

C6498802

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington



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

MODEL 700™ M24

SERIAL NO.

C6498802

ORDER NO.

5716

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

01



5716 C6498802

UPC



0 47700 25716 7

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400008028

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6498802

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	5 9 90		RW
600	Proof	5 9 90		RW
607	Check Headspace	5 9 90		RW
610	Dis-assemble Gun	5 9 90		RW
612	Magnaflux Barrel Action	5-15-90		KeR
	Magnaflux Bolt	5-15-90		KeR
615	Rollmark Caliber	5-15-90		ES
617	Drill and Tap Sight Holes		5/17/90	LB
618	Polish Barrel LB		5/17/90	WB
620	Apply Coatings (Barrel Action)		5-25-90	TA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/25/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/25/90	RW
	C) Inspect Ejector Hole for Chamfer		5/25/90	RW
	D) Oil Firing Pin Ass'y		5/25/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		6/5/90	JH

op. #	OP. NAME	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	4	4	4	6/6/90	SM		
	G) Safety Off Force	2	2	2	6/6/90	SM		
	H) Trigger Pull Test & Retainability				6/5/90	SM		
	I) Firing Pin Indent	.023	.023	.023	6/6/90	SM		
	J) Assemble Stock				6/6/90	RW		
	K) Assemble Swivel Studs				6-8-90	QD		
	L) Attach Front and Rear Sight Assemblies				6/6/90	RW		
	M) Iron Sight Alignment				6/6/90	RW		
	N) Detach Front & Rear Sights & place in numbered container				6/6/90	RW		
	O) Attach Scope to Rifle				6/6/90	WB		
	P) Detach & Attach Scope 20 Times				6/6/90	WB		
640	Gallery Target & Test				6-7-90	AC		
	A) Time				6-7-90	AC		
	B) Malfunctions				6-7-90	AC		
	C) Pierced Primers				6-7-90	AC		
	D) Optical Clarity of Scope				6-7-90	AC		
645	Inspect for Live Ammo				6-7-90	AC		
655	Final Inspection				6-8-90	QD		
	A) Headspace				6-8-90	QD		
	B) Trigger Pull	246	244	236	240	244	6-8-90	QD
	C) Function						6-8-90	QD
660	Pack						6-9-90	D/H

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. 06498802

DATE 6-5-90

TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.30	2.43	2.46	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.50	2.31	2.45	2.44	
PULL #3	2.32	2.37	2.35	2.36	
PULL #4	2.33	2.36	2.30	2.40	
PULL #5	2.30	2.36	2.36	2.44	
TOTAL	11.88	11.70	11.89		
AVG.	2.376	2.34	2.378		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.24	3.49		
PULL #2	3.43	3.35		
PULL #3	3.24	3.45		
PULL #4	3.34	3.36		
PULL #5	3.31	3.26		
TOTAL	16.56	16.89		
AVG.	3.312	3.378		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.20	4.32		4.27
PULL #2	4.12	4.26		4.46
PULL #3	4.39	4.33		4.49
PULL #4	4.43	4.29		4.33
PULL #5	4.33	4.20		4.23
TOTAL	21.47	21.39		21.78
AVG.	4.294	4.278		4.356

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6498802
7 Jun 1990

CENTROIDAL DISTANCES

0 TO	1	.271301
1 TO	2	.518047
1 TO	3	.63905
1 TO	4	.347908
1 TO	5	.240169

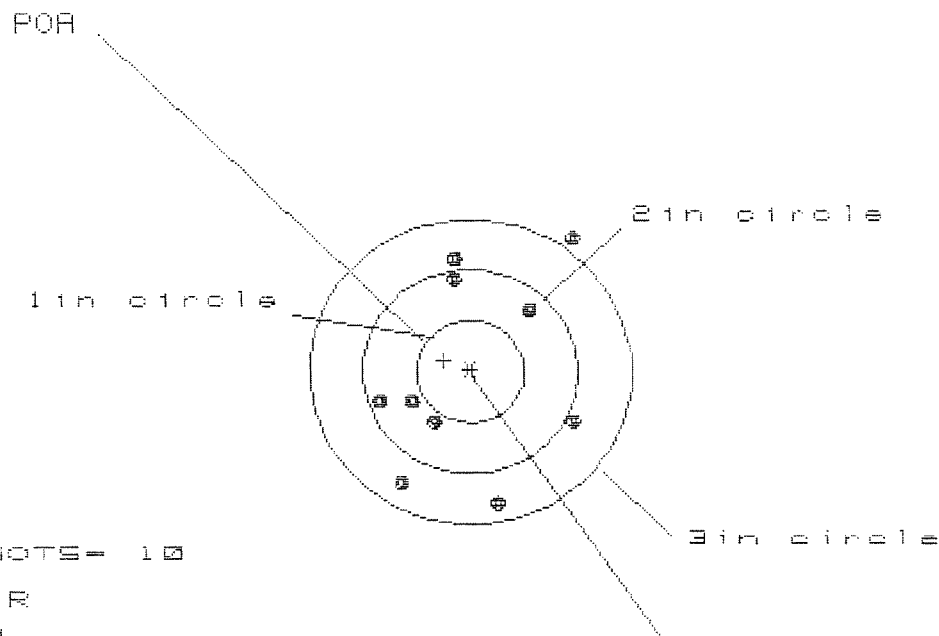
$\bar{x}_2$ <----POA
2

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .3264
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2582
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .416178
THE AMR FOR THIS RIFLE IS: .9082

7 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6496882

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 0

2in = 5

3in = 9

HS= 1.747

VS= 2.631

GS= 2.818

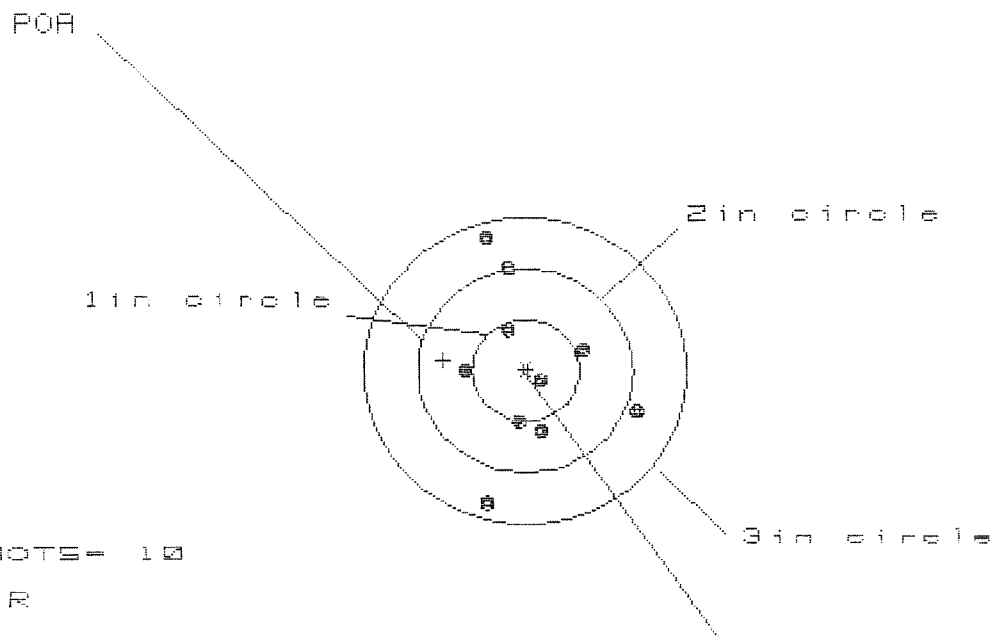
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.924	1.026	1.071
MINIMUM X	-.823	-.721	-.676
MAXIMUM Y	1.321	1.284	1.139
MINIMUM Y	-1.310	-1.163	-1.044
CENTROID X	.248	.146	.101
CENTROID Y	-.110	-.257	-.112
POR TO CENTROID in.	.272	.296	.151
MIN RADIUS	.633	.454	.521
MEAN RADIUS	1.025	.930	.890
MAX RADIUS	1.611	1.286	1.187
HORIZONTAL SPREAD	1.747	1.747	1.747
VERTICAL SPREAD	2.631	2.447	2.183
EXTREME SPREAD	2.818	2.483	2.228
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

7 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6498882

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 10

HS= 1.614

VS= 2.599

GS= 2.599

CENTROID #

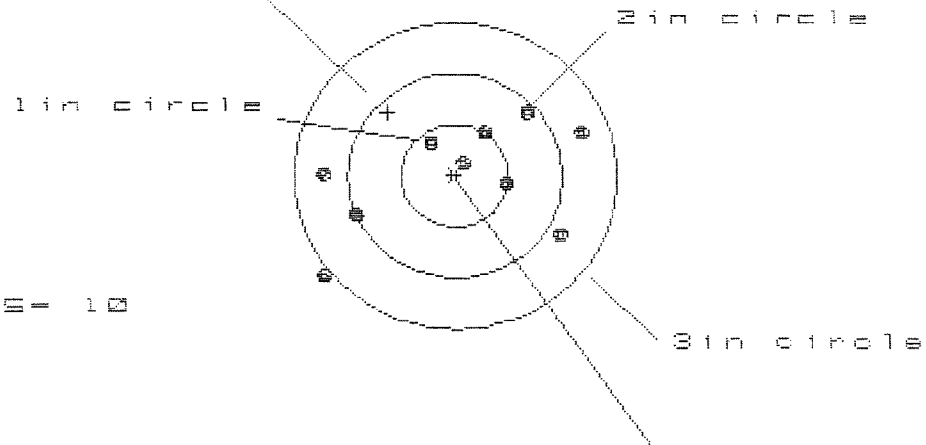
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.027	.983	.931
MINIMUM X	:	-.587	-.631	-.683
MAXIMUM Y	:	1.284	1.138	.988
MINIMUM Y	:	-1.315	-.724	-.582
CENTROID X	:	.766	.810	.862
CENTROID Y	:	-.103	.043	-.099
POA TO CENTROID in.	:	.772	.811	.868
MIN RADIUS	:	.105	.208	.062
MEAN RADIUS	:	.764	.700	.609
MAX RADIUS	:	1.375	1.212	1.027
HORIZONTAL SPREAD	:	1.614	1.614	1.614
VERTICAL SPREAD	:	2.599	1.862	1.570
EXTREME SPREAD	:	2.599	2.187	1.841
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

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FILE:/PATTERNING/CENTERFIRE_PATT/C8496882

CENTERFIRE PATTERNS # 3

FOR



OF SHOTS= 10

IN CIR

1in = 4

2in = 5

3in = 9

HS= 2.417

VS= 1.576

GS= 2.791

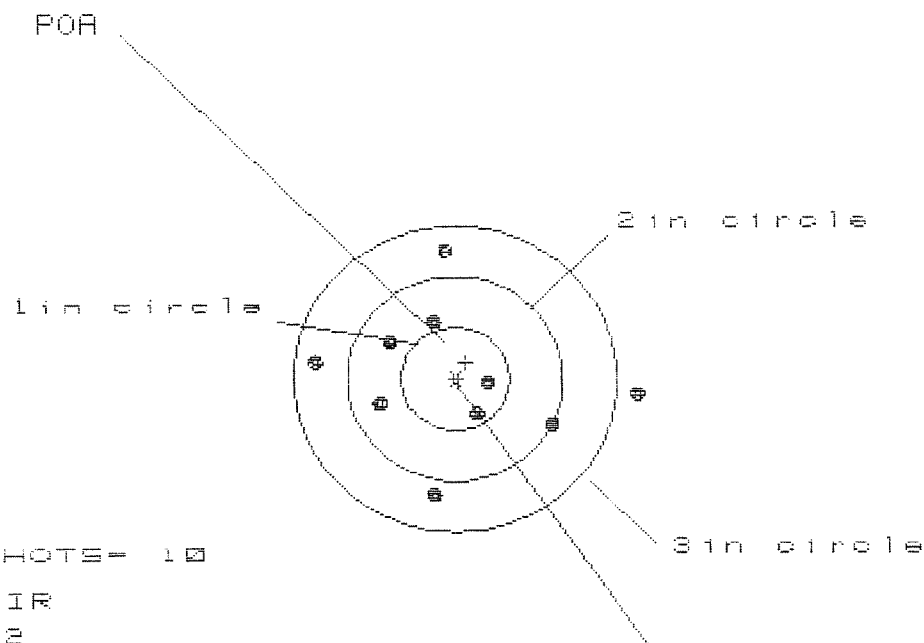
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.180	1.042	.977
MINIMUM X	:	-1.237	-1.344	-1.214
MAXIMUM Y	:	.623	.517	.559
MINIMUM Y	:	-.953	-.647	-.685
CENTROID X	:	.625	.763	.633
CENTROID Y	:	-.626	-.520	-.562
FOR TO CENTROID in.	:	.885	.923	.846
MIN RADIUS	:	.111	.078	.061
MEAN RADIUS	:	.863	.748	.710
MAX RADIUS	:	1.562	1.345	1.214
HORIZONTAL SPREAD	:	2.417	2.386	2.191
VERTICAL SPREAD	:	1.576	1.164	1.164
EXTREME SPREAD	:	2.791	2.417	2.271
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

7 Jun 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C0498882

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS= 3.075

VS= 2.426

GS= 3.094

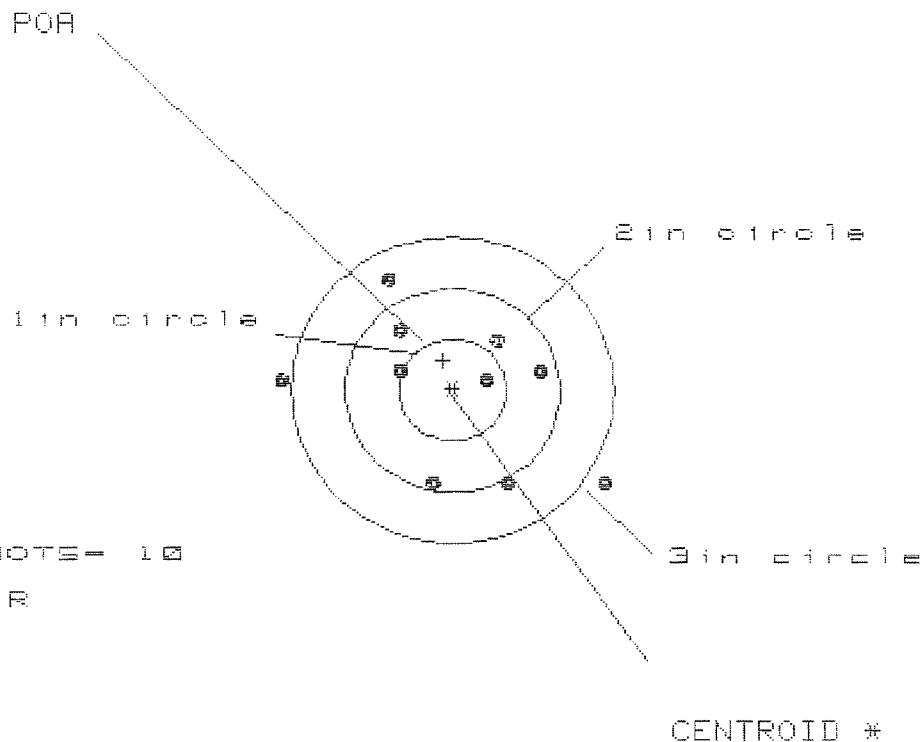
CENTROID *

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.731	1.132	.988
MINIMUM X	-1.344	-1.152	-.678
MAXIMUM Y	1.273	1.254	1.273
MINIMUM Y	-1.153	-1.172	-1.153
CENTROID X	-.096	-.288	-.144
CENTROID Y	-.162	-.143	-.162
POA TO CENTROID in.	.188	.322	.217
MIN RADIUS	.311	.488	.359
MEAN RADIUS	.932	.831	.778
MAX RADIUS	1.739	1.260	1.273
HORIZONTAL SPREAD	3.075	2.284	1.666
VERTICAL SPREAD	2.426	2.426	2.426
EXTREME SPREAD	3.094	2.430	2.430
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

7 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C643B802

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 8

HS = 3.032

VS = 2.042

GS = 3.195

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.413	.950	.767
MINIMUM X	:	-1.619	-1.462	-.643
MAXIMUM Y	:	1.098	.993	.988
MINIMUM Y	:	-.944	-.995	-1.000
CENTROID X	:	.089	-.068	.115
CENTROID Y	:	-.290	-.185	-.180
POA TO CENTROID in.	:	.303	.197	.213
MIN RADIUS	:	.299	.338	.262
MEAN RADIUS	:	.957	.864	.766
MAX RADIUS	:	1.699	1.463	1.178
HORIZONTAL SPREAD	:	3.032	2.412	1.410
VERTICAL SPREAD	:	2.042	1.988	1.988
EXTREME SPREAD	:	3.195	2.418	2.382
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	