

C6523365

MODEL 700<sup>TM</sup> M24

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

Action

Barrel Length

Capacity

Order No. **5716**

\*Includes 1 in chamber.

*Remington*

**Remington**  
 MODEL 700™ N24

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

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

SERIAL NO. C6520365

ORDER NO. 5716

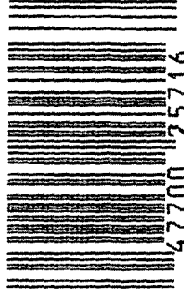
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

01



5716 C6520365

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6523365

| OP. #        | OP. NAME                                                       | READINGS | DATE     | INIT |
|--------------|----------------------------------------------------------------|----------|----------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   | 9 24     | 90       | RW   |
| 600          | Proof                                                          | 9 24     | 90       | RW   |
| 607          | Check Headspace                                                | 9 24     | 90       | RW   |
| 610          | Dis-assemble Gun                                               | 9 24     | 90       | RW   |
| 612          | Magnaflux Barrel<br>Action                                     |          | 9-23-90  | KR   |
|              | Magnaflux Bolt                                                 |          | 9-25-90  | KR   |
| 615          | Rollmark Caliber                                               |          | 9-25-90  | JB   |
| 617          | Drill and Tap Sight Holes                                      |          | 9-25-90  | FB   |
| 618          | Polish Barrel RB                                               |          | 9/28/90  | WBS  |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 9-28-90  | JA   |
|              | Apply Coating (Bolt)                                           |          | 9-28-90  | JA   |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 10/8/90  | RW   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 10/8/90  | RW   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 10/8/90  | RW   |
|              | D) Oil Firing Pin Ass'y                                        |          | 10/8/90  | RW   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 10/12/90 | JB   |

| op. #      | OP. NAME                                                    | READINGS |       |       |     | DATE     | INIT    |
|------------|-------------------------------------------------------------|----------|-------|-------|-----|----------|---------|
| 625<br>nt. | F) Safety On Force                                          | 5        | 5     | 5     |     | 10/12/90 | WB      |
|            | G) Safety Off Force                                         | 7 1/2    | 7 1/2 | 7 1/2 |     | 10/12/90 | WB      |
|            | H) Trigger Pull Test & Retainability                        |          |       |       |     | 10/22/90 | JH      |
|            | I) Firing Pin Indent                                        | .024     | .024  | .024  |     | 10/12/90 | WB      |
|            | J) Assemble Stock                                           |          |       |       |     | 10/12/90 | RW      |
|            | K) Assemble Swivel Studs                                    |          |       |       |     | 2/18/90  | JSS     |
|            | L) Attach Front and Rear Sight Assemblies                   |          |       |       |     | 10/12/90 | RW      |
|            | M) Iron Sight Alignment                                     |          |       |       |     | 10/12/90 | RW      |
|            | N) Detach Front & Rear Sights & place in numbered container |          |       |       |     | 10/12/90 | RW      |
|            | O) Attach Scope to Rifle                                    |          |       |       |     | 10/12/90 | RW      |
|            | P) Detach & Attach Scope 20 Times                           |          |       |       |     | 10/12/90 | RW      |
| 640        | Gallery Target & Test                                       |          |       |       |     | 10-16-90 | KT      |
|            | A) Time                                                     |          |       |       |     | 10-16-90 | KT      |
|            | B) Malfunctions                                             |          |       |       |     | 10-16-90 | KT      |
|            | C) Pierced Primers                                          |          |       |       |     | 10-16-90 | KT      |
|            | D) Optical Clarity of Scope                                 |          |       |       |     | 10-16-90 | KT      |
| 645        | Inspect for Live Ammo                                       |          |       |       |     | 10-16-90 | KT      |
| 655        | Final Inspection                                            |          |       |       |     |          |         |
|            | A) Headspace                                                |          |       |       |     | 2/18/90  | JSS     |
|            | B) Trigger Pull                                             | 211      | 207   | 204   | 201 | 210      | 2/18/90 |
|            | C) Function                                                 |          |       |       |     | 2/18/90  | JSS     |
| 660        | Pack                                                        |          |       |       |     | 2/17/90  | DH      |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6523365  
17 Oct 1990

CENTROIDAL DISTANCES

|        |         |
|--------|---------|
| 0 TO 1 | .163248 |
| 1 TO 2 | .211851 |
| 1 TO 3 | .225887 |
| 1 TO 4 | .283185 |
| 1 TO 5 | .175285 |

<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0772  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .133  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .153782  
THE AMR FOR THIS RIFLE IS: .957

16 Oct 1998

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# CENTERFIRE PATTERNS

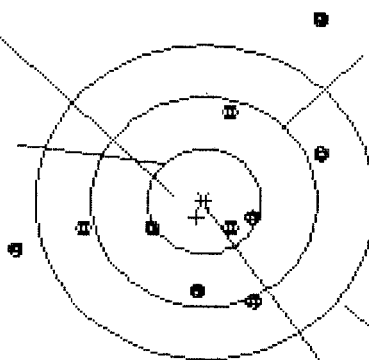
# 1

POA

1in circle

2in circle

3in circle



CENTROID \*

# OF SHOTS- 10

# IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.737

VS= 2.717

GS= 3.513

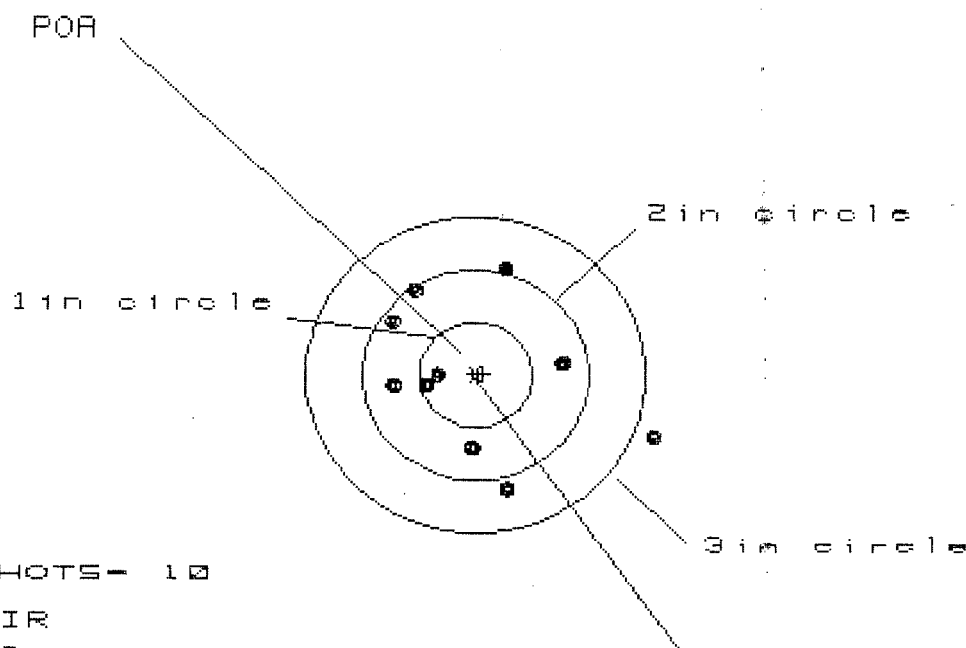
|                             |   |        |        |        |
|-----------------------------|---|--------|--------|--------|
| PATTERN #                   | : | 1      |        |        |
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.026  | 1.139  | .940   |
| MINIMUM X                   | : | -1.711 | -1.598 | -1.192 |
| MAXIMUM Y                   | : | 1.778  | 1.080  | 1.051  |
| MINIMUM Y                   | : | -.939  | -.742  | -.771  |
| CENTROID X                  | : | .071   | -.042  | .157   |
| CENTROID Y                  | : | .147   | -.050  | -.021  |
| POA TO CENTROID in.         | : | .164   | .066   | .159   |
| MIN RADIUS                  | : | .301   | .302   | .121   |
| MEAN RADIUS                 | : | 1.012  | .867   | .738   |
| MAX RADIUS                  | : | 2.051  | 1.614  | 1.196  |
| HORIZONTAL SPREAD           | : | 2.737  | 2.737  | 2.132  |
| VERTICAL SPREAD             | : | 2.717  | 1.822  | 1.822  |
| EXTREME SPREAD              | : | 3.513  | 2.871  | 2.244  |
| 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 - 7

3 in = 9

HS= 2.344

VS= 2.102

GS= 2.584

| PATTERN #                   | : | 2      |        |       |
|-----------------------------|---|--------|--------|-------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | 1.584  | .949   | 1.003 |
| MINIMUM X                   | : | -.760  | -.584  | -.529 |
| MAXIMUM Y                   | : | 1.038  | .973   | .881  |
| MINIMUM Y                   | : | -1.064 | -1.129 | -.888 |
| CENTROID X                  | : | -.069  | -.245  | -.299 |
| CENTROID Y                  | : | -.012  | .053   | .195  |
| POA TO CENTROID in.         | : | .070   | .250   | .357  |
| MIN RADIUS                  | : | .345   | .165   | .186  |
| MEAN RADIUS                 | : | .874   | .733   | .663  |
| MAX RADIUS                  | : | 1.688  | 1.212  | 1.005 |
| HORIZONTAL SPREAD           | : | 2.344  | 1.533  | 1.523 |
| VERTICAL SPREAD             | : | 2.102  | 2.102  | 1.719 |
| EXTREME SPREAD              | : | 2.584  | 2.102  | 1.747 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 7      |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |       |

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# CENTERFIRE PATTERNS

# 3

POA

1 in circle

2 in circle

3 in circle

# OF SHOTS- 10

# IN CIR

1 in = 1

2 in = 6

3 in = 8

HS= 2.315

VS= 3.085

GS= 3.395

CENTROID \*

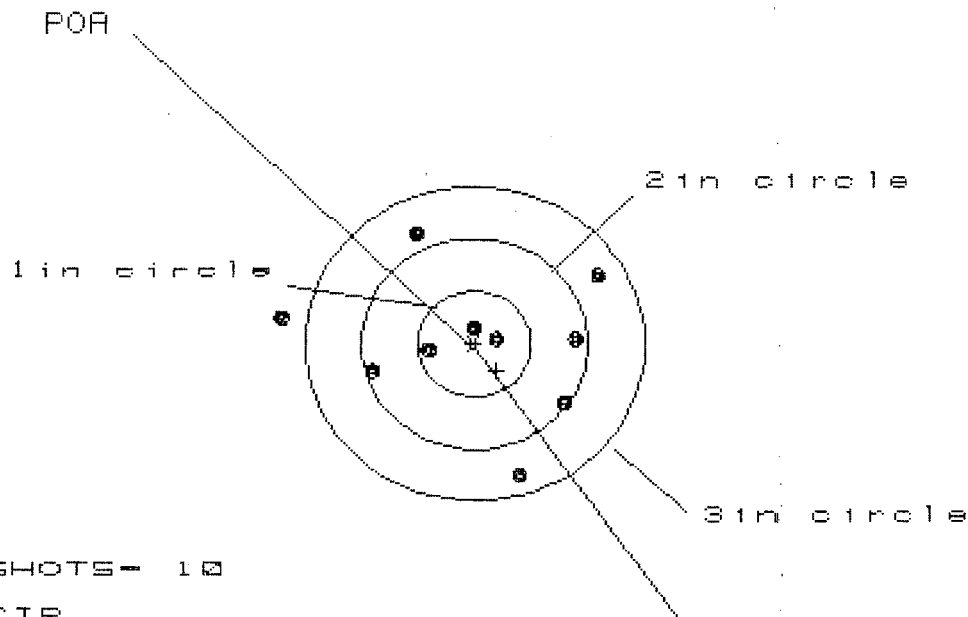
|                             |   |        |        |       |
|-----------------------------|---|--------|--------|-------|
| PATTERN #                   | : | 3      |        |       |
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | .822   | .909   | .784  |
| MINIMUM X                   | : | -1.493 | -1.402 | -.657 |
| MAXIMUM Y                   | : | 2.048  | 1.262  | 1.286 |
| MINIMUM Y                   | : | -1.037 | -.809  | -.885 |
| CENTROID X                  | : | -.133  | -.224  | -.049 |
| CENTROID Y                  | : | .244   | .016   | .042  |
| POA TO CENTROID in.         | : | .278   | .225   | .065  |
| MIN RADIUS                  | : | .406   | .330   | .366  |
| MEAN RADIUS                 | : | .975   | .794   | .703  |
| MAX RADIUS                  | : | 2.207  | 1.417  | 1.287 |
| HORIZONTAL SPREAD           | : | 2.315  | 2.311  | 1.391 |
| VERTICAL SPREAD             | : | 3.085  | 2.071  | 2.071 |
| EXTREME SPREAD              | : | 3.395  | 2.312  | 2.074 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 1      |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 6      |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 8      |       |



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# CENTERFIRE PATTERNS # 4



# OF SHOTS- 10

# IN CIR

1 in - 3

2 in - 5

3 in - 2

HS- 2.750

VS- 2.347

GS- 2.771

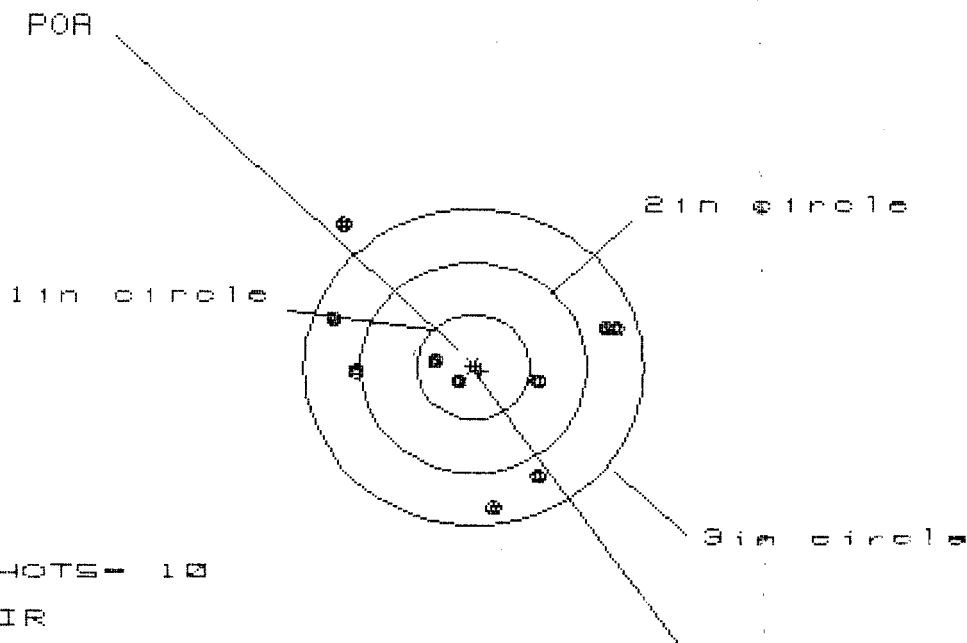
CENTROID #

| PATTERN #                   | : | 4      |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.082  | .897   | .927   |
| MINIMUM X                   | : | -1.668 | -1.118 | -1.088 |
| MAXIMUM Y                   | : | 1.075  | 1.108  | .953   |
| MINIMUM Y                   | : | -1.272 | -1.239 | -.654  |
| CENTROID X                  | : | -.192  | -.007  | -.037  |
| CENTROID Y                  | : | .252   | .219   | .374   |
| POA TO CENTROID in.         | : | .317   | .219   | .376   |
| MIN RADIUS                  | : | .103   | .062   | .181   |
| MEAN RADIUS                 | : | .896   | .790   | .727   |
| MAX RADIUS                  | : | 1.693  | 1.283  | 1.152  |
| HORIZONTAL SPREAD           | : | 2.750  | 2.015  | 2.015  |
| VERTICAL SPREAD             | : | 2.347  | 2.347  | 1.607  |
| EXTREME SPREAD              | : | 2.771  | 2.509  | 2.202  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 3      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 6      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |        |

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# CENTERFIRE PATTERNS # 5



# OF SHOTS- 10

# IN CIR

1 in = 2

2 in = 3

3 in = 5

HS= 2.499

VS= 2.700

GS= 2.983

CENTROID \*

|                             |   |        |        |        |
|-----------------------------|---|--------|--------|--------|
| PATTERN #                   | : | 5      |        |        |
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.305  | 1.183  | 1.211  |
| MINIMUM X                   | : | -1.194 | -1.316 | -1.168 |
| MAXIMUM Y                   | : | 1.383  | .646   | .717   |
| MINIMUM Y                   | : | -1.325 | -1.171 | -1.100 |
| CENTROID X                  | : | -.063  | .059   | -.089  |
| CENTROID Y                  | : | .034   | -.120  | -.191  |
| POR TO CENTROID in.         | : | .071   | .134   | .211   |
| MIN RADIUS                  | : | .249   | .301   | .162   |
| MEAN RADIUS                 | : | 1.028  | .936   | .866   |
| MAX RADIUS                  | : | 1.766  | 1.466  | 1.371  |
| HORIZONTAL SPREAD           | : | 2.499  | 2.499  | 2.379  |
| VERTICAL SPREAD             | : | 2.700  | 1.817  | 1.817  |
| EXTREME SPREAD              | : | 2.983  | 2.500  | 2.304  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 3      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |        |

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50#+ .50#

3.00#+ .75#

4.00#+1.00#

SERIAL NO. C6523365

DATE 10/12/90

TESTER 991

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.33             | 2.34                     | 2.30                           | 2.11 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.27             | 2.39                     | 2.40                           | 2.07 |                                                                        |
| PULL #3 | 2.42             | 2.33                     | 2.36                           | 2.04 |                                                                        |
| PULL #4 | 2.32             | 2.36                     | 2.42                           | 2.01 |                                                                        |
| PULL #5 | 2.36             | 2.33                     | 2.32                           | 2.10 |                                                                        |
| TOTAL   | 11.7             | 11.75                    | 11.80                          |      |                                                                        |
| AVG.    | 2.34             | 2.35                     | 2.36                           |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.33             | 3.27                     |  |          |
| PULL #2 | 3.22             | 3.23                     |  |          |
| PULL #3 | 3.19             | 3.24                     |  |          |
| PULL #4 | 3.50             | 3.25                     |  |          |
| PULL #5 | 3.50             | 3.30                     |  |          |
| TOTAL   | 16.74            | 16.29                    |  |          |
| AVG.    | 3.348            | 3.258                    |  |          |

|         | 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 | 4.33             | 4.25                     |                                | 4.29                                 |
| PULL #2 | 4.26             | 4.27                     |                                | 4.28                                 |
| PULL #3 | 4.25             | 4.25                     |                                | 4.31                                 |
| PULL #4 | 4.16             | 4.23                     |                                | 4.31                                 |
| PULL #5 | 4.24             | 4.32                     |                                | 4.32                                 |
| TOTAL   | 21.24            | 21.32                    |                                | 21.51                                |
| AVG.    | 4.248            | 4.264                    |                                | 4.302                                |