

C6611619

MODEL 700™ M24

Model SWS™

Action \_\_\_\_\_

Barrel Length \_\_\_\_\_

Capacity \_\_\_\_\_

Order No. 5715

\*Includes 1 in chamber.



**Remington**

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

**MODEL 700™ M24****SERIAL NO.**

C6611619

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

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

46



5716 C6611619

**UPC**

0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6611619

| 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 | 11   |
| 615          | Rollmark Caliber                                               |          | APR 2 1991 | GL   |
| 617          | Drill and Tap Sight Holes                                      |          | APR 5 1991 | LB   |
| 618          | Polish Barrel                                                  |          | APR 5 1991 | WB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 4-10-91    | TS   |
|              | Apply Coating (Bolt)                                           |          |            |      |
| 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                                          | 4        | 4    | 4    |      |      | 4/11/91 | SL   |
|              | G) Safety Off Force                                         | 2        | 2    | 2    |      |      | 4/11/91 | SL   |
|              | H) Trigger Pull Test & Retainability                        |          |      |      |      |      | 4/11/91 | SL   |
|              | I) Firing Pin Indent                                        | .022     | .022 | .022 |      |      | 4/11/91 | SL   |
|              | J) Assemble Stock                                           |          |      |      |      |      | 4/24/91 | KS   |
|              | K) Assemble Swivel Studs                                    |          |      |      |      |      | 5-1-91  | DH   |
|              | L) Attach Front and Rear Sight Assemblies                   |          |      |      |      |      | 4/24/91 | KS   |
|              | M) Iron Sight Alignment                                     |          |      |      |      |      | 4/24/91 | KS   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |      |      |      |      | 4/24/91 | KS   |
|              | O) Attach Scope to Rifle                                    |          |      |      |      |      | 4/24/91 | KS   |
|              | P) Detach & Attach Scope 20 Times                           |          |      |      |      |      | 4/24/91 | KS   |
| 640          | Gallery Target & Test                                       |          |      |      |      |      | 4/25/91 | KT   |
|              | A) Time                                                     |          |      |      |      |      |         | KT   |
|              | B) Malfunctions                                             |          |      |      |      |      |         | KT   |
|              | C) Pierced Primers                                          |          |      |      |      |      |         | KT   |
|              | D) Optical Clarity of Scope                                 |          |      |      |      |      |         | KT   |
| 645          | Inspect for Live Ammo                                       |          |      |      |      |      | 4/25/91 | KT   |
| 655          | Final Inspection                                            |          |      |      |      |      |         |      |
|              | A) Headspace                                                |          |      |      |      |      | 5-1-91  | DH   |
|              | B) Trigger Pull                                             | 2.55     | 2.53 | 2.54 | 2.60 | 2.60 | 4/26/91 | SL   |
|              | C) Function                                                 |          |      |      |      |      | 5-1-91  | DH   |
| 660          | Pack                                                        |          |      |      |      |      | 6-17-91 | VF   |

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO C-6611619DATE 4/11/91TESTER JM

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.26             | 2.37                     | 2.38                           | 2.55 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.24             | 2.32                     | 2.35                           | 2.53 |                                                                        |
| PULL #3 | 2.19             | 2.32                     | 2.31                           | 2.54 |                                                                        |
| PULL #4 | 2.19             | 2.31                     | 2.35                           | 2.60 |                                                                        |
| PULL #5 | 2.18             | 2.34                     | 2.36                           | 2.60 |                                                                        |
| TOTAL   |                  |                          |                                |      |                                                                        |
| AVG.    |                  |                          |                                |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.24             | 3.53                     |  |          |
| PULL #2 | 3.19             | 3.42                     |  |          |
| PULL #3 | 3.43             | 3.50                     |  |          |
| PULL #4 | 3.46             | 3.48                     |  |          |
| PULL #5 | 3.46             | 3.42                     |  |          |
| 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 | 4.23             | 4.26                     |                                | 4.40                                 |
| PULL #2 | 4.26             | 4.37                     |                                | 4.36                                 |
| PULL #3 | 4.35             | 4.48                     |                                | 4.19                                 |
| PULL #4 | 4.33             | 4.37                     |                                | 4.40                                 |
| PULL #5 | 4.41             | 4.45                     |                                | 4.38                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6611619  
25 Apr 1991

CENTROIDAL DISTANCES

|        |         |
|--------|---------|
| 0 TO 1 | .318423 |
| 1 TO 2 | .477504 |
| 1 TO 3 | .240853 |
| 1 TO 4 | .304311 |
| 1 TO 5 | .119097 |

POI <----POI

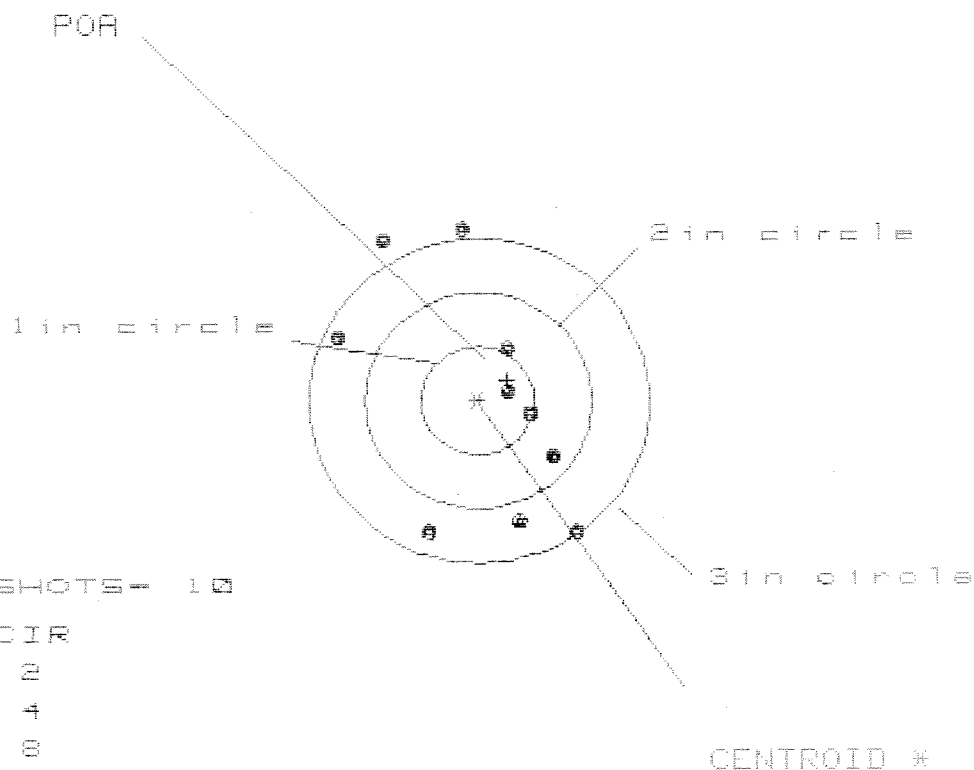
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0484  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0988  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .110618

THE AMR FOR THIS RIFLE IS: .8282

25 Apr 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C8B11619

# CENTERFIRE PATTERNS # 1



# OF SHOTS- 10

# IN CIR

1in = 2

2in = 4

3in = 8

HS= 2.127

VS= 2.787

GS= 3.137

CENTROID \*

|                             |   |        |        |        |
|-----------------------------|---|--------|--------|--------|
| PATTERN #                   | : | 1      |        |        |
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | .843   | .746   | .715   |
| MINIMUM X                   | : | -1.284 | -1.381 | -1.412 |
| MAXIMUM Y                   | : | 1.571  | 1.731  | .955   |
| MINIMUM Y                   | : | -1.216 | -1.056 | -.840  |
| CENTROID X                  | : | -.257  | -.160  | -.129  |
| CENTROID Y                  | : | -.188  | -.348  | -.564  |
| POA TO CENTROID in.         | : | .318   | .383   | .579   |
| MIN RADIUS                  | : | .258   | .269   | .432   |
| MEAN RADIUS                 | : | 1.071  | .971   | .860   |
| MAX RADIUS                  | : | 1.685  | 1.748  | 1.704  |
| HORIZONTAL SPREAD           | : | 2.127  | 2.127  | 2.127  |
| VERTICAL SPREAD             | : | 2.787  | 2.787  | 1.795  |
| EXTREME SPREAD              | : | 3.137  | 2.929  | 2.763  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 4      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 8      |        |

25 Apr 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6811619

# CENTERFIRE PATTERNS

# 2

POA

1in circle

2in circle

3in circle

CENTROID \*

# OF SHOTS- 10

# IN CIR

1in = 2

2in = 7

3in = 10

HS= 1.585

VS= 2.297

GS= 2.539

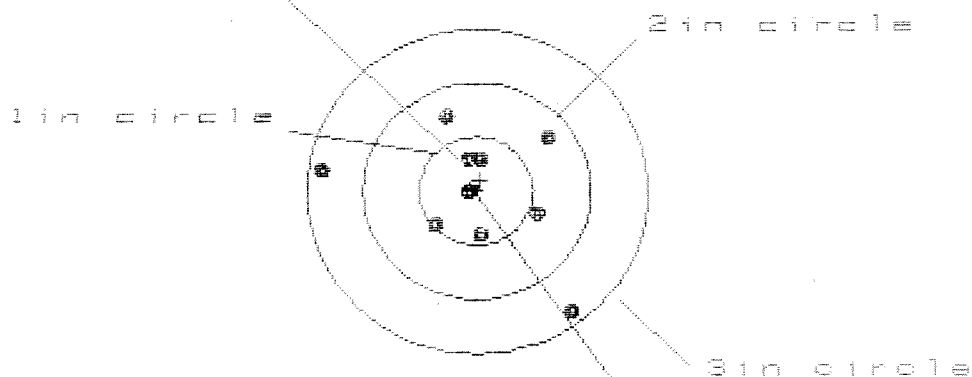
| PATTERN #                   | : | 2      |        |       |
|-----------------------------|---|--------|--------|-------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | .835   | .788   | .784  |
| MINIMUM X                   | : | -.750  | -.658  | -.663 |
| MAXIMUM Y                   | : | .925   | .793   | .605  |
| MINIMUM Y                   | : | -1.372 | -1.504 | -.860 |
| CENTROID X                  | : | .196   | .104   | .108  |
| CENTROID Y                  | : | -.037  | .095   | .283  |
| POA TO CENTROID in.         | : | .200   | .141   | .303  |
| MIN RADIUS                  | : | .241   | .143   | .169  |
| MEAN RADIUS                 | : | .872   | .767   | .638  |
| MAX RADIUS                  | : | 1.449  | 1.504  | 1.085 |
| HORIZONTAL SPREAD           | : | 1.585  | 1.446  | 1.446 |
| VERTICAL SPREAD             | : | 2.297  | 2.297  | 1.465 |
| EXTREME SPREAD              | : | 2.539  | 2.307  | 1.863 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 7      |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 10     |       |

25 Apr 1991

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# CENTERFIRE PATTERNS # 3

POA



# OF SHOTS= 10

# IN CIR

1in = 5

2in = 8

3in = 10

HS= 2.194

VS= 1.778

GS= 2.562

CENTROID #

| PATTERN #                     | 3      | 9      | 8     |
|-------------------------------|--------|--------|-------|
| SHOTS (BEST OF)               | 10     | 9      | 8     |
| MAXIMUM X                     | .840   | .690   | .536  |
| MINIMUM X                     | -1.354 | -.509  | -.423 |
| MAXIMUM Y                     | .696   | .722   | .590  |
| MINIMUM Y                     | -1.083 | -1.056 | -.527 |
| CENTROID X                    | -.034  | .116   | .030  |
| CENTROID Y                    | -.097  | -.123  | .009  |
| POA TO CENTROID in.           | .102   | .169   | .031  |
| MIN RADIUS                    | .061   | .209   | .174  |
| MEAN RADIUS                   | .645   | .576   | .457  |
| MAX RADIUS                    | 1.375  | 1.261  | .665  |
| HORIZONTAL SPREAD             | 2.194  | 1.199  | .959  |
| VERTICAL SPREAD               | 1.778  | 1.778  | 1.117 |
| EXTREME SPREAD                | 2.562  | 2.082  | 1.264 |
| NUMBER IN ONE INCH CIRCLE =   | 5      |        |       |
| NUMBER IN TWO INCH CIRCLE =   | 8      |        |       |
| NUMBER IN THREE INCH CIRCLE = | 10     |        |       |

25 Apr 1991

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# CENTERFIRE PATTERNS

# 4

POA

1in circle

2in circle

3in circle

CENTROID #

# OF SHOTS= 10

# IN CIR

1in = 2

2in = 8

3in = 9

HS= 2.200

VS= 2.115

GS= 2.347

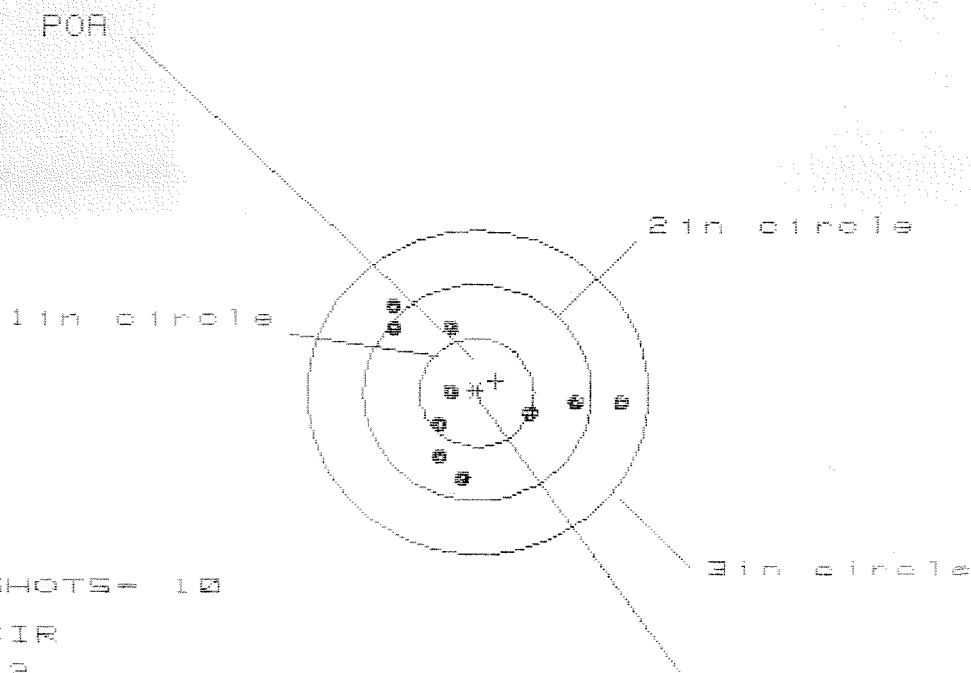
|                             |   |       |       |       |
|-----------------------------|---|-------|-------|-------|
| PATTERN #                   | : | 4     |       |       |
| SHOTS (BEST OF)             | : | 10    | 9     | 8     |
| MAXIMUM X                   | : | 1.406 | 1.334 | .676  |
| MINIMUM X                   | : | -.794 | -.866 | -.699 |
| MAXIMUM Y                   | : | 1.365 | .514  | .560  |
| MINIMUM Y                   | : | -.750 | -.598 | -.552 |
| CENTROID X                  | : | .020  | .092  | -.075 |
| CENTROID Y                  | : | -.062 | -.214 | -.260 |
| POA TO CENTROID in.         | : | .065  | .233  | .271  |
| MIN RADIUS                  | : | .391  | .445  | .442  |
| MEAN RADIUS                 | : | .801  | .708  | .610  |
| MAX RADIUS                  | : | 1.509 | 1.385 | .760  |
| HORIZONTAL SPREAD           | : | 2.200 | 2.200 | 1.375 |
| VERTICAL SPREAD             | : | 2.115 | 1.112 | 1.112 |
| EXTREME SPREAD              | : | 2.347 | 2.244 | 1.445 |
| NUMBER IN ONE INCH CIRCLE   | = |       | 2     |       |
| NUMBER IN TWO INCH CIRCLE   | = |       | 8     |       |
| NUMBER IN THREE INCH CIRCLE | = |       | 9     |       |

25 Apr 1991

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# CENTERFIRE PATTERNS

# 5



# OF SHOTS- 10

# IN CIR

1in = 2

2in = 8

3in = 10

HS= 1.989

VS= 1.608

GS= 2.174

CENTROID \*

PATTERN #

5

| SHOTS (BEST OF)               | 10    | 9     | 8     |
|-------------------------------|-------|-------|-------|
| MAXIMUM X                     | 1.247 | 1.045 | .970  |
| MINIMUM X                     | -.742 | -.604 | -.631 |
| MAXIMUM Y                     | .789  | .779  | .729  |
| MINIMUM Y                     | -.819 | -.829 | -.732 |
| CENTROID X                    | -.167 | -.305 | -.230 |
| CENTROID Y                    | -.110 | -.100 | -.197 |
| POA TO CENTROID in.           | .199  | .321  | .303  |
| MIN RADIUS                    | .271  | .135  | .249  |
| MEAN RADIUS                   | .752  | .671  | .630  |
| MAX RADIUS                    | 1.250 | 1.054 | .971  |
| HORIZONTAL SPREAD             | 1.989 | 1.649 | 1.601 |
| VERTICAL SPREAD               | 1.608 | 1.608 | 1.461 |
| EXTREME SPREAD                | 2.174 | 1.887 | 1.747 |
| NUMBER IN ONE INCH CIRCLE =   |       | 2     |       |
| NUMBER IN TWO INCH CIRCLE =   |       | 8     |       |
| NUMBER IN THREE INCH CIRCLE = |       | 10    |       |