

C6649231

MODEL 700™ M24

Model **SWS**™

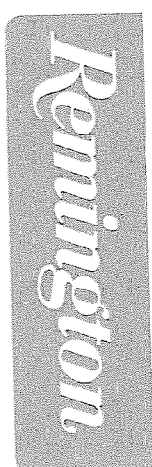
Action

Barrel Length

Capacity

Order No. **5716**

\*Includes 1 in chamber.



**Remington®**

REG. U.S. PAT. & TM. OFF.

**DU PONT**

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

MODEL 700™ M24

SERIAL NO. C6649231

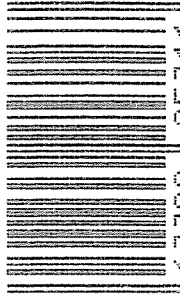
ORDER NO. 5716

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



5716 C6649231

UPC



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6649231

| OP. #        | OP. NAME                                                       | READINGS | DATE    | INIT |
|--------------|----------------------------------------------------------------|----------|---------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   |          | 7/24/91 | KA   |
| 600          | Proof                                                          |          | 7/24/91 | KA   |
| 607          | Check Headspace                                                |          | 7/24/91 | KA   |
| 610          | Dis-assemble Gun                                               |          | 7/24/91 | KA   |
| 612          | Magnaflux Barrel<br>Action                                     | AUG 7    | 1991    | KR   |
|              | Magnaflux Bolt                                                 | AUG 7    | 1991    | KR   |
| 615          | Rollmark Caliber                                               | AUG 7    | 1991    | SB   |
| 617          | Drill and Tap Sight Holes                                      | AUG 7    | 1991    | FB   |
| 618          | Polish Barrel                                                  | AUG 13   | 1991    | WB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 8/27/91 | KA   |
|              | Apply Coating (Bolt)                                           |          | 8/27/91 | KA   |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 8/29/91 | KA   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 8/29/91 | KA   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 8/29/91 | KA   |
|              | D) Oil Firing Pin Ass'y                                        |          | 8/29/91 | KA   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 8/30/91 | KA   |

| op. #        | OP. NAME                                                    | READINGS |      |      |     |     | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|------|------|-----|-----|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 6        | 6    | 6    |     |     | 8/30/91 | SH   |
|              | G) Safety Off Force                                         | 4        | 4    | 4    |     |     | 8/30/91 | SH   |
|              | H) Trigger Pull Test & Retainability                        |          |      |      |     |     | 8/30/91 | SH   |
|              | I) Firing Pin Indent                                        | .025     | .021 | .021 |     |     | 8/30/91 | SH   |
|              | J) Assemble Stock                                           |          |      |      |     |     | 8/30/91 | SH   |
|              | K) Assemble Swivel Studs                                    |          |      |      |     |     | 9/10/91 | DH   |
|              | L) Attach Front and Rear Sight Assemblies                   |          |      |      |     |     | 8/30/91 | SH   |
|              | M) Iron Sight Alignment                                     |          |      |      |     |     | 8/30/91 | SH   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |      |      |     |     | 8/30/91 | SH   |
|              | O) Attach Scope to Rifle                                    |          |      |      |     |     | 8/30/91 | SH   |
|              | P) Detach & Attach Scope 20 Times                           |          |      |      |     |     | 8/30/91 | SH   |
| 640          | Gallery Target & Test                                       |          |      |      |     |     | 9-4-91  | DH   |
|              | A) Time                                                     |          |      |      |     |     | 9-4-91  | DH   |
|              | B) Malfunctions                                             |          |      |      |     |     | 9-4-91  | DH   |
|              | C) Pierced Primers                                          |          |      |      |     |     | 9-4-91  | DH   |
|              | D) Optical Clarity of Scope                                 |          |      |      |     |     | 9-4-91  | DH   |
| 645          | Inspect for Live Ammo                                       |          |      |      |     |     | 9-4-91  | DH   |
| 655          | Final Inspection                                            |          |      |      |     |     |         |      |
|              | A) Headspace                                                |          |      |      |     |     | 9-10-91 | DH   |
|              | B) Trigger Pull                                             | 268      | 266  | 263  | 269 | 270 | 9-6-91  | SH   |
|              | C) Function                                                 |          |      |      |     |     | 9-10-91 | DH   |
| 660          | Pack                                                        |          |      |      |     |     | 9-18-91 | SH   |

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6649231

DATE 8/30/91

TESTER JL

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.38             | 2.19                     | 2.40                           | 2.68 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.20             | 2.17                     | 2.44                           | 2.66 |                                                                        |
| PULL #3 | 2.29             | 2.44                     | 2.40                           | 2.63 |                                                                        |
| PULL #4 | 2.26             | 2.50                     | 2.48                           | 2.69 |                                                                        |
| PULL #5 | 2.19             | 2.46                     | 2.50                           | 2.70 |                                                                        |
| TOTAL   |                  |                          |                                |      |                                                                        |
| AVG.    |                  |                          |                                |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.41             | 3.32                     |  |          |
| PULL #2 | 3.36             | 3.33                     |  |          |
| PULL #3 | 3.47             | 3.48                     |  |          |
| PULL #4 | 3.47             | 3.32                     |  |          |
| PULL #5 | 3.37             | 3.37                     |  |          |
| 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 | 4.45             | 4.45                     |                                | 4.56                                 |
| PULL #2 | 4.42             | 4.52                     |                                | 4.52                                 |
| PULL #3 | 4.39             | 4.49                     |                                | 4.60                                 |
| PULL #4 | 4.53             | 4.56                     |                                | 4.40                                 |
| PULL #5 | 4.49             | 4.39                     |                                | 4.62                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6649231  
4 Sep 1991

CENTROIDAL DISTANCES

|        |         |
|--------|---------|
| 0 TO 1 | .616437 |
| 1 TO 2 | .366853 |
| 1 TO 3 | .940707 |
| 1 TO 4 | .759084 |
| 1 TO 5 | .389197 |

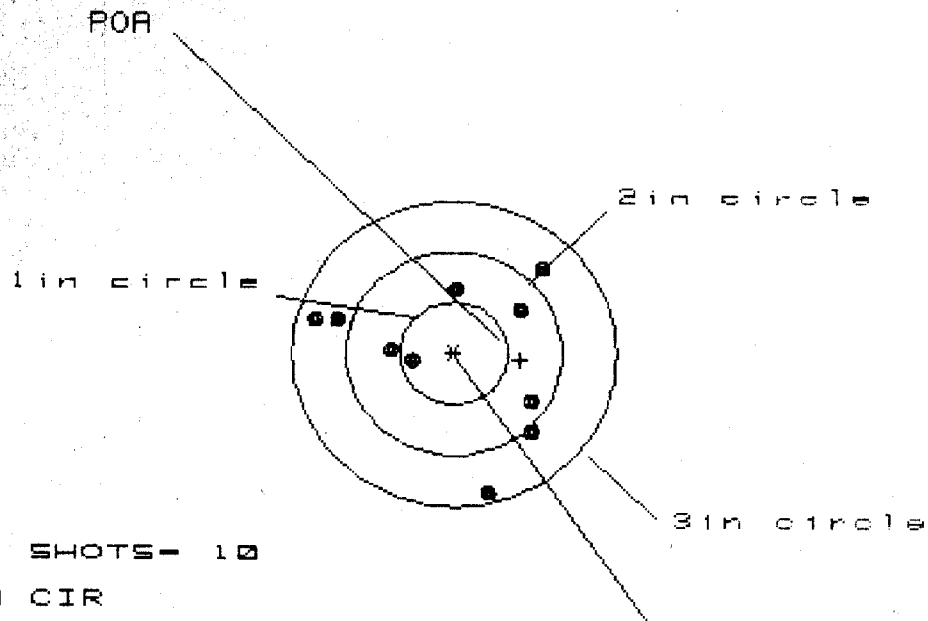
1st 2nd <----POA

AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2112  
AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1376  
AVERAGE POI RADIUS FOR THIS RIFLE IS: .25207  
SIF FOR THIS RIFLE IS: .956

4 Sep 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/06649231

# CENTERFIRE PATTERNS # 1



\* OF SHOTS- 10

\* IN CIR

1 in - 1

2 in - 5

3 in - 10

HS- 2.107

VS- 2.146

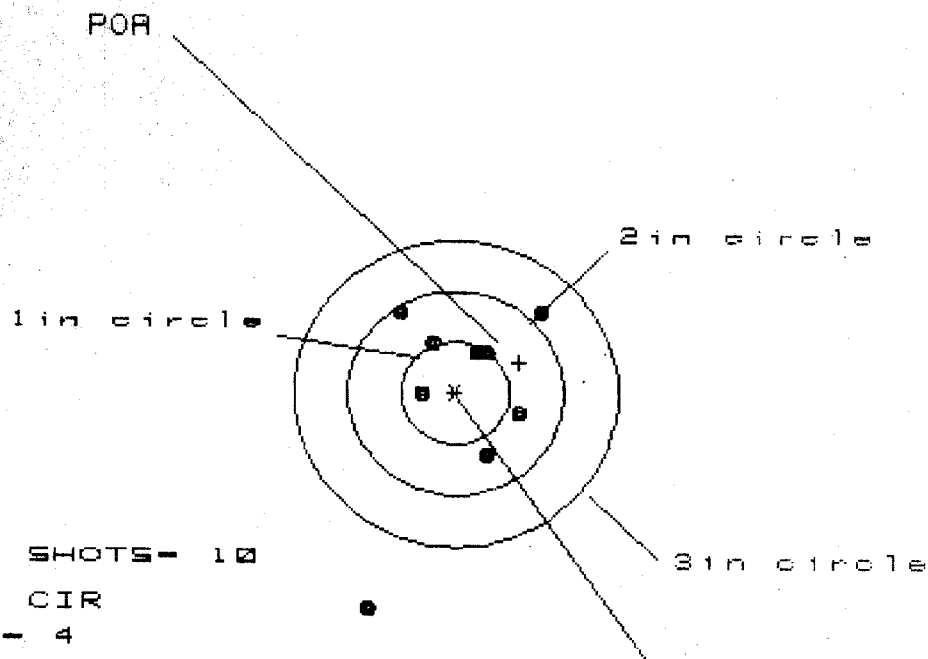
GS- 2.293

|                             |   |        |        |        |
|-----------------------------|---|--------|--------|--------|
| PATTERN #                   | : |        |        |        |
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | .846   | .885   | .732   |
| MINIMUM X                   | : | -1.261 | -1.222 | -1.177 |
| MAXIMUM Y                   | : | .829   | .683   | .704   |
| MINIMUM Y                   | : | -1.317 | -.915  | -.894  |
| CENTROID X                  | : | -.613  | -.652  | -.499  |
| CENTROID Y                  | : | .065   | .211   | .190   |
| POA TO CENTROID in.         | : | .617   | .685   | .534   |
| MIN RADIUS                  | : | .372   | .390   | .517   |
| MEAN RADIUS                 | : | .934   | .871   | .824   |
| MAX RADIUS                  | : | 1.362  | 1.234  | 1.195  |
| HORIZONTAL SPREAD           | : | 2.107  | 2.107  | 1.909  |
| VERTICAL SPREAD             | : | 2.146  | 1.598  | 1.598  |
| EXTREME SPREAD              | : | 2.293  | 2.257  | 2.092  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 1      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 5      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 10     |        |

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# CENTERFIRE PATTERNS # 2



# OF SHOTS- 10

# IN CIR

1in = 4

2in = 8

3in = 9

HS= 1.558

VS= 2.945

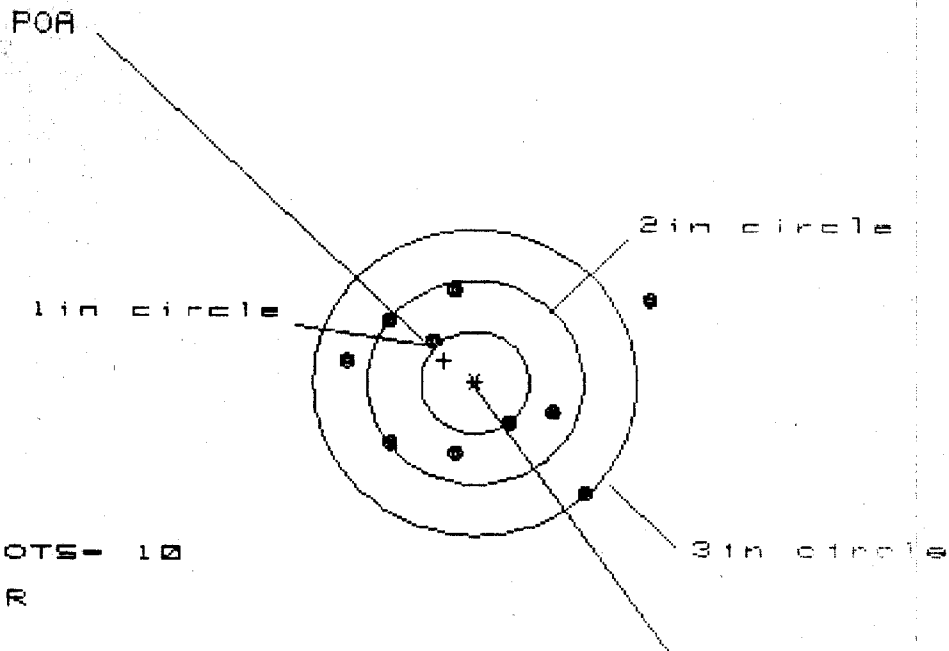
GS= 3.332

| PATTERN #                     | 10     | 9     | 8     |
|-------------------------------|--------|-------|-------|
| SHOTS (BEST OF)               | 10     | 9     | 8     |
| MAXIMUM X                     | .755   | .666  | .587  |
| MINIMUM X                     | -.803  | -.613 | -.530 |
| MAXIMUM Y                     | .846   | .612  | .650  |
| MINIMUM Y                     | -2.099 | -.856 | -.779 |
| CENTROID X                    | -.588  | -.499 | -.582 |
| CENTROID Y                    | -.301  | -.067 | -.144 |
| POA TO CENTROID in.           | .661   | .504  | .600  |
| MIN RADIUS                    | .292   | .200  | .313  |
| MEAN RADIUS                   | .770   | .550  | .512  |
| MAX RADIUS                    | 2.248  | .905  | .842  |
| HORIZONTAL SPREAD             | 1.558  | 1.279 | 1.117 |
| VERTICAL SPREAD               | 2.945  | 1.468 | 1.429 |
| EXTREME SPREAD                | 3.332  | 1.663 | 1.663 |
| NUMBER IN ONE INCH CIRCLE =   | 4      |       |       |
| NUMBER IN TWO INCH CIRCLE =   | 8      |       |       |
| NUMBER IN THREE INCH CIRCLE = | 9      |       |       |

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# CENTERFIRE PATTERNS # 3



# OF SHOTS- 10

# IN CIR

1in = 1

2in = 7

3in = 9

HS= 2.838

VS= 1.968

GS= 2.917

CENTROID #

| PATTERN #                   | : | 10     | 9      | 8     |
|-----------------------------|---|--------|--------|-------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | 1.642  | 1.197  | 1.007 |
| MINIMUM X                   | : | -1.196 | -1.014 | -.864 |
| MAXIMUM Y                   | : | .927   | 1.022  | .903  |
| MINIMUM Y                   | : | -1.041 | -.946  | -.732 |
| CENTROID X                  | : | .286   | .104   | -.046 |
| CENTROID Y                  | : | -.212  | -.307  | -.188 |
| POA TO CENTROID in.         | : | .356   | .324   | .194  |
| MIN RADIUS                  | : | .463   | .534   | .403  |
| MEAN RADIUS                 | : | .994   | .875   | .773  |
| MAX RADIUS                  | : | 1.850  | 1.526  | 1.053 |
| HORIZONTAL SPREAD           | : | 2.838  | 2.211  | 1.871 |
| VERTICAL SPREAD             | : | 1.968  | 1.968  | 1.635 |
| EXTREME SPREAD              | : | 2.917  | 2.525  | 1.927 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 1      |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 7      |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |       |

4 Sep 1931

FILE: /PATTERNING/CENTERFIRE\_PATT/C8649231

# CENTERFIRE PATTERNS

# 4

POA

1in circle

2in circle

3in circle

+ OF SHOTS- 10

# IN CIR

1in = 0

2in = 6

3in = 8

HS= 2.680

VS= 2.740

GS= 3.015

CENTROID \*

PATTERN #

| SHOTS (BEST OF)               | 10     | 9      | 8      |
|-------------------------------|--------|--------|--------|
| MAXIMUM X                     | 1.057  | 1.107  | .910   |
| MINIMUM X                     | -1.623 | -1.573 | -.976  |
| MAXIMUM Y                     | 1.032  | .843   | .871   |
| MINIMUM Y                     | -1.708 | -1.152 | -1.124 |
| CENTROID X                    | .115   | .065   | .262   |
| CENTROID Y                    | -.150  | .039   | .011   |
| POA TO CENTROID in.           | .189   | .076   | .262   |
| MIN RADIUS                    | .588   | .419   | .418   |
| MEAN RADIUS                   | 1.081  | .972   | .877   |
| MAX RADIUS                    | 1.765  | 1.598  | 1.446  |
| HORIZONTAL SPREAD             | 2.680  | 2.680  | 1.986  |
| VERTICAL SPREAD               | 2.740  | 1.995  | 1.995  |
| EXTREME SPREAD                | 3.015  | 3.015  | 2.483  |
| NUMBER IN ONE INCH CIRCLE =   |        | 0      |        |
| NUMBER IN TWO INCH CIRCLE =   |        | 6      |        |
| NUMBER IN THREE INCH CIRCLE = |        | 8      |        |

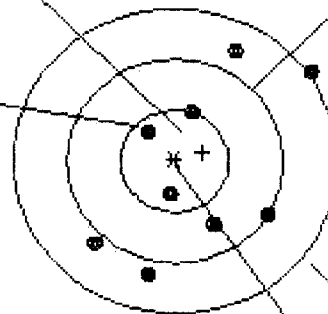
CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle



# OF SHOTS- 10

# IN CIR

1 in = 2

2 in = 4

3 in = 8

HS= 3.148

VS= 2.157

GS= 3.173

CENTROID \*

| PATTERN #                     | 10     | 9      | 8     |
|-------------------------------|--------|--------|-------|
| SHOTS (BEST OF)               | 10     | 9      | 8     |
| MAXIMUM X                     | 1.224  | 1.010  | .810  |
| MINIMUM X                     | -1.924 | -.948  | -.821 |
| MAXIMUM Y                     | 1.092  | 1.150  | 1.274 |
| MINIMUM Y                     | -1.065 | -1.007 | -.883 |
| CENTROID X                    | -.256  | -.042  | -.169 |
| CENTROID Y                    | -.090  | -.148  | -.272 |
| POA TO CENTROID in.           | .271   | .154   | .320  |
| MIN RADIUS                    | .344   | .357   | .185  |
| MEAN RADIUS                   | 1.001  | .877   | .780  |
| MAX RADIUS                    | 1.995  | 1.413  | 1.348 |
| HORIZONTAL SPREAD             | 3.148  | 1.958  | 1.631 |
| VERTICAL SPREAD               | 2.157  | 2.157  | 2.157 |
| EXTREME SPREAD                | 3.173  | 2.609  | 2.303 |
| NUMBER IN ONE INCH CIRCLE =   | 2      |        |       |
| NUMBER IN TWO INCH CIRCLE =   | 4      |        |       |
| NUMBER IN THREE INCH CIRCLE = | 8      |        |       |