

C6498834

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

M2400008634

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6498834

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	5 17	90	RW
600	Proof	5 17	90	RW
607	Check Headspace	5 17	90	RW
610	Dis-assemble Gun	5 17	90	RW
612	Magnaflux Barrel Action		5/22/90	KCB
	Magnaflux Bolt		5/22/90	KCB
615	Rollmark Caliber		6/27/90	BS
617	Drill and Tap Sight Holes		5/23/90	FB
618	Polish Barrel RB		5/24/90	WB
620	Apply Coatings (Barrel Action)		6-4-90	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		6/12/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6/12/90	RW
	C) Inspect Ejector Hole for Chamfer		6/12/90	RW
	D) Oil Firing Pin Ass'y		6/12/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9-4-90	GM

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			7/26/90	JH
	G) Safety Off Force	3	3	3			7/26/90	JH
	H) Trigger Pull Test & Retainability						9-4-90	JH
	I) Firing Pin Indent	.0205	.0205	.0205			7/26/90	JH
	J) Assemble Stock						7/30/90	RW
	K) Assemble Swivel Studs						9/5/90	JS
	L) Attach Front and Rear Sight Assemblies						7/30/90	RW
	M) Iron Sight Alignment						7/30/90	RW
	N) Detach Front & Rear Sights & place in numbered container						7/30/90	RW
	O) Attach Scope to Rifle						7/30/90	RW
	P) Detach & Attach Scope 20 Times						7/30/90	RW
640	Gallery Target & Test						8-8-90	KJ
	A) Time							KJ
	B) Malfunctions							KJ
	C) Pierced Primers							KJ
	D) Optical Clarity of Scope							KJ
645	Inspect for Live Ammo						8-8-90	KJ
655	Final Inspection							
	A) Headspace						9/5/90	JS
	B) Trigger Pull	2.27	2.22	2.15	2.20	2.26	9-4-90	JH
	C) Function						9/5/90	JS
660	Pack						9/20/90	AF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6498834
DATE 9-4-90
TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.24	2.28	2.30	2.27	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.32	2.33	2.33	2.22	
PULL #3	2.28	2.36	2.36	2.15	
PULL #4	2.28	2.31	2.28	2.20	
PULL #5	2.25	2.35	2.32	2.26	
TOTAL	11.37	11.63	11.59	11.10	
AVG.	2.274	2.326	2.318	2.22	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.49	3.48		
PULL #2	3.43	3.47		
PULL #3	3.50	3.47		
PULL #4	3.49	3.49		
PULL #5	3.50	3.50		
TOTAL	17.41	17.41		
AVG.	3.482	3.482		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.46	4.43		4.42
PULL #2	4.41	4.42		4.44
PULL #3	4.41	4.40		4.48
PULL #4	4.40	4.41		4.45
PULL #5	4.32	4.33		4.51
TOTAL	22.00	21.99		22.30
AVG.	4.4	4.398		4.46

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6498834
8 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.0896419
1 TO	2	.151644
1 TO	3	.302835
1 TO	4	.206022
1 TO	5	.172244

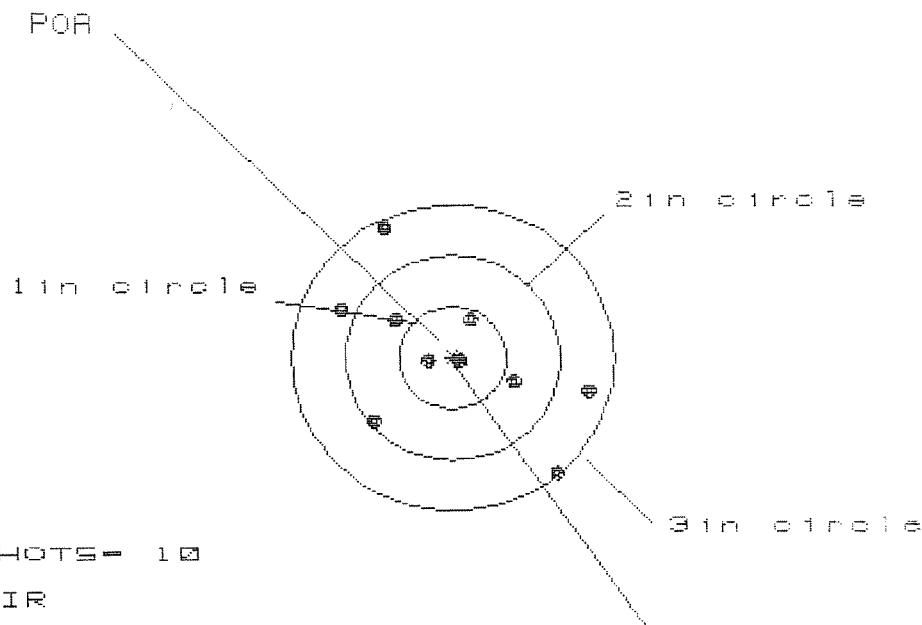
$\pm \frac{6}{5}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: $-.043$
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: $-.0342$
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: $.0549422$
THE AMR FOR THIS RIFLE IS: $.8376$

8 Aug 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6498834

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 3

2in = 6

3in = 9

HS= 2.352

VS= 2.382

GS= 2.883

CENTROID #

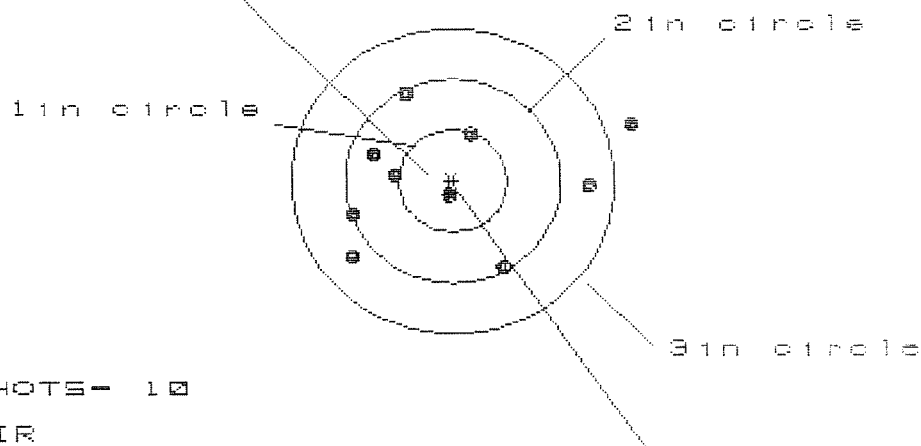
PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.297	1.407	1.342
MINIMUM X	:	-1.055	-.945	-1.010
MAXIMUM Y	:	1.226	1.098	.435
MINIMUM Y	:	-1.156	-.786	-.649
CENTROID X	:	-.065	-.175	-.110
CENTROID Y	:	.025	.153	.016
POA TO CENTROID in.	:	.070	.233	.111
MIN RADIUS	:	.074	.207	.107
MEAN RADIUS	:	.836	.755	.681
MAX RADIUS	:	1.523	1.468	1.371
HORIZONTAL SPREAD	:	2.352	2.352	2.352
VERTICAL SPREAD	:	2.382	1.884	1.084
EXTREME SPREAD	:	2.883	2.458	2.458
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

8 Aug 1998

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CENTERFIRE PATTERNS # 2

POB



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 2.630

VS= 1.673

GS= 2.833

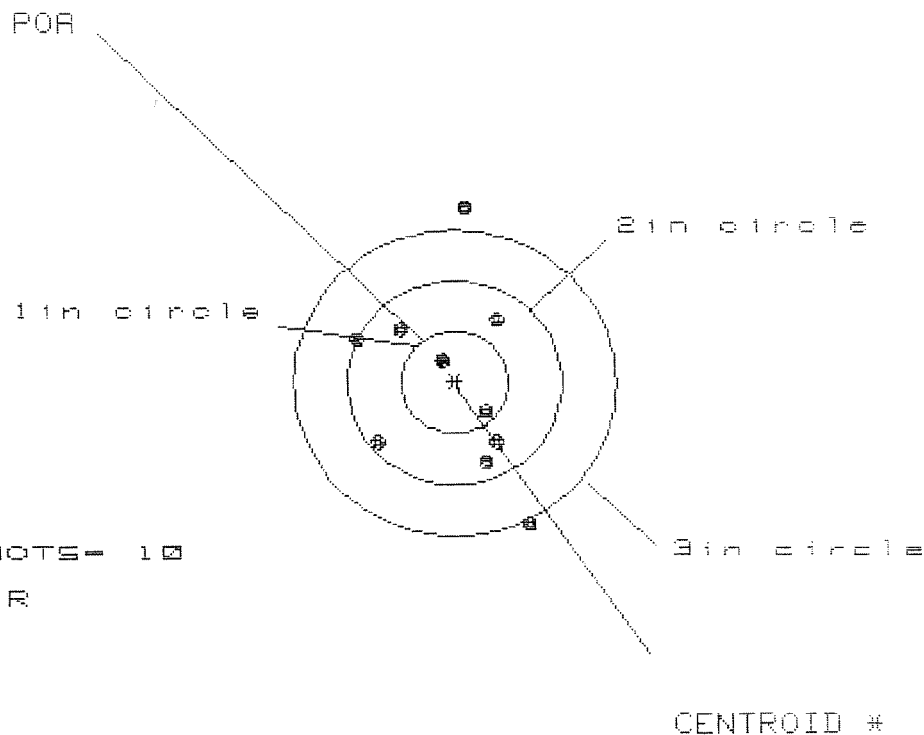
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.646	1.490	.837
MINIMUM X	:	-.984	-.801	-.615
MAXIMUM Y	:	.814	.876	.874
MINIMUM Y	:	-.859	-.797	-.799
CENTROID X	:	.035	-.148	-.334
CENTROID Y	:	.139	.077	.079
POB TO CENTROID in.	:	.143	.167	.344
MIN RADIUS	:	.151	.167	.182
MEAN RADIUS	:	.909	.783	.665
MAX RADIUS	:	1.739	1.490	1.157
HORIZONTAL SPREAD	:	2.630	2.291	1.452
VERTICAL SPREAD	:	1.673	1.673	1.673
EXTREME SPREAD	:	2.833	2.304	1.891
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

8 Aug 1998

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 8

HS = 1.645

VS = 3.108

GS = 3.168

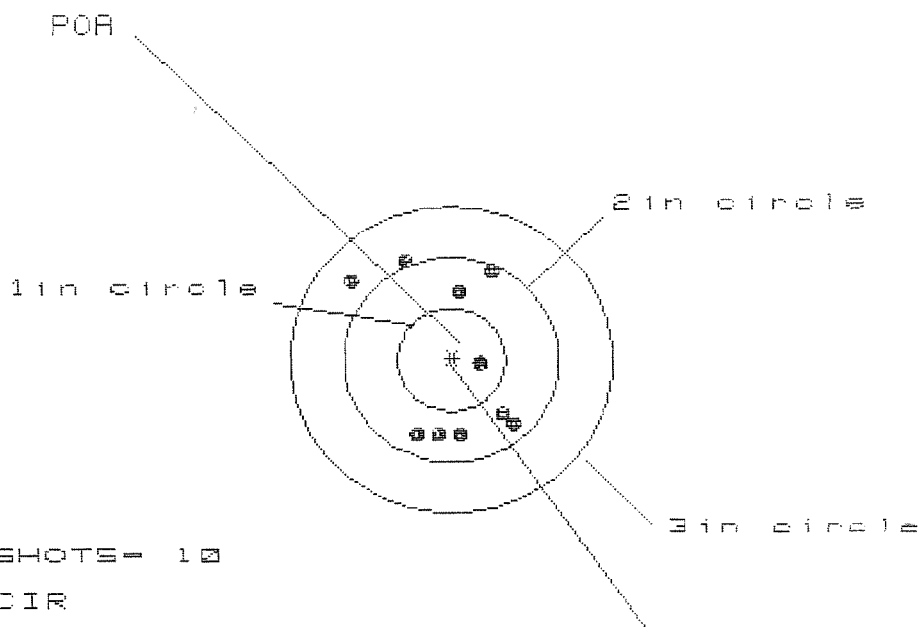
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.694	.703	.530
MINIMUM X	:	-.951	-.942	-.855
MAXIMUM Y	:	1.760	.781	.637
MINIMUM Y	:	-1.348	-1.152	-.708
CENTROID X	:	.113	.104	.017
CENTROID Y	:	-.220	-.416	-.272
POR TO CENTROID in.	:	.247	.428	.272
MIN RADIUS	:	.256	.331	.278
MEAN RADIUS	:	.881	.774	.692
MAX RADIUS	:	1.762	1.350	.985
HORIZONTAL SPREAD	:	1.645	1.645	1.385
VERTICAL SPREAD	:	3.108	1.933	1.345
EXTREME SPREAD	:	3.168	2.429	1.741
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

8 Aug 1998

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 1

2in = 8

3in = 10

HS= 1.509

VS= 1.684

GS= 2.098

CENTROID *

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.617	.518	.456
MINIMUM X	-.892	-.494	-.482
MAXIMUM Y	.934	1.023	1.132
MINIMUM Y	-.750	-.661	-.533
CENTROID X	-.271	-.172	-.111
CENTROID Y	.028	-.061	-.189
POA TO CENTROID in.	.273	.183	.219
MIN RADIUS	.235	.143	.193
MEAN RADIUS	.792	.716	.634
MAX RADIUS	1.199	1.136	1.145
HORIZONTAL SPREAD	1.509	1.012	.939
VERTICAL SPREAD	1.684	1.684	1.665
EXTREME SPREAD	2.098	1.885	1.788
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

B Aug 1998

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CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in - 2

2 in - 7

3 in - 10

HS- 1.958

VS= 2.222

GS= 2.223

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.918	.898	.865
MINIMUM X	:	-1.040	-1.060	-1.093
MAXIMUM Y	:	1.170	.908	.793
MINIMUM Y	:	-1.052	-.922	-.562
CENTROID X	:	-.027	-.007	.026
CENTROID Y	:	-.143	-.273	-.158
POA TO CENTROID in.	:	.146	.273	.160
MIN RADIUS	:	.127	.068	.095
MEAN RADIUS	:	.770	.720	.674
MAX RADIUS	:	1.185	1.070	1.123
HORIZONTAL SPREAD	:	1.958	1.958	1.958
VERTICAL SPREAD	:	2.222	1.830	1.355
EXTREME SPREAD	:	2.223	1.969	1.969
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

Remington.



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

MODEL 700TM H24

SERIAL NO.

C6498834

ORDER NO.

5716

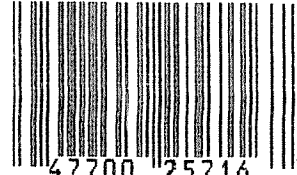
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5716 C6498834

UPC



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KINZER V. REMINGTON

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