

C6498811

MODEL 700TM M24

Model SWS TM

Action _____

Barrel Length _____

Capacity _____

Order No. 5716

*Includes 1 in chamber.

Remington

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6498811

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		KER
617	Drill and Tap Sight Holes		5/17/90	LB
618	Polish Barrel RB		5/17/90	WB
620	Apply Coatings (Barrel Action)		5-25-90	JA
	Apply Coating (Bolt)		5	JA
625	Final Assembly A) Clean inside of Bolt Assembly		5/30/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/90	RW
	C) Inspect Ejector Hole for Chamfer		5/30/90	RW
	D) Oil Firing Pin Ass'y		5/30/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		6-1-90	JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/4	4 1/4	4 1/4			6/7/90	WB
	G) Safety Off Force	2	2	2			6/7/90	WB
	H) Trigger Pull Test & Retainability						6-1-90	SM
	I) Firing Pin Indent	.025	.025	.025			6/7/90	WB
	J) Assemble Stock						7/13/90	RW
	K) Assemble Swivel Studs						8/20/90	DS
	L) Attach Front and Rear Sight Assemblies						7/13/90	RW
	M) Iron Sight Alignment						7/13/90	RW
	N) Detach Front & Rear Sights & place in numbered container						7/13/90	RW
	O) Attach Scope to Rifle						7/27/90	SM
	P) Detach & Attach Scope 20 Times						7/27/90	SM
640	Gallery Target & Test						7-31-90	AC
	A) Time						7-31-90	AC
	B) Malfunctions						7-31-90	AC
	C) Pierced Primers						7-31-90	AC
	D) Optical Clarity of Scope						7-31-90	AC
645	Inspect for Live Ammo						7-31-90	AC
655	Final Inspection						8/20/90	DS
	A) Headspace							
	B) Trigger Pull	2.50	2.43	2.50	2.46	2.51	8/23/90	SM
	C) Function						8/27/90	DS
660	Pack						9/19/90	AF

SWS TRIGGER PULL TEST

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

SERIAL NO. 66498811

DATE 6/1/90

TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.29	2.27	2.43	2.50	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.45	2.33	2.34	2.43	
PULL #3	2.29	2.26	2.30	2.50	
PULL #4	2.24	2.21	2.20	2.46	
PULL #5	2.32	2.30	2.24	2.51	
TOTAL	11.59	11.37	11.51	12.40	
AVG.	2.318	2.274	2.302	2.48	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.44	3.28		
PULL #2	3.54	3.32		
PULL #3	3.31	3.12		
PULL #4	3.34	3.30		
PULL #5	3.33	3.32		
TOTAL	16.96	16.34		
AVG.	3.392	3.268		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.46	4.43		4.29
PULL #2	4.47	4.48		4.48
PULL #3	4.44	4.50		4.47
PULL #4	4.48	4.13		4.53
PULL #5	4.55	4.52		4.46
TOTAL	22.40	22.06		22.23
AVG.	4.48	4.412		4.446

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6498811
1 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.460314
1 TO	2	.41824
1 TO	3	.635687
1 TO	4	.720535
1 TO	5	.413386

Fig 1 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0424
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0936
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .102756
THE AMR FOR THIS RIFLE IS: .7142

1 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/

08498811

C6498811

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 9

HS= 1.645

VS= 2.382

GS= 2.386

CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.761	.830	.772
MINIMUM X	:	-.884	-.815	-.712
MAXIMUM Y	:	.866	.697	.494
MINIMUM Y	:	-1.516	-.964	-.877
CENTROID X	:	.460	.391	.288
CENTROID Y	:	.017	.186	.099
POA TO CENTROID in.	:	.461	.433	.304
MIN RADIUS	:	.292	.233	.161
MEAN RADIUS	:	.749	.613	.518
MAX RADIUS	:	1.639	1.084	1.000
HORIZONTAL SPREAD	:	1.645	1.645	1.484
VERTICAL SPREAD	:	2.382	1.661	1.371
EXTREME SPREAD	:	2.386	1.787	1.534
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

1 Aug 1998

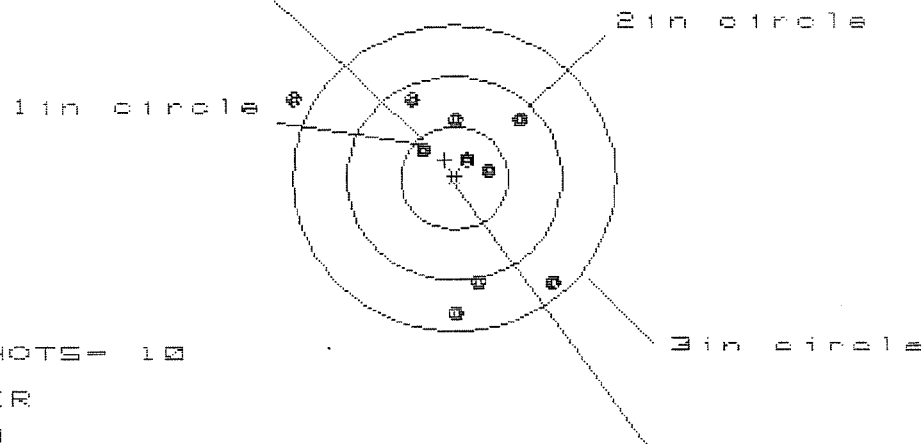
FILE:/PATTERNING/CENTERFIRE_PATT/

08498811

CENTERFIRE PATTERNS

2

POB



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 8

HS= 2.326

VS= 2.154

GS= 2.904

CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.865	.703	.681
MINIMUM X	:	-1.461	-.509	-.530
MAXIMUM Y	:	.823	.906	.750
MINIMUM Y	:	-1.331	-1.248	-1.065
CENTROID X	:	.090	.252	.274
CENTROID Y	:	-.178	-.261	-.105
POB TO CENTROID in.	:	.199	.363	.293
MIN RADIUS	:	.199	.252	.135
MEAN RADIUS	:	.856	.768	.654
MAX RADIUS	:	1.640	1.260	1.265
HORIZONTAL SPREAD	:	2.326	1.212	1.212
VERTICAL SPREAD	:	2.154	2.154	1.815
EXTREME SPREAD	:	2.904	2.182	2.182
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

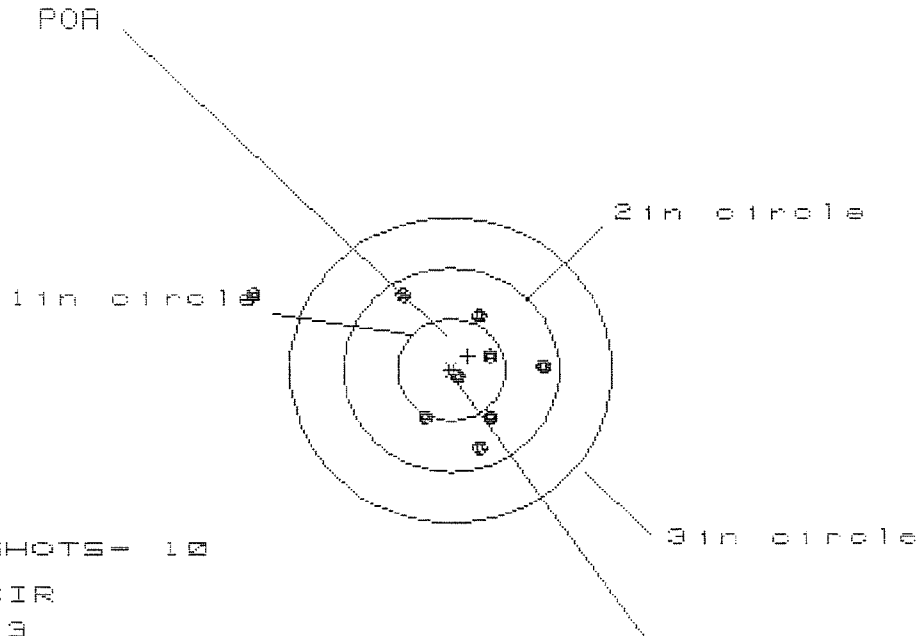
1 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/

08498811

CENTERFIRE PATTERNS

3



OF SHOTS- 10

IN CIR

1in = 3

2in = 3

3in = 4

HS= 2.617

VS= 1.464

GS= 2.710

CENTROID *

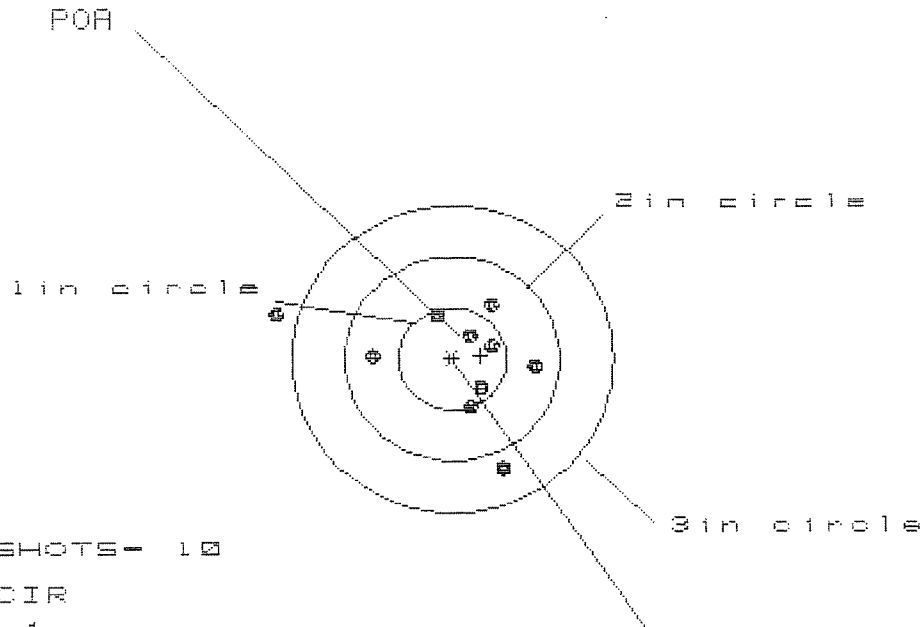
PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.810	.610	.530
MINIMUM X	-1.806	-.637	-.555
MAXIMUM Y	.720	.798	.726
MINIMUM Y	-.744	-.666	-.567
CENTROID X	-.157	.044	.124
CENTROID Y	-.136	-.214	-.313
POA TO CENTROID in.	.207	.218	.337
MIN RADIUS	.038	.195	.269
MEAN RADIUS	.706	.527	.448
MAX RADIUS	1.937	1.021	.727
HORIZONTAL SPREAD	2.617	1.247	1.085
VERTICAL SPREAD	1.464	1.464	1.293
EXTREME SPREAD	2.710	1.638	1.294
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		9	

1 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/

06498811

CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in = 4

2 in = 8

3 in = 9

HS = 0.4000

VS = 1.584

GS = 2.564

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.767	.586	.620
MINIMUM X	-1.633	-.916	-.882
MAXIMUM Y	.525	.574	.447
MINIMUM Y	-1.059	-1.010	-.556
CENTROID X	-.259	-.078	-.112
CENTROID Y	-.030	-.079	.048
POA TO CENTROID in.	.261	.111	.121
MIN RADIUS	.323	.240	.184
MEAN RADIUS	.706	.559	.482
MAX RADIUS	1.690	1.046	.883
HORIZONTAL SPREAD	2.400	1.502	1.502
VERTICAL SPREAD	1.584	1.584	1.003
EXTREME SPREAD	2.564	1.630	1.507
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	9		

1 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/

05498811

CENTERFIRE PATTERNS

5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 4

2 in = 9

3 in = 10

HS= 1.293

VS= 1.605

GS= 1.628

CENTROID #

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.625

.591

.510

MINIMUM X

-.668

-.702

-.628

MAXIMUM Y

.523

.403

.339

MINIMUM Y

-1.082

-.509

-.385

CENTROID X

.078

.112

.038

CENTROID Y

-.141

-.021

.043

POA TO CENTROID in.

.161

.114

.057

MIN RADIUS

.227

.178

.266

MEAN RADIUS

.554

.468

.419

MAX RADIUS

1.123

.780

.639

HORIZONTAL SPREAD

1.293

1.293

1.138

VERTICAL SPREAD

1.605

.912

.724

EXTREME SPREAD

1.628

1.419

1.205

NUMBER IN ONE INCH CIRCLE =

4

NUMBER IN TWO INCH CIRCLE =

9

NUMBER IN THREE INCH CIRCLE =

10

Remington



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

MODEL 700™ M24

SERIAL NO.

C6498811

ORDER NO.

5716

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

01



5716 C6498811

UPC



0 47700 25716 7

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400008194