

C6611811

MODEL 700™ M24

Model SWS™

Action \_\_\_\_\_

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

Capacity \_\_\_\_\_

Order No. 5715

\*Includes 1 in chamber.

*Remington*

*Remington*®



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

MODEL 700™ H24

SERIAL NO.

C6611811

ORDER NO.

5716

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

46



5716 C6611811

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611811

| OP. #        | OP. NAME                                                       | READINGS | DATE    | INIT |
|--------------|----------------------------------------------------------------|----------|---------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   | 3 28     | 91      | RW   |
| 600          | Proof                                                          | 3 28     | 91      | RW   |
| 607          | Check Headspace                                                | 3 28     | 91      | RW   |
| 610          | Dis-assemble Gun                                               | 3 28     | 91      | RW   |
| 612          | Magnaflux Barrel<br>Action                                     | APR      | 2 1991  | KR   |
|              | Magnaflux Bolt                                                 | APR      | 2 1991  | U    |
| 615          | Rollmark Caliber                                               | APR      | 2 1991  | GS   |
| 617          | Drill and Tap Sight Holes                                      | APR      | 5 1991  | FB   |
| 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             |          | 4-16-91 | DH   |

| op. #        | OP. NAME                                                    | READINGS |      |      |      |      | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|------|------|------|------|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 4.5      | 4    | 4    |      |      | 4-16-91 | AF   |
|              | G) Safety Off Force                                         | 2        | 2    | 2.5  |      |      | 4-16-91 | AC   |
|              | H) Trigger Pull Test & Retainability                        |          |      |      |      |      | 4-16-91 | D/H  |
|              | I) Firing Pin Indent                                        | .021     | .023 | .022 |      |      | 4-16-91 | AC   |
|              | J) Assemble Stock                                           |          |      |      |      |      | 4-17-91 | RW   |
|              | K) Assemble Swivel Studs                                    |          |      |      |      |      | 4-24-91 | D/H  |
|              | L) Attach Front and Rear Sight Assemblies                   |          |      |      |      |      | 4-17-91 | RW   |
|              | M) Iron Sight Alignment                                     |          |      |      |      |      | 4-17-91 | RW   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |      |      |      |      | 4-17-91 | RW   |
|              | O) Attach Scope to Rifle                                    |          |      |      |      |      | 4-17-91 | RW   |
|              | P) Detach & Attach Scope 20 Times                           |          |      |      |      |      | 4-17-91 | RW   |
| 640          | Gallery Target & Test                                       |          |      |      |      |      | 4-17-91 | AF   |
|              | A) Time                                                     |          |      |      |      |      | "       | AF   |
|              | B) Malfunctions                                             |          |      |      |      |      | "       | AF   |
|              | C) Pierced Primers                                          |          |      |      |      |      | "       | AF   |
|              | D) Optical Clarity of Scope                                 |          |      |      |      |      | "       | AF   |
| 645          | Inspect for Live Ammo                                       |          |      |      |      |      | 4-17-91 | AF   |
| 655          | Final Inspection                                            |          |      |      |      |      |         |      |
|              | A) Headspace                                                |          |      |      |      |      | 4-24-91 | D/H  |
|              | B) Trigger Pull                                             | 2.34     | 2.27 | 2.39 | 2.31 | 2.30 | 4-22-91 | RW   |
|              | C) Function                                                 |          |      |      |      |      | 4-24-91 | D/H  |
| 660          | Pack                                                        |          |      |      |      |      | 6-15-91 | AF   |

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50# + .50#  
3.00# + .75#  
4.00# + 1.00#

SERIAL NO. CG61181

DATE 4-16-91

TESTER D/H

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.55             | 2.60                     | 2.48                           | 2.34 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.27             | 2.54                     | 2.46                           | 2.27 |                                                                        |
| PULL #3 | 2.54             | 2.59                     | 2.51                           | 2.39 |                                                                        |
| PULL #4 | 2.57             | 2.64                     | 2.52                           | 2.31 |                                                                        |
| PULL #5 | 2.61             | 2.65                     | 2.49                           | 2.30 |                                                                        |
| TOTAL   |                  |                          |                                |      |                                                                        |
| AVG.    |                  |                          |                                |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.02             | 3.08                     |  |          |
| PULL #2 | 2.98             | 3.13                     |  |          |
| PULL #3 | 3.05             | 3.18                     |  |          |
| PULL #4 | 2.98             | 3.17                     |  |          |
| PULL #5 | 2.95             | 3.22                     |  |          |
| 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 | 4.41             | 4.53                     |                                | 4.01                                 |
| PULL #2 | 4.44             | 4.63                     |                                | 3.98                                 |
| PULL #3 | 4.46             | 4.70                     |                                | 3.95                                 |
| PULL #4 | 4.45             | 4.30                     |                                | 4.34                                 |
| PULL #5 | 4.55             | 4.76                     |                                | 4.16                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6611811  
17 Apr 1991

CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| 0 TO | 1 | .202181 |
| 1 TO | 2 | .246489 |
| 1 TO | 3 | .371016 |
| 1 TO | 4 | .168929 |
| 1 TO | 5 | .175932 |

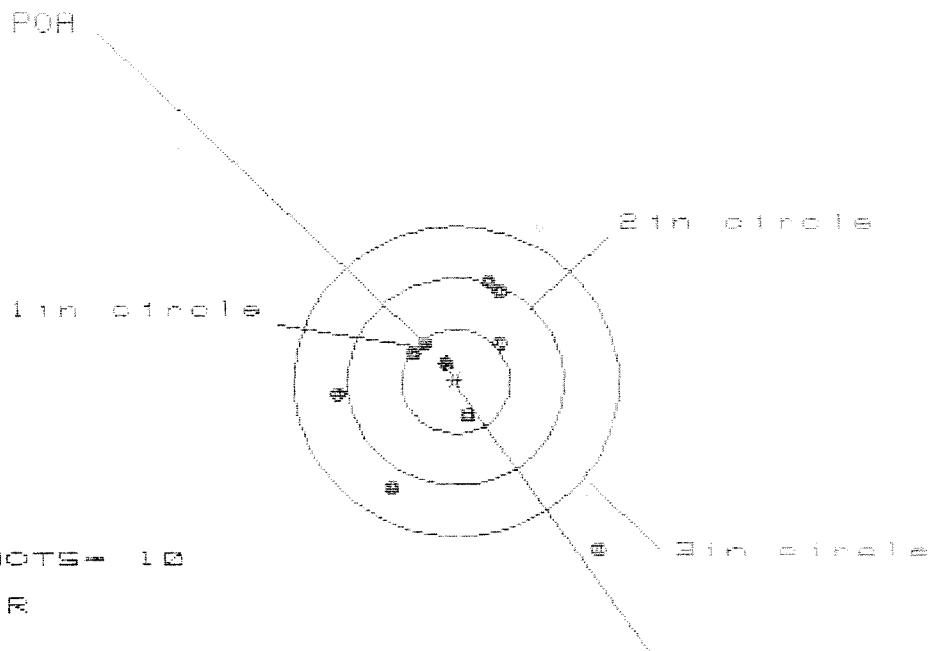
3.4 <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0136  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0396  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0419703  
THE AMR FOR THIS RIFLE IS: .937

17 Apr 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/CBB11811

# CENTERFIRE PATTERNS # 1



# OF SHOTS = 10

# IN CIR

1in = 4

2in = 5

3in = 8

HS = 2.369

VS = 2.594

GS = 2.813

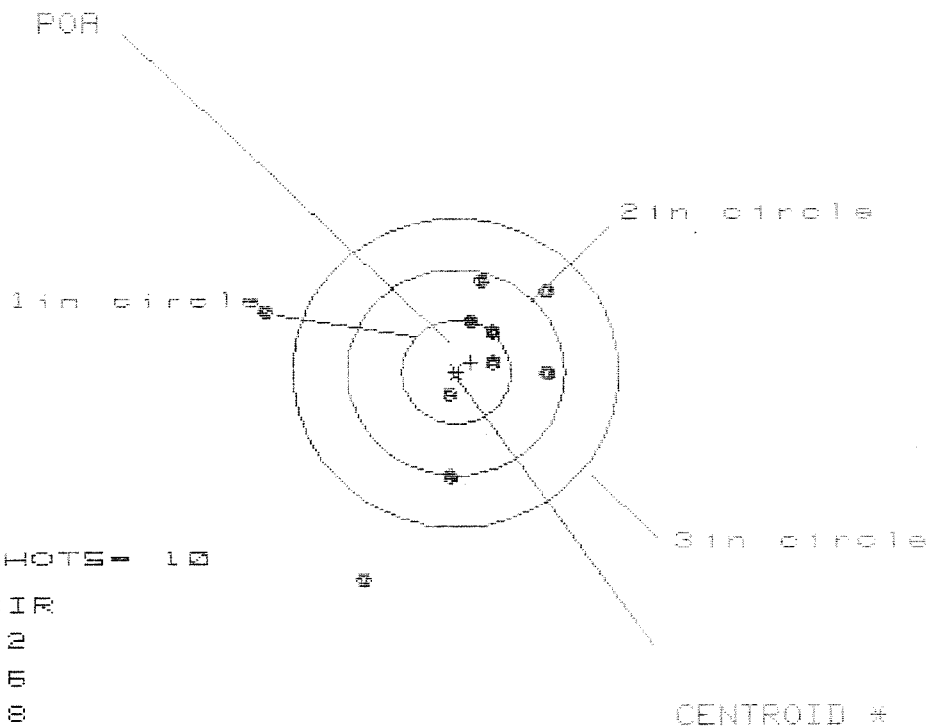
CENTROID #

| PATTERN #                     | 1      | 2      | 3      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.260  | .594   | .538   |
| MINIMUM X                     | -1.109 | -.969  | -1.025 |
| MAXIMUM Y                     | .990   | .812   | .663   |
| MINIMUM Y                     | -1.604 | -1.189 | -.613  |
| CENTROID X                    | .094   | -.046  | .010   |
| CENTROID Y                    | -.179  | -.001  | .148   |
| POA TO CENTROID in.           | .202   | .046   | .148   |
| MIN RADIUS                    | .244   | .052   | .110   |
| MEAN RADIUS                   | .832   | .637   | .549   |
| MAX RADIUS                    | 2.040  | 1.270  | 1.106  |
| HORIZONTAL SPREAD             | 2.369  | 1.563  | 1.563  |
| VERTICAL SPREAD               | 2.594  | 2.001  | 1.276  |
| EXTREME SPREAD                | 2.813  | 2.184  | 1.828  |
| NUMBER IN ONE INCH CIRCLE =   | 4      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 6      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 9      |        |        |

17 Apr 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C8511811

# CENTERFIRE PATTERNS # 2



# OF SHOTS - 10

# IN CIR

1 in = 2

2 in = 6

3 in = 8

HS = 2.590

VS = 2.871

GS = 3.194

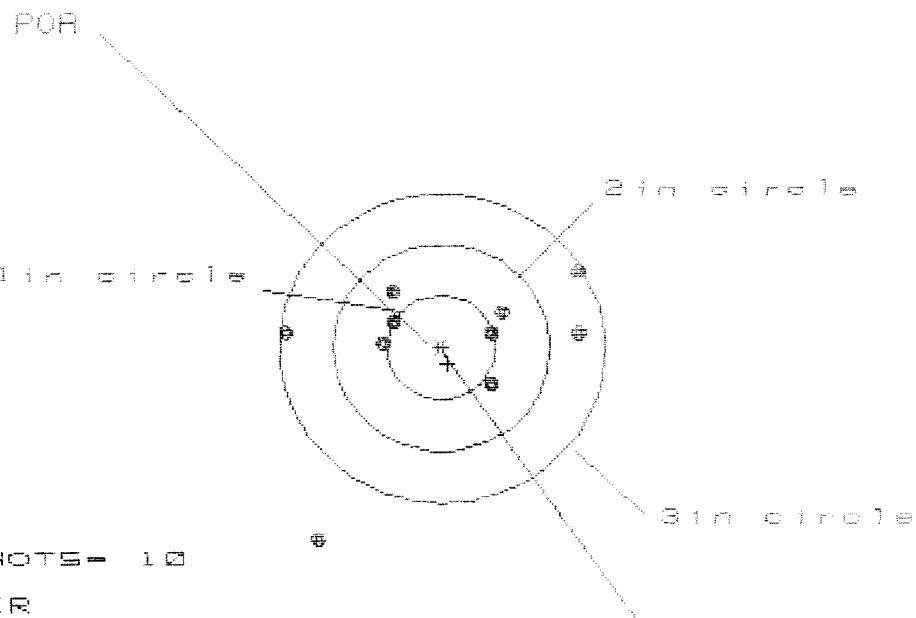
| PATTERN #                     | 2      | 9      | 8      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | .817   | .725   | .492   |
| MINIMUM X                     | -1.773 | -1.865 | -1.433 |
| MAXIMUM Y                     | .905   | .686   | .734   |
| MINIMUM Y                     | -1.966 | -1.260 | -1.212 |
| CENTROID X                    | -.137  | -.045  | .188   |
| CENTROID Y                    | -.093  | .126   | .078   |
| POA TO CENTROID in.           | .165   | .134   | .203   |
| MIN RADIUS                    | .220   | .258   | .034   |
| MEAN RADIUS                   | .954   | .763   | .558   |
| MAX RADIUS                    | 2.131  | 1.984  | 1.287  |
| HORIZONTAL SPREAD             | 2.590  | 2.590  | .925   |
| VERTICAL SPREAD               | 2.871  | 1.946  | 1.946  |
| EXTREME SPREAD                | 3.194  | 2.669  | 2.039  |
| NUMBER IN ONE INCH CIRCLE =   | 2      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 6      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 8      |        |        |



17 Apr 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C8611811

# CENTERFIRE PATTERNS # 3



# OF SHOTS- 10

# IN CIR

1 in = 2

2 in = 6

3 in = 8

HS= 2.705

VS= 2.578

GS= 3.509

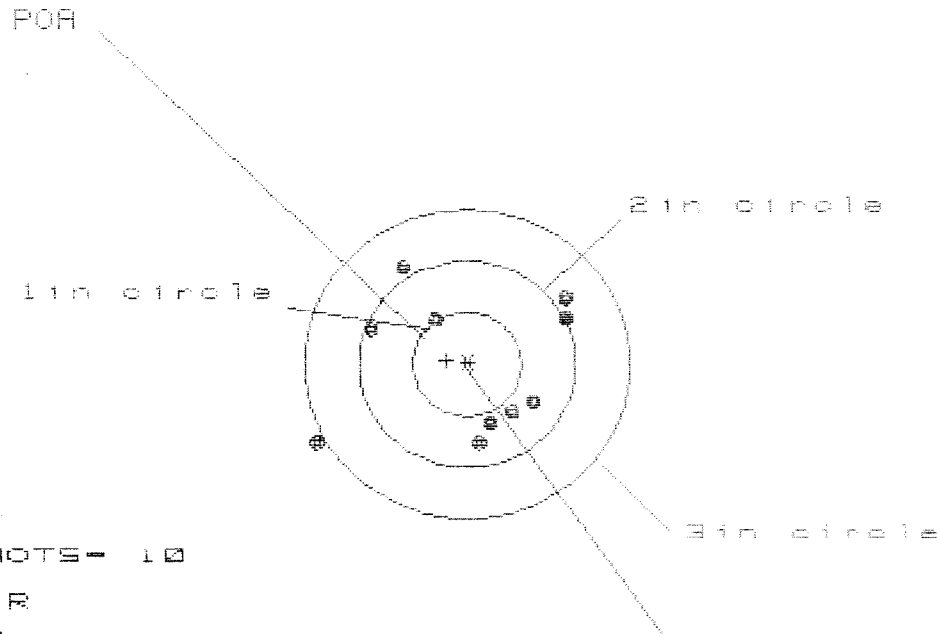
CENTROID #

| PATTERN #                     | 3      |        |       |
|-------------------------------|--------|--------|-------|
| SHOTS (BEST OF)               | 10     | 9      | 8     |
| MAXIMUM X                     | 1.264  | 1.137  | .941  |
| MINIMUM X                     | -1.441 | -1.568 | -.864 |
| MAXIMUM Y                     | .701   | .493   | .479  |
| MINIMUM Y                     | -1.877 | -.593  | -.607 |
| CENTROID X                    | -.059  | .068   | .264  |
| CENTROID Y                    | .159   | .367   | .381  |
| POR TO CENTROID in.           | .169   | .374   | .464  |
| MIN RADIUS                    | .467   | .339   | .169  |
| MEAN RADIUS                   | .982   | .814   | .690  |
| MAX RADIUS                    | 2.196  | 1.572  | 1.036 |
| HORIZONTAL SPREAD             | 2.705  | 2.705  | 1.805 |
| VERTICAL SPREAD               | 2.578  | 1.086  | 1.086 |
| EXTREME SPREAD                | 3.509  | 2.750  | 1.889 |
| NUMBER IN ONE INCH CIRCLE =   |        | 2      |       |
| NUMBER IN TWO INCH CIRCLE =   |        | 6      |       |
| NUMBER IN THREE INCH CIRCLE = |        | 9      |       |

17 Apr 1931

FILE:/PATTERNING/CENTERFIRE\_PATT/C8611811

# CENTERFIRE PATTERNS # 4



# OF SHOTS- 10

# IN CIR

1in = 0

2in = 6

3in = 8

HS= 2.360

VS= 1.698

GS= 2.763

CENTROID \*

|                             |   |        |        |       |
|-----------------------------|---|--------|--------|-------|
| PATTERN #                   | : | 4      |        |       |
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | .954   | .797   | .880  |
| MINIMUM X                   | : | -1.406 | -1.023 | -.923 |
| MAXIMUM Y                   | : | .933   | .849   | .922  |
| MINIMUM Y                   | : | -.763  | -.824  | -.751 |
| CENTROID X                  | : | .190   | .347   | .247  |
| CENTROID Y                  | : | -.040  | .044   | -.029 |
| POA TO CENTROID in.         | : | .195   | .349   | .240  |
| MIN RADIUS                  | : | .568   | .608   | .590  |
| MEAN RADIUS                 | : | .910   | .821   | .799  |
| MAX RADIUS                  | : | 1.600  | 1.156  | 1.149 |
| HORIZONTAL SPREAD           | : | 2.360  | 1.820  | 1.803 |
| VERTICAL SPREAD             | : | 1.696  | 1.673  | 1.673 |
| EXTREME SPREAD              | : | 2.763  | 1.852  | 1.831 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 0      |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 6      |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |       |

17 Apr 1991

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# CENTERFIRE PATTERNS

# 5

3.01.0000

POA

1in circle

2in circle

3in circle

# OF SHOTS- 10

# IN CIR

1in = 0

2in = 7

3in = 9

HS= 2.386

VS= 2.623

GS= 2.786

CENTROID #

PATTERN #

:

5

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

.954

1.050

.883

MINIMUM X

:

-1.432

-1.336

-.859

MAXIMUM Y

:

1.313

1.039

1.025

MINIMUM Y

:

-1.310

-1.164

-1.178

CENTROID X

:

-.020

-.116

.051

CENTROID Y

:

-.045

-.191

-.177

POA TO CENTROID in.:

.049

.223

.184

MIN RADIUS

:

.623

.660

.524

MEAN RADIUS

:

1.007

.934

.865

MAX RADIUS

:

1.575

1.340

1.179

HORIZONTAL SPREAD

:

2.386

2.386

1.742

VERTICAL SPREAD

:

2.623

2.203

2.203

EXTREME SPREAD

:

2.786

2.416

2.235

NUMBER IN ONE INCH CIRCLE = 0

NUMBER IN TWO INCH CIRCLE = 7

NUMBER IN THREE INCH CIRCLE = 9