

C6636278

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

\*Includes 1 in chamber.

*Remington*




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

MODEL 700<sup>TM</sup> M24

SERIAL NO.  
C6606278

ORDER NO.  
5716

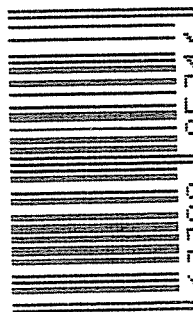
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

20



5716 C6606278

UPC



0 42700 25716 7

M-24

Amr Done

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636278

| OP. #        | OP. NAME                                                       | READINGS | DATE       | INIT |
|--------------|----------------------------------------------------------------|----------|------------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   |          | 6/25/91    | KL   |
| 600          | Proof                                                          |          | 6/25/91    | KL   |
| 607          | Check Headspace                                                |          | 6/25/91    | KL   |
| 610          | Dis-assemble Gun                                               |          | 6/25/91    | KL   |
| 612          | Magnaflux Barrel<br>Action                                     |          | JUL 1 1991 | KR   |
|              | Magnaflux Bolt                                                 |          | JUL 1 1991 | KR   |
| 615          | Rollmark Caliber                                               |          | JUL 1 1991 | LS   |
| 617          | Drill and Tap Sight Holes                                      |          | JUL 1 1991 | LB   |
| 618          | Polish Barrel                                                  |          | JUL 2 1991 | WB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 7-23-91    | AS   |
|              | Apply Coating (Bolt)                                           |          |            |      |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 7/23/91    | KS   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 7/23/91    | KS   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 7/23/91    | KS   |
|              | D) Oil Firing Pin Ass'y                                        |          | 7/23/91    | KS   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 7-31-91    | AS   |

| op. #        | OP. NAME                                                    | READINGS |       |       |      |      | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|-------|-------|------|------|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 7        | 7 1/2 | 7 1/2 |      |      | 7-31-91 | DH   |
|              | G) Safety Off Force                                         | 4        | 4     | 4     |      |      | 7-31-91 | DH   |
|              | H) Trigger Pull Test & Retainability                        |          |       |       |      |      | 7-31-91 | DH   |
|              | I) Firing Pin Indent                                        | .022     | .022  | .021  |      |      | 7-31-91 | DH   |
|              | J) Assemble Stock                                           |          |       |       |      |      | 7-31-91 | KL   |
|              | K) Assemble Swivel Studs                                    |          |       |       |      |      |         |      |
|              | L) Attach Front and Rear Sight Assemblies                   |          |       |       |      |      | 7-31-91 | KL   |
|              | M) Iron Sight Alignment                                     |          |       |       |      |      | 7-31-91 | KL   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |       |       |      |      | 7-31-91 | KL   |
|              | O) Attach Scope to Rifle                                    |          |       |       |      |      | 7-31-91 | KL   |
|              | P) Detach & Attach Scope 20 Times                           |          |       |       |      |      | 7-31-91 | KL   |
| 640          | Gallery Target & Test                                       |          |       |       |      |      | 8-1-91  | DH   |
|              | A) Time                                                     |          |       |       |      |      | 8-1-91  | DH   |
|              | B) Malfunctions                                             |          |       |       |      |      | 8-1-91  | DH   |
|              | C) Pierced Primers                                          |          |       |       |      |      | 8-1-91  | DH   |
|              | D) Optical Clarity of Scope                                 |          |       |       |      |      | 8-1-91  | DH   |
| 645          | Inspect for Live Ammo                                       |          |       |       |      |      | 8-1-91  | DH   |
| 655          | Final Inspection                                            |          |       |       |      |      | 8-5-91  | AC   |
|              | A) Headspace                                                |          |       |       |      |      | 8-5-91  | AC   |
|              | B) Trigger Pull                                             | 2.40     | 2.34  | 2.31  | 2.25 | 2.52 | 8-5-91  | AC   |
|              | C) Function                                                 |          |       |       |      |      | 8-5-91  | AC   |
| 660          | Pack                                                        |          |       |       |      |      | 9-19-91 | AC   |

SWS TRIGGER PULL TEST

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

SERIAL NO. 06636278

DATE 7-31-91

TESTER [Signature]

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.22             | 2.60                     | 2.55                           | 2.40 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.24             | 2.60                     | 2.49                           | 2.39 |                                                                        |
| PULL #3 | 2.22             | 2.57                     | 2.46                           | 2.31 |                                                                        |
| PULL #4 | 2.24             | 2.46                     | 2.50                           | 2.25 |                                                                        |
| PULL #5 | 2.24             | 2.54                     | 2.53                           | 2.52 |                                                                        |
| TOTAL   |                  |                          |                                |      |                                                                        |
| AVG.    |                  |                          |                                |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.38             | 3.62                     |  |          |
| PULL #2 | 3.27             | 3.58                     |  |          |
| PULL #3 | 3.30             | 3.48                     |  |          |
| PULL #4 | 3.28             | 3.46                     |  |          |
| PULL #5 | 3.57             | 3.16                     |  |          |
| 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 | 4.37             | 4.29                     |                                | 4.20                                 |
| PULL #2 | 4.30             | 4.31                     |                                | 4.18                                 |
| PULL #3 | 4.36             | 4.38                     |                                | 4.19                                 |
| PULL #4 | 4.23             | 4.30                     |                                | 4.37                                 |
| PULL #5 | 4.33             | 4.21                     |                                | 4.30                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6636278  
1 Aug 1991

CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| 0 TO | 1 | .489859 |
| 1 TO | 2 | .341013 |
| 2 TO | 3 | .671153 |
| 3 TO | 4 | .68906  |
| 4 TO | 5 | .615773 |

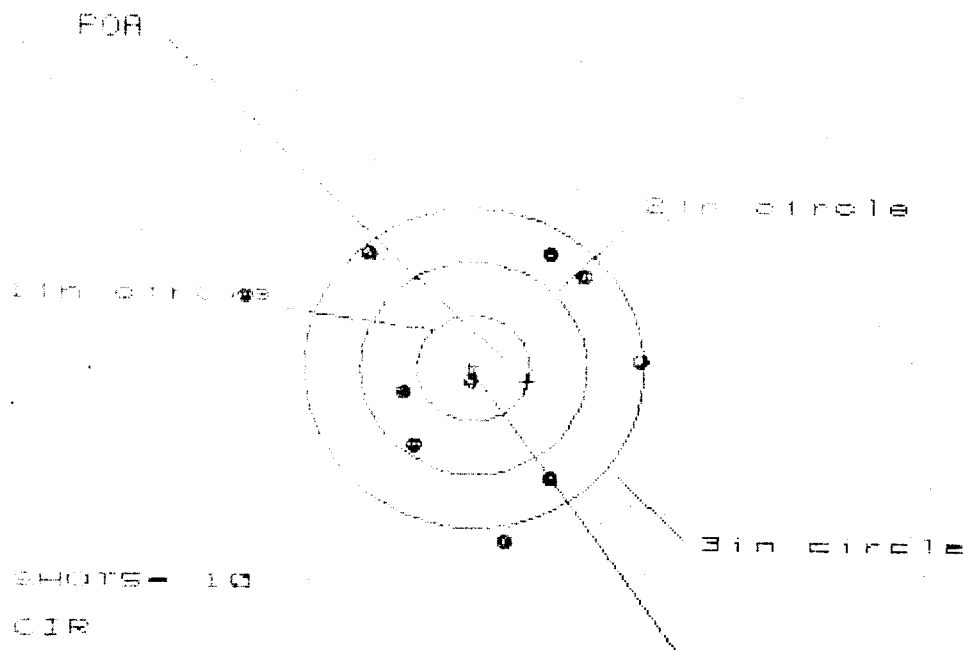
$\begin{matrix} 5 \\ 12.5 \\ 4 \end{matrix}$  <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1102  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0476  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .120041  
THE AMR FOR THIS RIFLE IS: 1.131

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FILE: \PATTERNING\CENTERFIRE\_PATT\08598270

# CENTERFIRE PATTERNS # 1



\* OF SHOTS - 10

\* IN CIR

1 in - 1

2 in - 3

3 in - 6

LS = 3.491

VS = 3.727

GS = 3.545

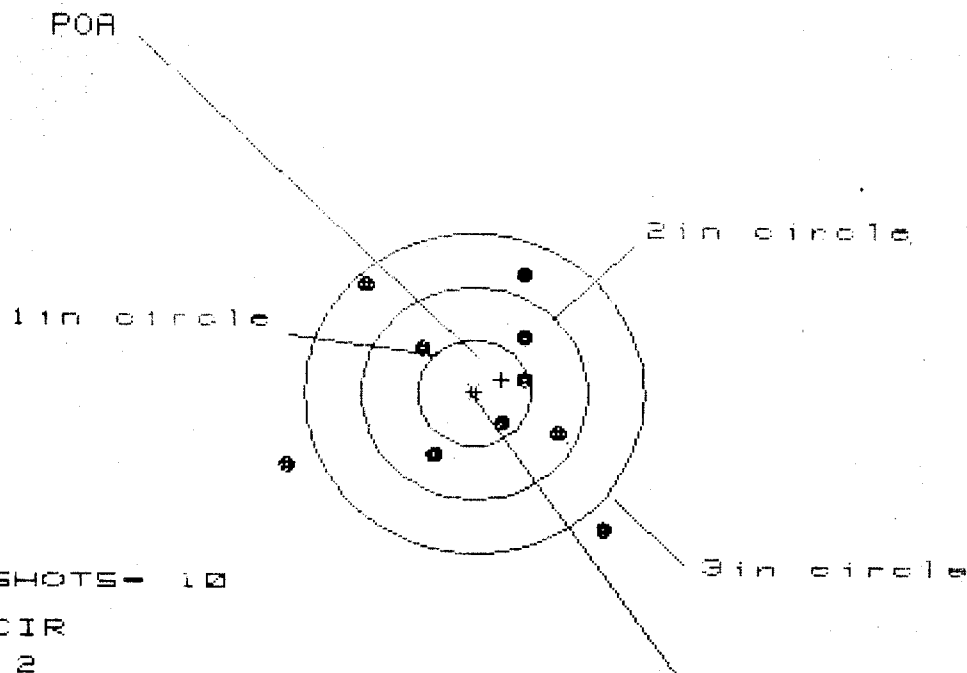
CENTROID \*

|                             |   |        |        |        |
|-----------------------------|---|--------|--------|--------|
| PATTERN #                   | : | 1      |        |        |
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.496  | 1.275  | 1.286  |
| MINIMUM X                   | : | -1.995 | -1.135 | -1.124 |
| MAXIMUM Y                   | : | 1.094  | 1.170  | .976   |
| MINIMUM Y                   | : | -1.633 | -1.557 | -1.159 |
| CENTROID X                  | : | -.474  | -.253  | -.264  |
| CENTROID Y                  | : | .123   | .047   | .241   |
| POA TO CENTROID in.         | : | .490   | .257   | .358   |
| MIN RADIUS                  | : | .165   | .251   | .361   |
| MEAN RADIUS                 | : | 1.220  | 1.118  | 1.064  |
| MAX RADIUS                  | : | 2.108  | 1.605  | 1.466  |
| HORIZONTAL SPREAD           | : | 3.491  | 2.410  | 2.410  |
| VERTICAL SPREAD             | : | 3.727  | 2.727  | 2.134  |
| EXTREME SPREAD              | : | 3.545  | 2.957  | 2.617  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 1      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 3      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 8      |        |

1 AUG

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# CENTERFIRE PATTERNS # 2



# OF SHOTS- 10

# IN CIR

1in - 2

2in - 6

3in - 8

HS- 2.818

VS- 2.372

GS- 3.106

| PATTERN #                   | : | 10     | 9      | 8      |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.185  | 1.004  | .636   |
| MINIMUM X                   | : | -1.633 | -1.159 | -1.034 |
| MAXIMUM Y                   | : | 1.139  | 1.064  | .900   |
| MINIMUM Y                   | : | -1.233 | -1.308 | -.798  |
| CENTROID X                  | : | -.241  | -.060  | -.185  |
| CENTROID Y                  | : | -.126  | -.051  | .112   |
| POA TO CENTROID in.         | : | .272   | .078   | .217   |
| MIN RADIUS                  | : | .315   | .306   | .454   |
| MEAN RADIUS                 | : | .969   | .850   | .761   |
| MAX RADIUS                  | : | 1.767  | 1.649  | 1.282  |
| HORIZONTAL SPREAD           | : | 2.818  | 2.163  | 1.670  |
| VERTICAL SPREAD             | : | 2.372  | 2.372  | 1.699  |
| EXTREME SPREAD              | : | 3.106  | 3.106  | 2.186  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 6      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 8      |        |

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# INTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

# OF SHOTS- 10

# IN CIR

1in = 0

2in = 3

3in = 7

HS= 2.514

VS= 3.039

GS= 3.134

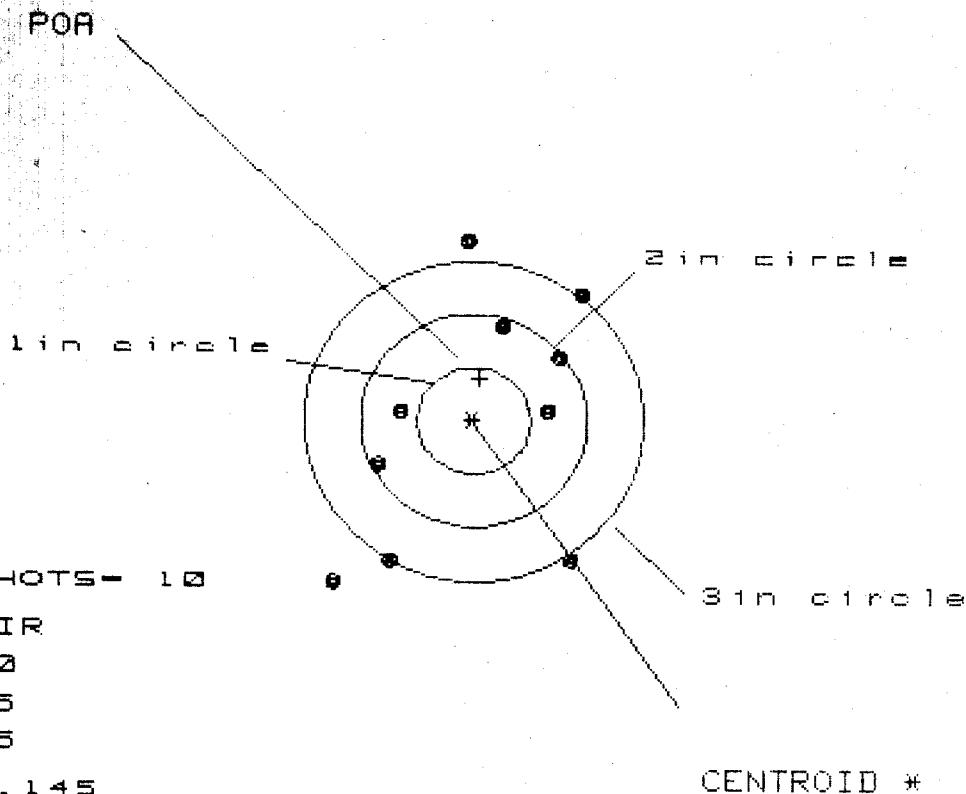
CENTROID #

| PATTERN #                   | : | 10     | 9      | 8      |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.385  | 1.464  | 1.332  |
| MINIMUM X                   | : | -1.128 | -1.050 | -1.149 |
| MAXIMUM Y                   | : | 1.566  | 1.402  | 1.239  |
| MINIMUM Y                   | : | -1.473 | -1.303 | -1.301 |
| CENTROID X                  | : | .110   | .031   | .163   |
| CENTROID Y                  | : | -.165  | -.001  | .162   |
| POA TO CENTROID in.         | : | .198   | .031   | .229   |
| MIN RADIUS                  | : | .520   | .427   | .219   |
| MEAN RADIUS                 | : | 1.173  | 1.094  | .972   |
| MAX RADIUS                  | : | 1.633  | 1.674  | 1.425  |
| HORIZONTAL SPREAD           | : | 2.514  | 2.514  | 2.481  |
| VERTICAL SPREAD             | : | 3.039  | 2.705  | 2.540  |
| EXTREME SPREAD              | : | 3.134  | 2.907  | 2.575  |
| NUMBER IN ONE INCH CIRCLE   | = | 0      |        |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 3      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 7      |        |

1 May 1981

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# CENTERFIRE PATTERNS # 4



# OF SHOTS- 10

# IN CIR

1 in = 0

2 in = 5

3 in = 5

HS= 2.145

VS= 3.190

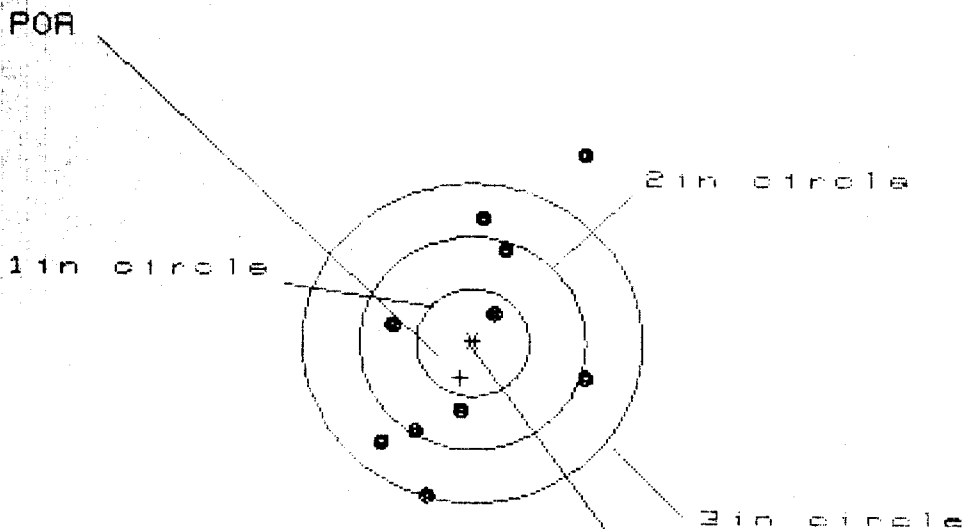
GS= 3.441

| PATTERN #                   | : |        |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | .932   | .798   | .780   |
| MINIMUM X                   | : | -1.213 | -.951  | -.969  |
| MAXIMUM Y                   | : | 1.686  | 1.519  | 1.210  |
| MINIMUM Y                   | : | -1.504 | -1.472 | -1.282 |
| CENTROID X                  | : | -.053  | .081   | .099   |
| CENTROID Y                  | : | -.397  | -.230  | -.420  |
| POA TO CENTROID in.         | : | .401   | .244   | .432   |
| MIN RADIUS                  | : | .650   | .535   | .512   |
| MEAN RADIUS                 | : | 1.233  | 1.125  | 1.080  |
| MAX RADIUS                  | : | 1.932  | 1.723  | 1.574  |
| HORIZONTAL SPREAD           | : | 2.145  | 1.749  | 1.749  |
| VERTICAL SPREAD             | : | 3.190  | 2.991  | 2.492  |
| EXTREME SPREAD              | : | 3.441  | 3.085  | 3.013  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 0      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 5      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 5      |        |

1 Aug 1991

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# CENTERFIRE PATTERNS # 5



\* OF SHOTS- 10

\* IN CIR

1in = 1

2in = 4

3in = 9

HS= 1.836

VS= 3.176

GS= 3.464

CENTROID \*

|                               |   |        |        |       |
|-------------------------------|---|--------|--------|-------|
| PATTERN #                     | : |        |        |       |
| SHOTS (BEST OF)               | : | 10     | 9      | 8     |
| MAXIMUM X                     | : | 1.004  | 1.058  | 1.025 |
| MINIMUM X                     | : | -.832  | -.721  | -.754 |
| MAXIMUM Y                     | : | 1.768  | 1.380  | 1.229 |
| MINIMUM Y                     | : | -1.408 | -1.212 | -.897 |
| CENTROID X                    | : | .107   | -.004  | .029  |
| CENTROID Y                    | : | .327   | .131   | .282  |
| POA TO CENTROID in.           | : | .344   | .131   | .284  |
| MIN RADIUS                    | : | .367   | .444   | .450  |
| MEAN RADIUS                   | : | 1.062  | .932   | .889  |
| MAX RADIUS                    | : | 2.033  | 1.394  | 1.239 |
| HORIZONTAL SPREAD             | : | 1.836  | 1.779  | 1.779 |
| VERTICAL SPREAD               | : | 3.176  | 2.592  | 2.126 |
| EXTREME SPREAD                | : | 3.464  | 2.632  | 2.313 |
| NUMBER IN ONE INCH CIRCLE =   | : |        | 1      |       |
| NUMBER IN TWO INCH CIRCLE =   | : |        | 4      |       |
| NUMBER IN THREE INCH CIRCLE = | : |        | 9      |       |