

C6611455

MODEL 700™ M24

Model **SWS**™

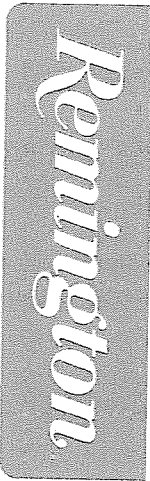
Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



Remington [®]		DU PONT REG. U.S. PAT. & TM. OFF.	VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700 TM M24		SERIAL NO. C6611455	ORDER NO. 5716
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		20	



CFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611455

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		2-25-91	RW
600	Proof		1-25-91	RW
607	Check Headspace		1-25-91	RW
610	Dis-assemble Gun			RW
612	Magnaflux Barrel Action		1-25-91	K.R.
	Magnaflux Bolt		1-25-91	RR
615	Rollmark Caliber		1-25-91	LS
617	Drill and Tap Sight Holes		1-30-91	EB
618	Polish Barrel <i>R.B.B.</i>		1-30-91	WB
620	Apply Coatings (Barrel Action)		2-10-91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/11/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/11/91	RW
	C) Inspect Ejector Hole for Chamfer		2/11/91	RW
	D) Oil Firing Pin Ass'y		2/11/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2/16/91	JS

op. #	BARBER M24 0077152	READINGS				DATE	INIT
625 cont.	F) Safety On Force	4	4	4		2/16/91	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2		2/16/91	WB
	H) Trigger Pull Test & Retainability					2/16/91	XL
	I) Firing Pin Indent	.0225	.0225	.0225		2/16/91	WB
	J) Assemble Stock					2/18/91	RW
	K) Assemble Swivel Studs					2-22-91	A
	L) Attach Front and Rear Sight Assemblies					2/18/91	RW
	M) Iron Sight Alignment					2/18/91	RW
	N) Detach Front & Rear Sights & place in numbered container					2/18/91	RW
	O) Attach Scope to Rifle					2/18/91	RW
	P) Detach & Attach Scope 20 Times					2/18/91	RW
640	Gallery Target & Test					2-19-91	NF
	A) Time					"	NF
	B) Malfunctions					"	NF
	C) Pierced Primers					"	NF
	D) Optical Clarity of Scope					"	NF
645	Inspect for Live Ammo					2-19-91	NF
655	Final Inspection						
	A) Headspace					2-22-91	A
	B) Trigger Pull	2.35	2.20	2.38	2.29	2.32	2/21/91
	C) Function					2-22-91	A
660	Pack					3-19-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS2.50# + .50#
3.00# + .75#
4.00# + 1.00#SERIAL NO. 26611455DATE 2/16/91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.33	2.30	2.35	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.43	2.43	2.20	2.20	
PULL #3	2.52	2.47	2.25	2.38	
PULL #4	2.48	2.28	2.30	2.29	
PULL #5	2.38	2.36	2.31	2.32	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.45	3.17		
PULL #2	3.20	3.42		
PULL #3	3.42	3.32		
PULL #4	3.44	3.41		
PULL #5	3.48	3.25		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.45	4.43		4.38
PULL #2	4.37	4.44		4.45
PULL #3	4.49	4.44		4.46
PULL #4	4.52	4.21		4.25
PULL #5	4.36	4.48		4.39
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611455
20 Feb 1991

CENTROIDAL DISTANCES

0 TO	1	.116417
1 TO	2	.0938616
1 TO	3	.129248
1 TO	4	.0576975
1 TO	5	.247164

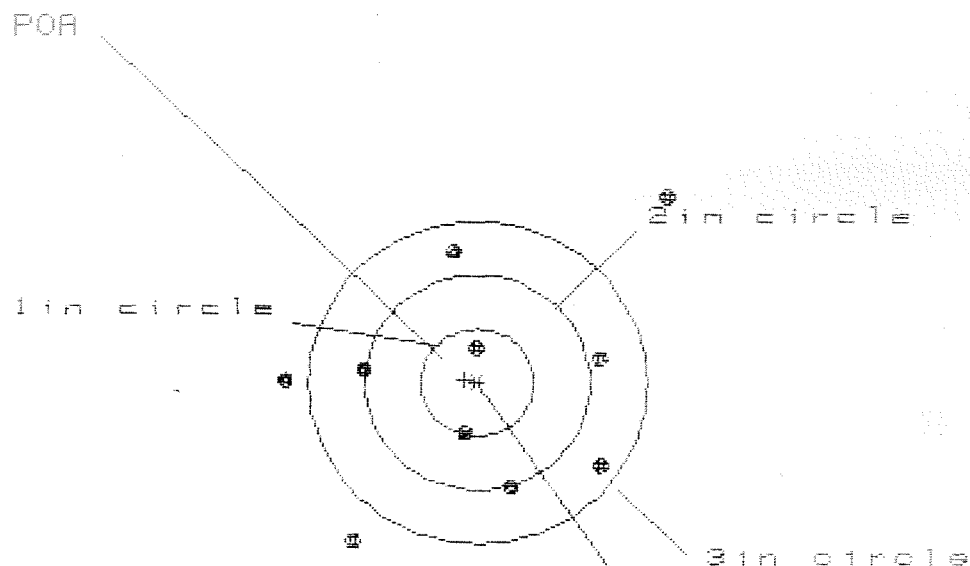
54 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0716
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0842
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .119527
THE AMP FOR THIS RIFLE IS: 1.026

28 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08611455

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 2

3 in = 7

HS = 3.389

VS = 3.224

GS = 4.223

CENTROID *

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.655	1.317	1.206
MINIMUM X	-1.734	-1.550	-1.661
MAXIMUM Y	1.708	1.453	1.287
MINIMUM Y	-1.516	-1.327	-0.933
CENTROID X	.113	-.071	.040
CENTROID Y	-.028	-.217	-.051
POA TO CENTROID in.	.116	.229	.065
MIN RADIUS	.364	.334	.399
MEAN RADIUS	1.264	1.124	1.051
MAX RADIUS	2.378	1.597	1.661
HORIZONTAL SPREAD	3.389	2.867	2.867
VERTICAL SPREAD	3.224	2.780	2.220
EXTREME SPREAD	4.223	2.957	2.957
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	7		

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FILE:/PATTERNING/CENTERFIRE_PATT/C8511455

CENTERFIRE PATTERNS

2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 3

3 in = 6

HS= 3.118

VS= 3.197

GS= 3.795

PATTERN #

2

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.792	1.705	1.389
MINIMUM X	-1.326	-1.413	-1.200
MAXIMUM Y	1.036	.796	.810
MINIMUM Y	-2.161	-1.224	-1.210
CENTROID X	.136	.223	.010
CENTROID Y	-.119	.121	.107
POA TO CENTROID in.	.181	.254	.107
MIN RADIUS	.369	.163	.376
MEAN RADIUS	1.256	1.107	1.046
MAX RADIUS	2.298	1.870	1.704
HORIZONTAL SPREAD	3.118	3.118	2.589
VERTICAL SPREAD	3.197	2.020	2.020
EXTREME SPREAD	3.795	3.393	3.284
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		6	

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CENTERFIRE PATTERNS

3

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 2

2in = 8

3in = 10

HS= 1.415

VS= 2.514

GS= 2.606

PATTERN #

3

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.663

.696

.651

MINIMUM X

-.752

-.719

-.764

MAXIMUM Y

1.303

.611

.478

MINIMUM Y

-1.211

-1.066

-.720

CENTROID X

.105

.072

.117

CENTROID Y

-.157

-.302

-.169

POA TO CENTROID in.

.189

.311

.205

MIN RADIUS

.076

.086

.063

MEAN RADIUS

.710

.647

.562

MAX RADIUS

1.337

1.124

.951

HORIZONTAL SPREAD

1.415

1.415

1.415

VERTICAL SPREAD

2.514

1.677

1.198

EXTREME SPREAD

2.606

1.882

1.604

NUMBER IN ONE

INCH CIRCLE

=

2

NUMBER IN TWO

INCH CIRCLE

=

8

BARBER - M24 0077158

20 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611455

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 2.374

VS= 2.243

GS= 2.653

CENTROID #

PATTERN #

4

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.219	1.090	.821
MINIMUM X	:	-1.155	-.757	-.620
MAXIMUM Y	:	1.198	1.288	1.253
MINIMUM Y	:	-1.045	-.955	-.990
CENTROID X	:	.138	.267	.130
CENTROID Y	:	-.080	-.170	-.135
POA TO CENTROID in.	:	.160	.316	.188
MIN RADIUS	:	.262	.381	.287
MEAN RADIUS	:	.890	.839	.780
MAX RADIUS	:	1.413	1.288	1.260
HORIZONTAL SPREAD	:	2.374	1.847	1.441
VERTICAL SPREAD	:	2.243	2.243	2.243

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

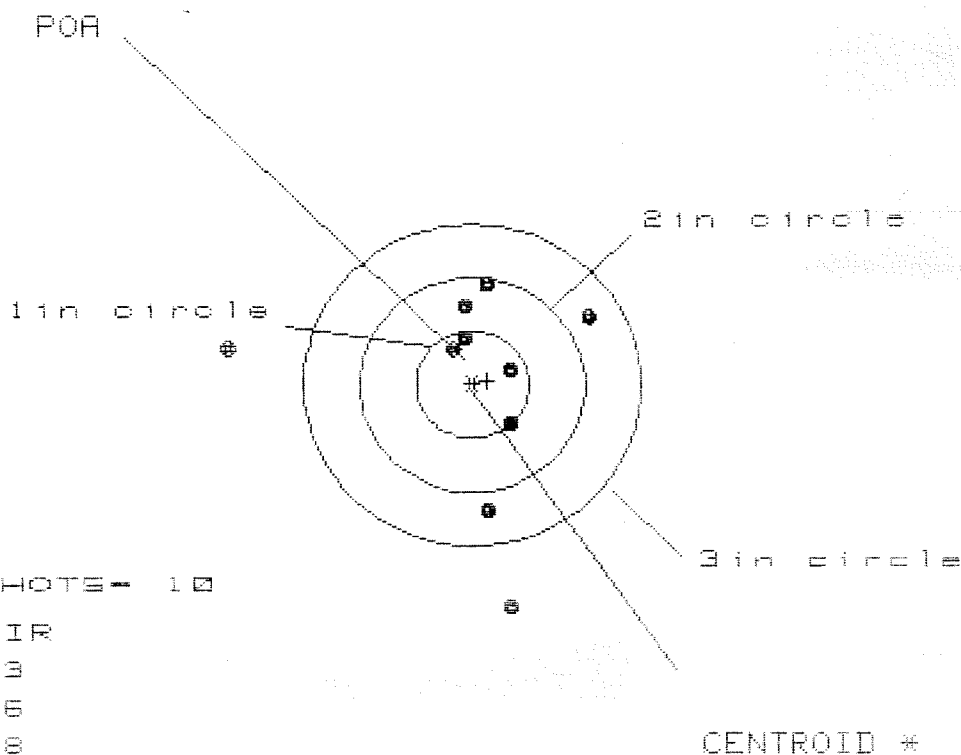
BARBER - M24 0077158

NUMBER IN ONE INCH CIRCLE = 2
 NUMBER IN TWO INCH CIRCLE = 5
 NUMBER IN THREE INCH CIRCLE = 10

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FILE:/PATTERNING/CENTERFIRE_PATT/C6611455

CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1in = 3

2in = 6

3in = 8

HS= 3.201

VS= 3.050

GS= 3.453

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.083

.848

.866

MINIMUM X

-2.117

-.407

-.389

MAXIMUM Y

.959

.992

.735

MINIMUM Y

-2.091

-2.058

-1.344

CENTROID X

-.134

.101

.083

CENTROID Y

-.037

-.070

.187

POA TO CENTROID in.

.139

.123

.205

MIN RADIUS

.366

.253

.152

MEAN RADIUS

1.010

.867

.647

HORIZONTAL SPREAD :	3.201	1.255	1.255
VER BARBER - M24 0077160	3.050	3.050	2.079
EXTREME SPREAD :	3.453	3.059	2.079
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	