

C6636311

MODEL 700<sup>TM</sup> M24

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

Action

Barrel Length

Capacity

Order No. **5715**

\*Includes 1 in chamber.



**Remington**<sup>®</sup> **DU PONT**  
REG. U.S. PAT. & TM. OFF.

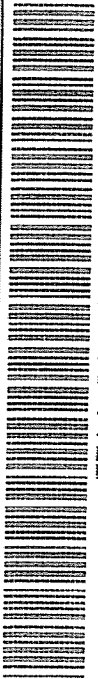
**MODEL 700<sup>TM</sup> H24**

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

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

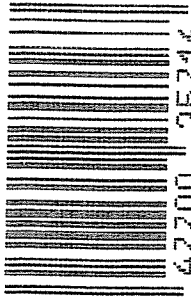
**SERIAL NO.**  
**C6636311**

**ORDER NO.**  
**5716**



5716 C6636311

LPC



0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636311

| OP. #        | OP. NAME                                                       | READINGS | DATE       | INIT |
|--------------|----------------------------------------------------------------|----------|------------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   |          | 6/27/91    | KA   |
| 600          | Proof                                                          |          | 6/27/91    | KA   |
| 607          | Check Headspace                                                |          | 6/27/91    | KA   |
| 610          | Dis-assemble Gun                                               |          | 6/27/91    | KA   |
| 612          | Magnaflux Barrel<br>Action                                     |          | JUL 2 1991 | KR   |
|              | Magnaflux Bolt                                                 |          | JUL 2 1991 | KR   |
| 615          | Rollmark Caliber                                               |          | JUL 2 1991 | KR   |
| 617          | Drill and Tap Sight Holes                                      |          | JUL 2 1991 | LB   |
| 618          | Polish Barrel                                                  |          | JUL 7 1991 | WB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 8/6/91     | KA   |
|              | Apply Coating (Bolt)                                           |          |            | KA   |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 8/15/91    | KA   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 8/15/91    | KA   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 8/15/91    | KA   |
|              | D) Oil Firing Pin Ass'y                                        |          | 8/15/91    | KA   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 8/16/91    | WB   |

| op. #        | OP. NAME                                                    | READINGS                      |                               |                               | DATE    | INIT |         |    |
|--------------|-------------------------------------------------------------|-------------------------------|-------------------------------|-------------------------------|---------|------|---------|----|
| 625<br>cont. | F) Safety On Force                                          | 4 <sup>3</sup> / <sub>4</sub> | 4 <sup>1</sup> / <sub>2</sub> | 4 <sup>1</sup> / <sub>2</sub> | 8/16/91 | WB   |         |    |
|              | G) Safety Off Force                                         | 2 <sup>1</sup> / <sub>4</sub> | 2 <sup>1</sup> / <sub>4</sub> | 2 <sup>1</sup> / <sub>4</sub> | 8/16/91 | WB   |         |    |
|              | H) Trigger Pull Test & Retainability                        |                               |                               |                               | 8/16/91 | WB   |         |    |
|              | I) Firing Pin Indent                                        | .0225                         | .0225                         | .022                          | 8/16/91 | WB   |         |    |
|              | J) Assemble Stock                                           |                               |                               |                               | 8/16/91 | KJ   |         |    |
|              | K) Assemble Swivel Studs                                    |                               |                               |                               | 8/22/91 | KJ   |         |    |
|              | L) Attach Front and Rear Sight Assemblies                   |                               |                               |                               | 8/16/91 | KJ   |         |    |
|              | M) Iron Sight Alignment                                     |                               |                               |                               | 8/16/91 | KJ   |         |    |
|              | N) Detach Front & Rear Sights & place in numbered container |                               |                               |                               | 8/16/91 | KJ   |         |    |
|              | O) Attach Scope to Rifle                                    |                               |                               |                               | 8/16/91 | KJ   |         |    |
|              | P) Detach & Attach Scope 20 Times                           |                               |                               |                               | 8/16/91 | KJ   |         |    |
| 640          | Gallery Target & Test                                       |                               |                               |                               | 8/16/91 | KJ   |         |    |
|              | A) Time                                                     |                               |                               |                               |         | KJ   |         |    |
|              | B) Malfunctions                                             |                               |                               |                               |         | KJ   |         |    |
|              | C) Pierced Primers                                          |                               |                               |                               |         | KJ   |         |    |
|              | D) Optical Clarity of Scope                                 |                               |                               |                               |         | KJ   |         |    |
| 645          | Inspect for Live Ammo                                       |                               |                               |                               | 8/19/91 | KJ   |         |    |
| 655          | Final Inspection                                            |                               |                               |                               |         |      |         |    |
|              | A) Headspace                                                |                               |                               |                               | 8/22/91 | KJ   |         |    |
|              | B) Trigger Pull                                             | 2.34                          | 2.41                          | 2.44                          | 2.46    | 2.37 | 8-20-91 | DH |
|              | C) Function                                                 |                               |                               |                               |         |      | 8/22/91 | KJ |
| 660          | Pack                                                        |                               |                               |                               |         |      | 9-18-91 | KJ |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6636311  
23 Aug 1991

CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| 0 TO | 1 | .133184 |
| 1 TO | 2 | .090802 |
| 1 TO | 3 | .158474 |
| 1 TO | 4 | .101789 |
| 1 TO | 5 | .191651 |

95 (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1448  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0236  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .146711

THE AMP FOR THIS RIFLE IS: .9444

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/CBB3B311

# CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

# OF SHOTS = 10

# IN CIR

1 in = 1

2 in = 4

3 in = 9

HS = 2.586

VS = 2.471

CS = 3.098

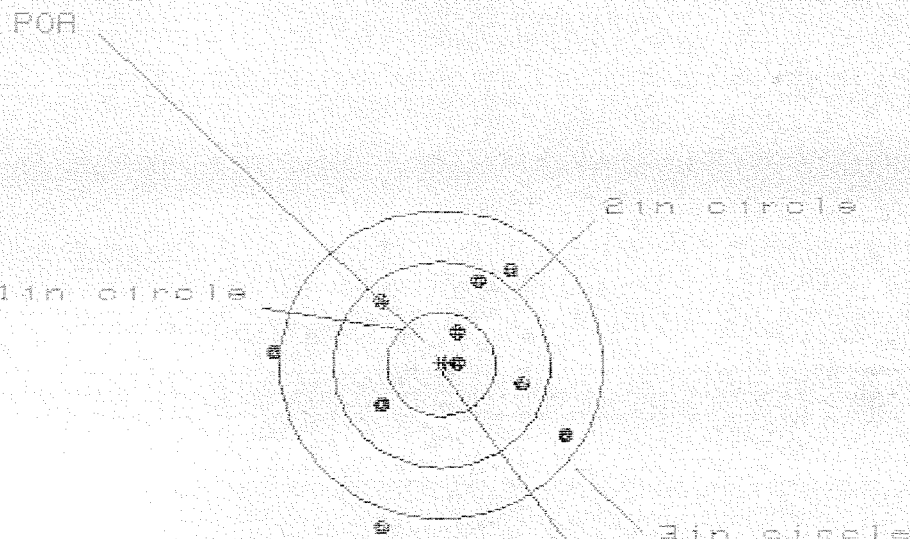
CENTROID \*

| PATTERN #                     | 1      | 2      | 3      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.331  | 1.229  | .873   |
| MINIMUM X                     | -1.255 | -1.357 | -1.203 |
| MAXIMUM Y                     | .922   | .749   | .800   |
| MINIMUM Y                     | -1.549 | -1.201 | -1.150 |
| CENTROID X                    | -.133  | -.031  | -.185  |
| CENTROID Y                    | .007   | .180   | .129   |
| POA TO CENTROID in.           | .134   | .182   | .225   |
| MIN RADIUS                    | .316   | .184   | .198   |
| MEAN RADIUS                   | 1.027  | .904   | .848   |
| MAX RADIUS                    | 1.802  | 1.366  | 1.404  |
| HORIZONTAL SPREAD             | 2.586  | 2.586  | 2.076  |
| VERTICAL SPREAD               | 2.471  | 1.950  | 1.950  |
| EXTREME SPREAD                | 3.098  | 2.619  | 2.335  |
| NUMBER IN ONE INCH CIRCLE =   | 1      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 4      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 9      |        |        |

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FILE:/PATTERNING/CENTERFIRE\_PATT/C8696311

# CENTERFIRE PATTERNS # 2



# OF SHOTS= 10

# IN CIR

1in = 2

2in = 6

3in = 8

HS= 2.715

VS= 2.534

CS= 2.817

CENTROID \*

|                             |   |        |        |       |
|-----------------------------|---|--------|--------|-------|
| PATTERN #                   | : | 2      |        |       |
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | 1.161  | 1.100  | .898  |
| MINIMUM X                   | : | -1.554 | -1.615 | -.849 |
| MAXIMUM Y                   | : | .968   | .794   | .783  |
| MINIMUM Y                   | : | -1.566 | -.836  | -.847 |
| CENTROID X                  | : | -.046  | .015   | .217  |
| CENTROID Y                  | : | -.019  | .155   | .165  |
| POA TO CENTROID in.         | : | .050   | .156   | .273  |
| MIN RADIUS                  | : | .189   | .183   | .187  |
| MEAN RADIUS                 | : | .945   | .830   | .711  |
| MAX RADIUS                  | : | 1.661  | 1.617  | 1.234 |
| HORIZONTAL SPREAD           | : | 2.715  | 2.715  | 1.747 |
| VERTICAL SPREAD             | : | 2.534  | 1.630  | 1.630 |
| EXTREME SPREAD              | : | 2.817  | 2.817  | 2.140 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 6      |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 8      |       |

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# CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

# OF SHOTS- 10

# IN CIR

1 in = 3

2 in = 5

3 in = 10

HS= 2.262

VS= 2.425

GS= 2.530

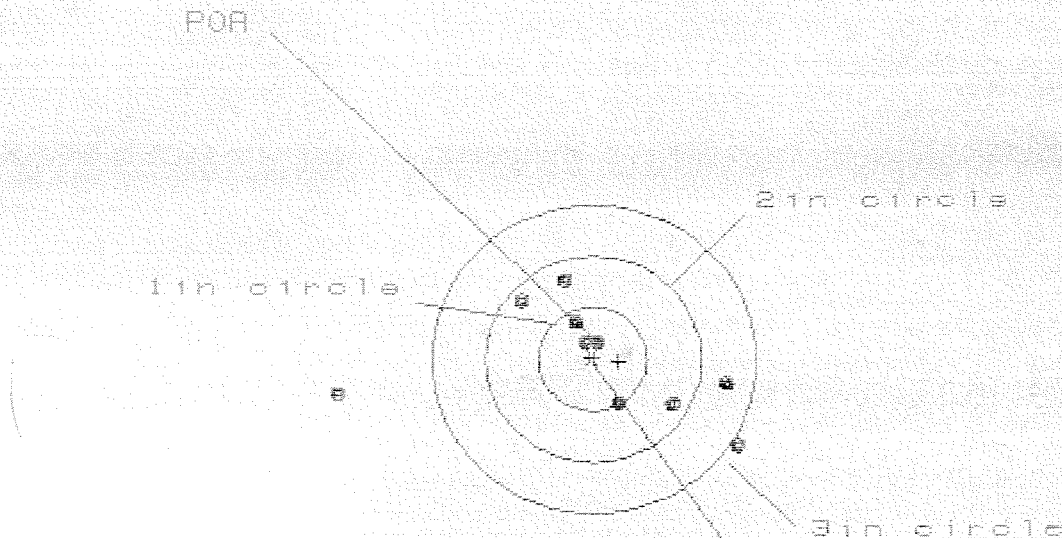
CENTROID #

| PATTERN #                   | 10     | 9      | 8     |
|-----------------------------|--------|--------|-------|
| SHOTS (BEST OF)             | 10     | 9      | 8     |
| MAXIMUM X                   | 1.050  | .989   | .829  |
| MINIMUM X                   | -1.212 | -1.273 | -.605 |
| MAXIMUM Y                   | 1.288  | .545   | .554  |
| MINIMUM Y                   | -1.137 | -.994  | -.926 |
| CENTROID X                  | .002   | .063   | .223  |
| CENTROID Y                  | -.076  | -.219  | -.287 |
| POA TO CENTROID in.         | .076   | .228   | .364  |
| MIN RADIUS                  | .064   | .186   | .307  |
| MEAN RADIUS                 | .782   | .722   | .655  |
| MAX RADIUS                  | 1.401  | 1.385  | .949  |
| HORIZONTAL SPREAD           | 2.262  | 2.262  | 1.434 |
| VERTICAL SPREAD             | 2.425  | 1.539  | 1.480 |
| EXTREME SPREAD              | 2.530  | 2.504  | 1.628 |
| NUMBER IN ONE INCH CIRCLE   | = 3    |        |       |
| NUMBER IN TWO INCH CIRCLE   | = 6    |        |       |
| NUMBER IN THREE INCH CIRCLE | = 10   |        |       |

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FILE=PATTERNING/CENTERFIRE\_PATT/C8636311

# CENTERFIRE PATTERNS # 4



# OF SHOTS= 10

# IN CIR= 10

1in = 4

2in = 7

3in = 8

HS= 3.649

VS= 1.566

GS= 3.680

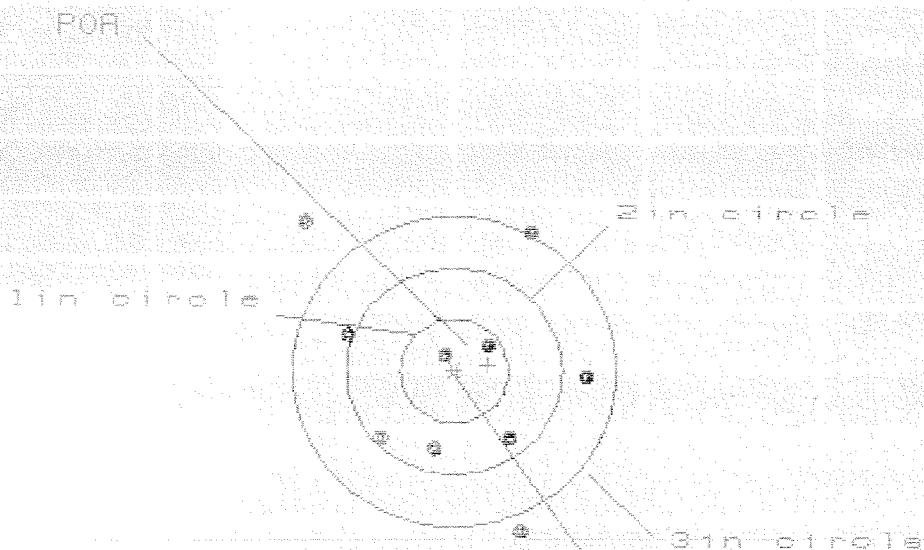
CENTROID #

| PATTERN #                   | : | 4      |       |       |
|-----------------------------|---|--------|-------|-------|
| SHOTS (BEST OF)             | : | 10     | 9     | 8     |
| MAXIMUM X                   | : | 1.207  | 1.025 | 1.065 |
| MINIMUM X                   | : | -2.362 | -.902 | -.774 |
| MAXIMUM Y                   | : | .782   | .748  | .646  |
| MINIMUM Y                   | : | -.784  | -.818 | -.595 |
| CENTROID X                  | : | -.233  | .029  | -.099 |
| CENTROID Y                  | : | .026   | .060  | .162  |
| POA TO CENTROID in.         | : | .235   | .066  | .190  |
| MIN RADIUS                  | : | .179   | .269  | .105  |
| MEAN RADIUS                 | : | .898   | .730  | .610  |
| MAX RADIUS                  | : | 2.381  | 1.311 | 1.129 |
| HORIZONTAL SPREAD           | : | 3.649  | 1.927 | 1.839 |
| VERTICAL SPREAD             | : | 1.566  | 1.566 | 1.241 |
| EXTREME SPREAD              | : | 3.680  | 2.373 | 2.021 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 4     |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 7     |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 8     |       |

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# CENTERFIRE PATTERNS # 5



# OF SHOTS= 10

# IN CIR

1in = 2

2in = 5

3in = 7

HE= 2.665

VE= 2.955

GE= 3.606

CENTROID #

PATTERN #

5

| SHOTS (BEST OF)               | 10     | 9      | 8      |
|-------------------------------|--------|--------|--------|
| MAXIMUM X                     | 1.247  | 1.089  | 1.150  |
| MINIMUM X                     | -1.418 | -1.164 | -1.103 |
| MAXIMUM Y                     | 1.429  | 1.501  | 1.330  |
| MINIMUM Y                     | -1.526 | -1.368 | -1.788 |
| CENTROID X                    | -.314  | -.156  | -.217  |
| CENTROID Y                    | -.056  | -.214  | -.043  |
| POA TO CENTROID in.           | .318   | .265   | .222   |
| MIN RADIUS                    | .218   | .440   | .276   |
| MEAN RADIUS                   | 1.070  | .956   | .877   |
| MAX RADIUS                    | 2.013  | 1.588  | 1.451  |
| HORIZONTAL SPREAD             | 2.665  | 2.253  | 2.253  |
| VERTICAL SPREAD               | 2.955  | 2.869  | 2.118  |
| EXTREME SPREAD                | 3.606  | 2.869  | 2.389  |
| NUMBER IN ONE INCH CIRCLE =   |        | 2      |        |
| NUMBER IN TWO INCH CIRCLE =   |        | 5      |        |
| NUMBER IN THREE INCH CIRCLE = |        | 7      |        |

SWS TRIGGER PULL TEST

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

SERIAL NO. C6636311  
DATE 8/16/91  
TESTER WB

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.36             | 2.55                     | 2.54                           | 2.34 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.38             | 2.61                     | 2.50                           | 2.41 |                                                                        |
| PULL #3 | 2.47             | 2.73                     | 2.47                           | 2.44 |                                                                        |
| PULL #4 | 2.44             | 2.74                     | 2.48                           | 2.46 |                                                                        |
| PULL #5 | 2.47             | 2.53                     | 2.38                           | 2.37 |                                                                        |
| TOTAL   | 12.12            | 13.16                    | 12.37                          |      |                                                                        |
| AVG.    | 2.42             | 2.63                     | 2.47                           |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.29             | 3.38                     |  |          |
| PULL #2 | 3.30             | 3.36                     |  |          |
| PULL #3 | 3.38             | 3.18                     |  |          |
| PULL #4 | 3.37             | 3.31                     |  |          |
| PULL #5 | 3.21             | 3.33                     |  |          |
| TOTAL   | 16.55            | 16.56                    |  |          |
| AVG.    | 3.31             | 3.31                     |  |          |

|         | 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 | 4.21             | 4.35                     |                                | 4.21                                 |
| PULL #2 | 4.08             | 4.31                     |                                | 4.37                                 |
| PULL #3 | 4.10             | 4.19                     |                                | 4.36                                 |
| PULL #4 | 4.16             | 4.17                     |                                | 4.36                                 |
| PULL #5 | 4.20             | 4.25                     |                                | 4.00                                 |
| TOTAL   | 20.75            | 21.27                    |                                | 21.30                                |
| AVG.    | 4.15             | 4.25                     |                                | 4.26                                 |