

C6649114

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

\*Includes 1 in chamber.



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

**MODEL 700™ H24**

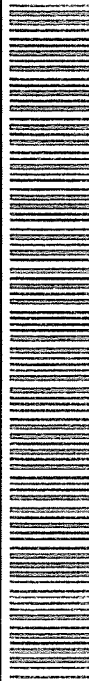
**SERIAL NO. C6649114**

**ORDER NO. 5716**

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

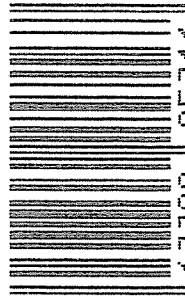
VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.

20



5716 C6649114

UPC



0 47700 25716 7

MOD. \_\_\_\_\_ GA. CAL. \_\_\_\_\_ GUN # 9114

| #<br>TEST | DATE    | MALFUNCTION/DEFECT                               | ASSEM.<br>#   |
|-----------|---------|--------------------------------------------------|---------------|
|           | 1st     |                                                  |               |
| KT        | 8/12/91 | Shane<br>Brass                                   | KS            |
|           | 2nd     |                                                  |               |
|           | 8/13/91 | Polish face of<br>Bolt<br>100 Rd. Test<br>Needed | Ru            |
|           | 3rd     |                                                  |               |
|           | 4th     |                                                  |               |
|           |         | FUNCTION                                         | RD 6654 Rev 1 |

| TEST INIT. ACTION TO CORRECT |                                                 | ASSEM.<br># |
|------------------------------|-------------------------------------------------|-------------|
| PROOF                        | <i>shot OK</i><br><i>Test</i><br><i>8-13-91</i> | <i>D/H</i>  |
| TEST                         |                                                 |             |
| TGT                          |                                                 |             |
| PROOF                        |                                                 |             |
| TEST                         |                                                 |             |
| TGT                          |                                                 |             |
| PROOF                        | ENGINEER                                        |             |
| TEST                         |                                                 |             |
| TGT                          |                                                 |             |
| PROOF                        | ENGINEER                                        |             |
| TEST                         |                                                 |             |
| TGT                          |                                                 |             |

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6649114

| OP. #        | OP. NAME                                                       | READINGS | DATE         | INIT |
|--------------|----------------------------------------------------------------|----------|--------------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   |          | 6/24/91      | KA   |
| 600          | Proof                                                          |          | 6/26/91      | KA   |
| 607          | Check Headspace                                                |          | 6/26/91      | KA   |
| 610          | Dis-assemble Gun                                               |          | 6/26/91      | KA   |
| 612          | Magnaflux Barrel<br>Action                                     |          | JUL 1 8 1991 | GS   |
|              | Magnaflux Bolt                                                 |          | JUL 1 8 1991 | GS   |
| 615          | Rollmark Caliber                                               |          | JUL 1 8 1991 | GS   |
| 617          | Drill and Tap Sight Holes                                      |          | JUL 1 8 1991 | FB   |
| 618          | Polish Barrel                                                  |          | JUL 2 6 1991 | WB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 8-7-91       | KA   |
|              | Apply Coating (Bolt)                                           |          |              | KA   |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 8/8/91       | KA   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 8/8/91       | KA   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 8/8/91       | KA   |
|              | D) Oil Firing Pin Ass'y                                        |          | 8/8/91       | KA   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 8-10-91      | D/H  |

| op. #        | OP. NAME                                                    | READINGS |       |       |      |      | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|-------|-------|------|------|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 5        | 5     | 5     |      |      | 8-10-91 | DH   |
|              | G) Safety Off Force                                         | 2 1/2    | 2 1/4 | 2 1/4 |      |      | 8-10-91 | DH   |
|              | H) Trigger Pull Test & Retainability                        |          |       |       |      |      | 8-10-91 | DH   |
|              | I) Firing Pin Indent                                        | .020     | .021  | .020  |      |      | 8-10-91 | DH   |
|              | J) Assemble Stock                                           |          |       |       |      |      | 8-10-91 | KA   |
|              | K) Assemble Swivel Studs                                    |          |       |       |      |      | 8-13-91 | DH   |
|              | L) Attach Front and Rear Sight Assemblies                   |          |       |       |      |      | 8-10-91 | KA   |
|              | M) Iron Sight Alignment                                     |          |       |       |      |      | 8-10-91 | KA   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |       |       |      |      | 8-10-91 | KA   |
|              | O) Attach Scope to Rifle                                    |          |       |       |      |      | 8-10-91 | KA   |
|              | P) Detach & Attach Scope 20 Times                           |          |       |       |      |      | 8-10-91 | KA   |
| 640          | Gallery Target & Test                                       |          |       |       |      |      | 8-12-91 | LT   |
|              | A) Time                                                     |          |       |       |      |      |         | KT   |
|              | B) Malfunctions                                             |          |       |       |      |      |         | KT   |
|              | C) Pierced Primers                                          |          |       |       |      |      |         | KT   |
|              | D) Optical Clarity of Scope                                 |          |       |       |      |      |         | KT   |
| 645          | Inspect for Live Ammo                                       |          |       |       |      |      | 8-12-91 | KT   |
| 655          | Final Inspection                                            |          |       |       |      |      |         |      |
|              | A) Headspace                                                |          |       |       |      |      | 8-13-91 | DH   |
|              | B) Trigger Pull                                             | 2.39     | 2.45  | 2.40  | 2.35 | 2.48 | 8-13-91 | KA   |
|              | C) Function                                                 |          |       |       |      |      | 8-13-91 | 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. CC649114  
DATE 8-10-91  
TESTER DH

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.50             | 2.50                     | 2.32                           | 2.39 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.49             | 2.45                     | 2.48                           | 2.45 |                                                                        |
| PULL #3 | 2.63             | 2.50                     | 2.85                           | 2.40 |                                                                        |
| PULL #4 | 2.53             | 2.48                     | 2.74                           | 2.35 |                                                                        |
| PULL #5 | 2.63             | 2.54                     | 2.95                           | 2.48 |                                                                        |
| TOTAL   |                  |                          |                                |      |                                                                        |
| AVG.    |                  |                          |                                |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.13             | 3.24                     |  |          |
| PULL #2 | 3.16             | 3.20                     |  |          |
| PULL #3 | 3.17             | 3.23                     |  |          |
| PULL #4 | 3.07             | 3.26                     |  |          |
| PULL #5 | 3.21             | 3.26                     |  |          |
| 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 | 4.16             | 4.49                     |                                | 4.27                                 |
| PULL #2 | 4.20             | 4.53                     |                                | 4.23                                 |
| PULL #3 | 4.06             | 4.57                     |                                | 4.28                                 |
| PULL #4 | 4.34             | 4.57                     |                                | 4.38                                 |
| PULL #5 | 4.34             | 4.30                     |                                | 4.36                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6649114  
12 Aug 1991

CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| 0 TO | 1 | .261138 |
| 1 TO | 2 | .644426 |
| 1 TO | 3 | .228965 |
| 1 TO | 4 | .432612 |
| 1 TO | 5 | .701565 |

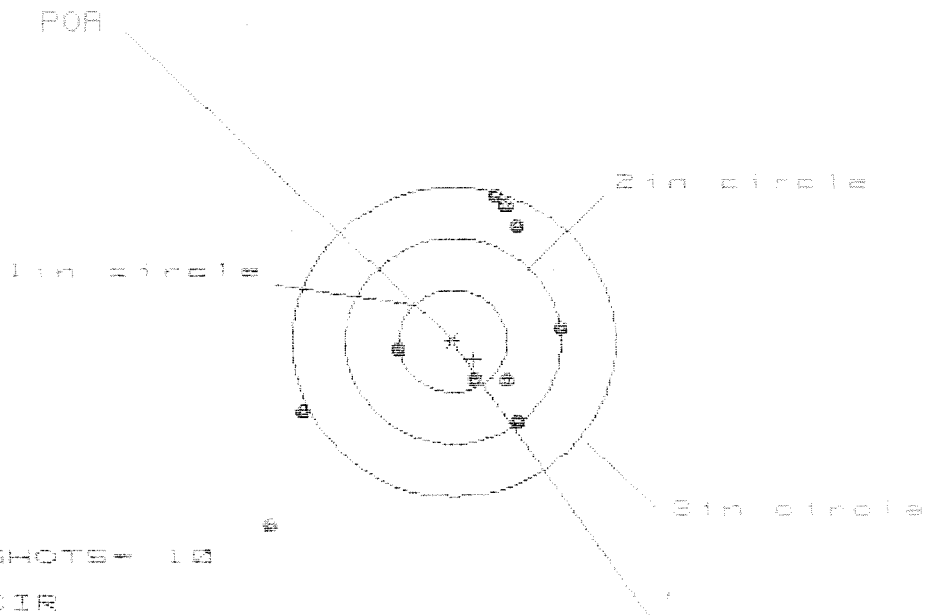
$\frac{1}{5} \sum x_i^2$  <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .123  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .05  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .132774  
THE AMR FOR THIS RIFLE IS: 1.021

12 Aug 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6649114

# CENTERFIRE PATTERNS # 1



# OF SHOTS = 10

# IN CIR

1 in = 1

2 in = 4

3 in = 8

HS = 2.758

VS = 3.214

GS = 3.837

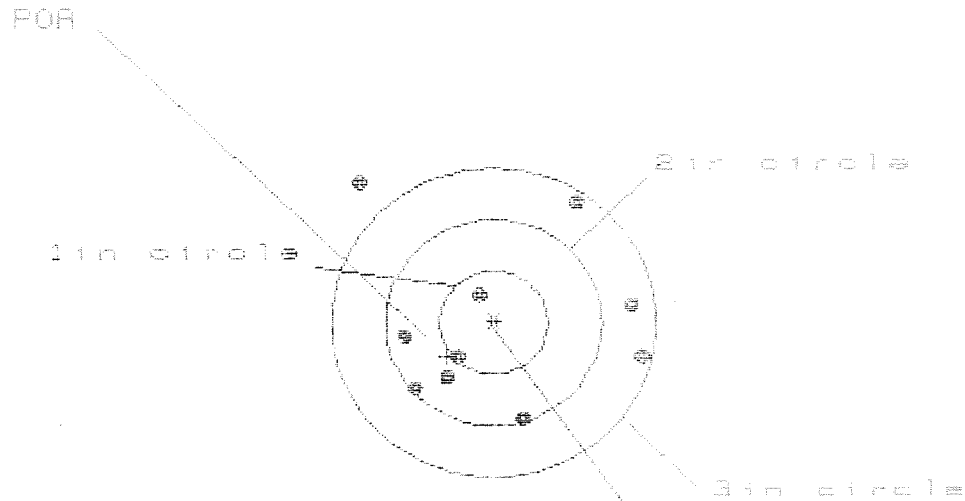
CENTROID #

| PATTERN #                     | 1      | 2      | 3      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.818  | .825   | .628   |
| MINIMUM X                     | -1.748 | -1.638 | -.911  |
| MAXIMUM Y                     | 1.453  | 1.257  | 1.147  |
| MINIMUM Y                     | -1.761 | -.959  | -1.068 |
| CENTROID X                    | -.192  | .001   | .386   |
| CENTROID Y                    | .177   | .373   | .482   |
| POA TO CENTROID in.           | .261   | .373   | .525   |
| MIN RADIUS                    | .437   | .601   | .645   |
| MEAN RADIUS                   | 1.184  | 1.023  | .981   |
| MAX RADIUS                    | 2.476  | 1.858  | 1.148  |
| HORIZONTAL SPREAD             | 2.758  | 2.463  | 1.531  |
| VERTICAL SPREAD               | 3.214  | 2.216  | 2.216  |
| EXTREME SPREAD                | 3.837  | 2.798  | 2.238  |
| NUMBER IN ONE INCH CIRCLE =   |        | 1      |        |
| NUMBER IN TWO INCH CIRCLE =   |        | 4      |        |
| NUMBER IN THREE INCH CIRCLE = |        | 8      |        |

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# CENTERFIRE PATTERNS # 2



# OF SHOTS = 10

# IN CIR

1in = 2

2in = 6

3in = 8

HS = 2.597

VS = 2.337

CS = 3.140

CENTROID #

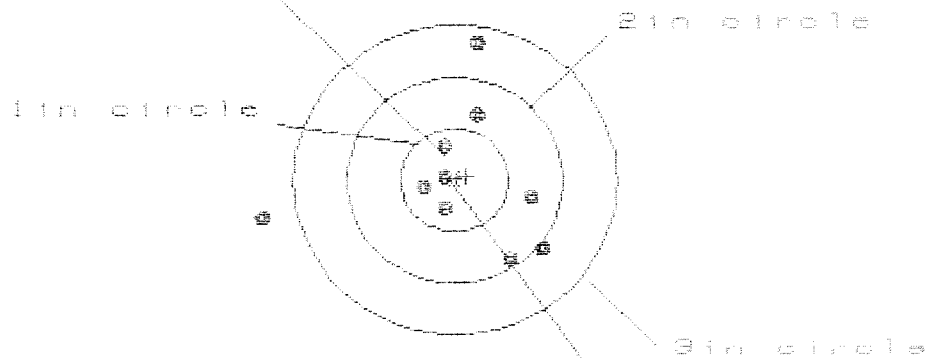
|                               |   |        |       |       |
|-------------------------------|---|--------|-------|-------|
| PATTERN #                     | : | 2      |       |       |
| SHOTS (BEST OF)               | : | 10     | 9     | 8     |
| MAXIMUM X                     | : | 1.358  | 1.228 | 1.329 |
| MINIMUM X                     | : | -1.239 | -.923 | -.778 |
| MAXIMUM Y                     | : | 1.396  | 1.334 | 1.387 |
| MINIMUM Y                     | : | -.941  | -.786 | -.813 |
| CENTROID X                    | : | .434   | .572  | .419  |
| CENTROID Y                    | : | .330   | .175  | .282  |
| POA TO CENTROID in.           | : | .545   | .598  | .465  |
| MIN RADIUS                    | : | .312   | .487  | .356  |
| MEAN RADIUS                   | : | 1.020  | .926  | .844  |
| MAX RADIUS                    | : | 1.866  | 1.470 | 1.517 |
| HORIZONTAL SPREAD             | : | 2.597  | 2.143 | 2.095 |
| VERTICAL SPREAD               | : | 2.337  | 2.120 | 2.120 |
| EXTREME SPREAD                | : | 3.140  | 2.342 | 2.342 |
| NUMBER IN ONE INCH CIRCLE =   |   |        | 2     |       |
| NUMBER IN TWO INCH CIRCLE =   |   |        | 6     |       |
| NUMBER IN THREE INCH CIRCLE = |   |        | 9     |       |

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# CENTERFIRE PATTERNS # 3

POA



# OF SHOTS- 10

# IN CIR

1 in = 4

2 in = 7

3 in = 9

IS= 2.596

VS= 2.130

ES= 2.666

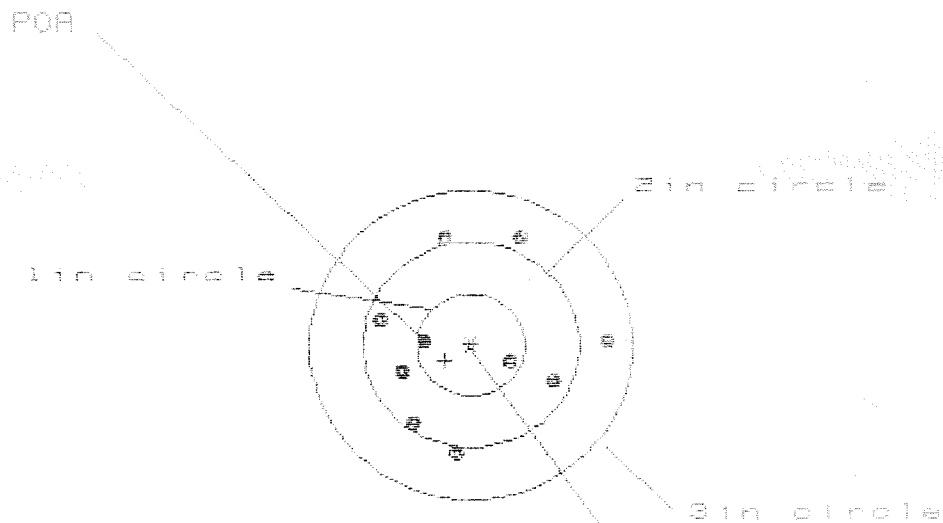
CENTROID #

|                               |   |        |        |        |
|-------------------------------|---|--------|--------|--------|
| PATTERN #                     | : | 3      |        |        |
| SHOTS (BEST OF)               | : | 10     | 9      | 8      |
| MAXIMUM X                     | : | .818   | .621   | .622   |
| MINIMUM X                     | : | -1.778 | -1.498 | -1.497 |
| MAXIMUM Y                     | : | 1.374  | 1.329  | .744   |
| MINIMUM Y                     | : | -.756  | -.801  | -.635  |
| CENTROID X                    | : | -.108  | .089   | .088   |
| CENTROID Y                    | : | -.036  | .009   | -.157  |
| POA TO CENTROID in.           | : | .114   | .090   | .180   |
| MIN RADIUS                    | : | .106   | .291   | .337   |
| MEAN RADIUS                   | : | .750   | .647   | .550   |
| MAX RADIUS                    | : | 1.822  | 1.329  | .819   |
| HORIZONTAL SPREAD             | : | 2.596  | 1.119  | 1.119  |
| VERTICAL SPREAD               | : | 2.130  | 2.130  | 1.379  |
| EXTREME SPREAD                | : | 2.666  | 2.145  | 1.409  |
| NUMBER IN ONE INCH CIRCLE =   |   |        | 4      |        |
| NUMBER IN TWO INCH CIRCLE =   |   |        | 7      |        |
| NUMBER IN THREE INCH CIRCLE = |   |        | 9      |        |

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# CENTERFIRE PATTERNS # 4



# OF SHOTS = 10

# IN CIR

1in = 2

2in = 5

3in = 10

HS = 2.131

VS = 2.090

CS = 2.145

CENTROID \*

| PATTERN #                     | 1      | 2      | 3     |
|-------------------------------|--------|--------|-------|
| SHOTS (BEST OF)               | 10     | 9      | 8     |
| MAXIMUM X                     | 1.292  | .922   | .997  |
| MINIMUM X                     | -.839  | -.696  | -.621 |
| MAXIMUM Y                     | 1.082  | 1.086  | 1.216 |
| MINIMUM Y                     | -1.008 | -1.004 | -.874 |
| CENTROID X                    | .240   | .097   | .022  |
| CENTROID Y                    | .154   | .150   | .020  |
| POA TO CENTROID in.           | .285   | .179   | .030  |
| MIN RADIUS                    | .402   | .356   | .350  |
| MEAN RADIUS                   | .876   | .808   | .734  |
| MAX RADIUS                    | 1.292  | 1.201  | 1.216 |
| HORIZONTAL SPREAD             | 2.131  | 1.618  | 1.613 |
| VERTICAL SPREAD               | 2.090  | 2.090  | 2.090 |
| EXTREME SPREAD                | 2.145  | 2.137  | 2.090 |
| NUMBER IN ONE INCH CIRCLE =   | 2      |        |       |
| NUMBER IN TWO INCH CIRCLE =   | 5      |        |       |
| NUMBER IN THREE INCH CIRCLE = | 10     |        |       |

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# CENTERFIRE PATTERNS

# 5

POA

1in circle

2in circle

3in circle

CENTROID \*

# OF SHOTS = 10

# IN CIR

1in = 2

2in = 3

3in = 7

HS = 2.946

VS = 3.353

GS = 3.839

| PATTERN #                   | 5      | 9      | 8      |
|-----------------------------|--------|--------|--------|
| SHOTS (BEST OF)             | 10     | 9      | 8      |
| MAXIMUM X                   | 1.452  | 1.386  | 1.191  |
| MINIMUM X                   | -1.494 | -1.560 | -1.945 |
| MAXIMUM Y                   | 1.966  | 1.110  | .964   |
| MINIMUM Y                   | -1.387 | -1.168 | -1.214 |
| CENTROID X                  | .241   | .307   | .502   |
| CENTROID Y                  | -.375  | -.594  | -.448  |
| POA TO CENTROID in.         | .446   | .668   | .672   |
| MIN RADIUS                  | .480   | .622   | .409   |
| MEAN RADIUS                 | 1.273  | 1.210  | 1.076  |
| MAX RADIUS                  | 2.052  | 1.949  | 1.701  |
| HORIZONTAL SPREAD           | 2.946  | 2.946  | 2.136  |
| VERTICAL SPREAD             | 3.353  | 2.278  | 2.178  |
| EXTREME SPREAD              | 3.839  | 3.179  | 3.045  |
| NUMBER IN ONE INCH CIRCLE   | =      | 2      |        |
| NUMBER IN TWO INCH CIRCLE   | =      | 3      |        |
| NUMBER IN THREE INCH CIRCLE | =      | 7      |        |