

C6523449

MODEL 700<sup>TM</sup> M24

Model SWS<sup>TM</sup>

Action

Barrel Length

Capacity

Order No. 5716

\*Includes 1 in chamber.

*Remington*




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

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

SERIAL NO.  
06523449

ORDER NO.  
5716

MODEL 700™ H24

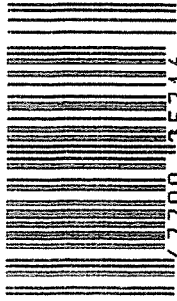
01

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



5716 06523449

UPC



0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523449

| OP. #        | OP. NAME                                                       | READINGS | DATE     | INIT |
|--------------|----------------------------------------------------------------|----------|----------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   |          | 10/2/90  | KJ   |
| 600          | Proof                                                          |          | 10/2/90  | KJ   |
| 607          | Check Headspace                                                |          | 10/2/90  | KJ   |
| 610          | Dis-assemble Gun                                               |          | 10/2/90  | KJ   |
| 612          | Magnaflux Barrel<br>Action                                     |          | 10/5/90  | KR   |
|              | Magnaflux Bolt                                                 |          | 10/5/90  | KR   |
| 615          | Rollmark Caliber                                               |          | 10/5/90  | SL   |
| 617          | Drill and Tap Sight Holes                                      |          | 10/8/90  | KJ   |
| 618          | Polish Barrel <i>PB</i>                                        |          | 10/9/90  | WB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 10-20-90 | KJ   |
|              | Apply Coating (Bolt)                                           |          |          |      |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 10/2/90  | KJ   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 10/21/90 | KJ   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 10/21/90 | KJ   |
|              | D) Oil Firing Pin Ass'y                                        |          | 10/21/90 | KJ   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 10/29/90 | KJ   |

| op. #                             | OP. NAME                                                    | READINGS |       |          | DATE     | INIT |          |    |
|-----------------------------------|-------------------------------------------------------------|----------|-------|----------|----------|------|----------|----|
| 625<br>cont.                      | F) Safety On Force                                          | 3 3/4    | 3 3/4 | 3 3/4    | 10/30/90 | WB   |          |    |
|                                   | G) Safety Off Force                                         | 2        | 2     | 2        | 10/30/90 | WB   |          |    |
|                                   | H) Trigger Pull Test & Retainability                        |          |       |          | 10/29/90 | JH   |          |    |
|                                   | I) Firing Pin Indent                                        | .021     | .0215 | .0215    | 10/30/90 | WB   |          |    |
|                                   | J) Assemble Stock                                           |          |       |          | 10/31/90 | KH   |          |    |
|                                   | K) Assemble Swivel Studs                                    |          |       |          | 11/19/90 | JS   |          |    |
|                                   | L) Attach Front and Rear Sight Assemblies                   |          |       |          | 10/31/90 | KH   |          |    |
|                                   | M) Iron Sight Alignment                                     |          |       |          | 10/31/90 | KH   |          |    |
|                                   | N) Detach Front & Rear Sights & place in numbered container |          |       |          | 10/31/90 | KH   |          |    |
|                                   | O) Attach Scope to Rifle                                    |          |       |          | 10/31/90 | KH   |          |    |
| P) Detach & Attach Scope 20 Times |                                                             |          |       | 10/31/90 | KH       |      |          |    |
| 640                               | Gallery Target & Test                                       |          |       |          | 11-1-90  | AC   |          |    |
|                                   | A) Time                                                     |          |       |          | 11-1-90  | AC   |          |    |
|                                   | B) Malfunctions                                             |          |       |          | 11-1-90  | AC   |          |    |
|                                   | C) Pierced Primers                                          |          |       |          | 11-1-90  | AC   |          |    |
|                                   | D) Optical Clarity of Scope                                 |          |       |          | 11-1-90  | AC   |          |    |
| 645                               | Inspect for Live Ammo                                       |          |       |          | 11-1-90  | AC   |          |    |
| 655                               | Final Inspection                                            |          |       |          |          |      |          |    |
|                                   | A) Headspace                                                |          |       |          | 11/19/90 | JS   |          |    |
|                                   | B) Trigger Pull                                             | 224      | 216   | 219      | 209      | 224  | 11/19/90 | JS |
|                                   | C) Function                                                 |          |       |          |          |      | 11/19/90 | JS |
| 660                               | Pack                                                        |          |       |          |          |      | 12-1-90  | DH |

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6523449

DATE 10/29/90

TESTER JH

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.24             | 2.49                     | 2.46                           | 2.24 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.22             | 2.42                     | 2.40                           | 2.16 |                                                                        |
| PULL #3 | 2.22             | 2.49                     | 2.38                           | 2.19 |                                                                        |
| PULL #4 | 2.47             | 2.39                     | 2.35                           | 2.09 |                                                                        |
| PULL #5 | 2.41             | 2.35                     | 2.30                           | 2.24 |                                                                        |
| TOTAL   | 11.54            | 12.14                    | 11.89                          |      |                                                                        |
| AVG.    | 2.312            | 2.428                    | 2.378                          |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.28             | 3.38                     |  |          |
| PULL #2 | 3.32             | 3.40                     |  |          |
| PULL #3 | 3.33             | 3.30                     |  |          |
| PULL #4 | 3.40             | 3.32                     |  |          |
| PULL #5 | 3.28             | 3.22                     |  |          |
| TOTAL   | 16.61            | 16.62                    |  |          |
| AVG.    | 3.322            | 3.324                    |  |          |

|         | 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 | 4.30             | 4.38                     |                                | 4.42                                 |
| PULL #2 | 4.40             | 4.34                     |                                | 4.14                                 |
| PULL #3 | 4.50             | 4.36                     |                                | 4.35                                 |
| PULL #4 | 4.47             | 4.37                     |                                | 4.33                                 |
| PULL #5 | 4.37             | 4.46                     |                                | 4.32                                 |
| TOTAL   | 22.04            | 21.91                    |                                | 21.56                                |
| AVG.    | 4.408            | 4.382                    |                                | 4.312                                |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6523449  
1 Nov 1990

CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| 0 TO | 1 | .391065 |
| 1 TO | 2 | .718672 |
| 1 TO | 3 | .341884 |
| 1 TO | 4 | .546883 |
| 1 TO | 5 | .498531 |

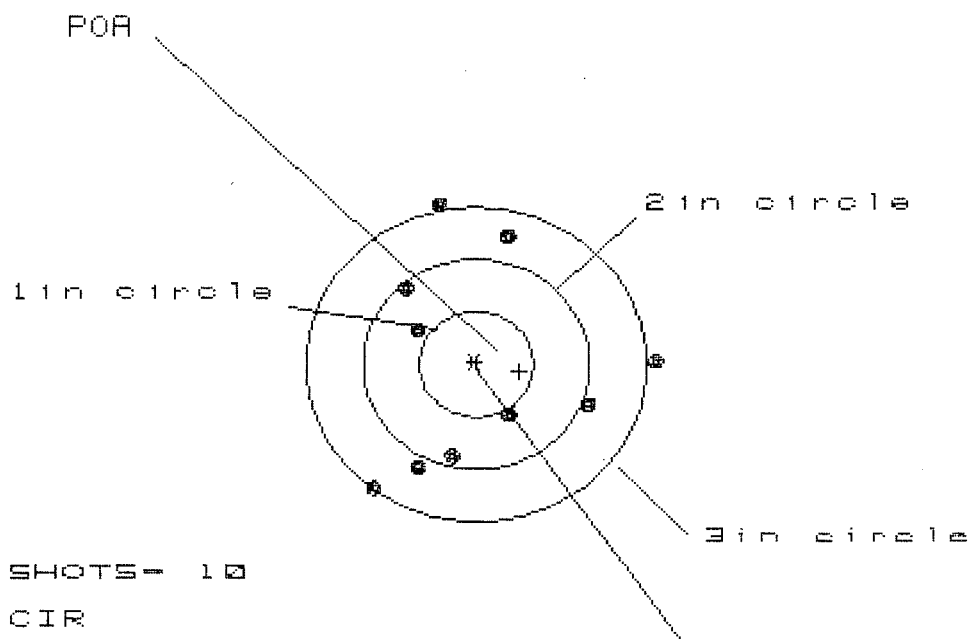
1.52 < ---- POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0042  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.058  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0581519  
THE AMR FOR THIS RIFLE IS: .8294

1 Nov 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/C6523449

# CENTERFIRE PATTERNS # 1



# OF SHOTS- 10

# IN CIR

1in = 0

2in = 4

3in = 7

HS= 2.528

VS= 2.733

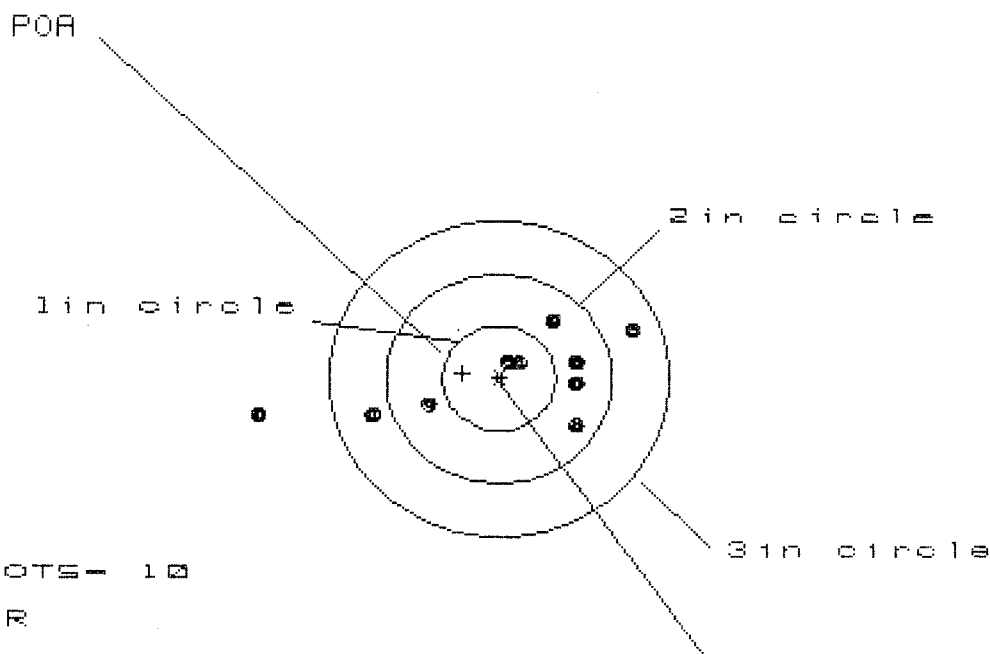
GS= 2.824

| PATTERN #                     | 1      | 2      | 3      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.571  | 1.188  | 1.168  |
| MINIMUM X                     | -.957  | -.782  | -.802  |
| MAXIMUM Y                     | 1.517  | 1.522  | 1.462  |
| MINIMUM Y                     | -1.216 | -1.211 | -1.021 |
| CENTROID X                    | -.384  | -.559  | -.539  |
| CENTROID Y                    | .074   | .069   | -.121  |
| POA TO CENTROID in.           | .391   | .563   | .552   |
| MIN RADIUS                    | .561   | .450   | .535   |
| MEAN RADIUS                   | 1.116  | 1.048  | .964   |
| MAX RADIUS                    | 1.572  | 1.530  | 1.532  |
| HORIZONTAL SPREAD             | 2.528  | 1.970  | 1.970  |
| VERTICAL SPREAD               | 2.733  | 2.733  | 2.483  |
| EXTREME SPREAD                | 2.824  | 2.804  | 2.783  |
| NUMBER IN ONE INCH CIRCLE =   | 0      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 4      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 7      |        |        |

1 Nov 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/C6523443

# CENTERFIRE PATTERNS # 2



# OF SHOTS- 10

# IN CIR

1in = 2

2in = 7

3in = 9

HS= 3.323

VS= 1.061

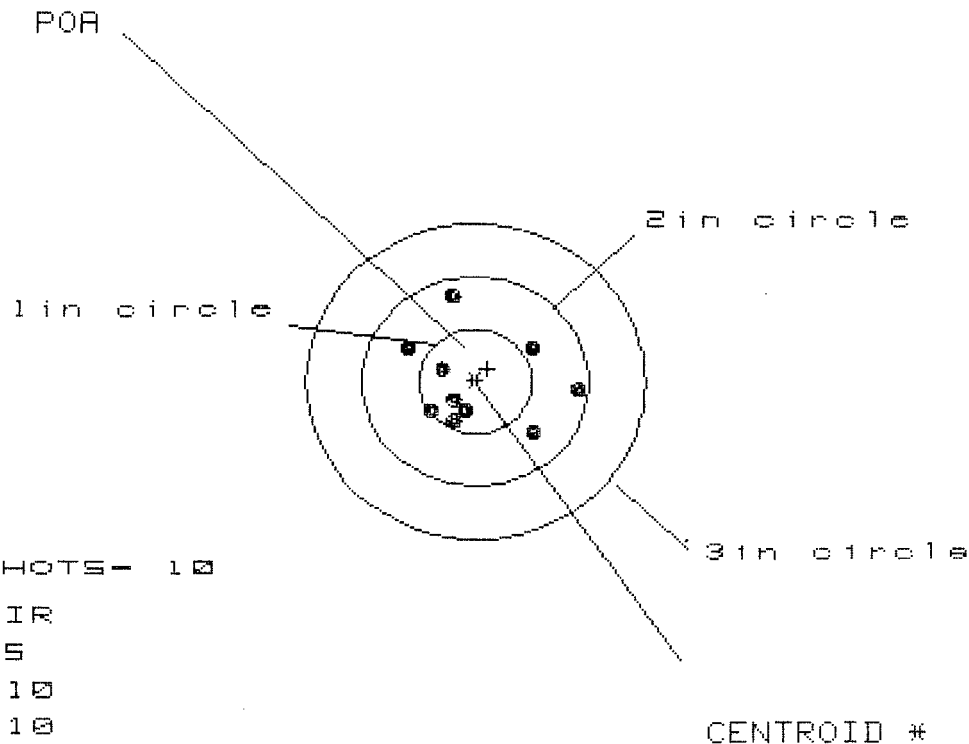
GS= 3.418

| PATTERN #                     | : | 2      |        |        |
|-------------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)               | : | 10     | 9      | 8      |
| MAXIMUM X                     | : | 1.179  | .940   | .584   |
| MINIMUM X                     | : | -2.144 | -1.407 | -1.289 |
| MAXIMUM Y                     | : | .579   | .540   | .592   |
| MINIMUM Y                     | : | -.482  | -.521  | -.469  |
| CENTROID X                    | : | .323   | .562   | .444   |
| CENTROID Y                    | : | -.055  | -.016  | -.068  |
| POA TO CENTROID in.           | : | .328   | .562   | .449   |
| MIN RADIUS                    | : | .145   | .147   | .148   |
| MEAN RADIUS                   | : | .873   | .670   | .637   |
| MAX RADIUS                    | : | 2.173  | 1.471  | 1.344  |
| HORIZONTAL SPREAD             | : | 3.323  | 2.347  | 1.873  |
| VERTICAL SPREAD               | : | 1.061  | 1.061  | 1.061  |
| EXTREME SPREAD                | : | 3.418  | 2.494  | 1.957  |
| NUMBER IN ONE INCH CIRCLE =   |   |        | 2      |        |
| NUMBER IN TWO INCH CIRCLE =   |   |        | 7      |        |
| NUMBER IN THREE INCH CIRCLE = |   |        | 9      |        |

1 Nov 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/C6523449

# CENTERFIRE PATTERNS # 3



# OF SHOTS- 10

# IN CIR

1in = 5

2in = 10

3in = 10

HS= 1.523

VS= 1.280

GS= 1.584

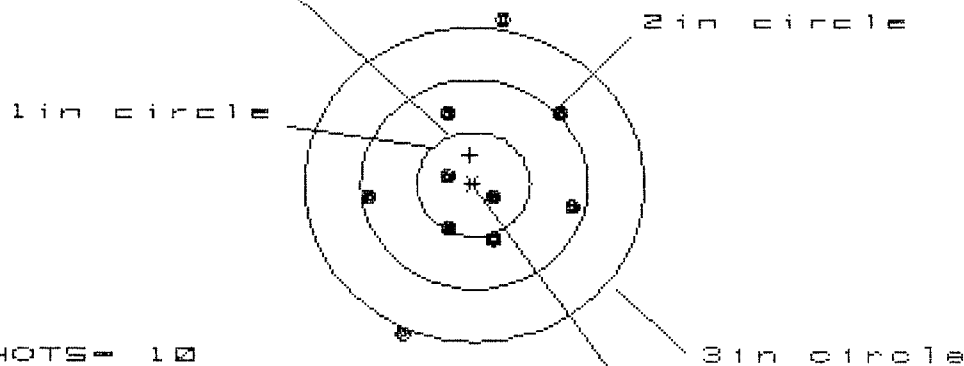
| PATTERN #                   | : | 3     |       |       |
|-----------------------------|---|-------|-------|-------|
| SHOTS (BEST OF)             | : | 10    | 9     | 8     |
| MAXIMUM X                   | : | .919  | .621  | .616  |
| MINIMUM X                   | : | -.604 | -.502 | -.507 |
| MAXIMUM Y                   | : | .846  | .835  | .460  |
| MINIMUM Y                   | : | -.434 | -.445 | -.341 |
| CENTROID X                  | : | -.106 | -.208 | -.203 |
| CENTROID Y                  | : | -.125 | -.114 | -.218 |
| POA TO CENTROID in.         | : | .164  | .237  | .298  |
| MIN RADIUS                  | : | .275  | .209  | .144  |
| MEAN RADIUS                 | : | .547  | .483  | .409  |
| MAX RADIUS                  | : | .925  | .836  | .729  |
| HORIZONTAL SPREAD           | : | 1.523 | 1.123 | 1.123 |
| VERTICAL SPREAD             | : | 1.280 | 1.280 | .801  |
| EXTREME SPREAD              | : | 1.584 | 1.443 | 1.359 |
| NUMBER IN ONE INCH CIRCLE   | = |       | 5     |       |
| NUMBER IN TWO INCH CIRCLE   | = |       | 10    |       |
| NUMBER IN THREE INCH CIRCLE | = |       | 10    |       |

1 Nov 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/C6523449

# CENTERFIRE PATTERNS # 4

POA



# OF SHOTS - 10

# IN CIR

1in = 3

2in = 7

3in = 8

HS = 1.748

VS = 2.967

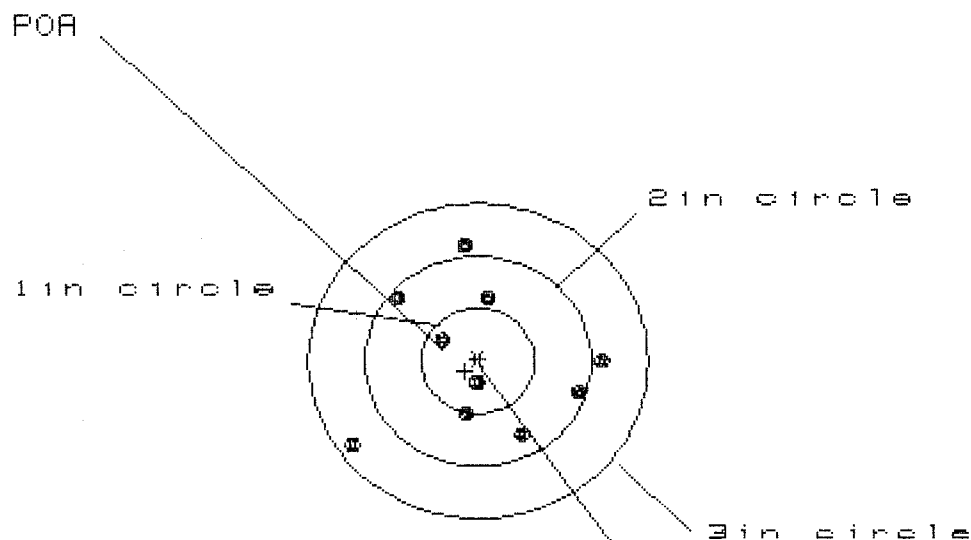
GS = 3.116

| PATTERN #                   | : | 4      | 9     | 8     |
|-----------------------------|---|--------|-------|-------|
| SHOTS (BEST OF)             | : | 10     | 9     | 8     |
| MAXIMUM X                   | : | .827   | .755  | .784  |
| MINIMUM X                   | : | -.921  | -.993 | -.964 |
| MAXIMUM Y                   | : | 1.537  | 1.379 | .729  |
| MINIMUM Y                   | : | -1.430 | -.726 | -.554 |
| CENTROID X                  | : | .032   | .104  | .074  |
| CENTROID Y                  | : | -.281  | -.123 | -.295 |
| POA TO CENTROID in.         | : | .283   | .161  | .304  |
| MIN RADIUS                  | : | .236   | .315  | .203  |
| MEAN RADIUS                 | : | .824   | .757  | .637  |
| MAX RADIUS                  | : | 1.568  | 1.398 | 1.007 |
| HORIZONTAL SPREAD           | : | 1.748  | 1.748 | 1.748 |
| VERTICAL SPREAD             | : | 2.967  | 2.105 | 1.283 |
| EXTREME SPREAD              | : | 3.116  | 2.109 | 1.865 |
| NUMBER IN ONE INCH CIRCLE   | = | 3      |       |       |
| NUMBER IN TWO INCH CIRCLE   | = | 7      |       |       |
| NUMBER IN THREE INCH CIRCLE | = | 8      |       |       |

1 Nov 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/C6523449

# CENTERFIRE PATTERNS # 5



# OF SHOTS- 10

# IN CIR

1in = 3

2in = 7

3in = 10

HS= 2.236

VS= 1.896

GS= 2.383

| PATTERN #                   | : | 5      |       |       |
|-----------------------------|---|--------|-------|-------|
| SHOTS (BEST OF)             | : | 10     | 9     | 8     |
| MAXIMUM X                   | : | 1.076  | .947  | .858  |
| MINIMUM X                   | : | -1.160 | -.863 | -.745 |
| MAXIMUM Y                   | : | 1.054  | .960  | .947  |
| MINIMUM Y                   | : | -.842  | -.794 | -.807 |
| CENTROID X                  | : | .114   | .243  | .125  |
| CENTROID Y                  | : | .097   | .191  | .205  |
| POA TO CENTROID in.         | : | .150   | .309  | .240  |
| MIN RADIUS                  | : | .156   | .287  | .265  |
| MEAN RADIUS                 | : | .787   | .720  | .672  |
| MAX RADIUS                  | : | 1.434  | 1.025 | .954  |
| HORIZONTAL SPREAD           | : | 2.236  | 1.810 | 1.603 |
| VERTICAL SPREAD             | : | 1.896  | 1.754 | 1.754 |
| EXTREME SPREAD              | : | 2.383  | 1.928 | 1.860 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 3     |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 7     |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 10    |       |