

C6649287

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

\*Includes 1 in chamber.

*Remington*

**Remington**<sup>®</sup> **DUPONT**  
REG. U.S. PAT. & TM. OFF.

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

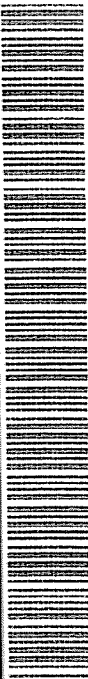
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada. Marque Deposee.

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

**SERIAL NO.**  
 C6649287

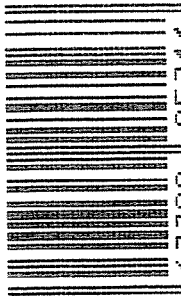
**ORDER NO.**  
**5716**

**20**



5716 C6649287

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649287

| OP. #        | OP. NAME                                                       | READINGS   | DATE    | INIT |
|--------------|----------------------------------------------------------------|------------|---------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   | 6 27 9 1   |         | dw   |
| 600          | Proof                                                          | 6 27 9 1   |         | dw   |
| 607          | Check Headspace                                                | 6 27 9 1   |         | dw   |
| 610          | Dis-assemble Gun                                               | 6 27 9 1   |         | dw   |
| 612          | Magnaflux Barrel<br>Action                                     | JUL 2 1991 |         | KR   |
|              | Magnaflux Bolt                                                 | JUL 2 1991 |         | KR   |
| 615          | Rollmark Caliber                                               | JUL 2 1991 |         | LS   |
| 617          | Drill and Tap Sight Holes                                      | JUL 2 1991 |         | LB   |
| 618          | Polish Barrel                                                  | JUL 7 1991 |         | WB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |            | 7-22-91 | TH   |
|              | Apply Coating (Bolt)                                           |            |         |      |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |            | 7/23/91 | RW   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |            | 7/23/91 | RW   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |            | 7/23/91 | RW   |
|              | D) Oil Firing Pin Ass'y                                        |            | 7/23/91 | RW   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |            | 8-5-91  | DH   |

| op. #        | OP. NAME                                                    | READINGS |       |       |     |     | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|-------|-------|-----|-----|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 5        | 5     | 5     |     |     | 8-6-91  | DH   |
|              | G) Safety Off Force                                         | 2 1/2    | 2 1/4 | 2     |     |     | 8-6-91  | DH   |
|              | H) Trigger Pull Test & Retainability                        |          |       |       |     |     | 8-5-91  | DH   |
|              | I) Firing Pin Indent                                        | 1.020    | 1.020 | 1.020 |     |     | 8-6-91  | DH   |
|              | J) Assemble Stock                                           |          |       |       |     |     | 8/7/91  | Rev  |
|              | K) Assemble Swivel Studs                                    |          |       |       |     |     | 8-8-91  | DH   |
|              | L) Attach Front and Rear Sight Assemblies                   |          |       |       |     |     | 8/7/91  | Rev  |
|              | M) Iron Sight Alignment                                     |          |       |       |     |     | 8/7/91  | Rev  |
|              | N) Detach Front & Rear Sights & place in numbered container |          |       |       |     |     | 8/7/91  | Rev  |
|              | O) Attach Scope to Rifle                                    |          |       |       |     |     | 8/7/91  | Rev  |
|              | P) Detach & Attach Scope 20 Times                           |          |       |       |     |     | 8/7/91  | Rev  |
| 640          | Gallery Target & Test                                       |          |       |       |     |     | 8-7-91  | NE   |
|              | A) Time                                                     |          |       |       |     |     | "       | NE   |
|              | B) Malfunctions                                             |          |       |       |     |     | "       | NE   |
|              | C) Pierced Primers                                          |          |       |       |     |     | "       | NE   |
|              | D) Optical Clarity of Scope                                 |          |       |       |     |     | "       | NE   |
| 645          | Inspect for Live Ammo                                       |          |       |       |     |     | 8-7-91  | NE   |
| 655          | Final Inspection                                            |          |       |       |     |     |         |      |
|              | A) Headspace                                                |          |       |       |     |     | 8-8-91  | DH   |
|              | B) Trigger Pull                                             | 265      | 260   | 263   | 268 | 269 | 8-8-91  | GR   |
|              | C) Function                                                 |          |       |       |     |     | 8-8-91  | DH   |
| 660          | Pack                                                        |          |       |       |     |     | 9-19-91 | NE   |

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

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

SERIAL NO. C66 49287

DATE 8-5-91

TESTER DH

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.46             | 2.57                     | 2.56                           | 2.65 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.36             | 2.49                     | 2.55                           | 2.60 |                                                                        |
| PULL #3 | 2.58             | 2.62                     | 2.70                           | 2.63 |                                                                        |
| PULL #4 | 2.57             | 2.56                     | 2.69                           | 2.68 |                                                                        |
| PULL #5 | 2.37             | 2.48                     | 2.72                           | 2.69 |                                                                        |
| TOTAL   |                  |                          |                                |      |                                                                        |
| AVG.    |                  |                          |                                |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.52             | 3.40                     |  |          |
| PULL #2 | 3.41             | 3.40                     |  |          |
| PULL #3 | 3.46             | 3.06                     |  |          |
| PULL #4 | 3.33             | 3.57                     |  |          |
| PULL #5 | 3.54             | 3.56                     |  |          |
| 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 | 4.64             | 4.39                     |                                | 4.36                                 |
| PULL #2 | 3.94             | 4.55                     |                                | 4.22                                 |
| PULL #3 | 4.49             | 4.40                     |                                | 4.27                                 |
| PULL #4 | 4.00             | 4.48                     |                                | 4.25                                 |
| PULL #5 | 3.99             | 4.33                     |                                | 4.31                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6649287  
7 Aug 1991

CENTROIDAL DISTANCES

|        |         |
|--------|---------|
| 0 TO 1 | .174108 |
| 1 TO 2 | .288669 |
| 1 TO 3 | .32039  |
| 1 TO 4 | .252343 |
| 1 TO 5 | .287272 |

←----POA

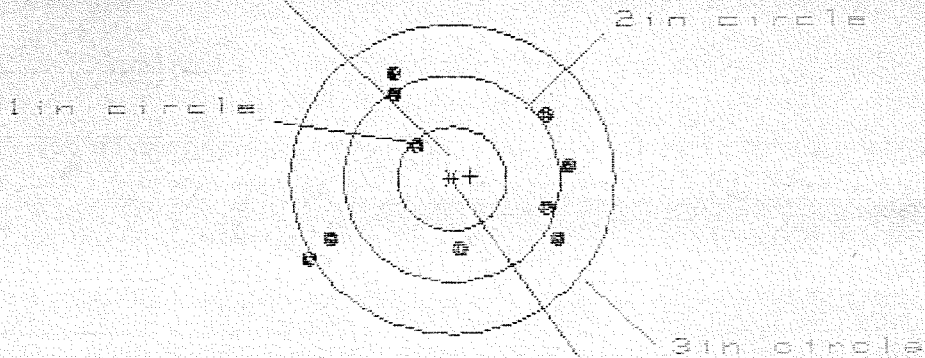
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .042  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0166  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0451615  
THE AMR FOR THIS RIFLE IS: .9334

7 Aug 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6B452B7

# CENTERFIRE PATTERNS # 1

POA



# OF SHOTS= 10

# IN CIR

1 in = 1

2 in = 4

3 in = 9

HS= 2.380

VS= 1.816

GS= 2.588

CENTROID #

| PATTERN #                     | 1      | 2      | 3     |
|-------------------------------|--------|--------|-------|
| SHOTS (BEST OF)               | 10     | 9      | 8     |
| MAXIMUM X                     | 1.025  | .875   | .721  |
| MINIMUM X                     | -1.355 | -1.232 | -.839 |
| MAXIMUM Y                     | 1.024  | .937   | .852  |
| MINIMUM Y                     | -.791  | -.756  | -.841 |
| CENTROID X                    | -.172  | -.022  | .132  |
| CENTROID Y                    | -.027  | .060   | .145  |
| POA TO CENTROID in.           | .175   | .064   | .196  |
| MIN RADIUS                    | .450   | .508   | .616  |
| MEAN RADIUS                   | 1.008  | .927   | .848  |
| MAX RADIUS                    | 1.569  | 1.407  | 1.196 |
| HORIZONTAL SPREAD             | 2.380  | 2.107  | 1.560 |
| VERTICAL SPREAD               | 1.816  | 1.693  | 1.693 |
| EXTREME SPREAD                | 2.588  | 2.250  | 2.168 |
| NUMBER IN ONE INCH CIRCLE =   | 1      |        |       |
| NUMBER IN TWO INCH CIRCLE =   | 4      |        |       |
| NUMBER IN THREE INCH CIRCLE = | 9      |        |       |

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FILE:/PATTERNING/CENTERFIRE\_PATT/066492B7

# CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

# OF SHOTS - 10

# IN CIR

1in = 2

2in = 7

3in = 9

HS= 1.383

VS= 2.985

GS= 2.988

CENTROID #

| PATTERN #                   | : | 2      |       |       |
|-----------------------------|---|--------|-------|-------|
| SHOTS (BEST OF)             | : | 10     | 9     | 8     |
| MAXIMUM X                   | : | .842   | .818  | .512  |
| MINIMUM X                   | : | -.541  | -.565 | -.463 |
| MAXIMUM Y                   | : | 1.134  | .928  | 1.019 |
| MINIMUM Y                   | : | -1.851 | -.871 | -.788 |
| CENTROID X                  | : | .091   | .115  | .013  |
| CENTROID Y                  | : | .092   | .298  | .207  |
| POA TO CENTROID in.         | : | .130   | .319  | .207  |
| MIN RADIUS                  | : | .318   | .111  | .225  |
| MEAN RADIUS                 | : | .822   | .662  | .618  |
| MAX RADIUS                  | : | 1.863  | 1.095 | 1.019 |
| HORIZONTAL SPREAD           | : | 1.383  | 1.383 | .975  |
| VERTICAL SPREAD             | : | 2.985  | 1.799 | 1.799 |
| EXTREME SPREAD              | : | 2.988  | 2.070 | 1.803 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2     |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 7     |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 9     |       |



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FILE:/PATTERNING/CENTERFIRE\_PATT/060492B7

# CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

# OF SHOTS- 10

# IN CIR

1 in - 4

2 in - 4

3 in - 7

HS= 2.932

VS= 2.977

GS= 3.301

CENTROID \*

| PATTERN #                     | 1      | 3      | 9      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 9      |
| MAXIMUM X                     | 1.478  | 1.316  | .945   |
| MINIMUM X                     | -1.454 | -1.286 | -1.121 |
| MAXIMUM Y                     | 1.513  | 1.351  | 1.250  |
| MINIMUM Y                     | -1.464 | -1.018 | -1.119 |
| CENTROID X                    | .139   | .301   | .136   |
| CENTROID Y                    | -.104  | .058   | .159   |
| POA TO CENTROID in.           | .174   | .306   | .209   |
| MIN RADIUS                    | .241   | .229   | .090   |
| MEAN RADIUS                   | 1.001  | .879   | .729   |
| MAX RADIUS                    | 2.063  | 1.543  | 1.415  |
| HORIZONTAL SPREAD             | 2.932  | 2.602  | 2.066  |
| VERTICAL SPREAD               | 2.977  | 2.369  | 2.369  |
| EXTREME SPREAD                | 3.301  | 2.662  | 2.551  |
| NUMBER IN ONE INCH CIRCLE =   |        | 4      |        |
| NUMBER IN TWO INCH CIRCLE =   |        | 4      |        |
| NUMBER IN THREE INCH CIRCLE = |        | 7      |        |

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FILE:/PATTERNING/CENTERFIRE\_PATT/C85492B7

# CENTERFIRE PATTERNS

# 4

POA

1in circle

2in circle

3in circle

# OF SHOTS= 10

# IN CIR

1in = 2

2in = 6

3in = 8

HS= 3.161

VS= 1.872

CS= 3.495

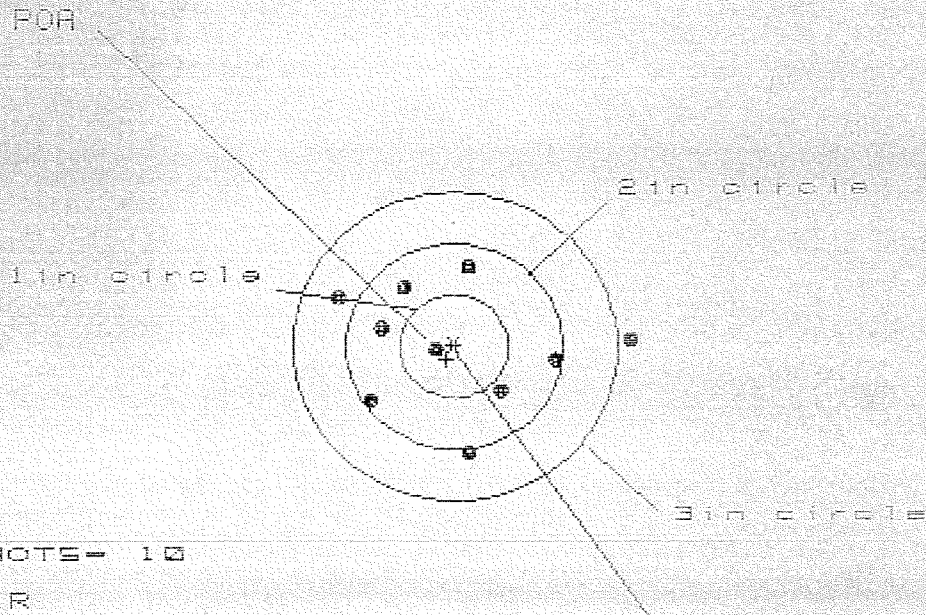
CENTROID #

| PATTERN #                   | : | 4      |        |       |
|-----------------------------|---|--------|--------|-------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | 1.758  | .993   | .842  |
| MINIMUM X                   | : | -1.403 | -1.208 | -.836 |
| MAXIMUM Y                   | : | .935   | .996   | .887  |
| MINIMUM Y                   | : | -.937  | -.876  | -.963 |
| CENTROID X                  | : | .879   | -.117  | .034  |
| CENTROID Y                  | : | -.001  | -.062  | .047  |
| POA TO CENTROID in.         | : | .879   | .132   | .058  |
| MIN RADIUS                  | : | .325   | .134   | .317  |
| MEAN RADIUS                 | : | .962   | .842   | .760  |
| MAX RADIUS                  | : | 1.843  | 1.492  | 1.163 |
| HORIZONTAL SPREAD           | : | 3.161  | 2.201  | 1.678 |
| VERTICAL SPREAD             | : | 1.872  | 1.872  | 1.850 |
| EXTREME SPREAD              | : | 3.495  | 2.822  | 2.012 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 6      |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 8      |       |

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FILE:/PATTERNING/CENTERFIRE\_PATT/C6649257

# CENTERFIRE PATTERNS # 5



# OF SHOTS = 10

# IN CIR

1in = 1

2in = 7

3in = 9

HS = 2.727

VS = 1.805

GS = 2.751

CENTROID #

|                             |   |        |        |        |
|-----------------------------|---|--------|--------|--------|
| PATTERN #                   | : | 5      |        |        |
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.666  | 1.109  | 1.000  |
| MINIMUM X                   | : | -1.061 | -1.876 | -1.710 |
| MAXIMUM Y                   | : | .753   | .762   | .818   |
| MINIMUM Y                   | : | -1.052 | -1.043 | -1.987 |
| CENTROID X                  | : | .073   | -.112  | -.003  |
| CENTROID Y                  | : | .123   | .114   | .058   |
| POA TO CENTROID in.         | : | .143   | .160   | .058   |
| MIN RADIUS                  | : | .166   | .052   | .083   |
| MEAN RADIUS                 | : | .874   | .753   | .727   |
| MAX RADIUS                  | : | 1.668  | 1.112  | 1.001  |
| HORIZONTAL SPREAD           | : | 2.727  | 1.985  | 1.710  |
| VERTICAL SPREAD             | : | 1.805  | 1.805  | 1.805  |
| EXTREME SPREAD              | : | 2.751  | 2.054  | 1.805  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 1      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 7      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |        |