

06611709

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

\*Includes 1 in chamber.

*Remington*

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

**Remington®**  
REG. U.S. PAT. & TM. OFF.

**MODEL 700™ H24**

**SERIAL NO.**  
C6611709

**ORDER NO.**  
5716

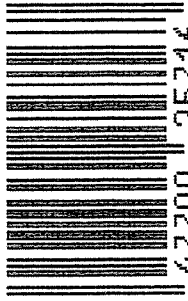
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

46



5716 C6611709

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611709

| OP. #        | OP. NAME                                                       | READINGS | DATE    | INIT |
|--------------|----------------------------------------------------------------|----------|---------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   | 3 28     | 9 1     | RW   |
| 600          | Proof                                                          | 3 28     | 9 1     | RW   |
| 607          | Check Headspace                                                | 3 28     | 9 1     | RW   |
| 610          | Dis-assemble Gun                                               | 3 28     | 9 1     | RW   |
| 612          | Magnaflux Barrel<br>Action                                     | APR      | 2 1991  | KR   |
|              | Magnaflux Bolt                                                 | APR      | 2 1991  | IC   |
| 615          | Rollmark Caliber                                               | APR      | 2 1991  | 28   |
| 617          | Drill and Tap Sight Holes                                      | APR      | 5 1991  | LB   |
| 618          | Polish Barrel                                                  | APR      | 5 1991  | WB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 4-9-91  | JA   |
|              | Apply Coating (Bolt)                                           |          |         |      |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 4/10/91 | RW   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 4/10/91 | RW   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 4/10/91 | RW   |
|              | D) Oil Firing Pin Ass'y                                        |          | 4/10/91 | RW   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 4/17/91 | JA   |

| op. #        | OP. NAME                                                    | READINGS |      |      |      |      | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|------|------|------|------|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 6        | 6    | 6    |      |      | 4/18/91 | SH   |
|              | G) Safety Off Force                                         | 4        | 4    | 4    |      |      | 4/18/91 | SH   |
|              | H) Trigger Pull Test & Retainability                        |          |      |      |      |      | 4/17/91 | SH   |
|              | I) Firing Pin Indent                                        | 1022     | 1022 | 1022 |      |      | 4/18/91 | SH   |
|              | J) Assemble Stock                                           |          |      |      |      |      | 4/22/91 | RW   |
|              | K) Assemble Swivel Studs                                    |          |      |      |      |      | 4-24-91 | DH   |
|              | L) Attach Front and Rear Sight Assemblies                   |          |      |      |      |      | 4/22/91 | RW   |
|              | M) Iron Sight Alignment                                     |          |      |      |      |      | 4/22/91 | RW   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |      |      |      |      | 4/22/91 | RW   |
|              | O) Attach Scope to Rifle                                    |          |      |      |      |      | 4/22/91 | RW   |
|              | P) Detach & Attach Scope 20 Times                           |          |      |      |      |      | 4/22/91 | RW   |
|              |                                                             |          |      |      |      |      |         |      |
| 640          | Gallery Target & Test                                       |          |      |      |      |      | 4-22-91 | NF   |
|              | A) Time                                                     |          |      |      |      |      | "       | NF   |
|              | B) Malfunctions                                             |          |      |      |      |      | "       | NF   |
|              | C) Pierced Primers                                          |          |      |      |      |      | "       | NF   |
|              | D) Optical Clarity of Scope                                 |          |      |      |      |      | "       | NF   |
| 645          | Inspect for Live Ammo                                       |          |      |      |      |      | 4-22-91 | NF   |
| 655          | Final Inspection                                            |          |      |      |      |      |         |      |
|              | A) Headspace                                                |          |      |      |      |      | 4-24-91 | DH   |
|              | B) Trigger Pull                                             | 2.30     | 2.34 | 2.21 | 2.37 | 2.38 | 4/23/91 | SH   |
|              | C) Function                                                 |          |      |      |      |      | 4-24-91 | DH   |
| 660          | Pack                                                        |          |      |      |      |      | 6-18-91 | NF   |

SWS TRIGGER PULL TEST

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

SERIAL NO. C6611709

DATE 4/17/91

TESTER [Signature]

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.28             | 2.32                     | 2.20                           | 2.30 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.29             | 2.36                     | 2.60                           | 2.34 |                                                                        |
| PULL #3 | 2.33             | 2.35                     | 2.43                           | 2.21 |                                                                        |
| PULL #4 | 2.30             | 2.32                     | 2.52                           | 2.37 |                                                                        |
| PULL #5 | 2.34             | 2.33                     | 2.54                           | 2.38 |                                                                        |
| TOTAL   |                  |                          |                                |      |                                                                        |
| AVG.    |                  |                          |                                |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.29             | 3.52                     |  |          |
| PULL #2 | 3.42             | 3.43                     |  |          |
| PULL #3 | 3.43             | 3.40                     |  |          |
| PULL #4 | 3.53             | 3.42                     |  |          |
| PULL #5 | 3.45             | 3.48                     |  |          |
| 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 | 4.30             | 4.33                     |                                | 4.27                                 |
| PULL #2 | 4.31             | 4.34                     |                                | 4.43                                 |
| PULL #3 | 4.22             | 4.17                     |                                | 4.34                                 |
| PULL #4 | 4.29             | 4.31                     |                                | 4.38                                 |
| PULL #5 | 4.32             | 4.22                     |                                | 4.41                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6611709  
22 Apr 1991

CENTROIDAL DISTANCES

|      |   |          |
|------|---|----------|
| 0 TO | 1 | .182148  |
| 1 TO | 2 | .043566  |
| 1 TO | 3 | .838974  |
| 1 TO | 4 | .0983514 |
| 1 TO | 5 | .143562  |

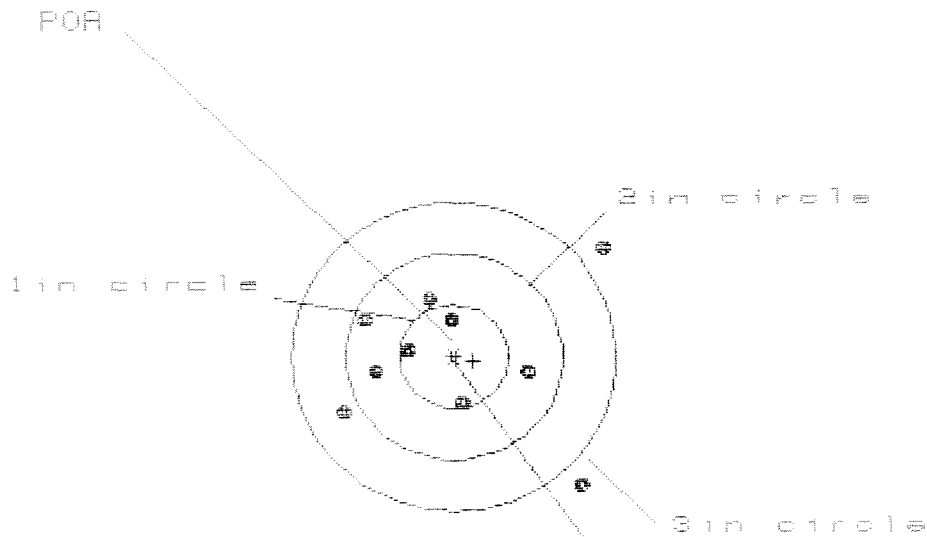
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2

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0922  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0726  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .117359  
THE AMR FOR THIS RIFLE IS: .773

22 Apr 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C8B11703

# CENTERFIRE PATTERNS # 1



# OF SHOTS= 10

# IN CIR

1in = 3

2in = 7

3in = 8

HS= 2.434

VS= 2.390

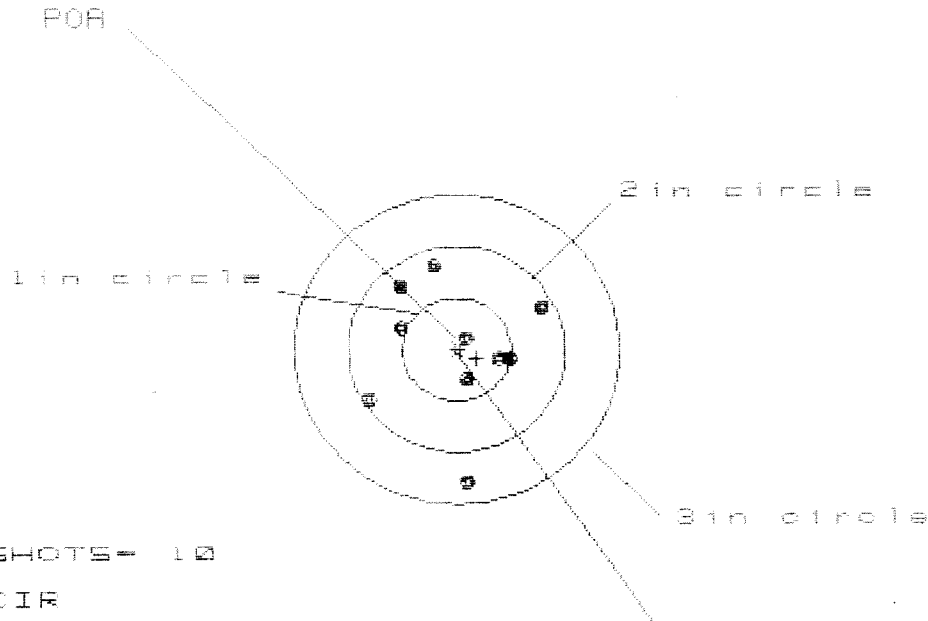
GS= 2.935

| PATTERN #                     | 1      | 2      | 3     |
|-------------------------------|--------|--------|-------|
| SHOTS (BEST OF)               | 10     | 9      | 8     |
| MAXIMUM X                     | 1.371  | 1.325  | .958  |
| MINIMUM X                     | -1.063 | -.911  | -.746 |
| MAXIMUM Y                     | 1.102  | .681   | .535  |
| MINIMUM Y                     | -1.288 | -1.165 | -.561 |
| CENTROID X                    | -.177  | -.329  | -.494 |
| CENTROID Y                    | .043   | -.080  | .066  |
| POA TO CENTROID in.           | .182   | .338   | .499  |
| MIN RADIUS                    | .354   | .278   | .061  |
| MEAN RADIUS                   | .873   | .754   | .571  |
| MAX RADIUS                    | 1.759  | 1.764  | .965  |
| HORIZONTAL SPREAD             | 2.434  | 2.236  | 1.783 |
| VERTICAL SPREAD               | 2.390  | 1.846  | 1.096 |
| EXTREME SPREAD                | 2.935  | 2.601  | 1.759 |
| NUMBER IN ONE INCH CIRCLE =   | 3      |        |       |
| NUMBER IN TWO INCH CIRCLE =   | 7      |        |       |
| NUMBER IN THREE INCH CIRCLE = | 8      |        |       |

22 Apr 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6B11709

# CENTERFIRE PATTERNS # 2



# OF SHOTS= 10

# IN CIR

1 in = 3

2 in = 3

3 in = 10

HS= 1.502

VS= 2.112

GS= 2.138

CENTROID \*

| PATTERN #                     | 2      |       |       |
|-------------------------------|--------|-------|-------|
| SHOTS (BEST OF)               | 10     | 9     | 8     |
| MAXIMUM X                     | .816   | .829  | .732  |
| MINIMUM X                     | -.786  | -.773 | -.601 |
| MAXIMUM Y                     | .849   | .708  | .627  |
| MINIMUM Y                     | -1.264 | -.646 | -.482 |
| CENTROID X                    | -.184  | -.197 | -.100 |
| CENTROID Y                    | .086   | .227  | .308  |
| POA TO CENTROID in.           | .203   | .300  | .323  |
| MIN RADIUS                    | .140   | .156  | .162  |
| MEAN RADIUS                   | .672   | .606  | .551  |
| MAX RADIUS                    | 1.268  | 1.008 | .759  |
| HORIZONTAL SPREAD             | 1.602  | 1.602 | 1.333 |
| VERTICAL SPREAD               | 2.112  | 1.354 | 1.109 |
| EXTREME SPREAD                | 2.138  | 1.850 | 1.348 |
| NUMBER IN ONE INCH CIRCLE =   |        | 3     |       |
| NUMBER IN TWO INCH CIRCLE =   |        | 9     |       |
| NUMBER IN THREE INCH CIRCLE = |        | 10    |       |



22 Apr 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C86117B9

# CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

# OF SHOTS = 10

# IN CIR

1in = 4

2in = 8

3in = 8

HS = 1.141

VS = 2.805

CS = 2.924

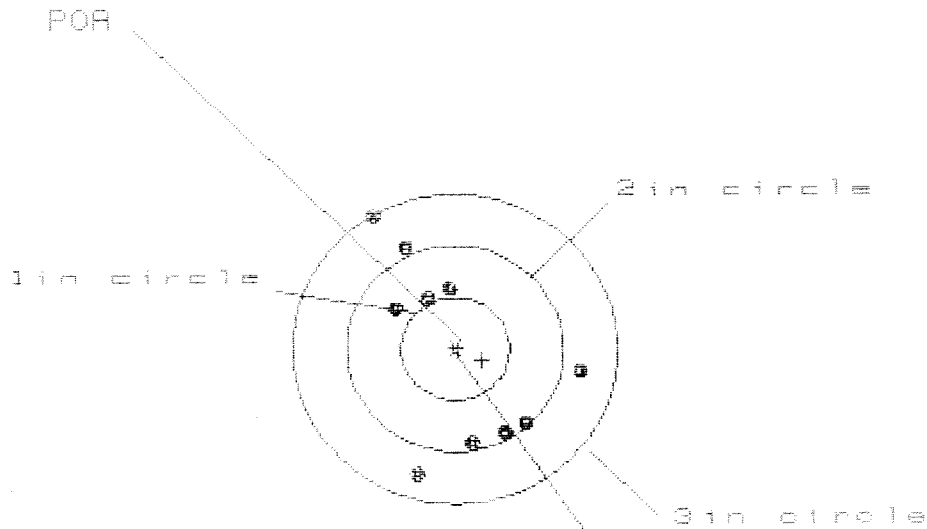
CENTROID #

|                             |   |       |       |       |
|-----------------------------|---|-------|-------|-------|
| PATTERN #                   | : | 3     |       |       |
| SHOTS (BEST OF)             | : | 10    | 9     | 8     |
| MAXIMUM X                   | : | .518  | .484  | .281  |
| MINIMUM X                   | : | -.623 | -.657 | -.596 |
| MAXIMUM Y                   | : | 1.881 | .943  | .853  |
| MINIMUM Y                   | : | -.924 | -.715 | -.710 |
| CENTROID X                  | : | .197  | .231  | .170  |
| CENTROID Y                  | : | -.708 | -.917 | -.827 |
| POA TO CENTROID in.         | : | .735  | .945  | .845  |
| MIN RADIUS                  | : | .182  | .276  | .175  |
| MEAN RADIUS                 | : | .720  | .564  | .521  |
| MAX RADIUS                  | : | 1.906 | .944  | .861  |
| HORIZONTAL SPREAD           | : | 1.141 | 1.141 | .877  |
| VERTICAL SPREAD             | : | 2.805 | 1.658 | 1.563 |
| EXTREME SPREAD              | : | 2.924 | 1.714 | 1.629 |
| NUMBER IN ONE INCH CIRCLE   | = |       | 4     |       |
| NUMBER IN TWO INCH CIRCLE   | = |       | 8     |       |
| NUMBER IN THREE INCH CIRCLE | = |       | 9     |       |

22 Apr 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6611709

# CENTERFIRE PATTERNS # 4



# OF SHOTS- 10

# IN CIR

1in = 0

2in = 5

3in = 9

HE= 1.818

VS= 2.492

GS= 2.512

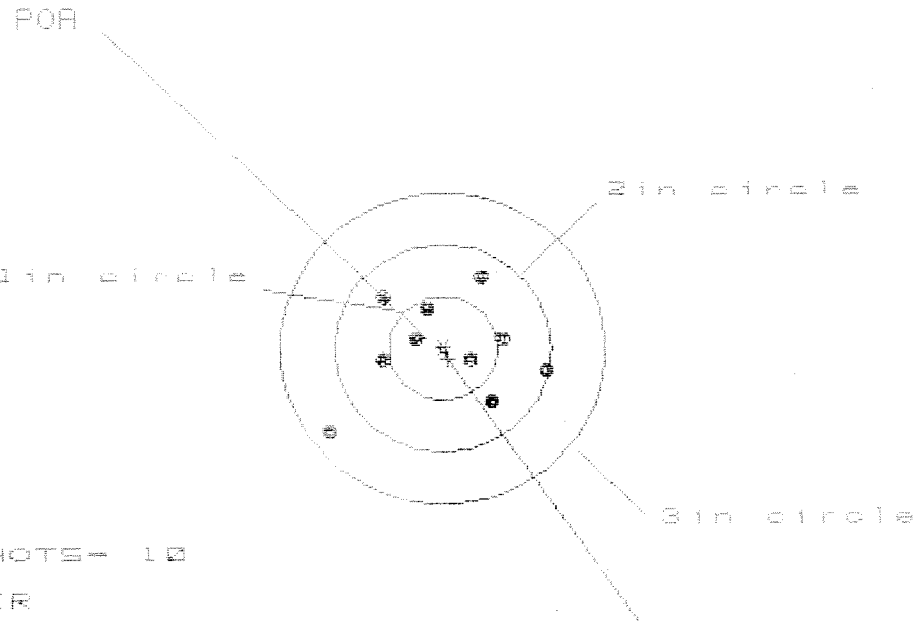
CENTROID #

|                             |   |        |        |       |
|-----------------------------|---|--------|--------|-------|
| PATTERN #                   | : | 4      |        |       |
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | 1.100  | 1.020  | .960  |
| MINIMUM X                   | : | -.718  | -.636  | -.696 |
| MAXIMUM Y                   | : | 1.322  | 1.159  | 1.031 |
| MINIMUM Y                   | : | -1.170 | -1.024 | -.843 |
| CENTROID X                  | : | -.249  | -.169  | -.109 |
| CENTROID Y                  | : | .110   | -.037  | .091  |
| POA TO CENTROID in.         | : | .272   | .173   | .142  |
| MIN RADIUS                  | : | .528   | .695   | .627  |
| MEAN RADIUS                 | : | .956   | .889   | .851  |
| MAX RADIUS                  | : | 1.504  | 1.263  | 1.173 |
| HORIZONTAL SPREAD           | : | 1.818  | 1.656  | 1.656 |
| VERTICAL SPREAD             | : | 2.492  | 2.183  | 1.874 |
| EXTREME SPREAD              | : | 2.512  | 2.183  | 2.059 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 0      |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 6      |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |       |

22 Apr 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C86117B9

# CENTERFIRE PATTERNS # 5



+ OF SHOTS- 10

# IN CIR

1in = 3

2in = 9

3in = 10

HS= 1.978

VS= 1.502

GS= 2.066

CENTROID #

PATTERN #

5

| SHOTS (BEST OF)               | 10     | 9     | 8     |
|-------------------------------|--------|-------|-------|
| MAXIMUM X                     | .924   | .807  | .539  |
| MINIMUM X                     | -1.054 | -.655 | -.554 |
| MAXIMUM Y                     | .682   | .590  | .551  |
| MINIMUM Y                     | -.820  | -.569 | -.608 |
| CENTROID X                    | -.048  | .069  | -.032 |
| CENTROID Y                    | .106   | .198  | .237  |
| POA TO CENTROID in.           | .117   | .209  | .239  |
| MIN RADIUS                    | .252   | .218  | .277  |
| MEAN RADIUS                   | .644   | .555  | .506  |
| MAX RADIUS                    | 1.336  | .866  | .737  |
| HORIZONTAL SPREAD             | 1.978  | 1.462 | 1.093 |
| VERTICAL SPREAD               | 1.502  | 1.159 | 1.159 |
| EXTREME SPREAD                | 2.066  | 1.620 | 1.382 |
| NUMBER IN ONE INCH CIRCLE =   |        | 3     |       |
| NUMBER IN TWO INCH CIRCLE =   |        | 9     |       |
| NUMBER IN THREE INCH CIRCLE = |        | 10    |       |