

C6611576

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

\*Includes 1 in chamber.

*Remington*

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

**MODEL 700™ M24**

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.**  
 C6611576

**ORDER NO.**  
 5716

**46**



5716 C6611576

UPC



0 47700 25716 7

| MOD.      |      | GA.<br>CAL.               | GUN<br># | ASSEM.<br>#   |
|-----------|------|---------------------------|----------|---------------|
| #<br>TEST | DATE | MALFUNCTION/DEFECT        |          |               |
|           | 1st  |                           |          |               |
| 4-591     |      | bolt handle hits<br>stock |          | K5            |
|           | 2nd  |                           |          |               |
|           |      | Repaired                  |          | A             |
|           | 3rd  |                           |          |               |
|           | 4th  |                           |          |               |
|           |      | FUNCTION                  |          | RD 6654 Rev 1 |

| TEST INIT. ACTION TO CORRECT |          | ASSEM.<br># |
|------------------------------|----------|-------------|
| PROOF                        |          |             |
| TEST                         |          |             |
| TGT                          |          |             |
| PROOF                        |          |             |
| TEST                         |          |             |
| TGT                          |          |             |
| PROOF                        | ENGINEER |             |
| TEST                         |          |             |
| TGT                          |          |             |
| PROOF                        | ENGINEER |             |
| TEST                         |          |             |
| TGT                          |          |             |

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6611576

| OP. #        | OP. NAME                                                       | READINGS | DATE    | INIT |
|--------------|----------------------------------------------------------------|----------|---------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   |          | 3/26/91 | K.S. |
| 600          | Proof                                                          |          | 3/26/91 | K.S. |
| 607          | Check Headspace                                                |          | 3/26/91 | K.S. |
| 610          | Dis-assemble Gun                                               |          | 3/26/91 | K.S. |
| 612          | Magnaflux Barrel<br>Action                                     | APR      | 2 1991  | KR   |
|              | Magnaflux Bolt                                                 | APR      | 2 1991  | "    |
| 615          | Rollmark Caliber                                               | APR      | 2 1991  | JS   |
| 617          | Drill and Tap Sight Holes                                      | APR      | 5 1991  | FB   |
| 618          | Polish Barrel                                                  | APR      | 5 1991  | WB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 4-10-91 | JS   |
|              | Apply Coating (Bolt)                                           |          |         | JS   |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 4/10/91 | KS   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 4/10/91 | KS   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 4/10/91 | KS   |
|              | D) Oil Firing Pin Ass'y                                        |          | 4/10/91 | KS   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 4/11/91 | JS   |

| op. #        | OP. NAME                                                    | READINGS |       |       |      |      | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|-------|-------|------|------|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 6        | 6     | 6     |      |      | 4/12/91 | WLB  |
|              | G) Safety Off Force                                         | 4        | 3 3/4 | 4     |      |      | 4/12/91 | WLB  |
|              | H) Trigger Pull Test & Retainability                        |          |       |       |      |      | 4/11/91 | SP   |
|              | I) Firing Pin Indent                                        | .0225    | .0225 | .0225 |      |      | 4/12/91 | WLB  |
|              | J) Assemble Stock                                           |          |       |       |      |      | 4/12/91 | KS   |
|              | K) Assemble Swivel Studs                                    |          |       |       |      |      | 4-17-91 | A    |
|              | L) Attach Front and Rear Sight Assemblies                   |          |       |       |      |      | 4/12/91 | KS   |
|              | M) Iron Sight Alignment                                     |          |       |       |      |      | 4/12/91 | KS   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |       |       |      |      | 4/12/91 | KS   |
|              | O) Attach Scope to Rifle                                    |          |       |       |      |      | 4/12/91 | KS   |
|              | P) Detach & Attach Scope 20 Times                           |          |       |       |      |      | 4/12/91 | KS   |
| 640          | Gallery Target & Test                                       |          |       |       |      |      | 4-15-91 | DH   |
|              | A) Time                                                     |          |       |       |      |      | 4-15-91 | DH   |
|              | B) Malfunctions                                             |          |       |       |      |      | 4-15-91 | DH   |
|              | C) Pierced Primers                                          |          |       |       |      |      | 4-15-91 | DH   |
|              | D) Optical Clarity of Scope                                 |          |       |       |      |      | 4-15-91 | DH   |
| 645          | Inspect for Live Ammo                                       |          |       |       |      |      | 4-15-91 | DH   |
| 655          | Final Inspection                                            |          |       |       |      |      | 4-17-91 | A    |
|              | A) Headspace                                                |          |       |       |      |      |         |      |
|              | B) Trigger Pull                                             | 2.48     | 2.56  | 2.47  | 2.47 | 2.48 | 2/16/91 | SP   |
|              | C) Function                                                 |          |       |       |      |      | 4-17-91 | A    |
| 660          | Pack                                                        |          |       |       |      |      | 6-18-91 | N    |

## SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS  
2.50# ± .50#  
3.00# ± .75#  
4.00# ± 1.00#

SERIAL NO. C6611576DATE 4/11/91TESTER J.P.

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.25             | 2.46                     | 2.40                           | 2.48 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.39             | 2.45                     | 2.46                           | 2.56 |                                                                        |
| PULL #3 | 2.29             | 2.47                     | 2.48                           | 2.47 |                                                                        |
| PULL #4 | 2.38             | 2.42                     | 2.40                           | 2.47 |                                                                        |
| PULL #5 | 2.43             | 2.45                     | 2.41                           | 2.48 |                                                                        |
| TOTAL   |                  |                          |                                |      |                                                                        |
| AVG.    |                  |                          |                                |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.51             | 3.45                     |  |          |
| PULL #2 | 3.50             | 3.55                     |  |          |
| PULL #3 | 3.45             | 3.55                     |  |          |
| PULL #4 | 3.35             | 3.49                     |  |          |
| PULL #5 | 3.52             | 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 | 4.34             | 4.31                     |                                | 4.25                                 |
| PULL #2 | 4.33             | 4.27                     |                                | 4.22                                 |
| PULL #3 | 4.32             | 4.27                     |                                | 4.25                                 |
| PULL #4 | 4.28             | 4.25                     |                                | 4.25                                 |
| PULL #5 | 4.25             | 4.20                     |                                | 4.28                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6611576  
15 Apr 1991

CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| Ø TO | 1 | .211559 |
| 1 TO | 2 | .192606 |
| 1 TO | 3 | .446878 |
| 1 TO | 4 | .407404 |
| 1 TO | 5 | .328952 |

34<sup>5</sup> <----POA

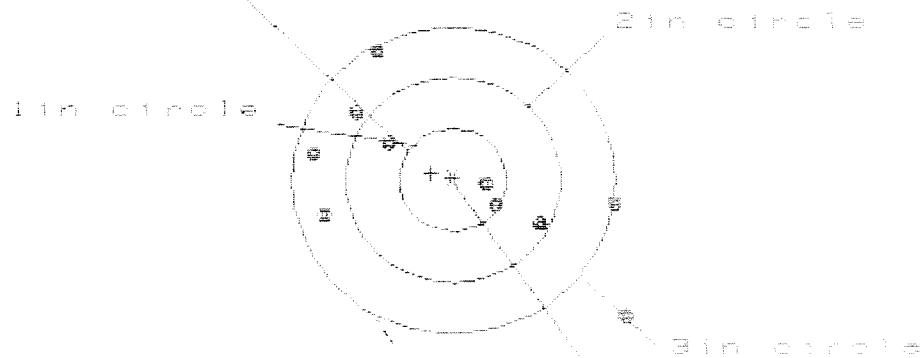
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0012  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0868  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0069083  
THE AMR FOR THIS RIFLE IS: .8656

15 Apr 1981

FILE:/PATTERNING/CENTERFIRE\_PATT/DEB11576

# CENTERFIRE PATTERNS # 1

FOR



# OF SHOTS = 10

# IN CIR

1in = 2

2in = 4

3in = 8

IS = 2.816

VS = 2.590

GS = 3.485

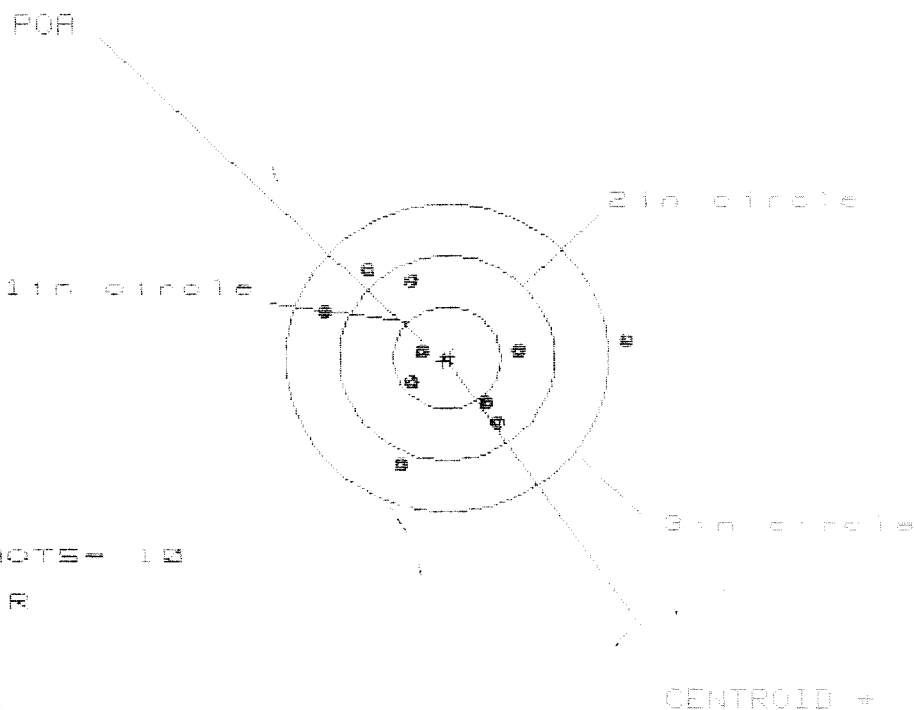
CENTROID =

| PATTERN #                   |        |        |        |
|-----------------------------|--------|--------|--------|
| SHOTS (BEST OF)             | 10     | 9      | 8      |
| MAXIMUM X                   | 1.560  | 1.668  | 1.139  |
| MINIMUM X                   | -1.256 | -1.082 | -0.874 |
| MAXIMUM Y                   | 1.270  | 1.124  | 1.079  |
| MINIMUM Y                   | -1.320 | -0.549 | -0.594 |
| CENTROID X                  | .201   | .027   | -.181  |
| CENTROID Y                  | -.066  | .080   | .125   |
| FOR TO CENTROID in.         | .211   | .085   | .220   |
| MIN RADIUS                  | .319   | .461   | .269   |
| MEAN RADIUS                 | 1.104  | .987   | .867   |
| MAX RADIUS                  | 2.043  | 1.705  | 1.329  |
| HORIZONTAL SPREAD           | 2.816  | 2.750  | 2.063  |
| VERTICAL SPREAD             | 2.590  | 1.673  | 1.679  |
| EXTREME SPREAD              | 3.485  | 2.739  | 2.219  |
| NUMBER IN ONE INCH CIRCLE   | =      | 2      |        |
| NUMBER IN TWO INCH CIRCLE   | =      | 4      |        |
| NUMBER IN THREE INCH CIRCLE | =      | 8      |        |

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# CENTERFIRE PATTERNS # 2



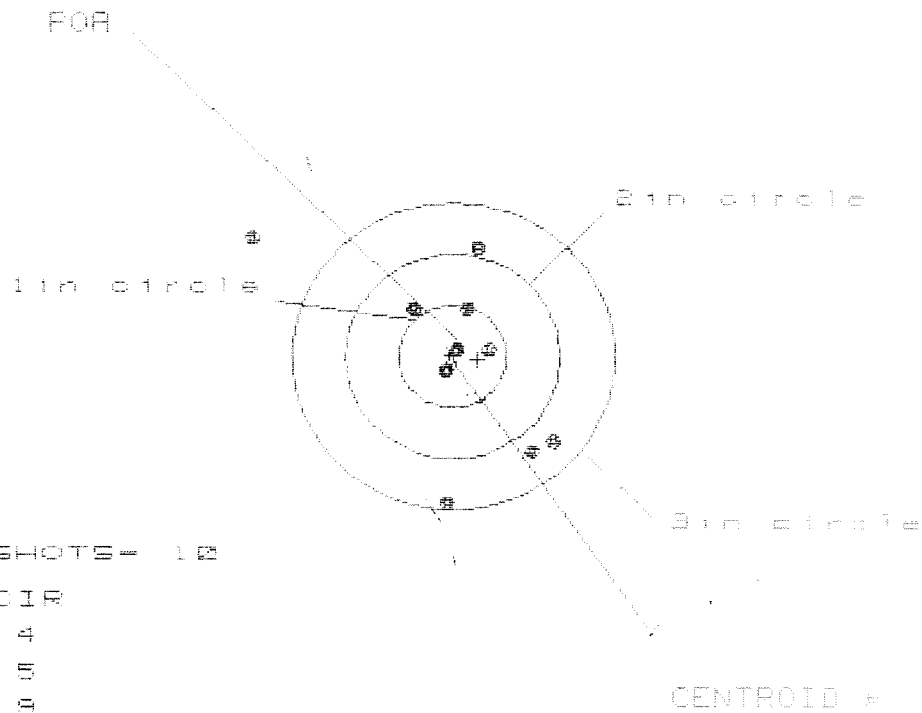
# OF SHOTS = 10  
 # IN CIR  
 1in = 2  
 2in = 6  
 3in = 8  
 AE = 2.771  
 VS = 1.915  
 GS = 2.787

| PATTERN #                   | 1      | 2      | 3     |
|-----------------------------|--------|--------|-------|
| SHOTS (BEST OF)             | 10     | 9      | 8     |
| MAXIMUM X                   | 1.674  | .889   | .775  |
| MINIMUM X                   | -1.897 | -.911  | -.712 |
| MAXIMUM Y                   | .852   | .869   | .928  |
| MINIMUM Y                   | -1.063 | -1.046 | -.987 |
| CENTROID X                  | .837   | -.149  | -.035 |
| CENTROID Y                  | .035   | .018   | -.041 |
| POA TO CENTROID in.         | .051   | .150   | .054  |
| MIN RADIUS                  | .219   | .048   | .174  |
| MEAN RADIUS                 | .863   | .742   | .795  |
| MAX RADIUS                  | 1.681  | 1.082  | 1.170 |
| HORIZONTAL SPREAD           | 2.771  | 1.300  | 1.487 |
| VERTICAL SPREAD             | 1.915  | 1.915  | 1.915 |
| EXTREME SPREAD              | 2.787  | 1.942  | 1.942 |
| 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



# OF SHOTS= 12

# IN CIR

1 in = 4

2 in = 5

3 in = 6

HS= 2.787

VS= 2.596

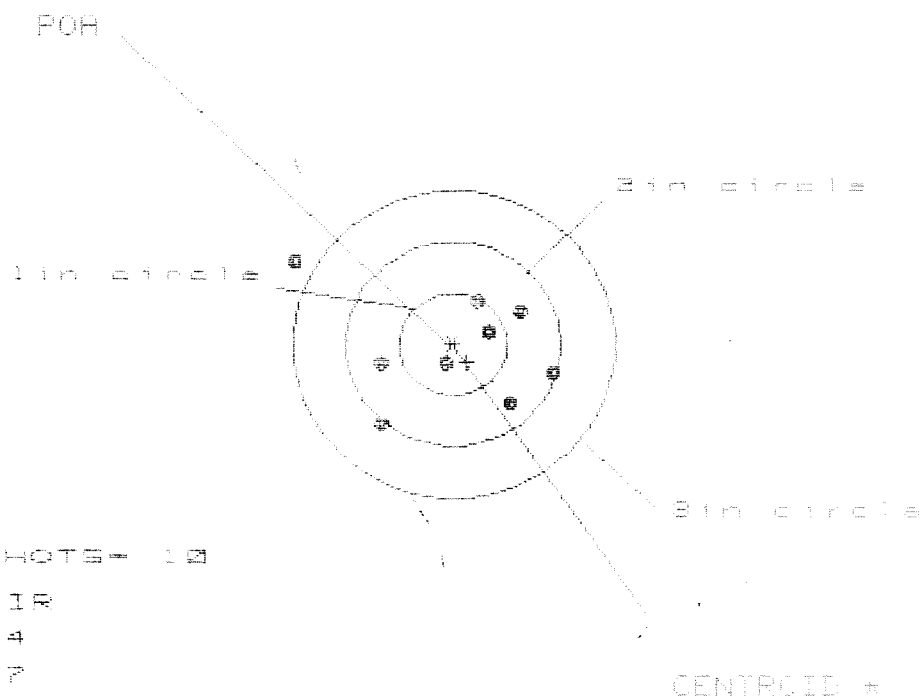
GS= 3.399

|                             |   |        |        |       |
|-----------------------------|---|--------|--------|-------|
| PATTERN #                   | : | 3      |        |       |
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | .903   | .700   | .862  |
| MINIMUM X                   | : | -1.824 | -.583  | -.611 |
| MAXIMUM Y                   | : | 1.189  | 1.216  | 1.056 |
| MINIMUM Y                   | : | -1.407 | -1.275 | -.997 |
| CENTROID X                  | : | -.235  | -.032  | .006  |
| CENTROID Y                  | : | .032   | -.100  | .060  |
| FOR TO CENTROID in.         | : | .237   | .105   | .060  |
| MIN RADIUS                  | : | .060   | .231   | .119  |
| MEAN RADIUS                 | : | .887   | .753   | .652  |
| MAX RADIUS                  | : | 2.178  | 1.310  | 1.123 |
| HORIZONTAL SPREAD           | : | 2.727  | 1.283  | 1.283 |
| VERTICAL SPREAD             | : | 2.596  | 2.491  | 2.053 |
| EXTREME SPREAD              | : | 3.399  | 2.512  | 2.121 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 4      |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 5      |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |       |

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# CENTERFIRE PATTERNS # 4



# OF SHOTS= 10

# IN CIR

1 in = 4

2 in = 7

3 in = 9

HS= 2.454

VS= 1.635

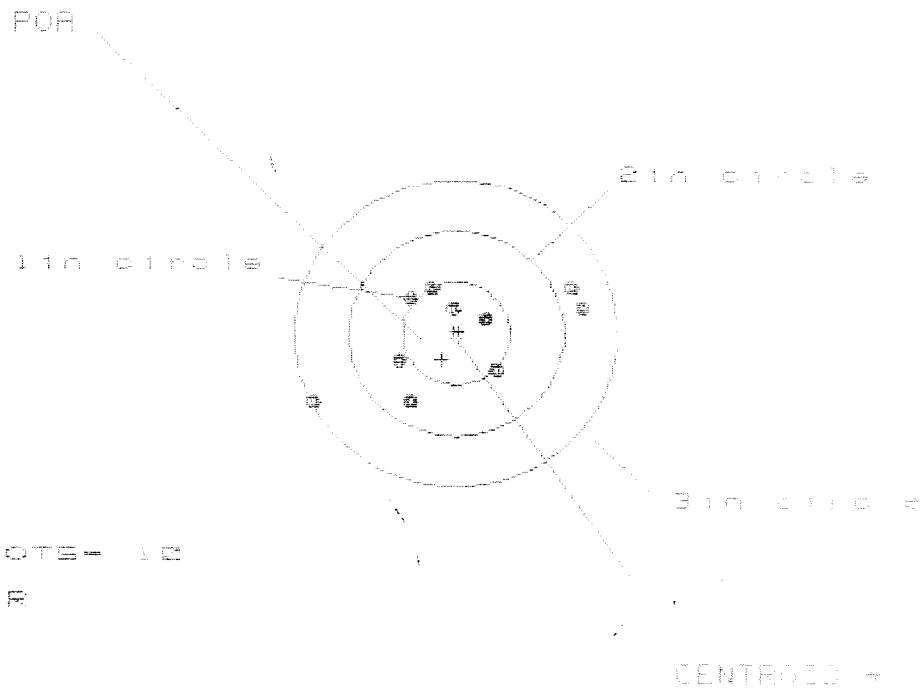
GS= 2.720

|                             |   |        |       |       |
|-----------------------------|---|--------|-------|-------|
| PATTERN #                   | : | 4      |       |       |
| SHOTS (BEST OF)             | : | 10     | 9     | 8     |
| MAXIMUM X                   | : | .955   | .788  | .688  |
| MINIMUM X                   | : | -1.499 | -.389 | -.991 |
| MAXIMUM Y                   | : | .852   | .554  | .468  |
| MINIMUM Y                   | : | -.782  | -.688 | -.540 |
| CENTROID X                  | : | -.126  | .041  | .143  |
| CENTROID Y                  | : | .177   | .082  | .168  |
| POR TO CENTROID in.         | : | .217   | .091  | .221  |
| MIN RADIUS                  | : | .164   | .255  | .184  |
| MEAN RADIUS                 | : | .740   | .604  | .511  |
| MAX RADIUS                  | : | 1.724  | 1.073 | 1.012 |
| HORIZONTAL SPREAD           | : | 2.454  | 1.677 | 1.677 |
| VERTICAL SPREAD             | : | 1.635  | 1.242 | 1.000 |
| EXTREME SPREAD              | : | 2.720  | 1.700 | 1.580 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 4     |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 7     |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 9     |       |

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# CENTERFIRE PATTERNS # 5



# OF SHOTS- 10  
 # IN CIR  
 1in = 2  
 2in = 7  
 3in = 10  
 HS= 2.503  
 VS= 1.103  
 GS= 2.662

| PATTERN #                     | 5      | 5      | 5      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 9      |
| MAXIMUM X                     | 1.188  | 1.041  | 1.101  |
| MINIMUM X                     | -1.315 | -1.689 | -1.598 |
| MAXIMUM Y                     | .484   | .415   | .436   |
| MINIMUM Y                     | -.619  | -.683  | -.662  |
| CENTROID X                    | .129   | .276   | .145   |
| CENTROID Y                    | .256   | .325   | .304   |
| POR TO CENTROID in.           | .287   | .426   | .397   |
| MIN RADIUS                    | .208   | .100   | .161   |
| MEAN RADIUS                   | .734   | .642   | .578   |
| MAX RADIUS                    | 1.454  | 1.055  | 1.176  |
| HORIZONTAL SPREAD             | 2.503  | 1.736  | 1.659  |
| VERTICAL SPREAD               | 1.103  | 1.098  | 1.099  |
| EXTREME SPREAD                | 2.662  | 1.872  | 1.872  |
| NUMBER IN ONE INCH CIRCLE =   | 2      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 7      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 10     |        |        |