  |
| MEAN RADIUS                   | .695   | .612  | .535  |
| MAX RADIUS                    | 1.481  | 1.022 | .847  |
| HORIZONTAL SPREAD             | 2.060  | 1.575 | 1.232 |
| VERTICAL SPREAD               | 1.731  | .989  | .928  |
| EXTREME SPREAD                | 2.438  | 1.603 | 1.419 |
| NUMBER IN ONE INCH CIRCLE =   |        | 4     |       |
| NUMBER IN TWO INCH CIRCLE =   |        | 8     |       |
| NUMBER IN THREE INCH CIRCLE = |        | 10    |       |