

C5549145

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> **DUPONT**  
REG. U.S. PAT. & TM. OFF.

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

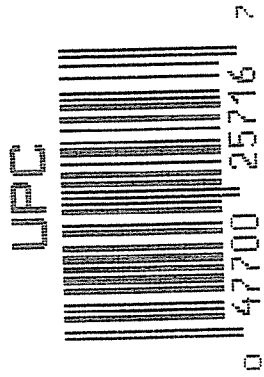
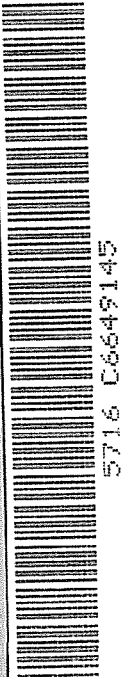
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marquo Deposee.

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

**SERIAL NO.**  
**C6649145**

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

**20**



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649/45

| OP. #        | OP. NAME                                                       | READINGS | DATE    | INIT |
|--------------|----------------------------------------------------------------|----------|---------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   | 6 25     | 9 1     | RW   |
| 600          | Proof                                                          | 6 25     | 9 1     | RW   |
| 607          | Check Headspace                                                | 6 25     | 8 1     | RW   |
| 610          | Dis-assemble Gun                                               | 6 25     | 9 1     | RW   |
| 612          | Magnaflux Barrel<br>Action                                     | JUL      | 1 1991  | KR   |
|              | Magnaflux Bolt                                                 | JUL      | 1 1991  | KR   |
| 615          | Rollmark Caliber                                               | JUL      | 1 1991  | LS   |
| 617          | Drill and Tap Sight Holes                                      | JUL      | 1 1991  | EB   |
| 618          | Polish Barrel                                                  | JUL      | 2 1991  | WB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 8-27-91 | AD   |
|              | Apply Coating (Bolt)                                           |          |         |      |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 8/28/91 | WB   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 8/28/91 | WB   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 8/28/91 | WB   |
|              | D) Oil Firing Pin Ass'y                                        |          | 8/28/91 | WB   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 8/26/91 | YU   |

| op. #        | OP. NAME                                                    | READINGS |       |       |      |      | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|-------|-------|------|------|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 4 3/4    | 4 1/2 | 5     |      |      | 8/26/91 | WB   |
|              | G) Safety Off Force                                         | 2 1/2    | 2 1/2 | 2 1/2 |      |      | 8/26/91 | WB   |
|              | H) Trigger Pull Test & Retainability                        |          |       |       |      |      | 8/26/91 | JV   |
|              | I) Firing Pin Indent                                        | .021     | .022  | .021  |      |      | 8/26/91 | WB   |
|              | J) Assemble Stock                                           |          |       |       |      |      |         |      |
|              | K) Assemble Swivel Studs                                    |          |       |       |      |      | 8-28-91 | D/H  |
|              | L) Attach Front and Rear Sight Assemblies                   |          |       |       |      |      | 8/28/91 | RW   |
|              | M) Iron Sight Alignment                                     |          |       |       |      |      | 8/28/91 | RW   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |       |       |      |      | 8/28/91 | RW   |
|              | O) Attach Scope to Rifle                                    |          |       |       |      |      | 8/28/91 | RW   |
|              | P) Detach & Attach Scope 20 Times                           |          |       |       |      |      | 8/28/91 | RW   |
| 640          | Gallery Target & Test                                       |          |       |       |      |      | 8-28-91 | AC   |
|              | A) Time                                                     |          |       |       |      |      | 8-28-91 | AC   |
|              | B) Malfunctions                                             |          |       |       |      |      | 8-28-91 | AC   |
|              | C) Pierced Primers                                          |          |       |       |      |      | 8-28-91 | AC   |
|              | D) Optical Clarity of Scope                                 |          |       |       |      |      | 8-28-91 | AC   |
| 645          | Inspect for Live Ammo                                       |          |       |       |      |      | 8-28-91 | AC   |
| 655          | Final Inspection                                            |          |       |       |      |      | 8-28-91 | D/H  |
|              | A) Headspace                                                |          |       |       |      |      |         |      |
|              | B) Trigger Pull                                             | 2.59     | 2.54  | 2.70  | 2.71 | 2.80 | 8-27-91 | D/H  |
|              | C) Function                                                 |          |       |       |      |      | 8-28-91 | D/H  |
| 660          | Pack                                                        |          |       |       |      |      | 9-17-91 | D/H  |

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

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

SERIAL NO. C-6649145

DATE 8/26/91

TESTER JY

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.50             | 2.54                     | 2.49                           | 2.59 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.55             | 2.51                     | 2.44                           | 2.54 |                                                                        |
| PULL #3 | 2.30             | 2.54                     | 2.54                           | 2.70 |                                                                        |
| PULL #4 | 2.53             | 2.50                     | 2.56                           | 2.71 |                                                                        |
| PULL #5 | 2.54             | 2.41                     | 2.58                           | 2.80 |                                                                        |
| TOTAL   |                  |                          |                                |      |                                                                        |
| AVG.    |                  |                          |                                |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.45             | 3.45                     |  |          |
| PULL #2 | 3.30             | 3.39                     |  |          |
| PULL #3 | 3.27             | 3.39                     |  |          |
| PULL #4 | 3.30             | 3.41                     |  |          |
| PULL #5 | 3.33             | 3.41                     |  |          |
| 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             | 4.24                     |                                | 4.26                                 |
| PULL #2 | 4.23             | 4.25                     |                                | 4.27                                 |
| PULL #3 | 4.34             | 4.26                     |                                | 4.23                                 |
| PULL #4 | 4.31             | 4.26                     |                                | 4.28                                 |
| PULL #5 | 4.22             | 4.29                     |                                | 4.32                                 |
| TOTAL   | <del>4.24</del>  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6649145  
26 Aug 1991

CENTROIDAL DISTANCES

|        |         |
|--------|---------|
| 0 TO 1 | .276139 |
| 1 TO 2 | .349986 |
| 1 TO 3 | .304237 |
| 1 TO 4 | .175    |
| 1 TO 5 | .322343 |

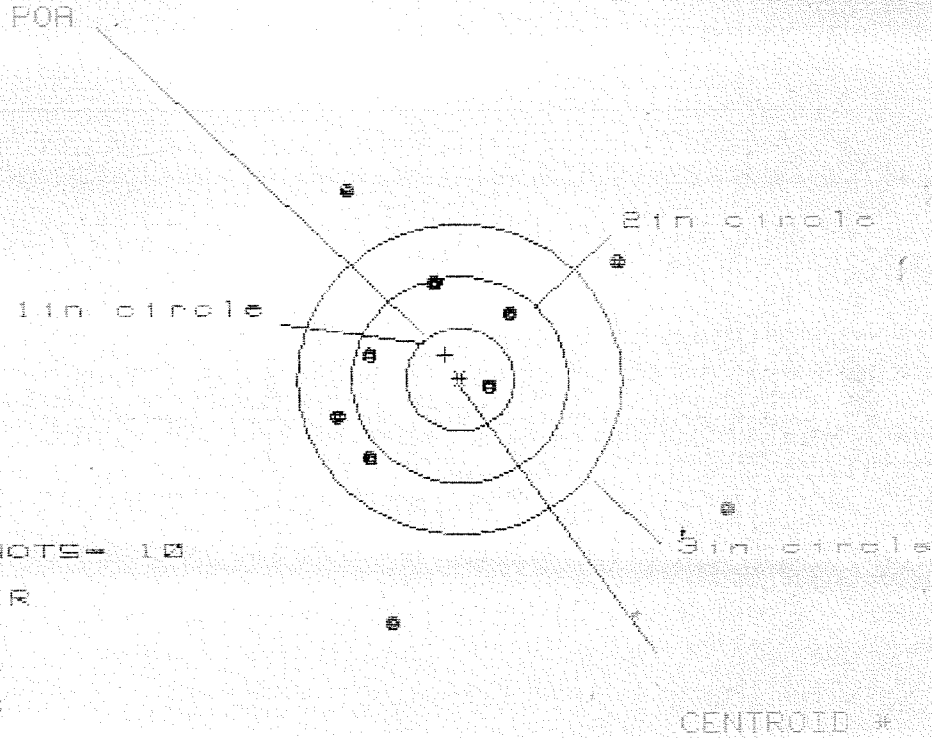
00 4 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0186  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0972  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0989636  
THE RMV FOR THIS RIFLE IS: 1.095

28 Aug 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/08649145

# CENTERFIRE PATTERNS # 1



# OF SHOTS= 10

# IN CIR

1in = 1

2in = 4

3in = 5

HS= 3.537

VS= 4.133

GS= 4.631

| PATTERN #                     | 1      | 2      | 3      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 2.436  | 1.714  | 1.673  |
| MINIMUM X                     | -1.101 | -1.830 | -1.871 |
| MAXIMUM Y                     | 1.810  | 1.666  | 1.358  |
| MINIMUM Y                     | -2.323 | -2.467 | -1.189 |
| CENTROID X                    | .133   | -.138  | -.097  |
| CENTROID Y                    | -.242  | -.098  | .210   |
| POA TO CENTROID in.           | .276   | .169   | .232   |
| MIN RADIUS                    | .286   | .588   | .461   |
| MEAN RADIUS                   | 1.425  | 1.238  | 1.058  |
| MAX RADIUS                    | 2.757  | 2.488  | 1.829  |
| HORIZONTAL SPREAD             | 3.537  | 2.544  | 2.544  |
| VERTICAL SPREAD               | 4.133  | 4.133  | 2.547  |
| EXTREME SPREAD                | 4.631  | 4.153  | 2.975  |
| NUMBER IN ONE INCH CIRCLE =   | 1      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 4      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 6      |        |        |

26 Aug 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C8649145

# CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

# OF SHOTS= 10

# IN CIR

1in = 2

2in = 7

3in = 8

HS= 2.896

VS= 2.071

GS= 2.956

CENTROID \*

| PATTERN #                     | 10     | 9      | 8      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | .946   | .730   | .805   |
| MINIMUM X                     | -1.950 | -1.096 | -1.021 |
| MAXIMUM Y                     | .778   | .749   | .583   |
| MINIMUM Y                     | -1.294 | -1.322 | -1.573 |
| CENTROID X                    | -.086  | .130   | .055   |
| CENTROID Y                    | .031   | .060   | .226   |
| POA TO CENTROID in.           | .092   | .144   | .232   |
| MIN RADIUS                    | .320   | .259   | .087   |
| MEAN RADIUS                   | .963   | .801   | .682   |
| MAX RADIUS                    | 1.967  | 1.454  | 1.130  |
| HORIZONTAL SPREAD             | 2.896  | 1.826  | 1.826  |
| VERTICAL SPREAD               | 2.071  | 2.071  | 1.156  |
| EXTREME SPREAD                | 2.956  | 2.342  | 1.954  |
| NUMBER IN ONE INCH CIRCLE =   |        | 2      |        |
| NUMBER IN TWO INCH CIRCLE =   |        | 7      |        |
| NUMBER IN THREE INCH CIRCLE = |        | 8      |        |

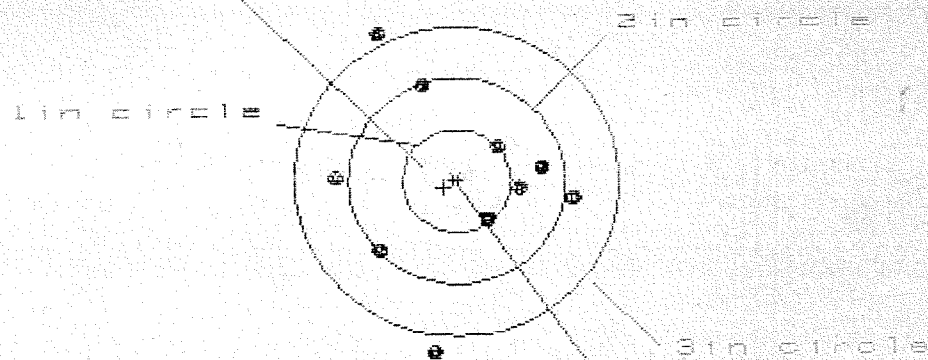


26 Aug 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C8B49145

# CENTERFIRE PATTERNS # 3

POA



# OF SHOTS- 10

# IN CIR

1 in = 1

2 in = 5

3 in = 4

HS= 2.227

VS= 3.023

CS= 3.062

CENTROID #

PATTERN # : 3

| SHOTS (BEST OF)               | 10     | 9      | 8      |
|-------------------------------|--------|--------|--------|
| MAXIMUM X                     | 1.110  | 1.081  | .983   |
| MINIMUM X                     | -1.117 | -1.146 | -1.244 |
| MAXIMUM Y                     | 1.405  | 1.225  | .877   |
| MINIMUM Y                     | -1.618 | -.864  | -.711  |
| CENTROID X                    | .121   | .150   | .248   |
| CENTROID Y                    | .062   | .242   | .089   |
| POA TO CENTROID in.           | .136   | .285   | .264   |
| MIN RADIUS                    | .440   | .398   | .392   |
| MEAN RADIUS                   | .983   | .898   | .791   |
| MAX RADIUS                    | 1.640  | 1.454  | 1.244  |
| HORIZONTAL SPREAD             | 2.227  | 2.227  | 2.227  |
| VERTICAL SPREAD               | 3.023  | 2.089  | 1.588  |
| EXTREME SPREAD                | 3.062  | 2.434  | 2.234  |
| NUMBER IN ONE INCH CIRCLE =   | 1      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 5      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 8      |        |        |

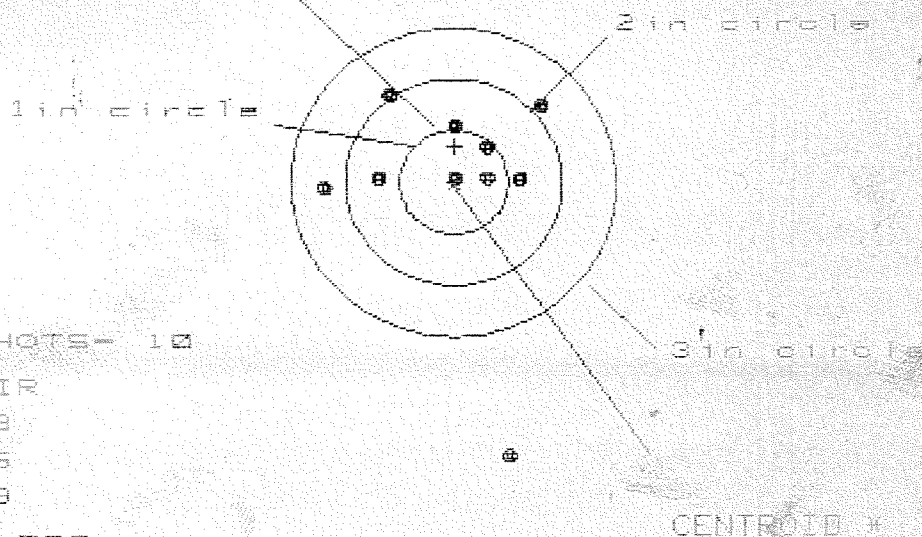
26 Aug 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6649145

# CENTERFIRE PATTERNS

# 4

FOR



# OF SHOTS- 10

# IN CIR

1in = 3

2in = 6

3in = 9

HS= 2.027

VS= 3.512

GS= 3.672

|                             |   |        |        |       |
|-----------------------------|---|--------|--------|-------|
| PATTERN #                   | : | 4      |        |       |
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | .792   | .849   | .701  |
| MINIMUM X                   | : | -1.235 | -1.178 | -.925 |
| MAXIMUM Y                   | : | .943   | .546   | .504  |
| MINIMUM Y                   | : | -2.669 | -.336  | -.336 |
| CENTROID X                  | : | -.007  | -.064  | .084  |
| CENTROID Y                  | : | -.347  | -.050  | -.003 |
| FOR TO CENTROID in.         | : | .347   | .081   | .084  |
| MIN RADIUS                  | : | .031   | .269   | .222  |
| MEAN RADIUS                 | : | .878   | .635   | .530  |
| MAX RADIUS                  | : | 2.718  | 1.225  | .865  |
| HORIZONTAL SPREAD           | : | 2.027  | 2.027  | 1.526 |
| VERTICAL SPREAD             | : | 3.512  | .882   | .839  |
| EXTREME SPREAD              | : | 3.672  | 2.169  | 1.660 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 3      |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 6      |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |       |

28 Aug 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6649145

# CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

# OF SHOTS= 10

# IN CIR

1in = 1

2in = 4

3in = 6

HS= 2.550

VS= 3.776

GS= 3.790

CENTROID \*

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.258

1.277

1.340

MINIMUM X

-1.292

-1.273

-1.210

MAXIMUM Y

1.648

1.412

1.502

MINIMUM Y

-2.128

-1.113

-1.936

CENTROID X

-.068

-.087

-.150

CENTROID Y

.010

.246

.070

POA TO CENTROID IN.

.068

.261

.166

MIN RADIUS

.300

.448

.302

MEAN RADIUS

1.194

1.087

1.010

MAX RADIUS

2.134

1.691

1.530

HORIZONTAL SPREAD

2.550

2.550

2.550

VERTICAL SPREAD

3.776

2.525

2.439

EXTREME SPREAD

3.790

3.091

2.662

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

4

NUMBER IN THREE INCH CIRCLE =

6