C6522170

MODEL 700™ M24

Model SWS ™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

Smead®

M2400003659

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

Remington®

DUPONT
REG. U.S. PAT. & TM. OFF.

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

MODEL 700™ M24

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

SERIAL NO.
C6522170

ORDER NO.
5716

5716 C6522170

UPC
0 47700 25716 7

CAR 15C

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C952170

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		8-21-90	
600	Proof		8-21-90	
607	Check Headspace		8-21-90	
610	Dis-assemble Gun		8-21-90	
612	Magnaflux Barrel Action	New BBL 8/22/90	8/23/90	KCK
	Magnaflux Bolt		8/22/90	KCK
615	Rollmark Caliber		8/23/90	GS
617	Drill and Tap Sight Holes		8/23/90	KB
618	Polish Barrel RB		8/23/90	WB
620	Apply Coatings (Barrel Action)		8-30-90	
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/3/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/3/90	RW
	C) Inspect Ejector Hole for Chamfer		10/3/90	RW
	D) Oil Firing Pin Ass'y		10/3/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/3/90	RW

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			10/4/90	RW
	G) Safety Off Force	3	2.5	2.5			10/4/90	RW
	H) Trigger Pull Test & Retainability						10/3/90	RW
	I) Firing Pin Indent	.022	.021	.022			10/4/90	RW
	J) Assemble Stock						10/5/90	RW
	K) Assemble Swivel Studs						10/30/90	GS
	L) Attach Front and Rear Sight Assemblies						10/5/90	RW
	M) Iron Sight Alignment						10/5/90	RW
	N) Detach Front & Rear Sights & place in numbered container						10/5/90	RW
	O) Attach Scope to Rifle						10/5/90	RW
	P) Detach & Attach Scope 20 Times						10/5/90	RW
640	Gallery Target & Test						10-9-90	DH
	A) Time						10-9-90	DH
	B) Malfunctions						10-9-90	DH
	C) Pierced Primers						10-9-90	DH
	D) Optical Clearity of Scope						10-9-90	DH
645	Inspect for Live Ammo						10-9-90	DH
655	Final Inspection A) Headspace						10/30/90	GS
	B) Trigger Pull	2.27	2.27	2.25	2.26	2.26	10-9-90	DH
	C) Function						10/30/90	GS
660	Pack						12/10/90	JF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6572170

DATE 10/3/90

TESTER [signature]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.57	2.40	2.45	2.37	MIN. SETTING,
PULL #2	2.62	2.43	2.49	2.27	NO AVG. OF 5
PULL #3	2.50	2.44	2.47	2.25	READINGS ACCEPT-
PULL #4	2.59	2.43	2.42	2.26	ABLE LESS THAN 2#
PULL #5	2.54	2.43	2.48	2.26	
TOTAL	12.82	12.13	12.31	11.31	
AVG.	2.56	2.43	2.46	2.262	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.02	3.02		
PULL #2	3.05	3.07		
PULL #3	3.03	3.05		
PULL #4	3.02	3.06		
PULL #5	3.01	3.02		
TOTAL	15.13	15.22		
AVG.	3.03	3.04		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.11	4.05		4.03
PULL #2	4.21	4.03		4.06
PULL #3	4.17	4.06		4.03
PULL #4	4.15	4.04		4.06
PULL #5	4.16	4.05		4.00
TOTAL	20.80	20.23		20.18
AVG.	4.16	4.05		4.04

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522170
9 Oct 1990

CENTROIDAL DISTANCES

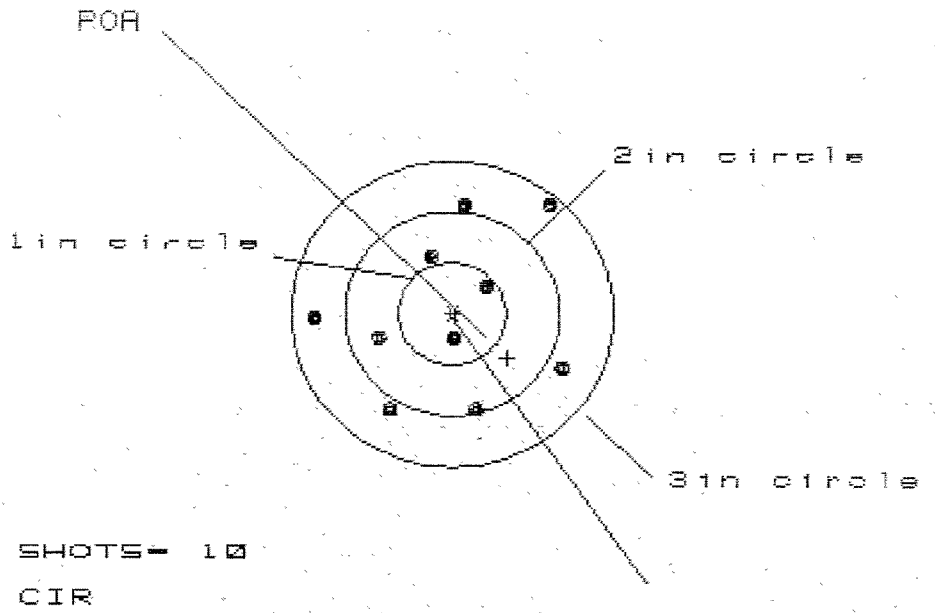
0	TO	1	.673484
1	TO	2	.649346
1	TO	3	.482254
1	TO	4	.796283
1	TO	5	.361831

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1762
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1462
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .228956

THE AMR FOR THIS RIFLE IS: .8926

9 Oct 1998 FILE:/PATTERNING/CENTERFIRE_PATT/C6522170

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

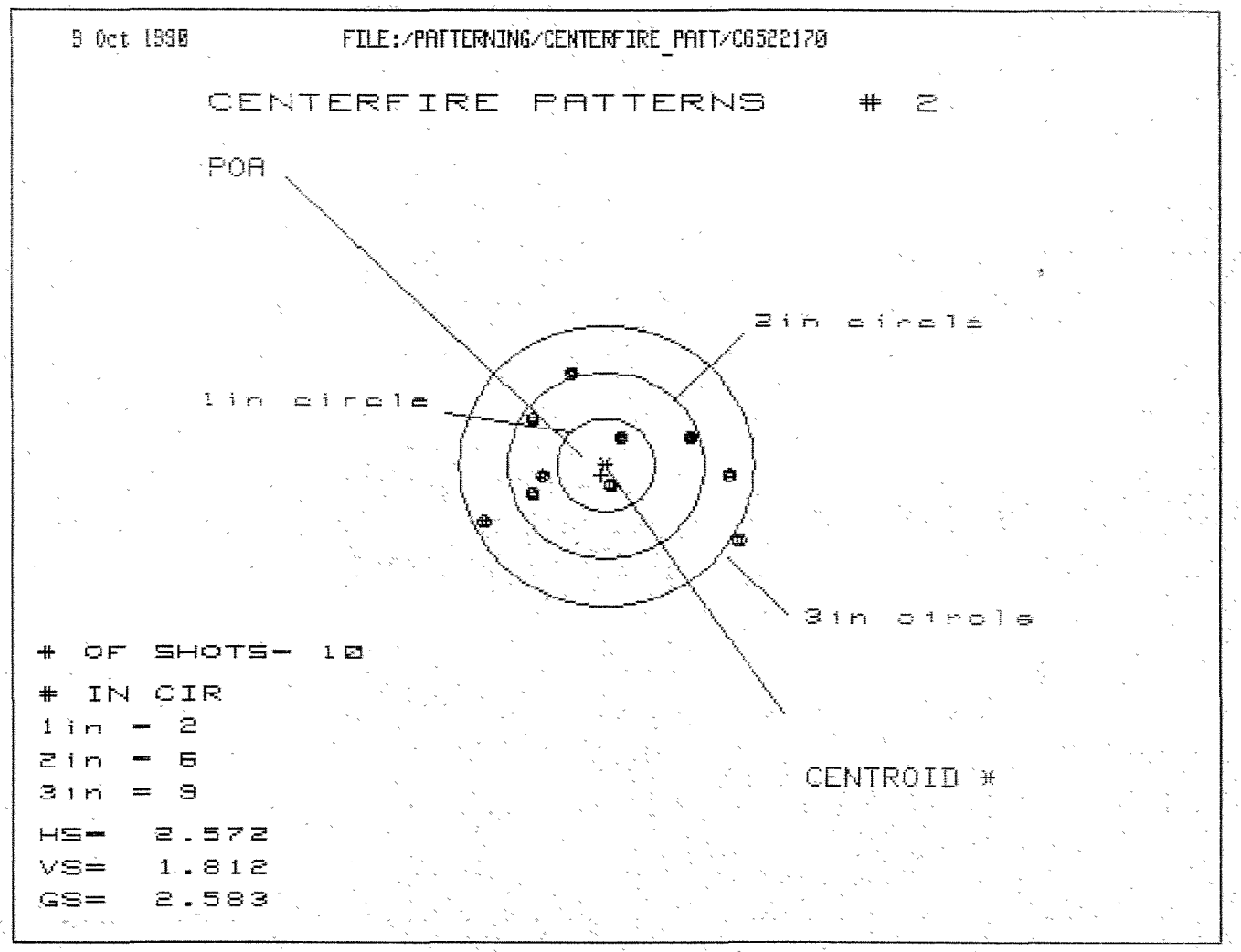
# IN CIR	
1in	2
2in	5
3in	10

HS= 2.278
VS= 1.997
GS= 2.430

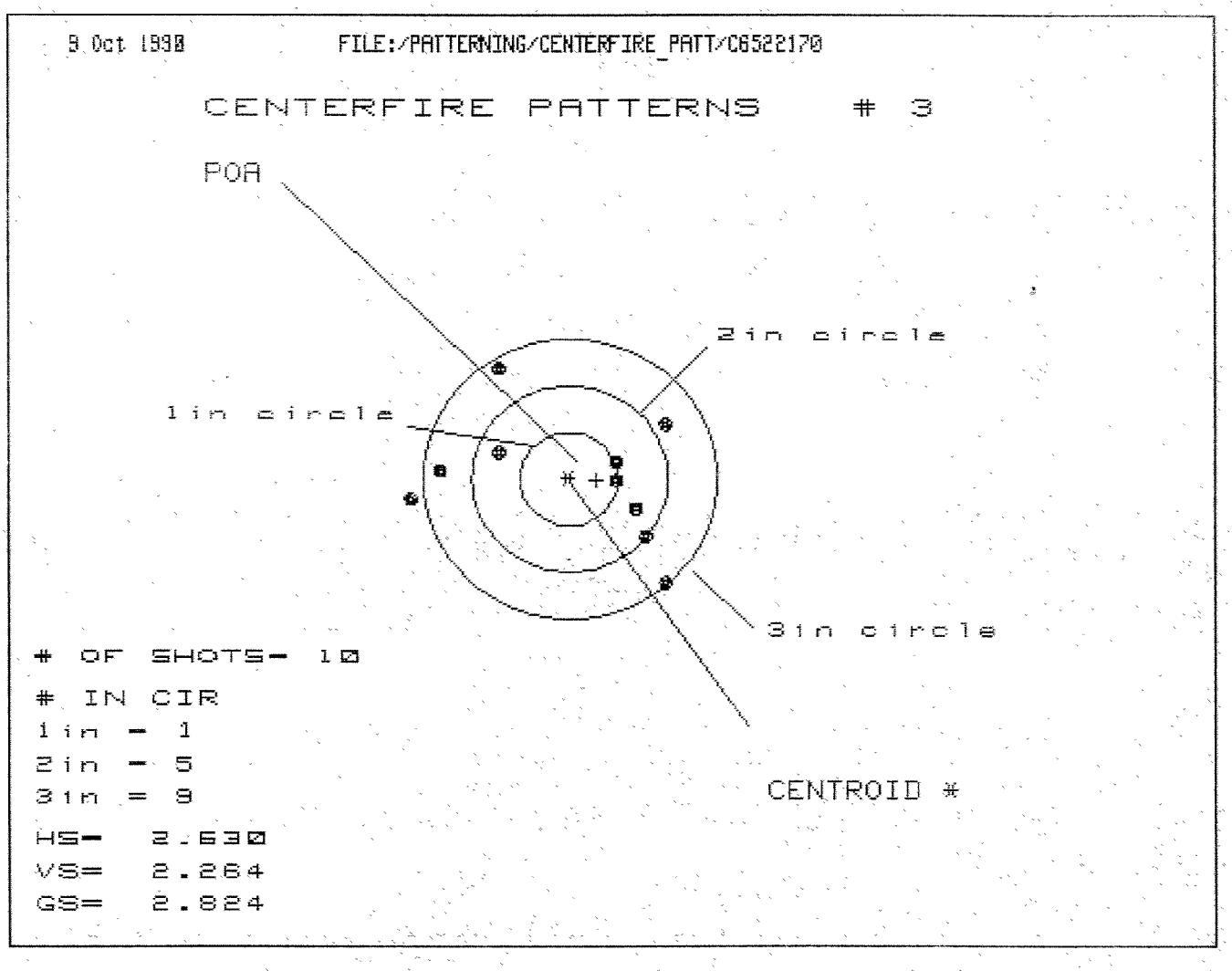
PATTERN # : 1

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.020	1.116	.971
MINIMUM X	:	-1.258	-1.162	-.692
MAXIMUM Y	:	1.046	1.162	1.172
MINIMUM Y	:	-.951	-.835	-.825
CENTROID X	:	-.515	-.611	-.466
CENTROID Y	:	.434	.319	.309
POA TO CENTROID in.	:	.674	.689	.559
MIN RADIUS	:	.288	.228	.157
MEAN RADIUS	:	.885	.823	.768
MAX RADIUS	:	1.357	1.190	1.174
HORIZONTAL SPREAD	:	2.278	2.278	1.663
VERTICAL SPREAD	:	1.997	1.997	1.997
EXTREME SPREAD	:	2.430	2.329	2.083

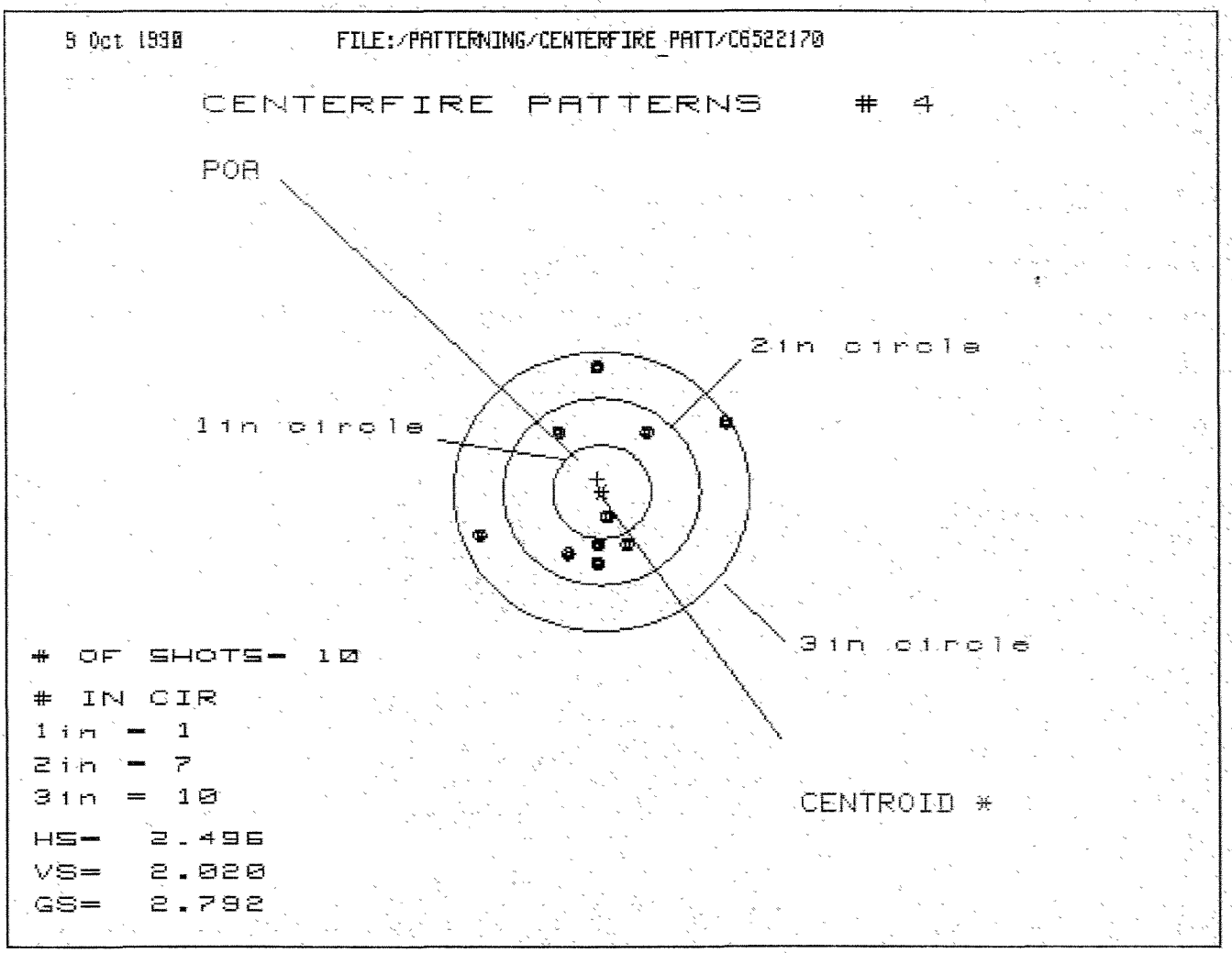
NUMBER IN ONE INCH CIRCLE = 2
NUMBER IN TWO INCH CIRCLE = 5
NUMBER IN THREE INCH CIRCLE = 10



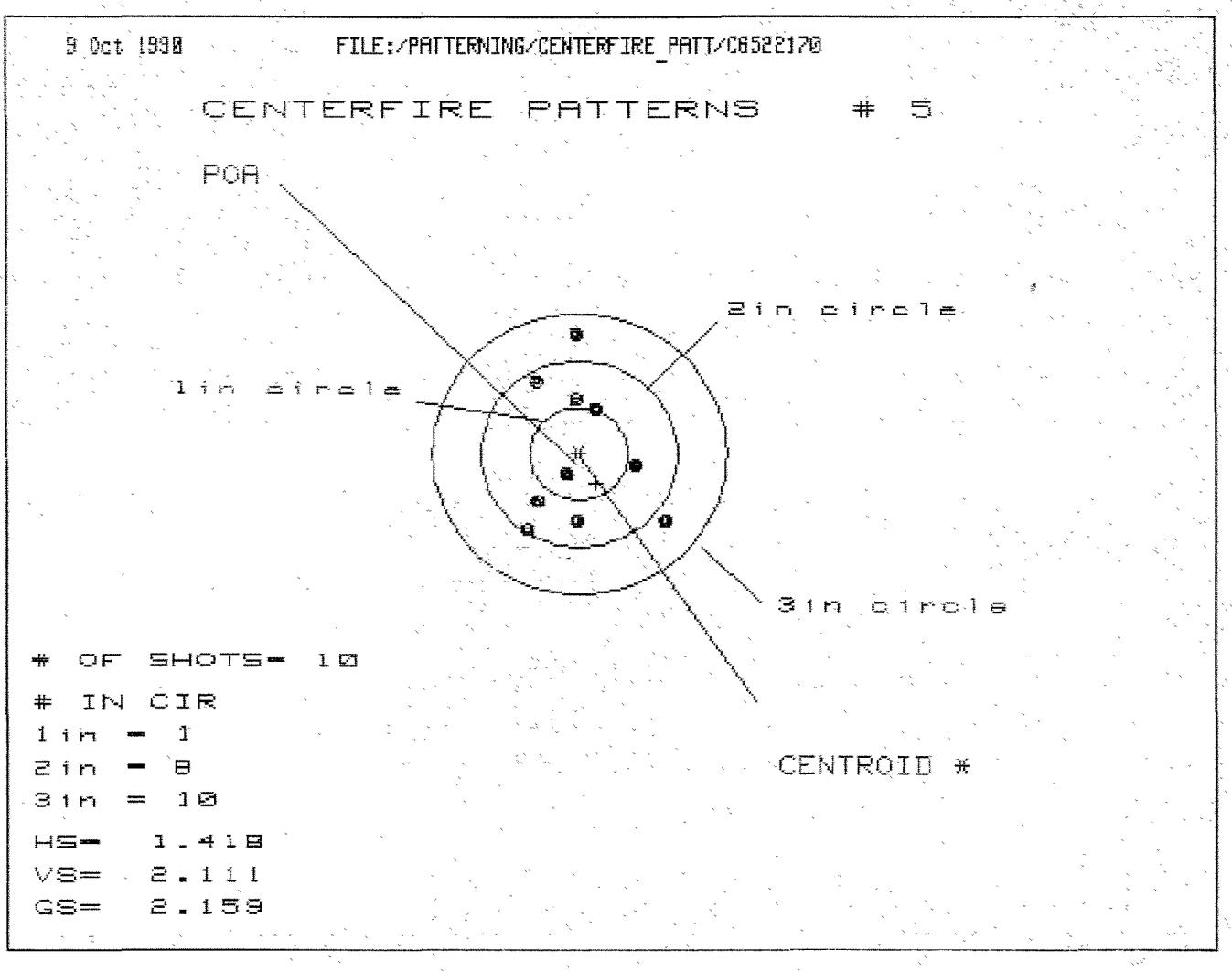
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.363	1.414	1.282
MINIMUM X	:	-1.209	-1.058	-.767
MAXIMUM Y	:	1.004	.915	.832
MINIMUM Y	:	-.808	-.661	-.485
CENTROID X	:	.046	-.105	.027
CENTROID Y	:	.107	.196	.279
POA TO CENTROID in.	:	.116	.223	.280
MIN RADIUS	:	.252	.393	.238
MEAN RADIUS	:	.917	.827	.767
MAX RADIUS	:	1.584	1.429	1.314
HORIZONTAL SPREAD	:	2.572	2.472	2.049
VERTICAL SPREAD	:	1.812	1.576	1.317
EXTREME SPREAD	:	2.583	2.514	2.063
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	



PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.000	.828	.922
MINIMUM X	:	-1.621	-1.477	-1.383
MAXIMUM Y	:	1.186	1.167	1.029
MINIMUM Y	:	-1.078	-1.097	-.813
CENTROID X	:	-.278	-.097	-.191
CENTROID Y	:	.014	.033	.171
POA TO CENTROID in.	:	.278	.103	.256
MIN RADIUS	:	.500	.328	.381
MEAN RADIUS	:	1.045	.933	.901
MAX RADIUS	:	1.631	1.497	1.386
HORIZONTAL SPREAD	:	2.630	2.305	2.305
VERTICAL SPREAD	:	2.264	2.264	1.842
EXTREME SPREAD	:	2.824	2.824	2.377
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	



PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.261	.604	.467
MINIMUM X	:	-1.235	-1.095	-.460
MAXIMUM Y	:	1.292	1.377	1.327
MINIMUM Y	:	-.720	-.643	-.693
CENTROID X	:	.040	-.100	.037
CENTROID Y	:	-.137	-.221	-.171
POA TO CENTROID in.	:	.142	.243	.175
MIN RADIUS	:	.314	.311	.282
MEAN RADIUS	:	.856	.767	.710
MAX RADIUS	:	1.474	1.381	1.328
HORIZONTAL SPREAD	:	2.496	1.699	.927
VERTICAL SPREAD	:	2.020	2.020	2.020
EXTREME SPREAD	:	2.792	2.144	2.020
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	



PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.914	.908	.633
MINIMUM X	:	-.504	-.510	-.396
MAXIMUM Y	:	1.251	.946	.879
MINIMUM Y	:	-.860	-.721	-.788
CENTROID X	:	-.174	-.168	-.282
CENTROID Y	:	.313	.174	.241
POA TO CENTROID in.	:	.358	.242	.371
MIN RADIUS	:	.281	.188	.168
MEAN RADIUS	:	.760	.689	.637
MAX RADIUS	:	1.252	1.054	.932
HORIZONTAL SPREAD	:	1.418	1.418	1.029
VERTICAL SPREAD	:	2.111	1.667	1.667
EXTREME SPREAD	:	2.159	1.991	1.669
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	