

C6636248

MODEL 700™ M24

Model SWS™

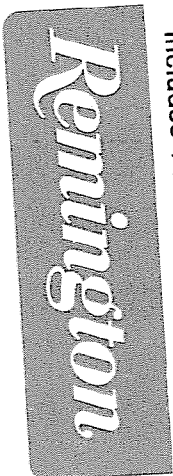
Action \_\_\_\_\_

Barrel Length \_\_\_\_\_

Capacity \_\_\_\_\_

Order No. 5716

\*Includes 1 in chamber.



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

**Remington**<sup>®</sup>

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

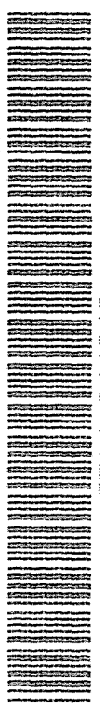
**MODEL 700<sup>TM</sup> H24**

**SERIAL NO. C6636248**

**ORDER NO. 5716**

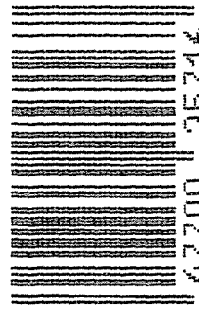
MADE IN ILION, N.Y., U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

20



5716 C6636248

UPC



0 47700 25716 7

| TEST INIT. ACTION TO CORRECT |                                  | ASSEM.<br># |
|------------------------------|----------------------------------|-------------|
| PROOF                        | shot 100 Rdr test<br>OK<br>89-91 |             |
| TEST                         |                                  |             |
| TGT                          |                                  |             |
| PROOF                        |                                  |             |
| TEST                         |                                  |             |
| TGT                          |                                  |             |
| PROOF                        | ENGINEER                         |             |
| TEST                         |                                  |             |
| TGT                          |                                  |             |
| PROOF                        | ENGINEER                         |             |
| TEST                         |                                  |             |
| TGT                          |                                  |             |

MOD. \_\_\_\_\_ GA. CAL. \_\_\_\_\_ GUN # 26636248

| #<br>TEST | DATE | MALFUNCTION/DEFECT  | ASSEM.<br># |
|-----------|------|---------------------|-------------|
|           | 1st  | <i>Skewed brass</i> | <i>KS</i>   |
|           | 2nd  |                     |             |
|           | 3rd  |                     |             |
|           | 4th  |                     |             |

FUNCTION \_\_\_\_\_

RD 6654 Rev 1

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6636248**

| OP. #        | OP. NAME                                                       | READINGS | DATE       | INIT |
|--------------|----------------------------------------------------------------|----------|------------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   |          | 6/24/91    | KL   |
| 600          | Proof                                                          |          | 6/24/91    | KL   |
| 607          | Check Headspace                                                |          | 6/24/91    | KL   |
| 610          | Dis-assemble Gun                                               |          | 6/24/91    | KL   |
| 612          | Magnaflux Barrel<br>Action                                     |          | JUL 1 1991 | KR   |
|              | Magnaflux Bolt                                                 |          | JUL 1 1991 | KR   |
| 615          | Rollmark Caliber                                               |          | JUL 1 1991 | LG   |
| 617          | Drill and Tap Sight Holes                                      |          | JUL 1 1991 | FB   |
| 618          | Polish Barrel                                                  |          | JUL 2 1991 | WB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 7-23-91    | DA   |
|              | Apply Coating (Bolt)                                           |          |            |      |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 8/5/91     | KL   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 8/5/91     | KL   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 8/5/91     | KL   |
|              | D) Oil Firing Pin Ass'y                                        |          | 8/5/91     | KL   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 8-6-91     | DH   |

| op. #        | OP. NAME                                                    | READINGS |      |      |      |      | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|------|------|------|------|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 5        | 5    | 5    |      |      | 8-6-91  | DH   |
|              | G) Safety Off Force                                         | 3        | 3    | 3    |      |      | 8-6-91  | DH   |
|              | H) Trigger Pull Test & Retainability                        |          |      |      |      |      | 8-6-91  | DH   |
|              | I) Firing Pin Indent                                        | .021     | .022 | .021 |      |      | 8-6-91  | DH   |
|              | J) Assemble Stock                                           |          |      |      |      |      | 8-8-91  | KS   |
|              | K) Assemble Swivel Studs                                    |          |      |      |      |      | 8-10-91 | DH   |
|              | L) Attach Front and Rear Sight Assemblies                   |          |      |      |      |      | 8-8-91  | KS   |
|              | M) Iron Sight Alignment                                     |          |      |      |      |      | 8-8-91  | KS   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |      |      |      |      | 8-8-91  | KS   |
|              | O) Attach Scope to Rifle                                    |          |      |      |      |      | 8-8-91  | KS   |
|              | P) Detach & Attach Scope 20 Times                           |          |      |      |      |      | 8-8-91  | KS   |
| 640          | Gallery Target & Test                                       |          |      |      |      |      | 8-9-91  | DH   |
|              | A) Time                                                     |          |      |      |      |      | 8-9-91  | DH   |
|              | B) Malfunctions                                             |          |      |      |      |      | 8-9-91  | DH   |
|              | C) Pierced Primers                                          |          |      |      |      |      | 8-9-91  | DH   |
|              | D) Optical Clarity of Scope                                 |          |      |      |      |      | 8-9-91  | DH   |
| 645          | Inspect for Live Ammo                                       |          |      |      |      |      | 8-9-91  | DH   |
| 655          | Final Inspection                                            |          |      |      |      |      | 8-10-91 | DH   |
|              | A) Headspace                                                |          |      |      |      |      | 8-10-91 | DH   |
|              | B) Trigger Pull                                             | 2.68     | 2.56 | 2.53 | 2.57 | 2.40 | 8-10-91 | JCP  |
|              | C) Function                                                 |          |      |      |      |      | 8-10-91 | DH   |
| 660          | Pack                                                        |          |      |      |      |      | 9-19-91 | AF   |

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6636248

DATE 8-6-91

TESTER DH

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.52             | 2.34                     | 2.41                           | 2.68 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.57             | 2.56                     | 2.67                           | 2.56 |                                                                        |
| PULL #3 | 2.19             | 2.38                     | 2.60                           | 2.53 |                                                                        |
| PULL #4 | 2.53             | 2.42                     | 2.45                           | 2.57 |                                                                        |
| PULL #5 | 2.60             | 2.36                     | 2.52                           | 2.40 |                                                                        |
| TOTAL   |                  |                          |                                |      |                                                                        |
| AVG.    |                  |                          |                                |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.19             | 3.41                     |  |          |
| PULL #2 | 3.27             | 3.28                     |  |          |
| PULL #3 | 3.23             | 3.33                     |  |          |
| PULL #4 | 3.00             | 3.38                     |  |          |
| PULL #5 | 3.23             | 3.29                     |  |          |
| TOTAL   |                  |                          |  |          |
| AVG.    |                  |                          |  |          |

|         | 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             | 4.20                     |                                | 4.02                                 |
| PULL #2 | 4.22             | 4.32                     |                                | 4.20                                 |
| PULL #3 | 4.24             | 4.18                     |                                | 4.10                                 |
| PULL #4 | 4.07             | 3.98                     |                                | 4.29                                 |
| PULL #5 | 4.05             | 4.26                     |                                | 4.11                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

# CENTROIDAL DISTANCE CALCULATIONS

FOR RIFLE # C6636248

2 Aug 1991

## CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| 0 TO | 1 | .417797 |
| 1 TO | 2 | 1.22058 |
| 1 TO | 3 | .828401 |
| 1 TO | 4 | .707799 |
| 1 TO | 5 | .627446 |

$\frac{5}{4} + \frac{1}{2}$ 
(----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.241  
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.084  
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .25522

THE AMR FOR THIS RIFLE IS: .9456

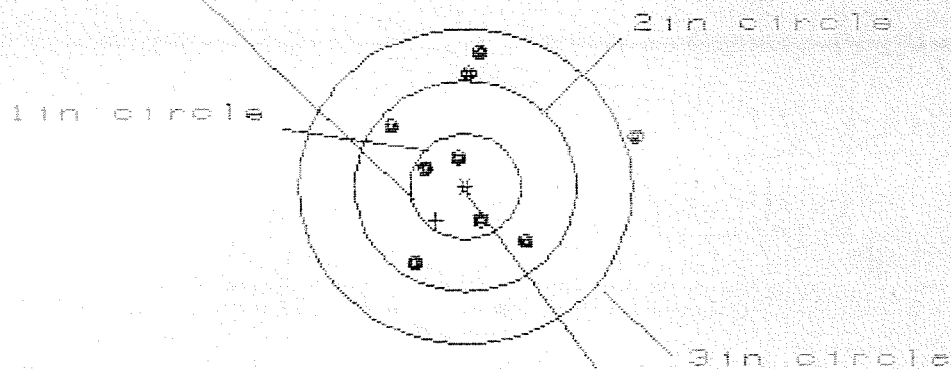


9 Aug 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6636248

# CENTERFIRE PATTERNS # 1

POB



# OF SHOTS= 10

# IN CIR

1in = 3

2in = 6

3in = 8

HS= 2.362

VS= 3.653

GS= 3.780

CENTROID #

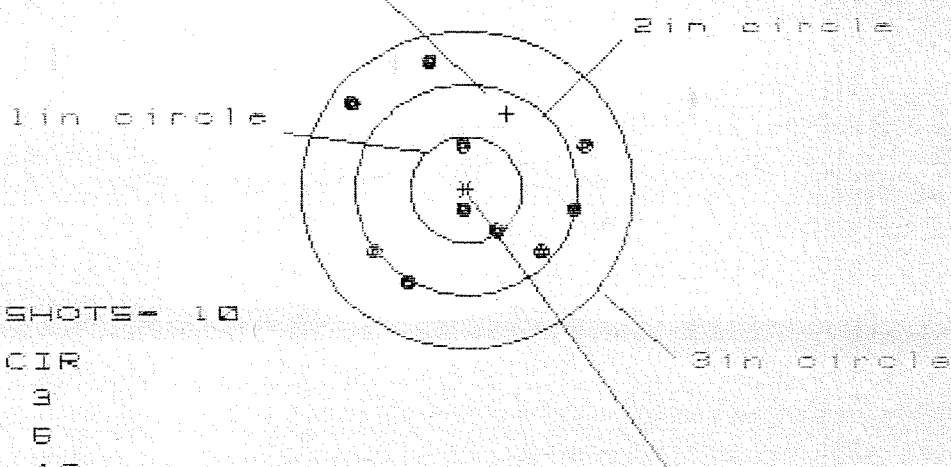
|                             |   |        |        |       |
|-----------------------------|---|--------|--------|-------|
| PATTERN #                   | : | 10     | 9      | 8     |
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | 1.539  | 1.448  | .605  |
| MINIMUM X                   | : | -.823  | -.773  | -.593 |
| MAXIMUM Y                   | : | 1.270  | 1.006  | 1.038 |
| MINIMUM Y                   | : | -2.383 | -1.023 | -.991 |
| CENTROID X                  | : | .265   | .356   | .176  |
| CENTROID Y                  | : | .323   | .587   | .555  |
| POB TO CENTROID in.         | : | .417   | .687   | .582  |
| MIN RADIUS                  | : | .308   | .169   | .068  |
| MEAN RADIUS                 | : | 1.012  | .824   | .699  |
| MAX RADIUS                  | : | 2.521  | 1.471  | 1.068 |
| HORIZONTAL SPREAD           | : | 2.362  | 2.221  | 1.197 |
| VERTICAL SPREAD             | : | 3.653  | 2.029  | 2.029 |
| EXTREME SPREAD              | : | 3.780  | 2.399  | 2.126 |
| NUMBER IN ONE INCH CIRCLE   | = | 3      |        |       |
| NUMBER IN TWO INCH CIRCLE   | = | 6      |        |       |
| NUMBER IN THREE INCH CIRCLE | = | 8      |        |       |

9 Aug 1991

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# CENTERFIRE PATTERNS # 2

POA



# OF SHOTS = 10

# IN CIR

1in = 3

2in = 6

3in = 10

HS = 2.117

VS = 2.113

GS = 2.272

CENTROID #

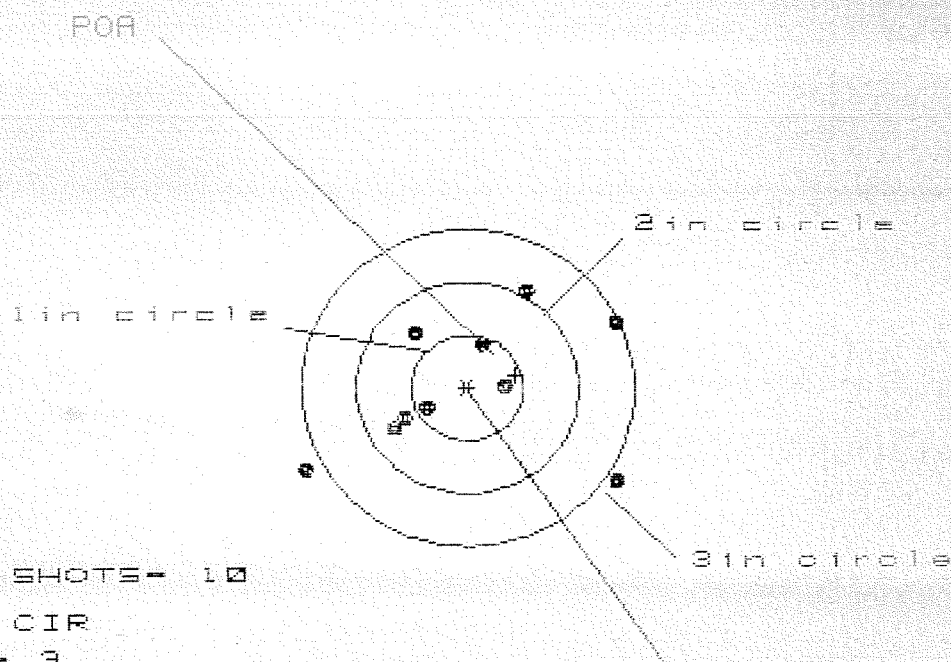
|                             |   |        |       |       |
|-----------------------------|---|--------|-------|-------|
| PATTERN #                   | : | 2      |       |       |
| SHOTS (BEST OF)             | : | 10     | 9     | 8     |
| MAXIMUM X                   | : | 1.053  | .935  | .876  |
| MINIMUM X                   | : | -1.064 | -.908 | -.967 |
| MAXIMUM Y                   | : | 1.186  | 1.277 | .674  |
| MINIMUM Y                   | : | -.927  | -.836 | -.676 |
| CENTROID X                  | : | -.369  | -.251 | -.192 |
| CENTROID Y                  | : | -.720  | -.811 | -.971 |
| POA TO CENTROID in.         | : | .810   | .849  | .990  |
| MIN RADIUS                  | : | .169   | .177  | .116  |
| MEAN RADIUS                 | : | .867   | .794  | .698  |
| MAX RADIUS                  | : | 1.341  | 1.361 | 1.095 |
| HORIZONTAL SPREAD           | : | 2.117  | 1.843 | 1.843 |
| VERTICAL SPREAD             | : | 2.113  | 2.113 | 1.350 |
| EXTREME SPREAD              | : | 2.272  | 2.125 | 2.107 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 3     |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 6     |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 10    |       |

9 Aug 1991

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# CENTERFIRE PATTERNS

# 3



# OF SHOTS- 10

# IN CIR

1 in = 3

2 in = 6

3 in = 8

HS= 2.801

VS= 1.798

GS= 3.125

CENTROID \*

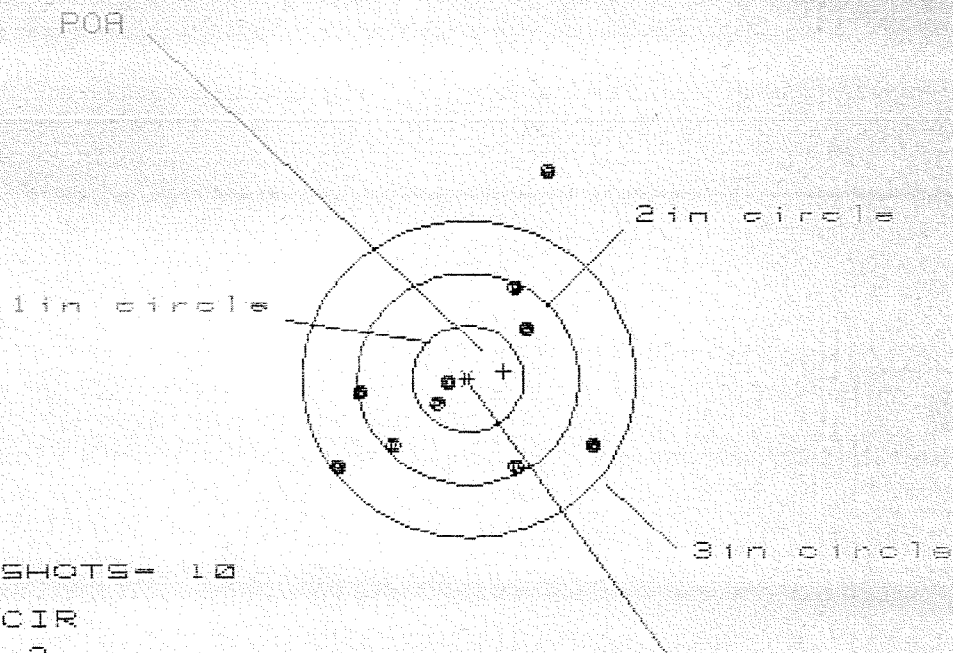
| PATTERN #                   | : | 3      | 9     | 8     |
|-----------------------------|---|--------|-------|-------|
| SHOTS (BEST OF)             | : | 10     | 9     | 8     |
| MAXIMUM X                   | : | 1.340  | 1.177 | 1.384 |
| MINIMUM X                   | : | -1.461 | -.849 | -.702 |
| MAXIMUM Y                   | : | .920   | .829  | .708  |
| MINIMUM Y                   | : | -.878  | -.969 | -.632 |
| CENTROID X                  | : | -.435  | -.272 | -.419 |
| CENTROID Y                  | : | -.120  | -.029 | .092  |
| POA TO CENTROID in.         | : | .451   | .274  | .429  |
| MIN RADIUS                  | : | .336   | .187  | .230  |
| MEAN RADIUS                 | : | .917   | .829  | .714  |
| MAX RADIUS                  | : | 1.672  | 1.524 | 1.365 |
| HORIZONTAL SPREAD           | : | 2.801  | 2.026 | 2.006 |
| VERTICAL SPREAD             | : | 1.798  | 1.798 | 1.340 |
| EXTREME SPREAD              | : | 3.125  | 2.327 | 2.256 |
| NUMBER IN ONE INCH CIRCLE   | = | 3      |       |       |
| NUMBER IN TWO INCH CIRCLE   | = | 6      |       |       |
| NUMBER IN THREE INCH CIRCLE | = | 8      |       |       |

9 Aug 1991

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# CENTERFIRE PATTERNS

# 4



# OF SHOTS- 10

# IN CIR

1in = 2

2in = 7

3in = 9

HS= 2.205

VS= 2.752

GS= 3.291

CENTROID #

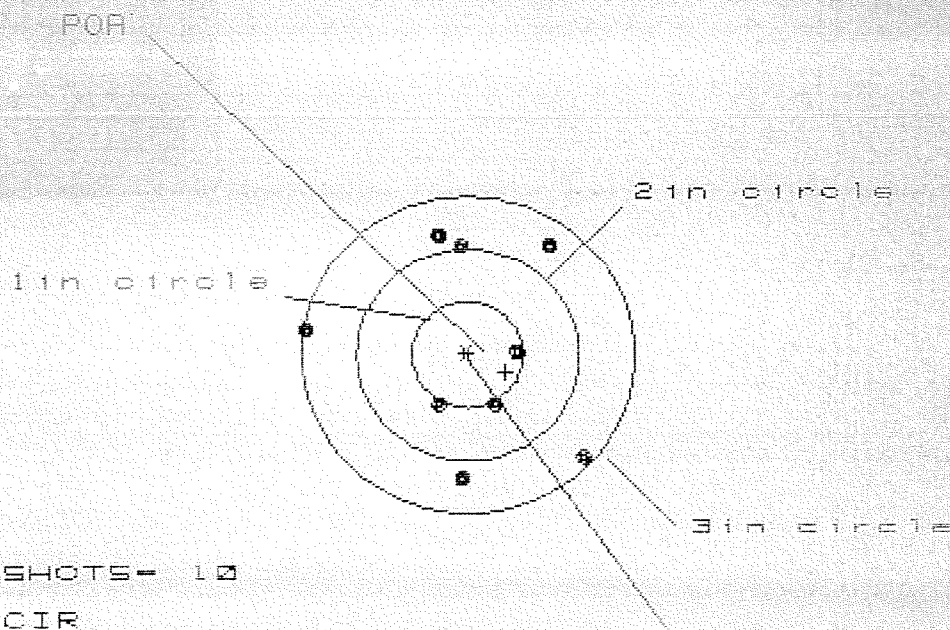
| PATTERN #                   | : | 4      |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.073  | 1.151  | 1.019  |
| MINIMUM X                   | : | -1.132 | -1.054 | -1.001 |
| MAXIMUM Y                   | : | 1.934  | 1.075  | 1.002  |
| MINIMUM Y                   | : | -.818  | -.603  | -.676  |
| CENTROID X                  | : | -.323  | -.401  | -.269  |
| CENTROID Y                  | : | -.071  | -.286  | -.213  |
| POA TO CENTROID in.         | : | .330   | .492   | .343   |
| MIN RADIUS                  | : | .165   | .163   | .217   |
| MEAN RADIUS                 | : | .964   | .806   | .769   |
| MAX RADIUS                  | : | 2.058  | 1.212  | 1.115  |
| HORIZONTAL SPREAD           | : | 2.205  | 2.205  | 2.020  |
| VERTICAL SPREAD             | : | 2.752  | 1.678  | 1.678  |
| EXTREME SPREAD              | : | 3.291  | 2.286  | 2.067  |
| NUMBER IN ONE INCH CIRCLE   | = | 2      |        |        |
| NUMBER IN TWO INCH CIRCLE   | = | 7      |        |        |
| NUMBER IN THREE INCH CIRCLE | = | 9      |        |        |



9 Aug 1991

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# CENTERFIRE PATTERNS # 5



# OF SHOTS = 10

# IN CIR

1in = 2

2in = 4

3in = 10

HS = 2.568

VS = 2.344

GS = 2.803

CENTROID +

| PATTERN #                   | : | 5      | 9      | 8      |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.090  | .925   | .653   |
| MINIMUM X                   | : | -1.478 | -.478  | -.354  |
| MAXIMUM Y                   | : | 1.175  | 1.196  | 1.082  |
| MINIMUM Y                   | : | -1.169 | -1.148 | -1.262 |
| CENTROID X                  | : | -.343  | -.178  | -.294  |
| CENTROID Y                  | : | .168   | .147   | .261   |
| POA TO CENTROID in.         | : | .382   | .231   | .393   |
| MIN RADIUS                  | : | .452   | .291   | .407   |
| MEAN RADIUS                 | : | .968   | .893   | .852   |
| MAX RADIUS                  | : | 1.490  | 1.301  | 1.270  |
| HORIZONTAL SPREAD           | : | 2.568  | 1.395  | 1.007  |
| VERTICAL SPREAD             | : | 2.344  | 2.344  | 2.344  |
| EXTREME SPREAD              | : | 2.803  | 2.529  | 2.354  |
| NUMBER IN ONE INCH CIRCLE   | = | 2      |        |        |
| NUMBER IN TWO INCH CIRCLE   | = | 4      |        |        |
| NUMBER IN THREE INCH CIRCLE | = | 10     |        |        |