C6587590

MODEL 700™ M24

Model SWS ™

Action

Barrel Length

Capacity

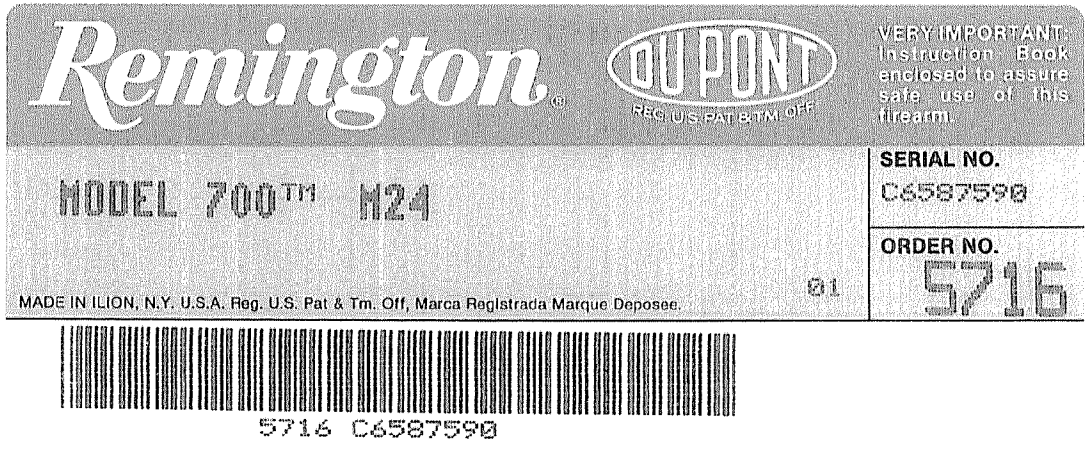
Order No. 5716

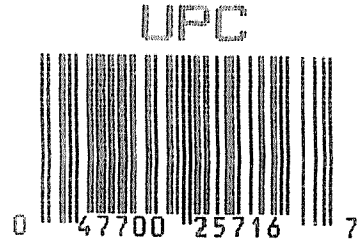
*Includes 1 in chamber.

Remington

M2400023330

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON





E-PIM-01K

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587590

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/19/90	KA
600	Proof		10/19/90	KA
607	Check Headspace		10/19/90	KA
610	Dis-assemble Gun		10/19/90	KA
612	Magnaflux Barrel Action		10/22/90	KA
	Magnaflux Bolt		10/22/90	K.R
615	Rollmark Caliber		10/22/90	KA
617	Drill and Tap Sight Holes		10/23/90	KB
618	Polish Barrel KB		10/24/90	KB
620	Apply Coatings (Barrel Action)		11-7-90	KA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		12/5/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/5/90	KS
	C) Inspect Ejector Hole for Chamfer		12/5/90	KS
	D) Oil Firing Pin Ass'y		12/5/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		12/6/90	KA

Op. #	OP. NAME	READINGS	DATE	INIT
625 cont.	F) Safety On Force	5 1/4 : 5 1/4 : 5 1/4	12/6/90	WB
	G) Safety Off Force	2 1/2 : 2 1/2 : 2 1/2	12/6/90	WB
	H) Trigger Pull Test & Retainability		12/6/90	DH
	I) Firing Pin Indent	.0223 : .0233 : .023	12/6/90	WB
	J) Assemble Stock		12/7/90	KS
	K) Assemble Swivel Studs		12-8-90	DH
	L) Attach Front and Rear Sight Assemblies		12/7/90	KS
	M) Iron Sight Alignment		12/7/90	KS
	N) Detach Front & Rear Sights & place in numbered container		12/7/90	KS
	O) Attach Scope to Rifle		12/7/90	KS
	P) Detach & Attach Scope 20 Times		12/7/90	KS
640	Gallery Target & Test		12/7/90	KS
	A) Time		"	KS
	B) Malfunctions		"	KS
	C) Pierced Primers		"	KS
	D) Optical Clearity of Scope		"	KS
645	Inspect for Live Ammo		12/7/90	KS
655	Final Inspection A) Headspace		12-8-90	DH
	B) Trigger Pull	265 : 282 : 282 : 280 : 287	12-8-90	DH
	C) Function		12-8-90	DH
660	Pack		12-17-90	DH

SWS TRIGGER PULL TEST

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

SERIAL NO. BC587540
DATE 12/6/90
TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.45	2.46	2.46	265	MIN. SETTING,
PULL #2	2.38	2.44	2.44	282	NO AVG. OF 5
PULL #3	2.40	2.38	2.44	282	READINGS ACCEPT-
PULL #4	2.39	2.43	2.46	280	ABLE LESS THAN 2#
PULL #5	2.40	2.42	2.42	281	
TOTAL					
AVG.					

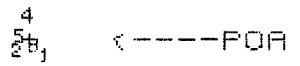
	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.30	3.16		
PULL #2	3.22	3.20		
PULL #3	3.23	3.17		
PULL #4	3.18	3.24		
PULL #5	3.20	3.20		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.27	4.24		4.19
PULL #2	4.23	4.20		4.20
PULL #3	4.22	4.19		4.22
PULL #4	4.21	4.17		4.25
PULL #5	4.26	4.22		4.20
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587590
8 Dec 1990

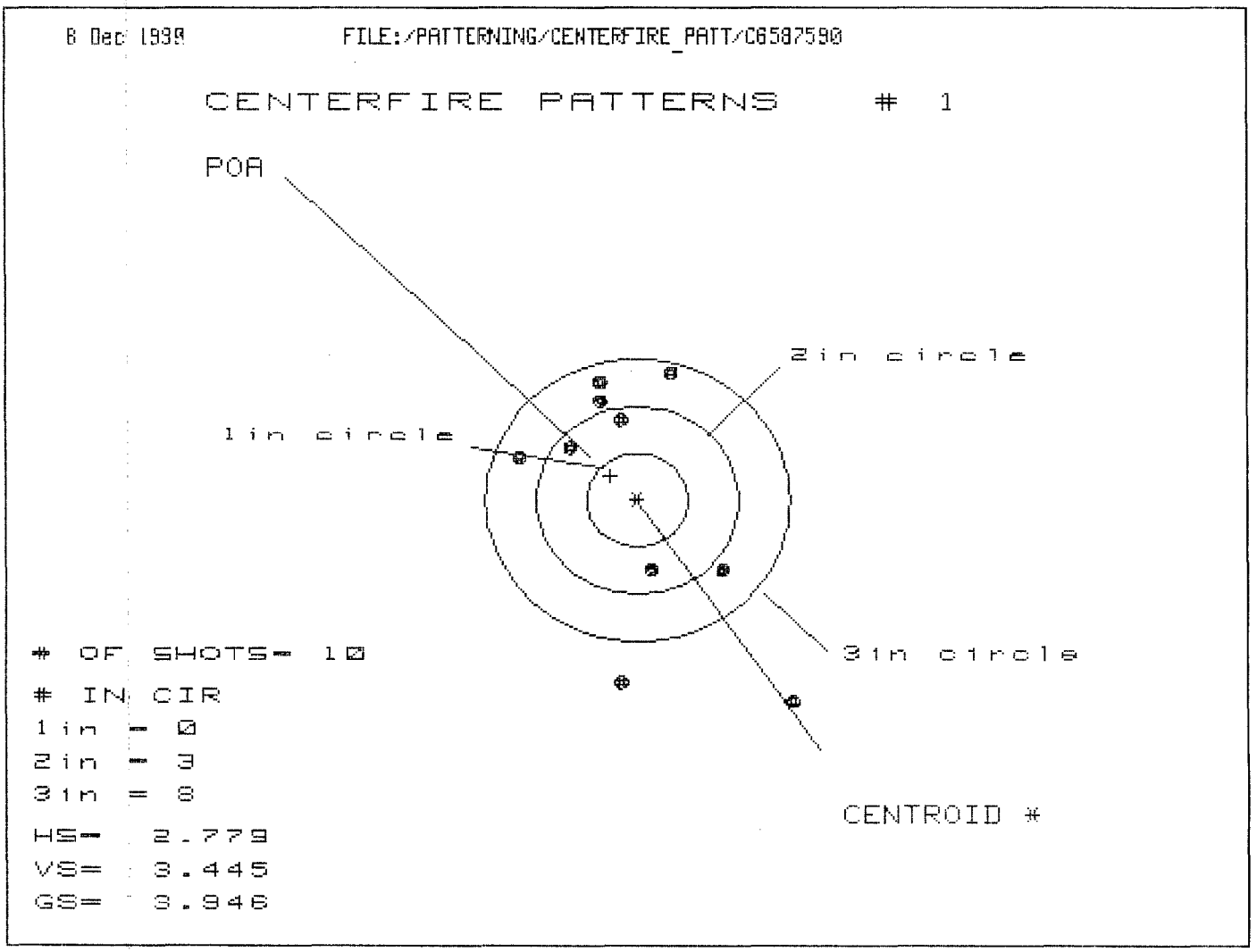
CENTROIDAL DISTANCES

Ø	TO	1	.372678
1	TO	2	.492297
1	TO	3	.263139
1	TO	4	.784593
1	TO	5	.558014



THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0118
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .01
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0154674

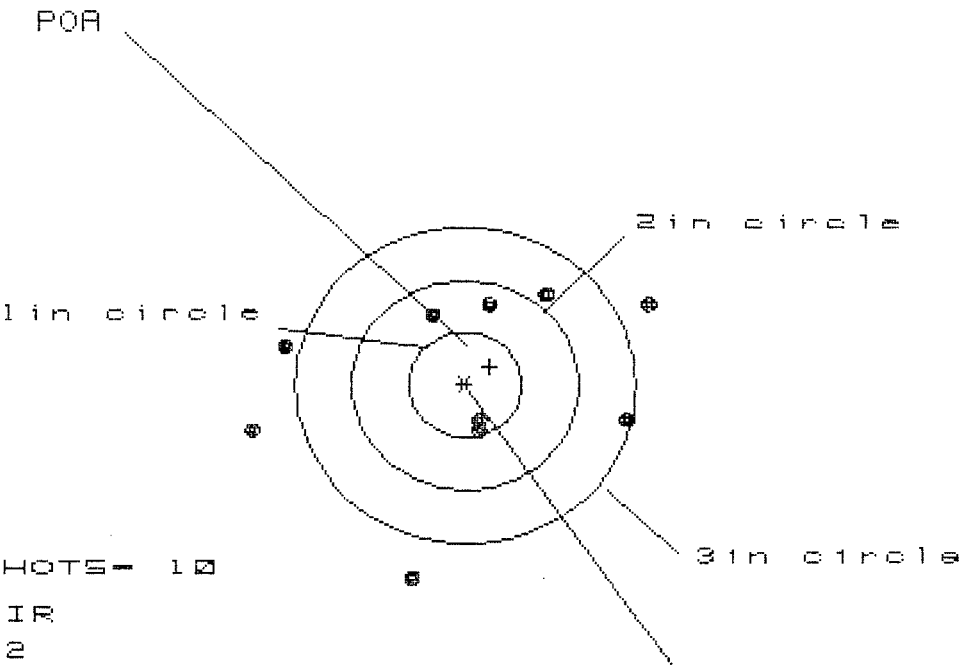
THE AMR FOR THIS RIFLE IS: 1.007



PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.576	.985	.988
MINIMUM X	:	-1.203	-1.028	-1.025
MAXIMUM Y	:	1.325	1.090	.813
MINIMUM Y	:	-2.120	-2.214	-1.275
CENTROID X	:	.267	.092	.089
CENTROID Y	:	-.260	-.025	.252
POA TO CENTROID in.	:	.373	.095	.267
MIN RADIUS	:	.727	.598	.356
MEAN RADIUS	:	1.336	1.117	.892
MAX RADIUS	:	2.641	2.214	1.613
HORIZONTAL SPREAD	:	2.779	2.013	2.013
VERTICAL SPREAD	:	3.445	3.304	2.088
EXTREME SPREAD	:	3.946	3.347	2.388
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

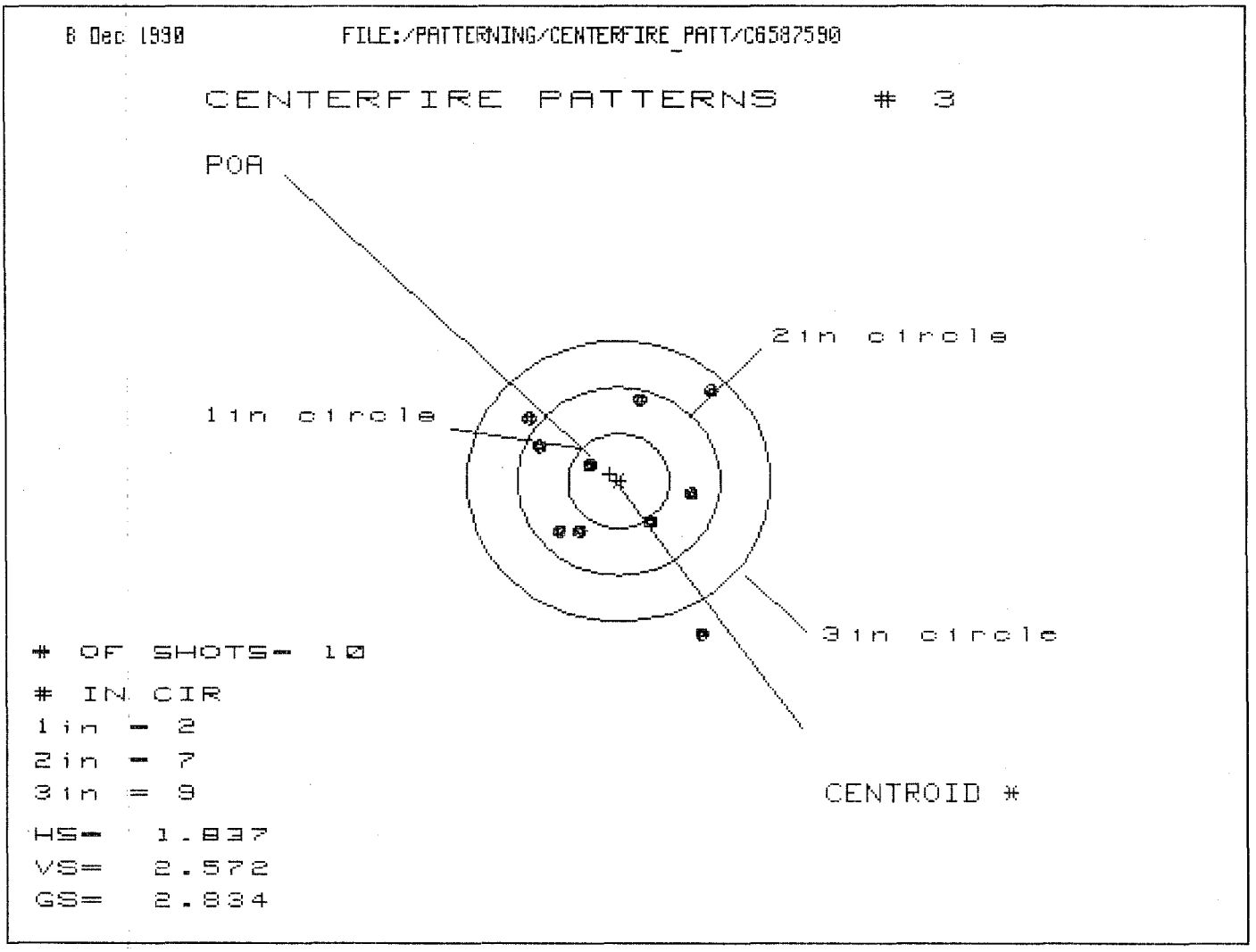
8 Dec 1998 FILE:/PATTERNING/CENTERFIRE_PATT/C6507590

CENTERFIRE PATTERNS # 2



# OF SHOTS= 10
# IN CIR
1in = 2
2in = 4
3in = 6
HS= 3.449
VS= 2.692
GS= 3.661

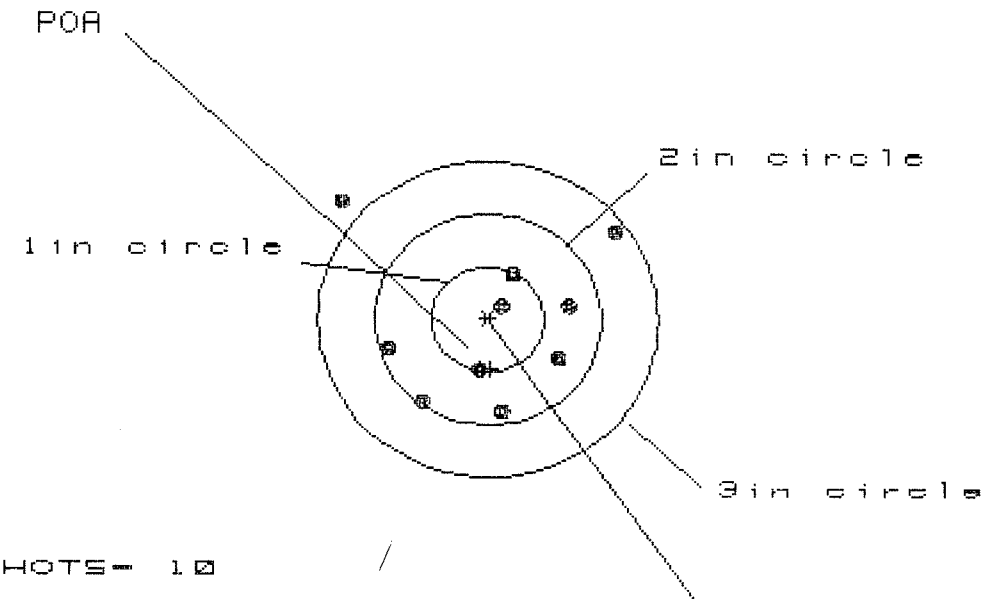
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.601	1.549	1.311
MINIMUM X	:	-1.848	-1.900	-1.859
MAXIMUM Y	:	.837	.631	.547
MINIMUM Y	:	-1.855	-.682	-.766
CENTROID X	:	-.217	-.165	.072
CENTROID Y	:	-.170	.036	.120
POA TO CENTROID in.	:	.275	.169	.140
MIN RADIUS	:	.371	.550	.496
MEAN RADIUS	:	1.221	1.126	.987
MAX RADIUS	:	1.913	2.014	1.861
HORIZONTAL SPREAD	:	3.449	3.449	3.171
VERTICAL SPREAD	:	2.692	1.313	1.313
EXTREME SPREAD	:	3.661	3.661	3.197
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	



PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.947	1.036	.922
MINIMUM X	:	-.890	-.801	-.671
MAXIMUM Y	:	.988	.812	.799
MINIMUM Y	:	-1.584	-.697	-.596
CENTROID X	:	.086	-.003	-.133
CENTROID Y	:	-.069	.107	.006
POA TO CENTROID in.	:	.110	.107	.133
MIN RADIUS	:	.373	.231	.155
MEAN RADIUS	:	.904	.792	.697
MAX RADIUS	:	1.776	1.316	.952
HORIZONTAL SPREAD	:	1.837	1.837	1.593
VERTICAL SPREAD	:	2.572	1.509	1.395
EXTREME SPREAD	:	2.834	2.102	1.807
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

8 Dec 1998 FILE:/PATTERNING/CENTERFIRE_PATT/C6587590

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

# IN CIR
1in = 3
2in = 8
3in = 9

HS= 2.410
VS= 1.932
GS= 2.424

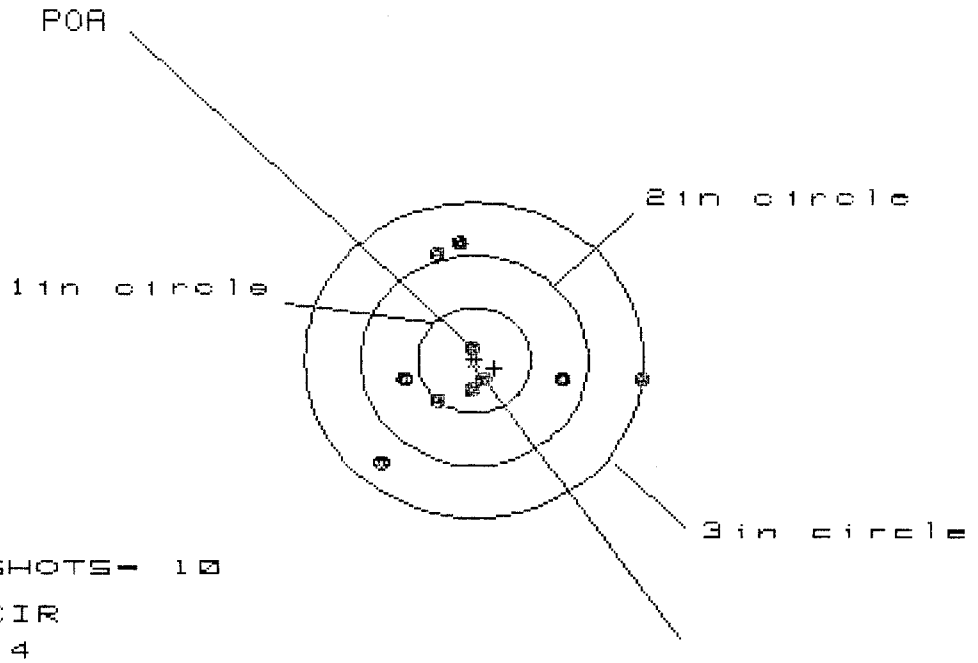
PATTERN # : 4

SHOTS (BEST OF) :	10	9	8
MAXIMUM X :	1.082	.935	.680
MINIMUM X :	-1.328	-1.023	-.906
MAXIMUM Y :	1.109	.975	.665
MINIMUM Y :	-.823	-.700	-.578
CENTROID X :	-.018	.129	.012
CENTROID Y :	.471	.348	.226
POA TO CENTROID in.:	.471	.371	.226
MIN RADIUS :	.186	.275	.232
MEAN RADIUS :	.835	.709	.621
MAX RADIUS :	1.730	1.351	.908
HORIZONTAL SPREAD :	2.410	1.958	1.586
VERTICAL SPREAD :	1.932	1.675	1.243
EXTREME SPREAD :	2.424	2.323	1.653

NUMBER IN ONE INCH CIRCLE = 3
NUMBER IN TWO INCH CIRCLE = 8
NUMBER IN THREE INCH CIRCLE = 9

8 Dec 1998 FILE:/PATTERNING/CENTERFIRE_PATT/C6587590

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

# IN CIR
1in = 4
2in = 6
3in = 10

HS= 2.326
VS= 2.042
GS= 2.456

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.476	.904	.818
MINIMUM X	:	-.850	-.686	-.568
MAXIMUM Y	:	1.109	1.093	.974
MINIMUM Y	:	-.933	-.949	-.512
CENTROID X	:	-.177	-.341	-.255
CENTROID Y	:	.078	.094	.213
POA TO CENTROID in.	:	.194	.354	.333
MIN RADIUS	:	.112	.211	.107
MEAN RADIUS	:	.740	.660	.601
MAX RADIUS	:	1.483	1.171	.976
HORIZONTAL SPREAD	:	2.326	1.590	1.386
VERTICAL SPREAD	:	2.042	2.042	1.486
EXTREME SPREAD	:	2.456	2.162	1.606

NUMBER IN ONE INCH CIRCLE = 4
NUMBER IN TWO INCH CIRCLE = 6
NUMBER IN THREE INCH CIRCLE = 10

RECEIVING AND ESTIMATING REPORT

COMMENTS: W/10X SCOPE, M-24 SNIPER, W/DEPLOYMENT KIT
ATTN: FRED MARTIN
SCOPE 90-0997

ORDER R 94-18352

INITIAL	CUSTOMER ORDER NO.
FDC	DAAA09-92-C-0834

DATE RECEIVED	DATE OPENED	DATE CODE	SERIAL NUMBER	NEW SERIAL NUMBER	MODEL AND GRADE
06/11/94	06/11/94		C6587590		700 7.62 NATO

ACCESSORIES: SLING STRAP HARD CASE SCOPE MNTS SCOPE BASE

FROM:

COMMANDER (W52H094138H226)
DEFENSE DIST DEPOT ANNISTON
ATTN DDAA-UR BLDG 112
ANNISTON AL 36201-5025

SHIP TO:

COMMANDER (W52H094138H226)
DEFENSE DIST DEPOT ANNISTON
ATTN DDAA-UR BLDG 112
ANNISTON AL 36201-5025

CUST NO: 098397 C.O.D.

ACCOUNT NUMBER	ACCOUNT NUMBER N/C	WRITE	PROM. DATE	ESTIMATED	VIA
		☐			FRT

GUN CONDITION
- ☐ NEW
- ☐ LIGHTLY WORN
- ☐ WORN
- ☐ VERY WORN
- ☐ UNREPAIRABLE
- ☐ MARRED

REPAIR CHARGE	
EXCISE	
TAX	
INSURANCE	
UPS	
PARCEL POST	
TOTAL	

CUSTOMER CONCERN	AMMO	FUNCTION	FINISH	ACCURACY	FIT	INSPECT
CYCLE	A1	B1				
TRIGGER GROUP		B2			E1	F1
BOLT ASSY.		B3			E2	F2
BARREL ASSY.		B4		D1	E3	F3
REC. ASSY.		B5		D2	E4	F4
WOOD			C1	D3	E5	F5
METAL			C2			

MAIN FAULT

PARTS

Trigger ASSY	$ 173.31
V.F. Firing pin ASSY	9.96
CTL	50.00
	$ 233.27

COMMENTS

REPAIRMAN	PROOF	CLEAN	TEST	TARGET	PATTERN
GALLERY TESTER	DATE	DATE	DATE	DATE	DATE
			10/20		

OFFICE COPY

RD6925 REV. 1/94

SWS TRIGGER PULL TEST

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

SERIAL NO. C65820590

DATE _____

TESTER RW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.63	2.58	2.76		MIN. SETTING,
PULL #2	2.66	2.63	2.72		NO AVG. OF 5
PULL #3	2.65	2.67	2.78		READINGS ACCEPT-
PULL #4	2.63	2.64	2.74		ABLE LESS THAN 2#
PULL #5	2.64	2.70	2.81		
TOTAL	13.21	13.22	13.81		
AVG.	2.64	2.64	2.76		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.04	3.18		
PULL #2	3.12	3.17		
PULL #3	3.09	3.17		
PULL #4	3.11	3.21		
PULL #5	3.16	3.14		
TOTAL	15.52	15.87		
AVG.	3.10	3.17		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.14	4.07		4.32
PULL #2	4.08	4.11		4.30
PULL #3	4.04	4.07		4.30
PULL #4	4.02	4.01		4.25
PULL #5	4.05	4.04		4.34
TOTAL	20.33	20.30		21.51
AVG.	4.07	4.06		4.30

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587590

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock			
600	Proof			
607	Check Headspace			
610	Dis-assemble Gun			
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6½	6½	6¼			12/5	WB
	G) Safety Off Force	3	3	3			12/5	WB
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent							
	J) Assemble Stock							
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies							
	M) Iron Sight Alignment							
	N) Detach Front & Rear Sights & place in numbered container							
	O) Attach Scope to Rifle							
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test							
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clearity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection A) Headspace							
	B) Trigger Pull	2.69	2.69	2.51	2.56	2.65	12/5	WB
	C) Function							
660	Pack							