

C6498863

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

\*Includes 1 in chamber.



M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6498863

| OP. #        | OP. NAME                                                       | READINGS | DATE    | INIT |
|--------------|----------------------------------------------------------------|----------|---------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   | 6 29     | 90      | RW   |
| 600          | Proof                                                          | 6 29     | 90      | RW   |
| 607          | Check Headspace                                                | 6 29     | 90      | RW   |
| 610          | Dis-assemble Gun                                               | 6 29     | 90      | RW   |
| 612          | Magnaflux Barrel<br>Action                                     |          | 7-12-90 | KR   |
|              | Magnaflux Bolt                                                 |          | 7-12-90 | KR   |
| 615          | Rollmark Caliber                                               |          | 7-12-90 | GL   |
| 617          | Drill and Tap Sight Holes                                      |          | 7-13-90 | LB   |
| 618          | Polish Barrel AB                                               |          | 7-16-90 | WB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 7-23-90 | JA   |
|              | Apply Coating (Bolt)                                           |          |         |      |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 8/14/90 | KS   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 8/14/90 | KS   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 8/14/90 | KS   |
|              | D) Oil Firing Pin Ass'y                                        |          | 8/14/90 | KS   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 8/15/90 | SH   |

| op. #        | OP. NAME                                                    | READINGS |      |      |      |      | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|------|------|------|------|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 4        | 4    | 4    |      |      | 7/30/90 | 928  |
|              | G) Safety Off Force                                         | 3        | 3    | 3    |      |      | 7/30/90 | 928  |
|              | H) Trigger Pull Test & Retainability                        |          |      |      |      |      | 8/15/90 | 928  |
|              | I) Firing Pin Indent                                        | .023     | .023 | .023 |      |      | 7/30/90 | 928  |
|              | J) Assemble Stock                                           |          |      |      |      |      | 8/15/90 | KS   |
|              | K) Assemble Swivel Studs                                    |          |      |      |      |      | 8/15/90 | KS   |
|              | L) Attach Front and Rear Sight Assemblies                   |          |      |      |      |      | 8/15/90 | KS   |
|              | M) Iron Sight Alignment                                     |          |      |      |      |      | 8/15/90 | KS   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |      |      |      |      | 8/15/90 | KS   |
|              | O) Attach Scope to Rifle                                    |          |      |      |      |      | 8/15/90 | KS   |
|              | P) Detach & Attach Scope 20 Times                           |          |      |      |      |      | 8/15/90 | KS   |
| 640          | Gallery Target & Test                                       |          |      |      |      |      | 8-16-90 | KJ   |
|              | A) Time                                                     |          |      |      |      |      | 8-16-90 | KJ   |
|              | B) Malfunctions                                             |          |      |      |      |      | 8-16-90 | KJ   |
|              | C) Pierced Primers                                          |          |      |      |      |      | 8-16-90 | KJ   |
|              | D) Optical Clarity of Scope                                 |          |      |      |      |      | 8-16-90 | KJ   |
| 645          | Inspect for Live Ammo                                       |          |      |      |      |      | 8-16-90 | KJ   |
| 655          | Final Inspection                                            |          |      |      |      |      | 8/29/90 | 928  |
|              | A) Headspace                                                |          |      |      |      |      | 8/29/90 | 928  |
|              | B) Trigger Pull                                             | 2.55     | 2.54 | 2.50 | 2.19 | 2.18 | 8/21/90 | 928  |
|              | C) Function                                                 |          |      |      |      |      | 8/29/90 | 928  |
| 660          | Pack                                                        |          |      |      |      |      | 9/20/90 | NF   |

SWS TRIGGER PULL TEST

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

SERIAL NO. C6498863  
DATE 8/15/90  
TESTER g21

|         | 2.50#<br>INITIAL       | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |                      | COMMENTS                                                               |
|---------|------------------------|--------------------------|--------------------------------|----------------------|------------------------------------------------------------------------|
| PULL #1 | <sup>1 2</sup><br>2.34 | <sup>3</sup><br>2.36     | <sup>1</sup><br>2.40           | <sup>2</sup><br>2.55 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.37                   | 2.33                     | 2.36                           | 2.54                 |                                                                        |
| PULL #3 | 2.44                   | 2.36                     | 2.39                           | 2.50                 |                                                                        |
| PULL #4 | 2.35                   | 2.39                     | 2.33                           | 2.19                 |                                                                        |
| PULL #5 | 2.34                   | 2.38                     | 2.30                           | 2.18                 |                                                                        |
| TOTAL   | 11.84                  | 11.82                    | 11.78                          | 11.96                |                                                                        |
| AVG.    | 2.368                  | 2.364                    | 2.356                          | 2.392                |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.14             | 3.33                     |  |          |
| PULL #2 | 3.18             | 3.30                     |  |          |
| PULL #3 | 3.25             | 3.33                     |  |          |
| PULL #4 | 3.25             | 3.36                     |  |          |
| PULL #5 | 3.33             | 3.40                     |  |          |
| TOTAL   | 16.07            | 16.72                    |  |          |
| AVG.    | 3.214            | 3.344                    |  |          |

|         | 4.00#<br>INITIAL | 4.00# AFTER<br>20 CYCLES | MAX SETTING<br>GREATER THAN 4# | RESET TO 4# FOR<br>TARGET & ACCURACY |
|---------|------------------|--------------------------|--------------------------------|--------------------------------------|
| PULL #1 | 4.10             | 4.46                     |                                | 4.21                                 |
| PULL #2 | 4.21             | 4.49                     |                                | 4.25                                 |
| PULL #3 | 4.24             | 4.20                     |                                | 4.34                                 |
| PULL #4 | 4.22             | 4.25                     |                                | 4.37                                 |
| PULL #5 | 4.30             | 4.30                     |                                | 4.36                                 |
| TOTAL   | 21.07            | 21.70                    |                                | 21.53                                |
| AVG.    | 4.214            | 4.34                     |                                | 4.306                                |

| TEST INIT. ACTION TO CORRECT |                    | ASSEM.<br># |
|------------------------------|--------------------|-------------|
| PROOF                        | Adjust Mac-<br>BOX | 8/16        |
| TEST ✓                       |                    | 90          |
| TGT                          |                    | RW          |
| PROOF                        | OK<br>[Signature]  |             |
| TEST                         |                    |             |
| TGT                          |                    |             |
| PROOF                        | ENGINEER           |             |
| TEST                         |                    |             |
| TGT                          |                    |             |
| PROOF                        | ENGINEER           |             |
| TEST                         |                    |             |
| TGT                          |                    |             |

| MOD. _____ |      | GA.<br>CAL. _____  | GUN<br># _____ |
|------------|------|--------------------|----------------|
| #<br>TEST  | DATE | MALFUNCTION/DEFECT | ASSEM.<br>#    |
|            | 1st  | TIGHT mag Box      |                |
|            |      |                    |                |
|            | 2nd  |                    |                |
|            |      |                    |                |
|            | 3rd  |                    |                |
|            |      |                    |                |
|            | 4th  |                    |                |
|            |      |                    |                |
|            |      | FUNCTION           | RD 6654 Rev 1  |

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER  
KINZER V. REMINGTON

M240000915

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # 06498863  
17 Aug 1990

CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| 0 TO | 1 | .503123 |
| 1 TO | 2 | .611138 |
| 1 TO | 3 | 1.04638 |
| 1 TO | 4 | 1.6548  |
| 1 TO | 5 | 1.05784 |

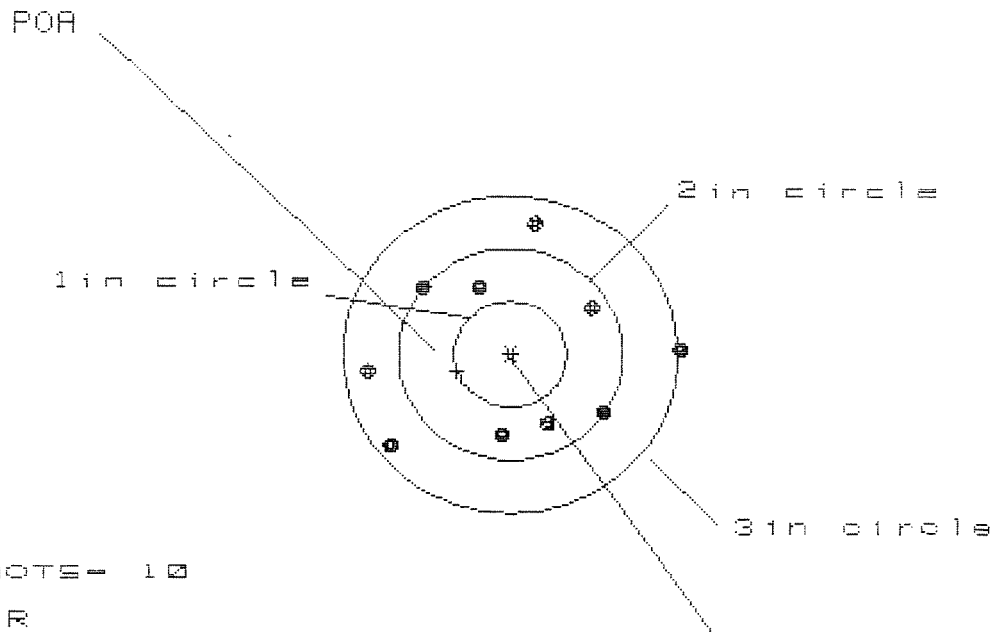
3 2 1 <----POA  
4 5

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0292  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.3086  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .389978  
THE AMR FOR THIS RIFLE IS: 1.075

17 Aug 1938

FILE:/PATTERNING/CENTERFIRE\_PATT/06498863

# CENTERFIRE PATTERNS # 1



# OF SHOTS - 10

# IN CIR

1 in = 0

2 in = 5

3 in = 8

HS = 2.751

VS = 2.106

GS = 2.759

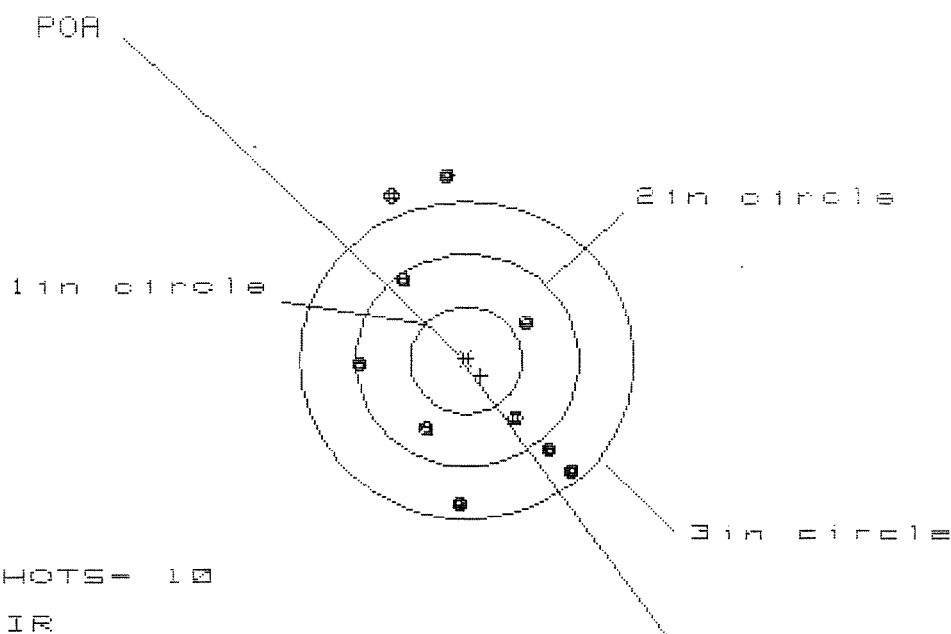
CENTROID \*

|                             |   |        |        |        |
|-----------------------------|---|--------|--------|--------|
| PATTERN #                   | : | 1      |        |        |
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.512  | .955   | .840   |
| MINIMUM X                   | : | -1.239 | -1.071 | -1.186 |
| MAXIMUM Y                   | : | 1.277  | 1.281  | 1.178  |
| MINIMUM Y                   | : | -.829  | -.825  | -.860  |
| CENTROID X                  | : | .478   | .310   | .425   |
| CENTROID Y                  | : | .157   | .153   | .256   |
| POA TO CENTROID in.         | : | .503   | .346   | .496   |
| MIN RADIUS                  | : | .701   | .643   | .588   |
| MEAN RADIUS                 | : | 1.049  | .989   | .948   |
| MAX RADIUS                  | : | 1.512  | 1.341  | 1.219  |
| HORIZONTAL SPREAD           | : | 2.751  | 2.026  | 2.026  |
| VERTICAL SPREAD             | : | 2.106  | 2.106  | 2.038  |
| EXTREME SPREAD              | : | 2.759  | 2.482  | 2.069  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 0      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 5      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |        |

17 Aug 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/05498863

# CENTERFIRE PATTERNS # 2



# OF SHOTS- 10

# IN CIR

1 in = 0

2 in = 5

3 in = 8

HS= 1.847

VS= 3.019

GS= 3.083

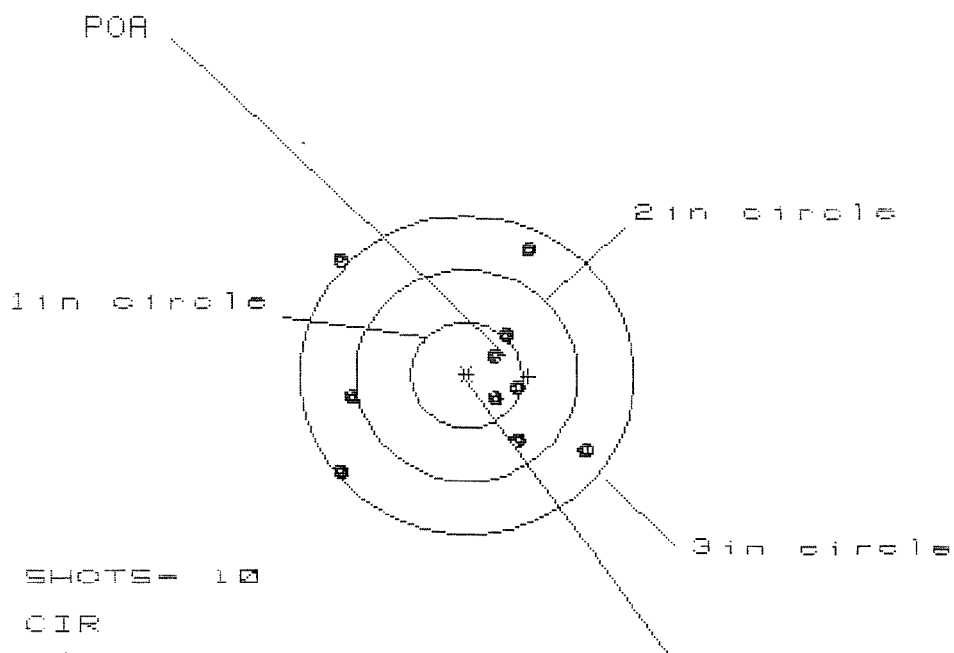
CENTROID \*

| PATTERN #                   | : | 2      |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | .922   | .904   | .824   |
| MINIMUM X                   | : | -.925  | -.943  | -1.024 |
| MAXIMUM Y                   | : | 1.722  | 1.788  | 1.183  |
| MINIMUM Y                   | : | -1.297 | -1.106 | -.882  |
| CENTROID X                  | : | -.133  | -.115  | -.034  |
| CENTROID Y                  | : | .144   | -.047  | -.271  |
| POA TO CENTROID in.         | : | .196   | .124   | .273   |
| MIN RADIUS                  | : | .677   | .583   | .395   |
| MEAN RADIUS                 | : | 1.132  | 1.032  | .873   |
| MAX RADIUS                  | : | 1.729  | 1.900  | 1.360  |
| HORIZONTAL SPREAD           | : | 1.847  | 1.847  | 1.847  |
| VERTICAL SPREAD             | : | 3.019  | 2.894  | 2.065  |
| EXTREME SPREAD              | : | 3.083  | 3.083  | 2.369  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 0      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 5      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 8      |        |

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FILE:/PATTERNING/CENTERFIRE\_PATT/06498863

# CENTERFIRE PATTERNS # 3



# OF SHOTS= 10

# IN CIR

1in = 4

2in = 5

3in = 8

HS= 2.207

VS= 2.094

GS= 2.835

CENTROID \*

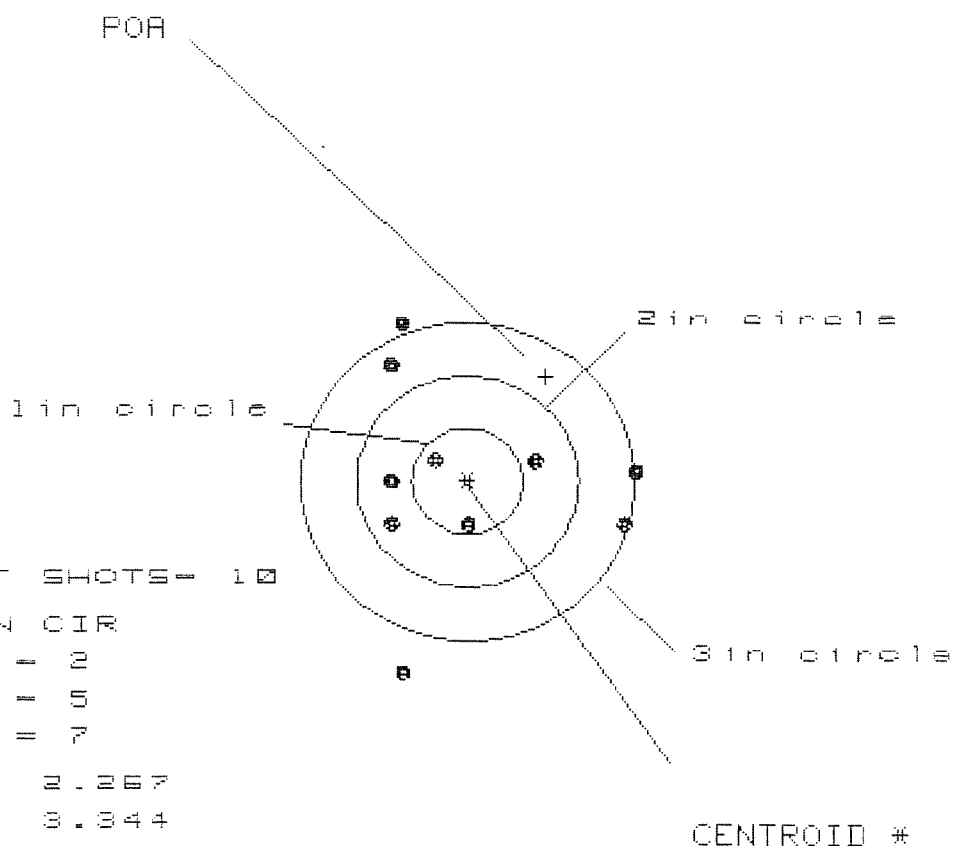
| PATTERN #                   | : | 3      |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.042  | .919   | .757   |
| MINIMUM X                   | : | -1.164 | -1.288 | -1.321 |
| MAXIMUM Y                   | : | 1.146  | 1.269  | 1.165  |
| MINIMUM Y                   | : | -.948  | -.825  | -.712  |
| CENTROID X                  | : | -.558  | -.434  | -.272  |
| CENTROID Y                  | : | .010   | -.113  | -.010  |
| POA TO CENTROID in.         | : | .558   | .448   | .273   |
| MIN RADIUS                  | : | .267   | .095   | .154   |
| MEAN RADIUS                 | : | .896   | .777   | .638   |
| MAX RADIUS                  | : | 1.571  | 1.530  | 1.334  |
| HORIZONTAL SPREAD           | : | 2.207  | 2.207  | 2.078  |
| VERTICAL SPREAD             | : | 2.094  | 2.094  | 1.878  |
| EXTREME SPREAD              | : | 2.835  | 2.733  | 2.143  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 4      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 5      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 8      |        |

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# CENTERFIRE PATTERNS

# 4



# OF SHOTS= 10

# IN CIR

1in = 2

2in = 5

3in = 7

HS= 2.267

VS= 3.344

GS= 3.344

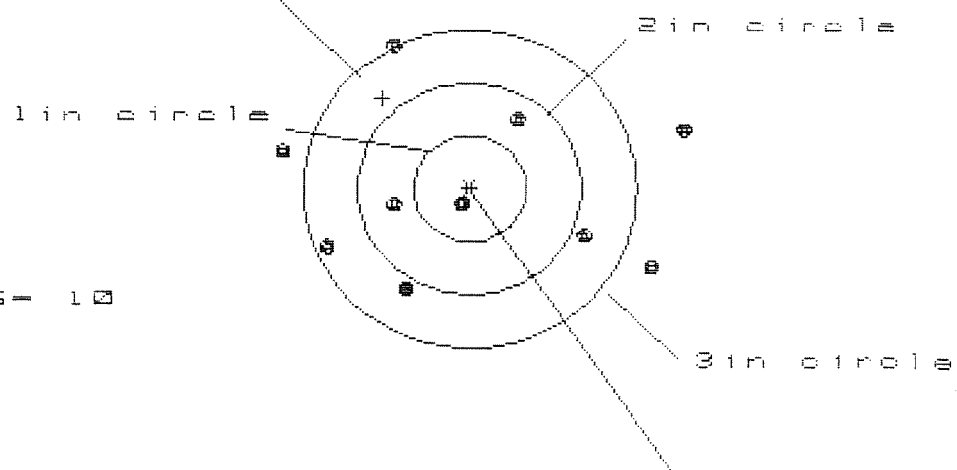
|                             |   |        |       |       |
|-----------------------------|---|--------|-------|-------|
| PATTERN #                   | : | 4      |       |       |
| SHOTS (BEST OF)             | : | 10     | 9     | 8     |
| MAXIMUM X                   | : | 1.538  | 1.470 | 1.385 |
| MINIMUM X                   | : | -.729  | -.797 | -.882 |
| MAXIMUM Y                   | : | 1.545  | 1.345 | 1.050 |
| MINIMUM Y                   | : | -1.799 | -.628 | -.460 |
| CENTROID X                  | : | -.709  | -.641 | -.556 |
| CENTROID Y                  | : | -.996  | -.796 | -.964 |
| POA TO CENTROID in.         | : | 1.223  | 1.022 | 1.113 |
| MIN RADIUS                  | : | .314   | .337  | .441  |
| MEAN RADIUS                 | : | 1.066  | .981  | .900  |
| MAX RADIUS                  | : | 1.902  | 1.507 | 1.385 |
| HORIZONTAL SPREAD           | : | 2.267  | 2.267 | 2.267 |
| VERTICAL SPREAD             | : | 3.344  | 1.973 | 1.510 |
| EXTREME SPREAD              | : | 3.344  | 2.771 | 2.499 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2     |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 5     |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 7     |       |

17 Aug 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/0649B863

# CENTERFIRE PATTERNS # 5

POA



# OF SHOTS- 10

# IN CIR

1 in = 1

2 in = 3

3 in = 6

HS= 3.641

VS= 2.362

GS= 3.644

CENTROID #

| PATTERN #                   | : | 5      |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.954  | 1.799  | 1.514  |
| MINIMUM X                   | : | -1.687 | -1.470 | -1.245 |
| MAXIMUM Y                   | : | 1.381  | 1.438  | 1.358  |
| MINIMUM Y                   | : | .981   | -.924  | -1.004 |
| CENTROID X                  | : | .076   | .559   | .334   |
| CENTROID Y                  | : | -.858  | -.915  | -.835  |
| POA TO CENTROID in.         | : | 1.157  | 1.072  | .899   |
| MIN RADIUS                  | : | .163   | .119   | .317   |
| MEAN RADIUS                 | : | 1.233  | 1.111  | 1.000  |
| MAX RADIUS                  | : | 2.021  | 1.909  | 1.571  |
| HORIZONTAL SPREAD           | : | 3.641  | 3.269  | 2.759  |
| VERTICAL SPREAD             | : | 2.362  | 2.362  | 2.362  |
| EXTREME SPREAD              | : | 3.644  | 3.439  | 2.864  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 1      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 3      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 6      |        |



**MODEL 700<sup>TM</sup> H24**



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

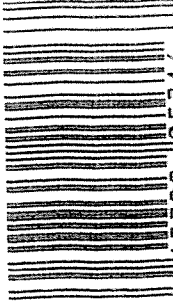
VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.

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

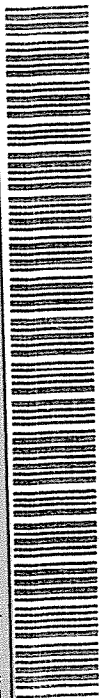
SERIAL NO.  
**C6498863**

ORDER NO.  
**5716**

UPC



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