

C6587565

MODEL 700™ M24

Model **SWS**™

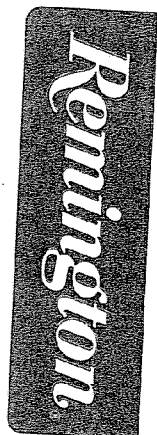
Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



No. 2-152-51

HASTINGS, MN
CHICAGO, ILL.
CINCINNATI, OH

Remington®

MODEL 700™ H24

DU PONT
REG. U.S. PAT. & TM. OFF.

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

SERIAL NO.
C6587565

ORDER NO.
5716

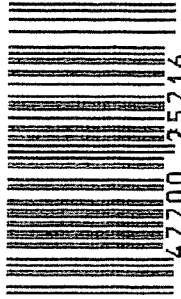
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada. Marque Deposee.

Ø1



5716 C6587565

UPC



0 47700 25716 7

INTERCHANGEABILITY M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6587565

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY ACBIT	10/19/90	KA
600	Proof		10/19/90	KA
607	Check Headspace		10/19/90	KA
610	Dis-assemble Gun		10/19/90	KA
612	Magnaflux Barrel Action		10/22/90	KR
	Magnaflux Bolt		10/22/90	KR
615	Rollmark Caliber		10/22/90	GB
617	Drill and Tap Sight Holes		10/23/90	KB
618	Polish Barrel <i>KB</i>		10/24/90	KB
620	Apply Coatings (Barrel Action)		11-7-90	TSA
	Apply Coating (Bolt)			
625	Final Assembly		11/30/90	KS
	A) Clean inside of Bolt Assembly		11/30/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/30/90	KS
	C) Inspect Ejector Hole for Chamfer		11/30/90	KS
	D) Oil Firing Pin Ass'y		11/30/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		12/1/90	SM

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/2	5 1/2	5 1/2			12/3/90	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			12/3/90	WB
	H) Trigger Pull Test & Retainability						12-1-90	JH
	I) Firing Pin Indent	.0225	.0225	.0225			12/3/90	WB
	J) Assemble Stock						12/1/90	KS
	K) Assemble Swivel Studs						12-4-90	JH
	L) Attach Front and Rear Sight Assemblies						12/1/90	KS
	M) Iron Sight Alignment						12/1/90	KS
	N) Detach Front & Rear Sights & place in numbered container						12/1/90	KS
	O) Attach Scope to Rifle						12/1/90	KS
	P) Detach & Attach Scope 20 Times						12/1/90	KS
640	Gallery Target & Test						12/3/90	VF
	A) Time						"	VF
	B) Malfunctions						"	VF
	C) Pierced Primers						"	VF
	D) Optical Clarity of Scope						12/3/90	VF
645	Inspect for Live Ammo						12/3/90	VF
655	Final Inspection							
	A) Headspace						12-4-90	JH
	B) Trigger Pull	2.77	2.67	2.61	2.49	2.53	12-4-90	JH
	C) Function						12-4-90	JH
660	Pack						12-19-90	DH

SWS TRIGGER PULL TEST

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

SERIAL NO. C6587565
DATE 12-1-90
TESTER 84

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.22	2.22	2.77	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.45	2.22	2.31	2.67	
PULL #3	2.50	2.24	2.24	2.61	
PULL #4	2.48	2.28	2.12	2.49	
PULL #5	2.26	2.23	2.38	2.53	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.40	3.48		
PULL #2	3.39	3.14		
PULL #3	3.41	3.17		
PULL #4	3.41	3.17		
PULL #5	3.40	3.20		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.43	4.26		4.48
PULL #2	4.31	4.32		4.18
PULL #3	4.34	4.44		4.29
PULL #4	4.35	4.32		4.48
PULL #5	4.16	4.38		4.40
TOTAL				
AVG.				

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587565
12 Dec 1990

CENTROIDAL DISTANCES

0 TO 1	.137004
1 TO 2	.152846
1 TO 3	.218874
1 TO 4	.0532541
1 TO 5	.058

✂ <----POA

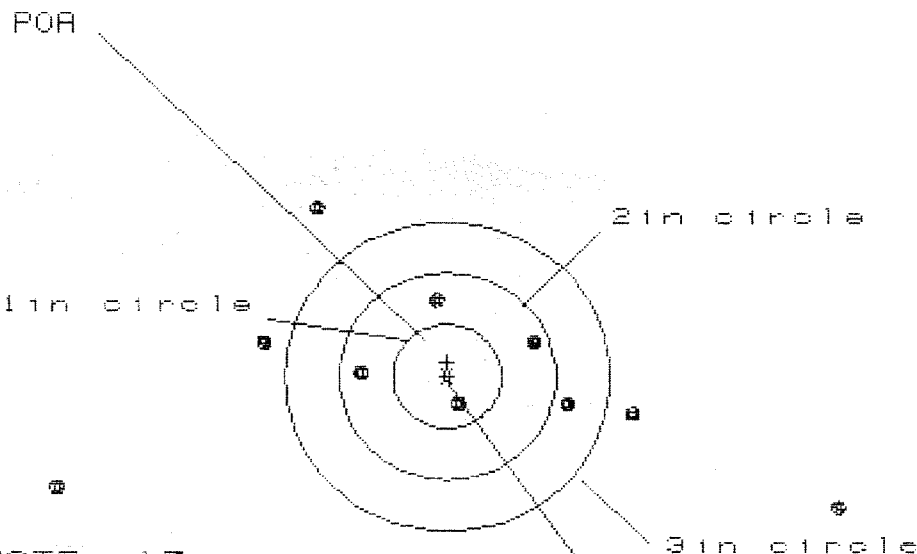
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0454
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0966
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .106737

THE AMR FOR THIS RIFLE IS: 1.273

12 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587585

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 5

HS= 7.246

VS= 2.941

GS= 7.250

CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	3.639	2.124	1.724
MINIMUM X	:	-3.607	-3.203	-1.694
MAXIMUM Y	:	1.653	1.510	1.363
MINIMUM Y	:	-1.288	-1.180	-1.005
CENTROID X	:	-.001	-.405	-.005
CENTROID Y	:	-.137	.006	.153
POA TO CENTROID in.	:	.137	.405	.153
MIN RADIUS	:	.279	.447	.441
MEAN RADIUS	:	1.704	1.467	1.161
MAX RADIUS	:	3.860	3.413	1.827
HORIZONTAL SPREAD	:	7.246	5.327	3.418
VERTICAL SPREAD	:	2.941	2.690	1.968
EXTREME SPREAD	:	7.250	5.376	3.533
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		5	

12 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C9587585

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS - 10

IN CIR

1in = 1

2in = 4

3in = 8

HS = 2.413

VS = 3.686

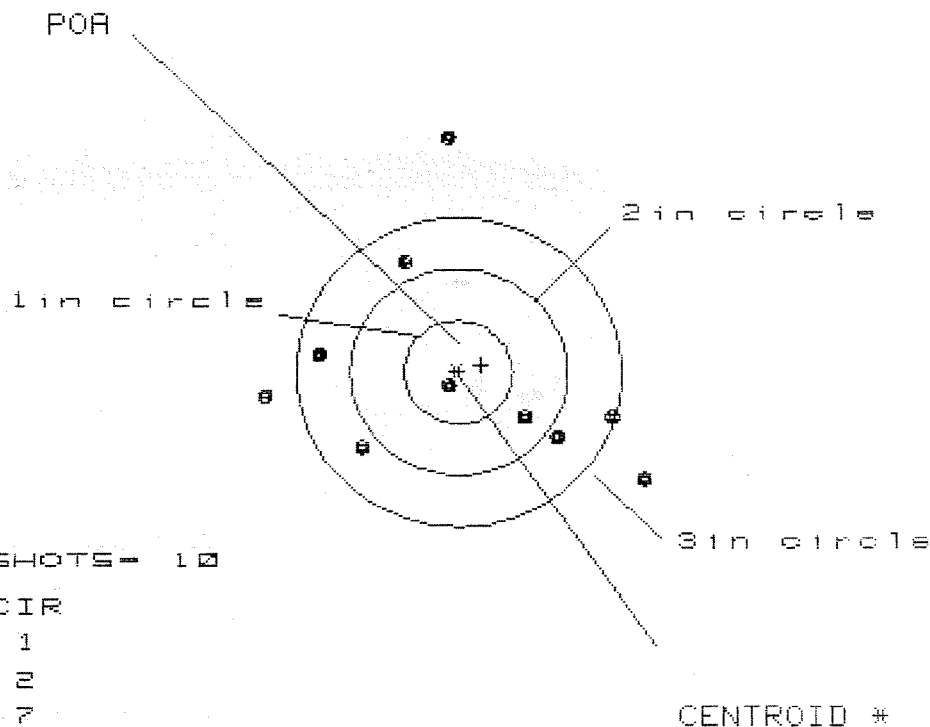
GS = 3.752

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.008	1.043	1.003
MINIMUM X	:	-1.405	-1.370	-1.240
MAXIMUM Y	:	1.288	1.022	.820
MINIMUM Y	:	-2.398	-1.461	-1.333
CENTROID X	:	.058	.023	-.107
CENTROID Y	:	.004	.270	.142
POA TO CENTROID in.	:	.058	.271	.178
MIN RADIUS	:	.480	.215	.373
MEAN RADIUS	:	1.228	1.045	1.000
MAX RADIUS	:	2.418	1.702	1.669
HORIZONTAL SPREAD	:	2.413	2.413	2.243
VERTICAL SPREAD	:	3.686	2.483	2.153
EXTREME SPREAD	:	3.752	2.826	2.826
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

12 Dec 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6587565

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 1

2in = 2

3in = 7

HS = 3.408

VS = 3.262

GS = 3.695

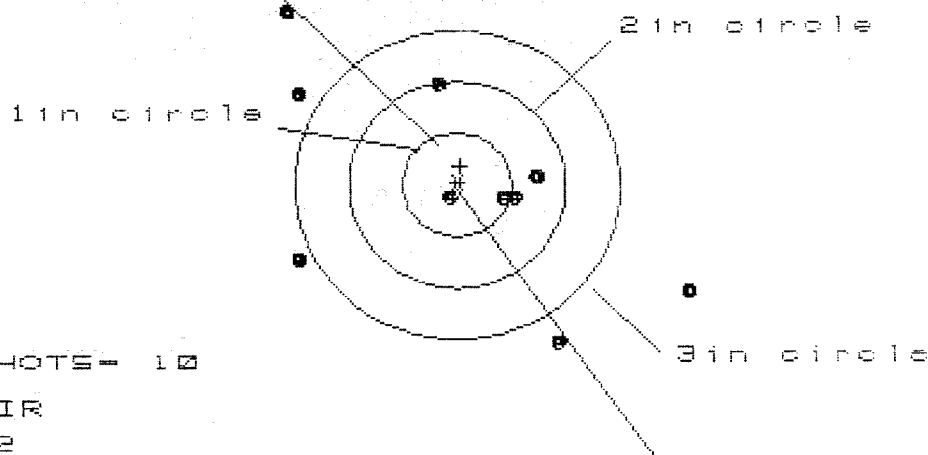
PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.661
MINIMUM X	-1.747
MAXIMUM Y	2.273
MINIMUM Y	-0.989
CENTROID X	-0.210
CENTROID Y	-0.072
POA TO CENTROID in.	.222
MIN RADIUS	.132
MEAN RADIUS	1.311
MAX RADIUS	2.274
HORIZONTAL SPREAD	3.408
VERTICAL SPREAD	3.262
EXTREME SPREAD	3.695
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	2
NUMBER IN THREE INCH CIRCLE =	7

12 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06587565

CENTERFIRE PATTERNS # 4

FOR



OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 5

HS= 3.669

VS= 3.143

GS= 4.560

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.099	1.197	1.030
MINIMUM X	:	-1.570	-1.337	-1.418
MAXIMUM Y	:	1.642	1.523	1.069
MINIMUM Y	:	-1.501	-1.620	-1.429
CENTROID X	:	-.031	-.264	-.097
CENTROID Y	:	-.181	-.062	-.253
FOR TO CENTROID in.	:	.183	.271	.271
MIN RADIUS	:	.093	.265	.013
MEAN RADIUS	:	1.253	1.172	.993
MAX RADIUS	:	2.353	2.027	1.761
HORIZONTAL SPREAD	:	3.669	2.534	2.448
VERTICAL SPREAD	:	3.143	3.143	2.498
EXTREME SPREAD	:	4.560	4.037	3.379
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		5	

12 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C65875B5

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 8

HS= 1.798

VS= 2.928

GS= 3.366

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.117	.850	.797
MINIMUM X	:	-.681	-.556	-.609
MAXIMUM Y	:	1.445	1.369	1.204
MINIMUM Y	:	-1.483	-1.323	-.623
CENTROID X	:	-.043	-.168	-.115
CENTROID Y	:	-.097	-.257	-.092
POA TO CENTROID in.	:	.106	.307	.147
MIN RADIUS	:	.193	.383	.211
MEAN RADIUS	:	.867	.737	.651
MAX RADIUS	:	1.826	1.388	1.205
HORIZONTAL SPREAD	:	1.798	1.406	1.406
VERTICAL SPREAD	:	2.928	2.692	1.827
EXTREME SPREAD	:	3.366	2.741	1.828
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587565
4 Dec 1990

CENTROIDAL DISTANCES

0 TO 1	.216566
1 TO 2	.223486
1 TO 3	.159013
1 TO 4	.0497293
1 TO 5	.0707107

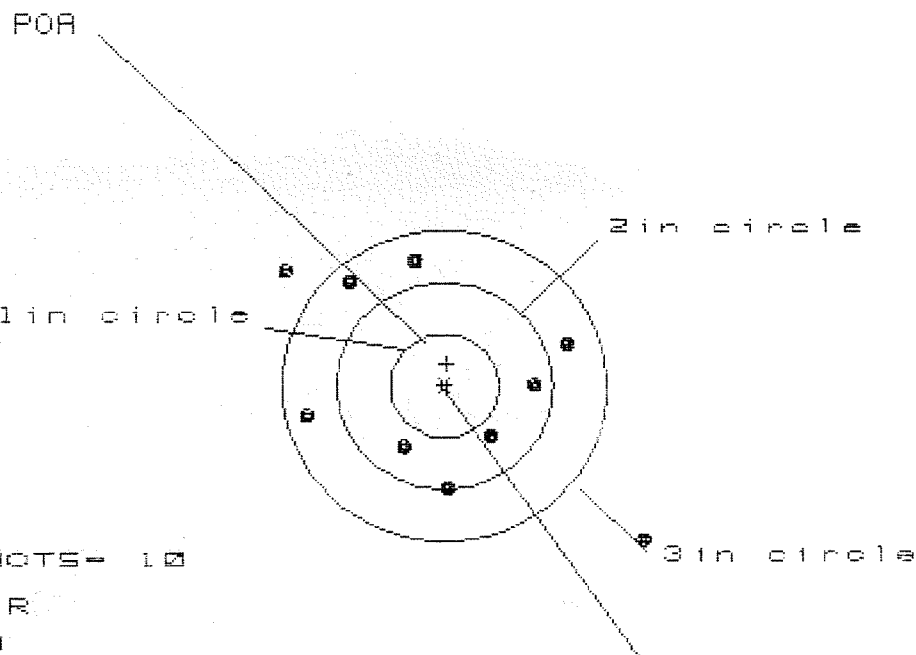
☒ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0026
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1416
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .141624
THE AMR FOR THIS RIFLE IS: 1.157

4 Dec 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6587565

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 0

2in = 4

3in = 8

HS= 3.273

VS= 2.610

GS= 4.136

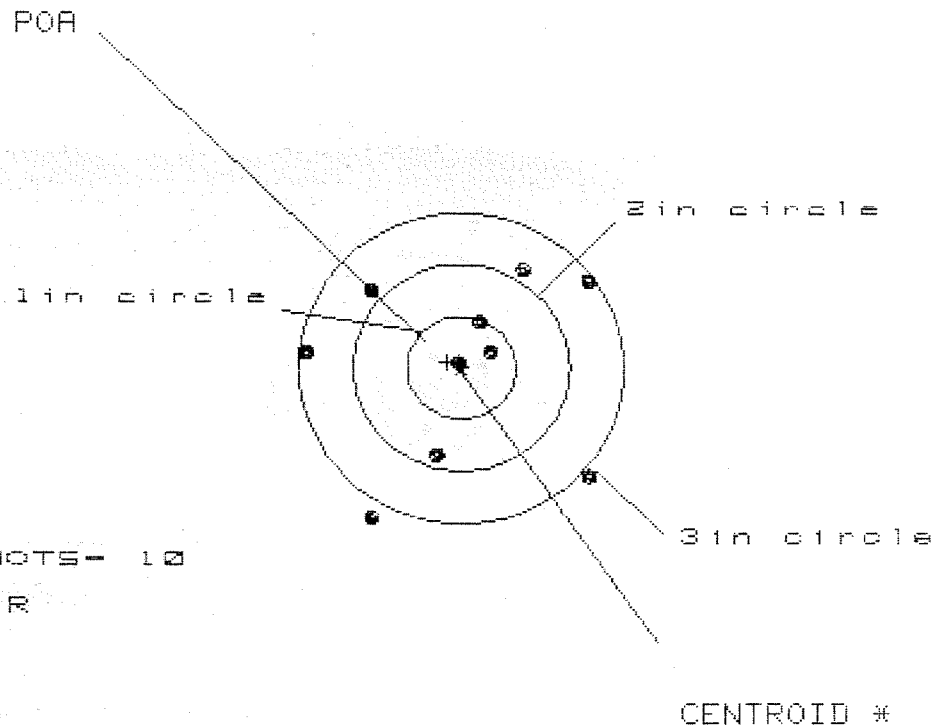
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.796	1.313	1.153
MINIMUM X	-1.477	-1.278	-1.228
MAXIMUM Y	1.168	1.008	1.124
MINIMUM Y	-1.442	-1.119	-1.003
CENTROID X	-.026	-.225	-.065
CENTROID Y	-.215	-.055	-.171
POR TO CENTROID in.	.217	.232	.183
MIN RADIUS	.597	.730	.657
MEAN RADIUS	1.222	1.107	1.017
MAX RADIUS	2.303	1.579	1.273
HORIZONTAL SPREAD	3.273	2.591	2.381
VERTICAL SPREAD	2.610	2.127	2.127
EXTREME SPREAD	4.136	2.667	2.496
NUMBER IN ONE INCH CIRCLE =	0	0	0
NUMBER IN TWO INCH CIRCLE =	4	4	4
NUMBER IN THREE INCH CIRCLE =	8	8	8

4 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C65875B5

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 2.639

VS= 2.414

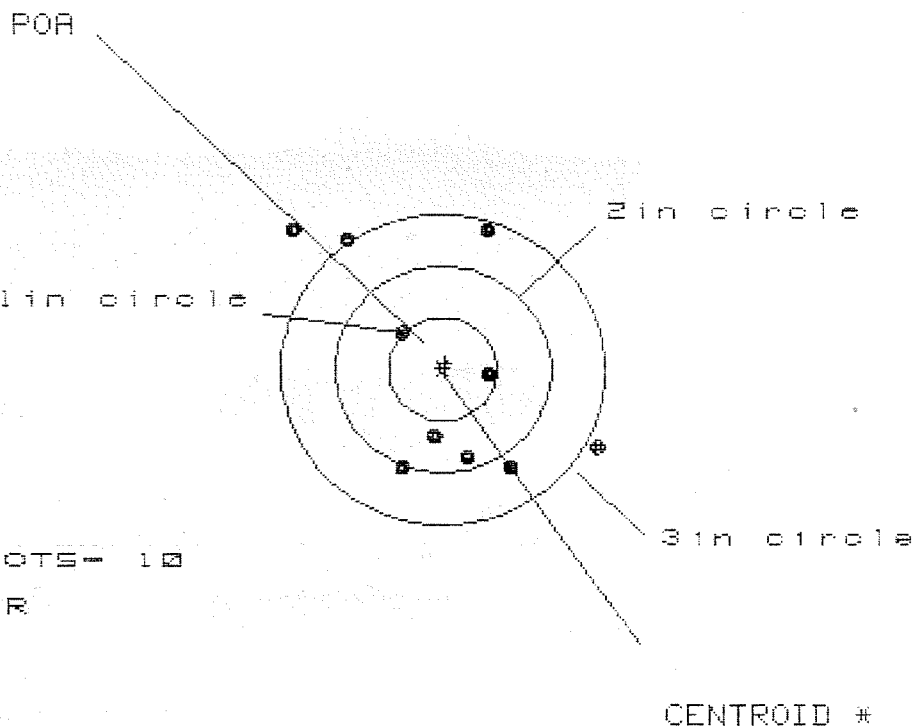
GS= 3.051

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.203	1.117	1.178
MINIMUM X	:	-1.436	-1.522	-1.383
MAXIMUM Y	:	.929	.764	.607
MINIMUM Y	:	-1.485	-1.258	-1.169
CENTROID X	:	.129	.215	.076
CENTROID Y	:	-.054	.111	.269
POA TO CENTROID in.	:	.139	.242	.279
MIN RADIUS	:	.020	.152	.297
MEAN RADIUS	:	1.014	.914	.825
MAX RADIUS	:	1.678	1.682	1.393
HORIZONTAL SPREAD	:	2.639	2.639	2.561
VERTICAL SPREAD	:	2.414	2.022	1.776
EXTREME SPREAD	:	3.051	2.918	2.667
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

4 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06587565

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 7

HS= 2.793

VS= 2.375

GS= 3.514

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.423	1.271	.637
MINIMUM X	-1.370	-1.038	-.879
MAXIMUM Y	1.382	1.489	1.414
MINIMUM Y	-.993	-.839	-.914
CENTROID X	-.024	.128	-.031
CENTROID Y	-.056	-.210	-.135
POA TO CENTROID in.	.061	.246	.139
MIN RADIUS	.436	.324	.450
MEAN RADIUS	1.122	.993	.947
MAX RADIUS	1.946	1.720	1.566
HORIZONTAL SPREAD	2.793	2.309	1.516
VERTICAL SPREAD	2.375	2.328	2.328
EXTREME SPREAD	3.514	3.033	2.680
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		7	

4 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06587565

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 7

3 in = 7

HS = 3.354

VS = 3.493

GS = 3.984

CENTROID #

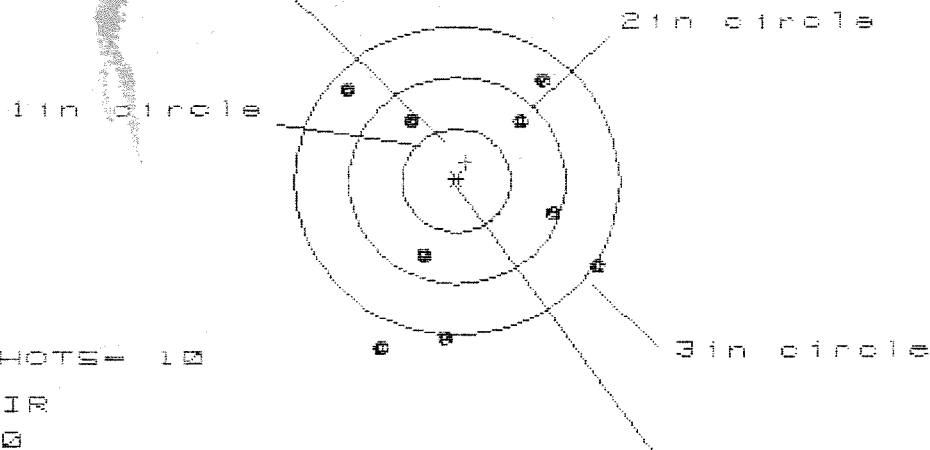
PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.497	1.451	1.213
MINIMUM X	:	-1.857	-1.903	-.908
MAXIMUM Y	:	2.298	1.175	1.320
MINIMUM Y	:	-1.195	-.940	-.795
CENTROID X	:	.022	.068	.306
CENTROID Y	:	-.202	-.457	-.602
POA TO CENTROID in.	:	.203	.462	.676
MIN RADIUS	:	.494	.286	.100
MEAN RADIUS	:	1.136	.914	.694
MAX RADIUS	:	2.336	2.230	1.450
HORIZONTAL SPREAD	:	3.354	3.354	2.121
VERTICAL SPREAD	:	3.493	2.115	2.115
EXTREME SPREAD	:	3.984	3.959	2.391
NUMBER IN ONE INCH CIRCLE =	:	1		
NUMBER IN TWO INCH CIRCLE =	:	7		
NUMBER IN THREE INCH CIRCLE =	:	7		

4 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587565

CENTERFIRE PATTERNS # 5

POA



OF SHOTS = 10

IN CIR

1in = 0

2in = 4

3in = 7

HS = 2.288

VS = 3.628

GS = 3.686

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.246	1.133	1.032
MINIMUM X	:	-1.043	-1.156	-1.257
MAXIMUM Y	:	2.015	1.161	.987
MINIMUM Y	:	-1.613	-1.389	-1.498
CENTROID X	:	-.088	.025	.126
CENTROID Y	:	-.181	-.405	-.231
POA TO CENTROID in.	:	.201	.406	.263
MIN RADIUS	:	.711	.668	.704
MEAN RADIUS	:	1.290	1.166	1.087
MAX RADIUS	:	2.258	1.605	1.562
HORIZONTAL SPREAD	:	2.289	2.289	2.289
VERTICAL SPREAD	:	3.628	2.550	2.485
EXTREME SPREAD	:	3.686	2.964	2.844
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	