

C6636313

MODEL 760™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

\*Includes 1 in chamber.

*Remington*

| MOD. _____ |      | GA.<br>CAL. _____           | GUN<br># _____ |
|------------|------|-----------------------------|----------------|
| #          | DATE | MALFUNCTION/DEFECT          | ASSEM.<br>#    |
| 7-18-91    | 1st  | after hits stuck            | KS             |
| 7/18/91    | 2nd  | FILED STUCK<br><u>REP'D</u> | <u>KS</u>      |
|            | 3rd  |                             |                |
|            | 4th  |                             |                |

FUNCTION \_\_\_\_\_ RD 6654 Rev 1

| TEST INIT. ACTION TO CORRECT |          | ASSEM.<br># |
|------------------------------|----------|-------------|
| PROOF                        |          |             |
| TEST                         |          |             |
| TGT                          |          |             |
| PROOF                        |          |             |
| TEST                         |          |             |
| TGT                          |          |             |
| PROOF                        | ENGINEER |             |
| TEST                         |          |             |
| TGT                          |          |             |
| PROOF                        | ENGINEER |             |
| TEST                         |          |             |
| TGT                          |          |             |




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

MODEL 700<sup>TM</sup> M24

SERIAL NO.  
C6636313

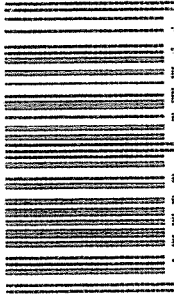
ORDER NO.  
5716

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



5716 C6636313

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636313

| OP. #     | OP. NAME                                                 | READINGS         | DATE    | INIT |
|-----------|----------------------------------------------------------|------------------|---------|------|
| 575 & 580 | Assemble Action and Stock                                | QUALITY<br>AUDIT | 5/3/91  | KS   |
| 600       | Proof                                                    |                  | 5/3/91  | KS   |
| 607       | Check Headspace                                          |                  | 5/3/91  | KS   |
| 610       | Dis-assemble Gun                                         |                  | 5/3/91  | KS   |
| 612       | Magnaflux Barrel Action                                  | 5 8 9 1          |         | KCK  |
|           | Magnaflux Bolt                                           | 5 8 9 1          |         | KCK  |
| 615       | Rollmark Caliber                                         | 5 8 9 1          |         | GB.  |
| 617       | Drill and Tap Sight Holes                                | 5 15 9 1         |         | LB   |
| 618       | Polish Barrel                                            | 5 15 9 1         |         | WB   |
| 620       | Apply Coatings (Barrel Action)                           |                  | 5-25-91 | JA   |
|           | Apply Coating (Bolt)                                     |                  |         |      |
| 625       | Final Assembly                                           |                  |         |      |
|           | A) Clean inside of Bolt Assembly                         |                  | 6/4/91  | KS   |
|           | B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head |                  | 6/4/91  | KS   |
|           | C) Inspect Ejector Hole for Chamfer                      |                  | 6/4/91  | KS   |
|           | D) Oil Firing Pin Ass'y                                  |                  | 6/4/91  | KS   |
|           | E) Adjust Trigger Pull to Min Setting and Stake          |                  | 6-5-91  | GM   |

~~REAR SEAT~~

| op. #        | OP. NAME                                                    | READINGS |      |      | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|------|------|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 6        | 6    | 6    | 6/5/91  | JH   |
|              | G) Safety Off Force                                         | 4        | 4    | 4    | 6-5-91  | JH   |
|              | H) Trigger Pull Test & Retainability                        |          |      |      | 6-5-91  | JH   |
|              | I) Firing Pin Indent                                        | .022     | .022 | .022 | 6-5-91  | JH   |
|              | J) Assemble Stock                                           |          |      |      | 7/16/91 | KS   |
|              | K) Assemble Swivel Studs                                    |          |      |      | 7-23-91 | DH   |
|              | L) Attach Front and Rear Sight Assemblies                   |          |      |      | 7/16/91 | KS   |
|              | M) Iron Sight Alignment                                     |          |      |      | 7/16/91 | KS   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |      |      | 7/16/91 | KS   |
|              | O) Attach Scope to Rifle                                    |          |      |      | 7/16/91 | KS   |
|              | P) Detach & Attach Scope 20 Times                           |          |      |      | 7/16/91 | KS   |
| 640          | Gallery Target & Test                                       |          |      |      | 7-18-91 | DH   |
|              | A) Time                                                     |          |      |      | 7-18-91 | DH   |
|              | B) Malfunctions                                             |          |      |      | 7-18-91 | DH   |
|              | C) Pierced Primers                                          |          |      |      | 7-18-91 | DH   |
|              | D) Optical Clarity of Scope                                 |          |      |      | 7-18-91 | DH   |
| 645          | Inspect for Live Ammo                                       |          |      |      | 7-18-91 | DH   |
| 655          | Final Inspection                                            |          |      |      |         |      |
|              | A) Headspace                                                |          |      |      | 7-23-91 | DH   |
|              | B) Trigger Pull                                             | 2.57     | 2.52 | 2.35 | 7-23-91 | JH   |
|              | C) Function                                                 |          |      | 2.43 | 7-23-91 | DH   |
| 660          | Pack                                                        |          |      |      | 7-17-91 | DH   |

SWS TRIGGER PULL TEST

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

SERIAL NO. C6636313  
DATE 6-17-91  
TESTER DH

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.45             | 2.46                     | 2.74                           | 2.51 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.48             | 2.27                     | 2.72                           | 2.52 |                                                                        |
| PULL #3 | 2.39             | 2.47                     | 2.70                           | 2.35 |                                                                        |
| PULL #4 | 2.44             | 2.45                     | 2.71                           | 2.43 |                                                                        |
| PULL #5 | 2.45             | 2.57                     | 2.72                           | 2.40 |                                                                        |
| TOTAL   |                  |                          |                                |      |                                                                        |
| AVG.    |                  |                          |                                |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.28             | 3.38                     |  |          |
| PULL #2 | 3.38             | 3.48                     |  |          |
| PULL #3 | 3.25             | 3.42                     |  |          |
| PULL #4 | 3.32             | 3.33                     |  |          |
| PULL #5 | 3.35             | 3.42                     |  |          |
| 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 | 4.20             | 4.27                     |                                | 4.36                                 |
| PULL #2 | 4.19             | 4.28                     |                                | 4.20                                 |
| PULL #3 | 4.16             | 4.27                     |                                | 4.24                                 |
| PULL #4 | 4.20             | 4.28                     |                                | 4.26                                 |
| PULL #5 | 4.24             | 4.23                     |                                | 4.11                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6636313  
18 Jul 1991

CENTROIDAL DISTANCES

|        |          |
|--------|----------|
| 0 TO 1 | .241748  |
| 1 TO 2 | .639088  |
| 1 TO 3 | .202872  |
| 1 TO 4 | .0922008 |
| 1 TO 5 | .56978   |

24 1000000 FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0436  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0112  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0450155

THE AMR FOR THIS RIFLE IS: .9058

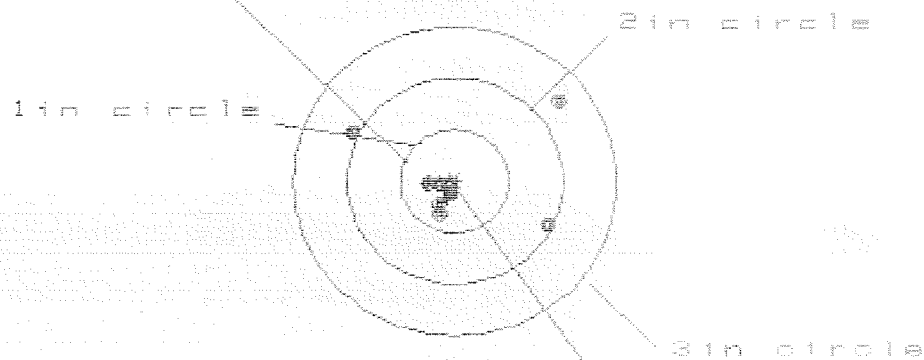
18 Jul 1991

FILE:/PATTERNING/CENTERFIRE PATT/C8696313

# CENTERFIRE PATTERNS

# 1

POB



# OF SHOTS= 10

# IN CIR

1in = 7

2in = 8

3in = 10

HS= 1.868

VS= 1.214

GS= 2.019

CENTROID #

|                             |   |       |       |       |
|-----------------------------|---|-------|-------|-------|
| PATTERN #                   | : | 1     |       |       |
| SHOTS (BEST OF)             | : | 10    | 9     | 8     |
| MAXIMUM X                   | : | .951  | .999  | .898  |
| MINIMUM X                   | : | -.917 | -.812 | -.201 |
| MAXIMUM Y                   | : | .815  | .584  | .186  |
| MINIMUM Y                   | : | -.400 | -.309 | -.236 |
| CENTROID X                  | : | .241  | .136  | .237  |
| CENTROID Y                  | : | .019  | -.072 | -.145 |
| POB TO CENTROID in.         | : | .242  | .154  | .278  |
| MIN RADIUS                  | : | .091  | .031  | .117  |
| MEAN RADIUS                 | : | .475  | .330  | .278  |
| MAX RADIUS                  | : | 1.252 | 1.046 | .928  |
| HORIZONTAL SPREAD           | : | 1.868 | 1.811 | 1.099 |
| VERTICAL SPREAD             | : | 1.214 | .893  | .422  |
| EXTREME SPREAD              | : | 2.019 | 2.019 | 1.161 |
| NUMBER IN ONE INCH CIRCLE   | = |       | 7     |       |
| NUMBER IN TWO INCH CIRCLE   | = |       | 8     |       |
| NUMBER IN THREE INCH CIRCLE | = |       | 10    |       |

18 Jul 1931

FILE:/PATTERNING/CENTERFIRE\_PATT/C8636313

# CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

# OF SHOTS= 10

# IN CIR

1in = 1

2in = 2

3in = 5

HS= 3.296

VS= 2.381

CS= 3.859

CENTROID #

PATTERN #

2

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.615

1.428

1.386

MINIMUM X

-1.681

-1.822

-1.643

MAXIMUM Y

.927

.807

.783

MINIMUM Y

-1.454

-1.574

-1.473

CENTROID X

-.392

-.205

-.384

CENTROID Y

-.069

.051

-.050

POA TO CENTROID in.

.398

.211

.387

MIN RADIUS

.369

.263

.349

MEAN RADIUS

1.330

1.220

1.177

MAX RADIUS

1.998

1.983

1.722

HORIZONTAL SPREAD

3.296

3.250

3.029

VERTICAL SPREAD

2.381

2.381

2.176

EXTREME SPREAD

3.859

3.452

3.098

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

2

NUMBER IN THREE INCH CIRCLE =

5

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FILE:/PATTERNING/CENTERFIRE\_PATT/C8B3B313

# CENTERFIRE PATTERNS

# 3

POA

1 in circle

2 in circle

3 in circle

CENTROID #

# OF SHOTS = 10

# IN CIR

1 in = 3

2 in = 6

3 in = 10

HS = 2.401

VS = 2.366

GS = 2.602

PATTERN #

3

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.091

.970

.932

MINIMUM X

-1.310

-1.431

-1.469

MAXIMUM Y

1.401

1.293

.710

MINIMUM Y

-.965

-.948

-.786

CENTROID X

.082

.203

.241

CENTROID Y

-.107

.001

-.161

POA TO CENTROID in.

.135

.203

.290

MIN RADIUS

.355

.298

.359

MEAN RADIUS

.919

.833

.769

MAX RADIUS

1.457

1.443

1.508

HORIZONTAL SPREAD

2.401

2.401

2.401

VERTICAL SPREAD

2.366

2.241

1.504

EXTREME SPREAD

2.602

2.602

2.602

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

6

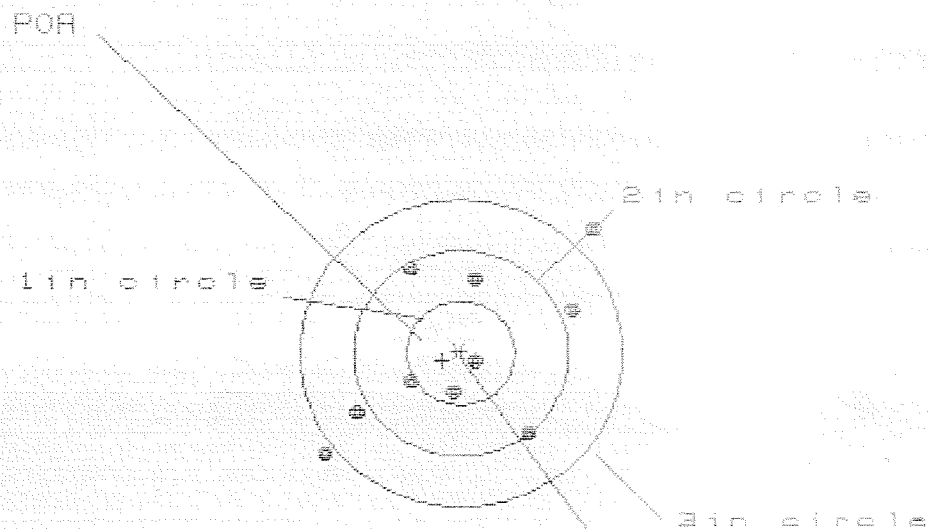
NUMBER IN THREE INCH CIRCLE =

10

18 Jul 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/CAB36313

# CENTERFIRE PATTERNS # 4



# OF SHOTS= 10

# IN CIR

1in = 3

2in = 5

3in = 8

HS= 2.515

VS= 2.160

GS= 3.315

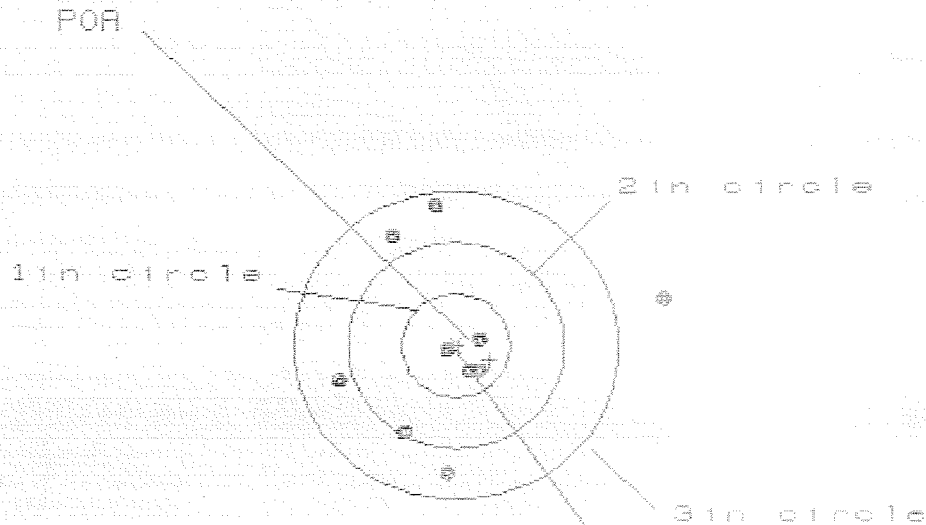
CENTROID #

|                             |   |        |        |       |
|-----------------------------|---|--------|--------|-------|
| PATTERN #                   | : | 4      |        |       |
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | 1.235  | 1.196  | 1.053 |
| MINIMUM X                   | : | -1.280 | -1.143 | -.991 |
| MAXIMUM Y                   | : | 1.184  | .941   | .835  |
| MINIMUM Y                   | : | -.976  | -.844  | -.794 |
| CENTROID X                  | : | .167   | .030   | .173  |
| CENTROID Y                  | : | .074   | -.058  | .048  |
| POA TO CENTROID in.         | : | .183   | .065   | .179  |
| MIN RADIUS                  | : | .180   | .285   | .168  |
| MEAN RADIUS                 | : | .933   | .830   | .749  |
| MAX RADIUS                  | : | 1.711  | 1.421  | 1.134 |
| HORIZONTAL SPREAD           | : | 2.515  | 2.339  | 2.044 |
| VERTICAL SPREAD             | : | 2.160  | 1.785  | 1.629 |
| EXTREME SPREAD              | : | 3.315  | 2.711  | 2.253 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 3      |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 5      |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 8      |       |

18 Jul 1991

FILE:/PATTERNING/CENTERFIRE\_PAT/C6636313

# CENTERFIRE PATTERNS # 5



# OF SHOTS- 10

# IN CIR

1in = 4

2in = 5

3in = 9

HS= 2.995

VS= 2.622

CS= 3.109

CENTROID #

PATTERN #

5

| SHOTS (BEST OF)             | 10     | 9      | 8      |
|-----------------------------|--------|--------|--------|
| MAXIMUM X                   | 1.914  | .420   | .424   |
| MINIMUM X                   | -1.080 | -.068  | -.064  |
| MAXIMUM Y                   | 1.370  | 1.424  | 1.260  |
| MINIMUM Y                   | -1.252 | -1.198 | -1.020 |
| CENTROID X                  | -.316  | -.528  | -.532  |
| CENTROID Y                  | .139   | .085   | -.093  |
| POA TO CENTROID in.         | .345   | .535   | .541   |
| MIN RADIUS                  | .112   | .116   | .213   |
| MEAN RADIUS                 | .872   | .761   | .664   |
| MAX RADIUS                  | 1.976  | 1.425  | 1.300  |
| HORIZONTAL SPREAD           | 2.995  | 1.288  | 1.288  |
| VERTICAL SPREAD             | 2.622  | 2.622  | 2.280  |
| EXTREME SPREAD              | 3.109  | 2.622  | 2.316  |
| NUMBER IN ONE INCH CIRCLE   | =      | 4      |        |
| NUMBER IN TWO INCH CIRCLE   | =      | 5      |        |
| NUMBER IN THREE INCH CIRCLE | =      | 9      |        |