C6611554

MODEL 700™ M24

Model SWS ™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

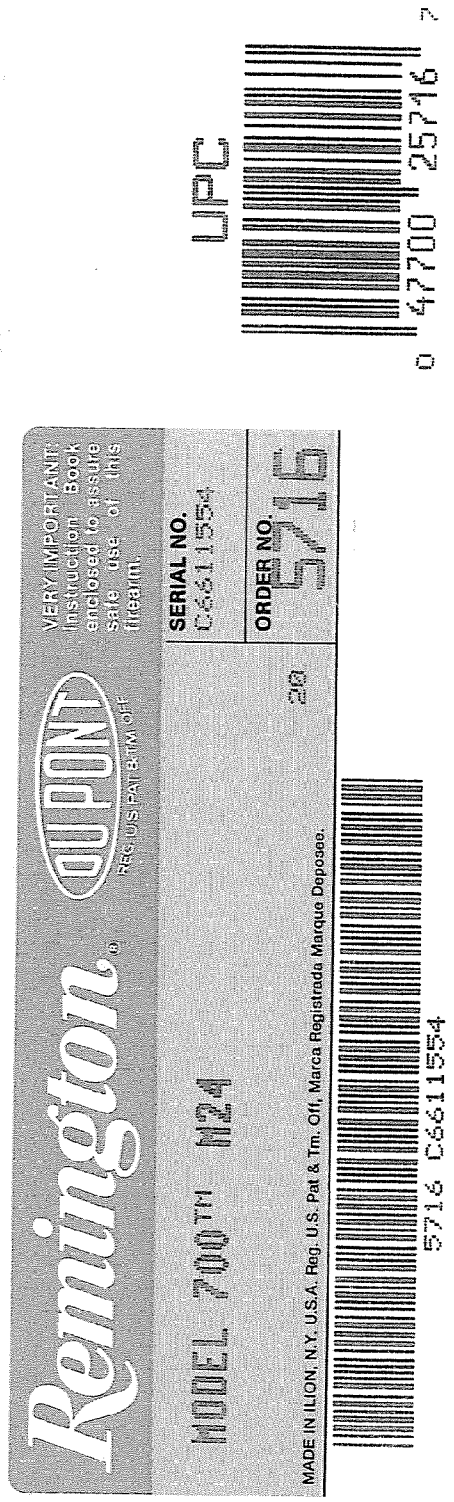
Remington

BARBER - M24 0078792

BARBER - M24 0078753

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

Smead®
No. 2-152-5L


Remington
DUPONT
REG. U.S. PAT. & TM. OFF.
VERY IMPORTANT
Instruction Book
enclosed to assure
safe use of this
firearm.
MODEL 700TH M24
SERIAL NO.
C6611554
ORDER NO.
5716
20
MADE IN ILION, N.Y., U.S.A. Reg. U.S. Pat. & Tm. Off., Marca Registrada Marque Deposee.
5716 C6611554
UPC
0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611554

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 25 91		
600	Proof	3 25 91		
607	Check Headspace	3 25 91		
610	Dis-assemble Gun	3 25 91		
612	Magnaflux Barrel Action	3 28 91		KR
	Magnaflux Bolt	3 28 91		
615	Rollmark Caliber	3 28 91		
617	Drill and Tap Sight Holes	APR	3-1991	
618	Polish Barrel	APR	3 1991	
620	Apply Coatings (Barrel Action)		4-11-91	
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/16/91	
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/16/91	
	C) Inspect Ejector Hole for Chamfer		4/16/91	
	D) Oil Firing Pin Ass'y		4/16/91	
	E) Adjust Trigger Pull to Min Setting and Stake		5-13-91	

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KINZER V. REMINGTON

BARBER - M24 0078756

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5-14-91	DH
	G) Safety Off Force	3	3	3			5-14-91	DH
	H) Trigger Pull Test & Retainability						5-13-91	JH
	I) Firing Pin Indent	.020	.020	.021			5-14-91	DH
	J) Assemble Stock						5/14/91	RW
	K) Assemble Swivel Studs						5-21-91	DH
	L) Attach Front and Rear Sight Assemblies						5/14/91	RW
	M) Iron Sight Alignment						5/14/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/14/91	RW
	O) Attach Scope to Rifle						5/14/91	RW
	P) Detach & Attach Scope 20 Times						5/14/91	RW
640	Gallery Target & Test						5-14-91	DH
	A) Time						5-14-91	DH
	B) Malfunctions						5-15-91	DH
	C) Pierced Primers						5-15-91	DH
	D) Optical Clearity of Scope						5-15-91	DH
645	Inspect for Live Ammo						5-15-91	DH
655	Final Inspection A) Headspace						5-21-91	DH
	B) Trigger Pull	2.25	2.16	2.18	2.20	2.25	5-20-90	JH
	C) Function						5-21-91	DH
660	Pack						6-17-91	N-

SWS TRIGGER PULL TEST

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

SERIAL NO. C6611554

DATE 5-13-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.37	2.32	2.33	2.25	MIN. SETTING,
PULL #2	2.56	2.15	2.28	2.16	NO AVG. OF 5
PULL #3	2.49	2.23	2.28	2.18	READINGS ACCEPT-
PULL #4	2.30	2.33	2.35	2.20	ABLE LESS THAN 2#
PULL #5	2.50	2.30	2.33	2.25	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.47		
PULL #2	3.44	3.42		
PULL #3	3.49	3.48		
PULL #4	3.49	3.36		
PULL #5	3.54	3.47		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.58	4.21		4.22
PULL #2	4.34	4.21		4.21
PULL #3	4.30	4.23		4.17
PULL #4	4.22	4.15		4.19
PULL #5	4.19	4.18		4.20
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611554
15 May 1991

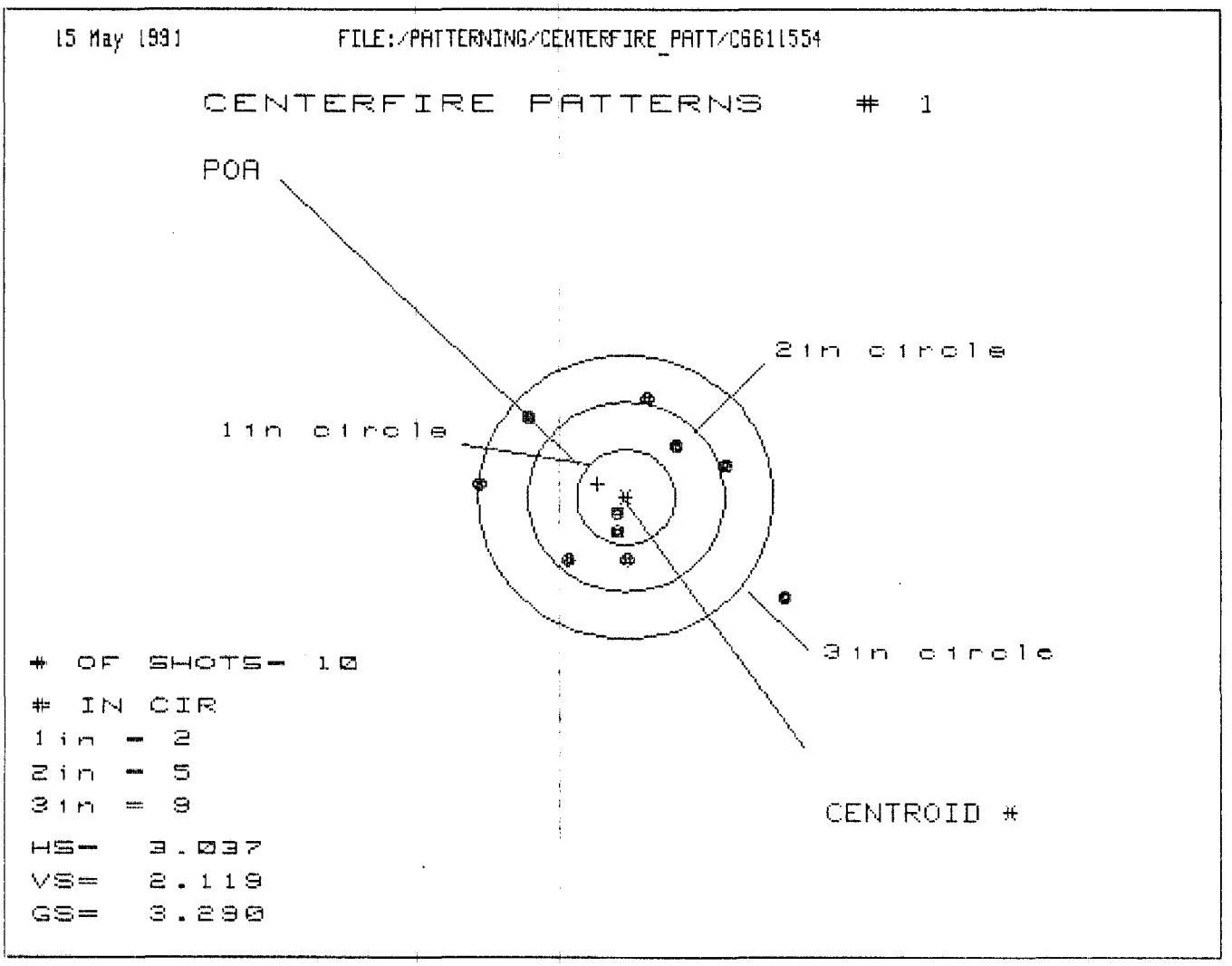
CENTROIDAL DISTANCES

0	TO	1	.317553
1	TO	2	.180942
1	TO	3	.372055
1	TO	4	.4219
1	TO	5	.502021

<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0666
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0162
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .068542

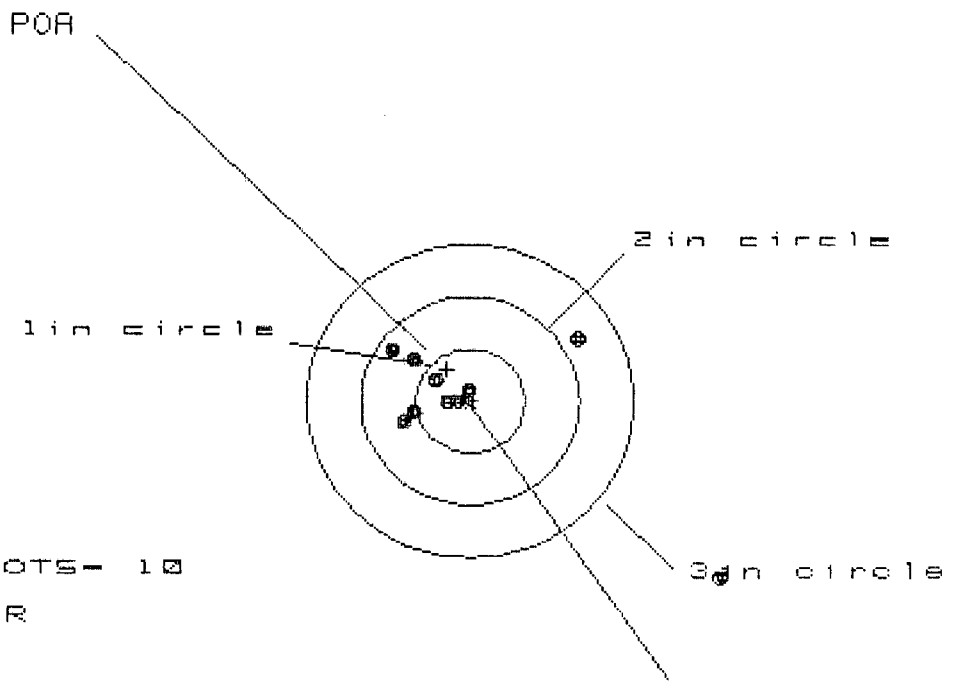
THE AMR FOR THIS RIFLE IS: .8604



PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.566	1.144	.982
MINIMUM X	:	-1.471	-1.297	-.996
MAXIMUM Y	:	1.026	.904	.910
MINIMUM Y	:	-1.094	-.813	-.807
CENTROID X	:	.286	.112	.274
CENTROID Y	:	-.138	-.016	-.022
POA TO CENTROID in.	:	.317	.113	.275
MIN RADIUS	:	.170	.302	.278
MEAN RADIUS	:	.959	.865	.791
MAX RADIUS	:	1.910	1.298	1.217
HORIZONTAL SPREAD	:	3.037	2.441	1.978
VERTICAL SPREAD	:	2.119	1.717	1.717
EXTREME SPREAD	:	3.290	2.448	2.031
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

15 May 1991 FILE:/PATTERNING/CENTERFIRE_PATT/C6811554

CENTERFIRE PATTERNS # 2

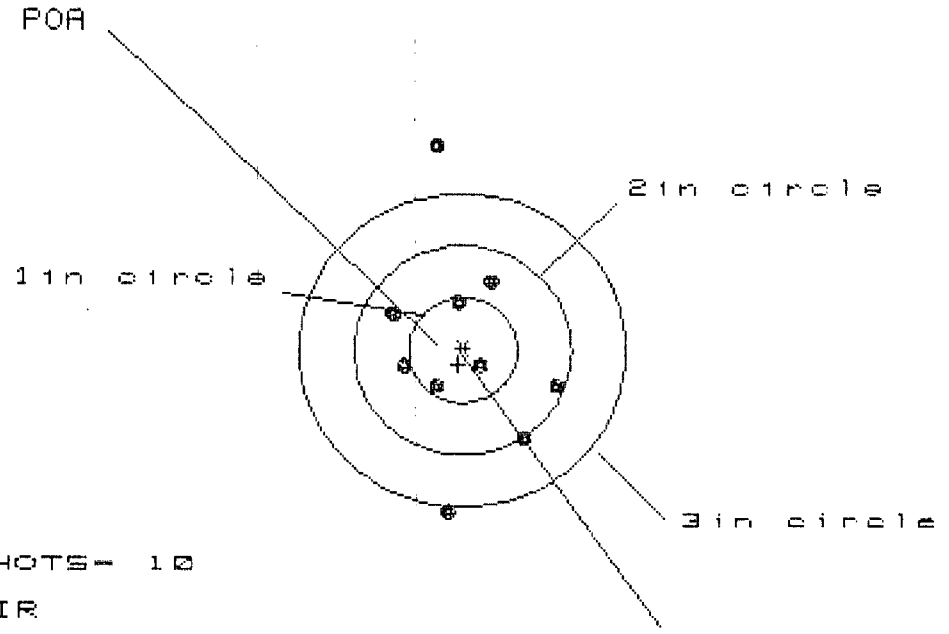


# OF SHOTS= 10
# IN CIR
1in = 4
2in = 8
3in = 9
HS= 2.965
VS= 2.226
GS= 3.695

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.239	1.191	.402
MINIMUM X	:	-.726	-.477	-.328
MAXIMUM Y	:	.555	.370	.395
MINIMUM Y	:	-1.671	-.390	-.344
CENTROID X	:	.214	-.035	-.184
CENTROID Y	:	-.304	-.119	-.165
POA TO CENTROID in.	:	.372	.124	.247
MIN RADIUS	:	.152	.093	.097
MEAN RADIUS	:	.766	.427	.306
MAX RADIUS	:	2.794	1.247	.514
HORIZONTAL SPREAD	:	2.965	1.668	.730
VERTICAL SPREAD	:	2.226	.760	.739
EXTREME SPREAD	:	3.695	1.767	.824
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

15 May 1991 FILE:/PATTERNING/CENTERFIRE_PATT/C6811554

CENTERFIRE PATTERNS # 3

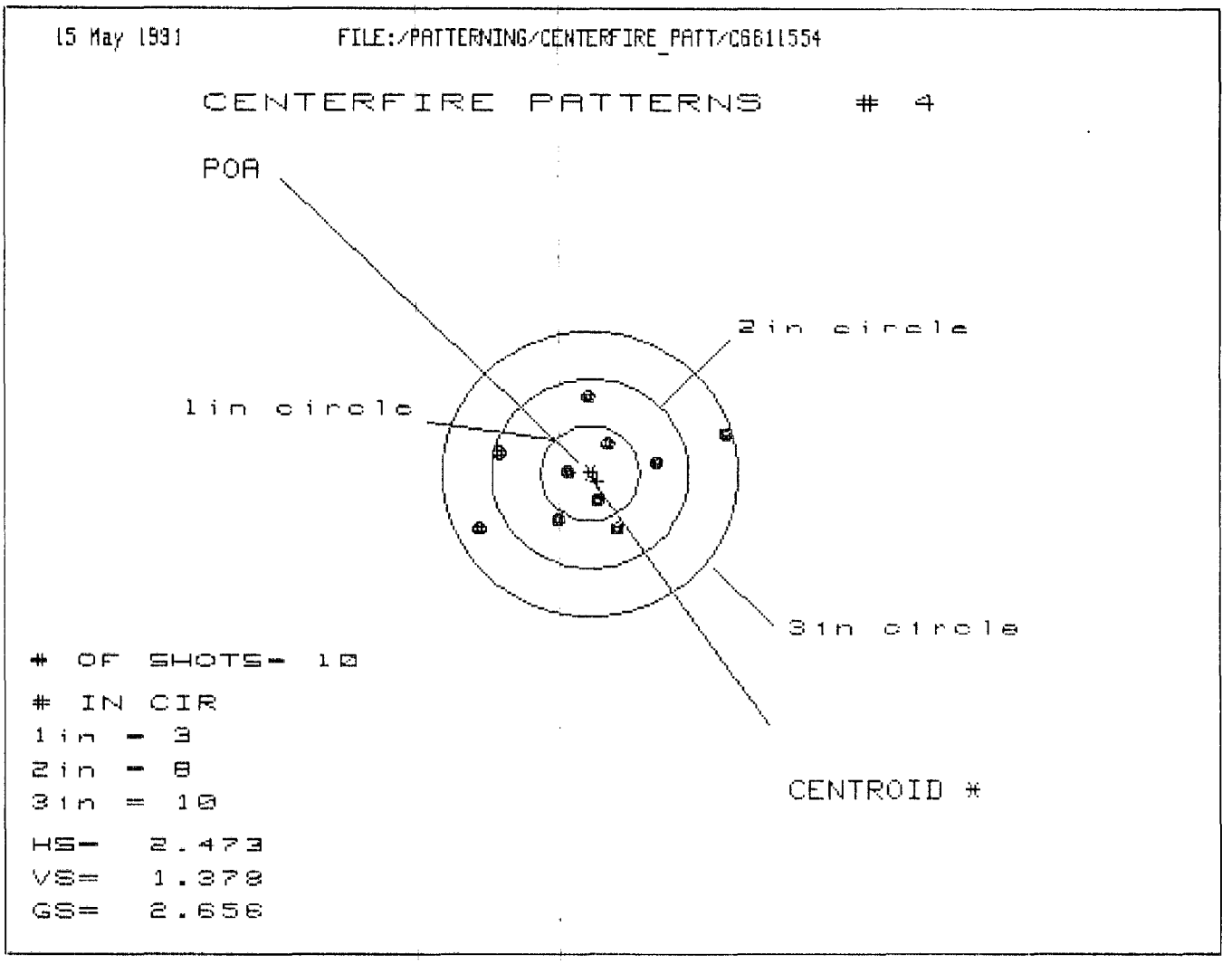


OF SHOTS= 10

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

HS= 1.498
VS= 3.570
GS= 3.574

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.877	.845	.827
MINIMUM X	:	-.621	-.653	-.671
MAXIMUM Y	:	1.999	.861	.693
MINIMUM Y	:	-1.571	-1.349	-.755
CENTROID X	:	.041	.073	.091
CENTROID Y	:	.142	-.080	.088
POA TO CENTROID in.	:	.148	.109	.127
MIN RADIUS	:	.275	.178	.203
MEAN RADIUS	:	.862	.718	.625
MAX RADIUS	:	2.020	1.356	.892
HORIZONTAL SPREAD	:	1.498	1.498	1.498
VERTICAL SPREAD	:	3.570	2.210	1.448
EXTREME SPREAD	:	3.574	2.234	1.683
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		8	



PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.336	.857	.733
MINIMUM X	:	-1.137	-.988	-.886
MAXIMUM Y	:	.798	.845	.783
MINIMUM Y	:	-.580	-.533	-.595
CENTROID X	:	-.074	-.223	-.099
CENTROID Y	:	.082	.035	.097
POA TO CENTROID in.	:	.111	.225	.138
MIN RADIUS	:	.199	.116	.171
MEAN RADIUS	:	.721	.637	.568
MAX RADIUS	:	1.402	1.106	.921
HORIZONTAL SPREAD	:	2.473	1.845	1.619
VERTICAL SPREAD	:	1.378	1.378	1.378
EXTREME SPREAD	:	2.656	1.944	1.631
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	8		
NUMBER IN THREE INCH CIRCLE	=	10		

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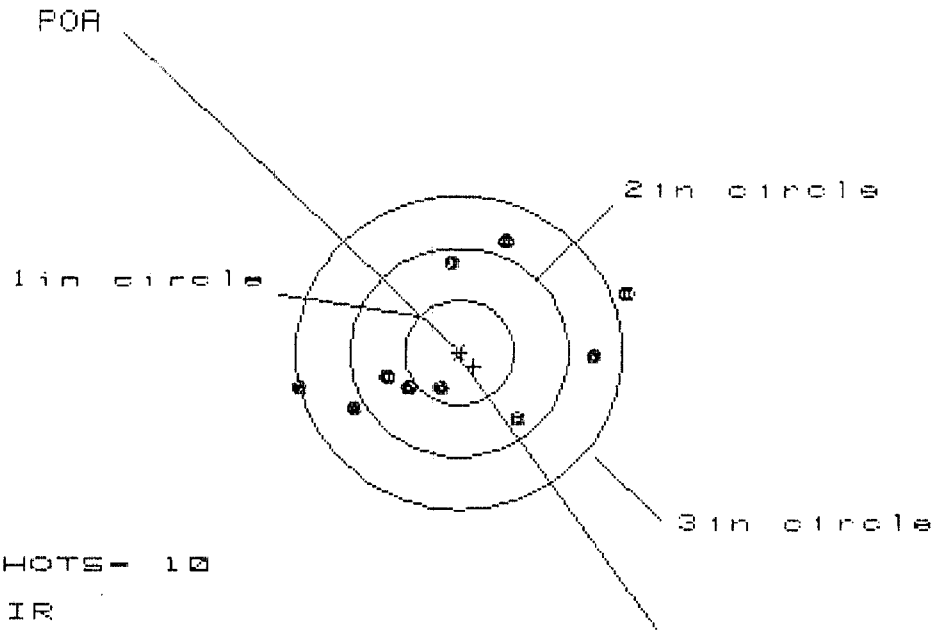
CENTERFIRE PATTERNS # 5



# OF SHOTS= 10
# IN CIR
1in = 1
2in = 5
3in = 9
HS= 2.964
VS= 1.749
GS= 3.115

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.528	1.420	1.262
MINIMUM X	:	-1.436	-1.266	-.962
MAXIMUM Y	:	1.101	1.168	1.131
MINIMUM Y	:	-.647	-.581	-.618
CENTROID X	:	-.134	-.304	-.145
CENTROID Y	:	.137	.070	.107
POA TO CENTROID in.	:	.191	.312	.181
MIN RADIUS	:	.377	.267	.346
MEAN RADIUS	:	.994	.879	.846
MAX RADIUS	:	1.641	1.420	1.263
HORIZONTAL SPREAD	:	2.964	2.686	2.223
VERTICAL SPREAD	:	1.749	1.749	1.749
EXTREME SPREAD	:	3.115	2.700	2.264
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	