

C6594503

MODEL 700™ N24

Model **545**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.





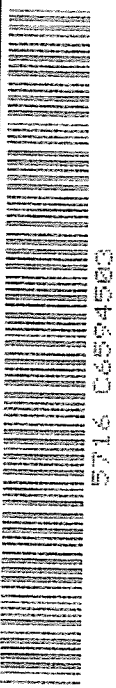

VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700TM H24

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

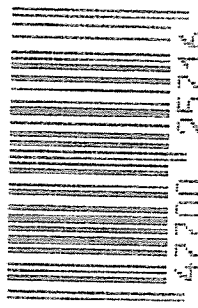
SERIAL NO.
C6594503

ORDER NO.
5716



5716 C6594503

UPC



0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6594503

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY CONTROL BOLT	10/31/90	KA
600	Proof		10/31/90	KA
607	Check Headspace		10/31/90	KA
610	Dis-assemble Gun		10/31/90	KA
612	Magnaflux Barrel Action		11/1/90	KCR
	Magnaflux Bolt		11/1/90	KCR
615	Rollmark Caliber		11/1/90	GB
617	Drill and Tap Sight Holes		11/6/90	FB
618	Polish Barrel AB		11/7/90	WB
620	Apply Coatings (Barrel Action)		11-26-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/17/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/17/91	KS
	C) Inspect Ejector Hole for Chamfer		11/17/91	KS
	D) Oil Firing Pin Ass'y		11/17/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		1-24-91	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 ^{3/4}	5 ^{3/4}	5 ^{3/4}			1/22/91	WLB
	G) Safety Off Force	2 ^{1/2}	2 ^{1/2}	2 ^{1/2}			1/22/91	WLB
	H) Trigger Pull Test & Retainability						1/24/91	JP
	I) Firing Pin Indent	.0205	.021	.021			1/22/91	WLB
	J) Assemble Stock						1/25/91	KS
	K) Assemble Swivel Studs						2-4-91	AC
	L) Attach Front and Rear Sight Assemblies						1/25/91	KS
	M) Iron Sight Alignment						1/25/91	KS
	N) Detach Front & Rear Sights & place in numbered container						1/25/91	KS
	O) Attach Scope to Rifle						1/25/91	KS
	P) Detach & Attach Scope 20 Times						1/25/91	KS
640	Gallery Target & Test						1-28-91	AC
	A) Time						1-28-91	AC
	B) Malfunctions						1-28-91	AC
	C) Pierced Primers						1-28-91	AC
	D) Optical Clarity of Scope						1-28-91	AC
645	Inspect for Live Ammo						1-28-91	AC
655	Final Inspection							
	A) Headspace						2-4-91	AC
	B) Trigger Pull	2.65	2.67	2.67	2.54	2.55	2-1-91	JP
	C) Function						2-4-91	AC
660	Pack						3-16-91	N

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6594503

DATE 1/21/91

TESTER JEP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.24	2.29	2.30		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.38	2.19		
PULL #3	2.36	2.43	2.25		
PULL #4	2.19	2.40	2.21		
PULL #5	2.38	2.38	2.29		
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.45	3.38		
PULL #2	3.38	3.40		
PULL #3	3.41	3.30		
PULL #4	3.36	3.32		
PULL #5	3.19	3.40		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.14	4.22		4.11
PULL #2	4.18	4.11		4.13
PULL #3	4.21	4.15		4.15
PULL #4	4.20	4.14		4.25
PULL #5	4.12	4.15		4.19
TOTAL				
AVG.				

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#
3.00# + .75#
4.00# + 1.00#

*NEW
Trigger*

SERIAL NO. C6594503

DATE 1-24-91

TESTER JH.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.32	2.35	2.44	2.55	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.33	2.20	2.39	2.59	
PULL #3	2.32	2.22	2.29	2.57	
PULL #4	2.35	2.47	2.46	2.54	
PULL #5	2.35	2.47	2.33	2.55	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.45	3.48		
PULL #2	3.45	3.24		
PULL #3	3.50	3.40		
PULL #4	3.41	3.44		
PULL #5	3.48	3.45		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.31	4.50		4.43
PULL #2	4.32	4.40		4.35
PULL #3	4.30	4.39		4.22
PULL #4	4.28	4.24		4.46
PULL #5	4.29	4.39		4.40
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594503
28 Jan 1991

CENTROIDAL DISTANCES

0 TO	1	.151608
1 TO	2	.244804
1 TO	3	.149482
1 TO	4	.291625
1 TO	5	.235646

$\frac{A^2}{4\pi}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0456
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0562
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0723726
THE AMR FOR THIS RIFLE IS: .8952

28 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06594583

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HE= 3.623

VS= 2.573

GS= 3.644

CENTROID #

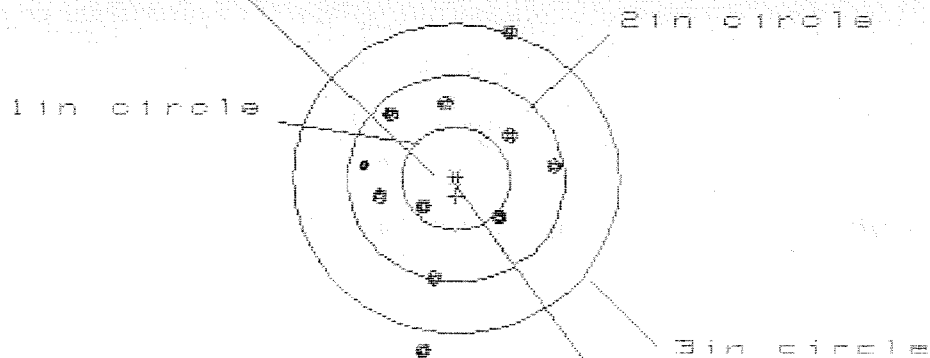
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.038	.882	.712
MINIMUM X	-1.585	-1.358	-.674
MAXIMUM Y	1.344	1.250	1.085
MINIMUM Y	-1.229	-1.323	-1.152
CENTROID X	.149	-.078	.092
CENTROID Y	-.028	.066	.231
POA TO CENTROID in.	.151	.102	.249
MIN RADIUS	.306	.469	.291
MEAN RADIUS	1.103	.973	.816
MAX RADIUS	2.206	1.896	1.269
HORIZONTAL SPREAD	3.623	2.240	1.386
VERTICAL SPREAD	2.573	2.573	2.237
EXTREME SPREAD	3.644	3.130	2.372
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

28 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06534503

CENTERFIRE PATTERNS # 2

POA



OF SHOTS- 10

IN CIR

1in = 1

2in = 8

3in = 9

HS= 1.611

VS= 3.061

GS= 3.171

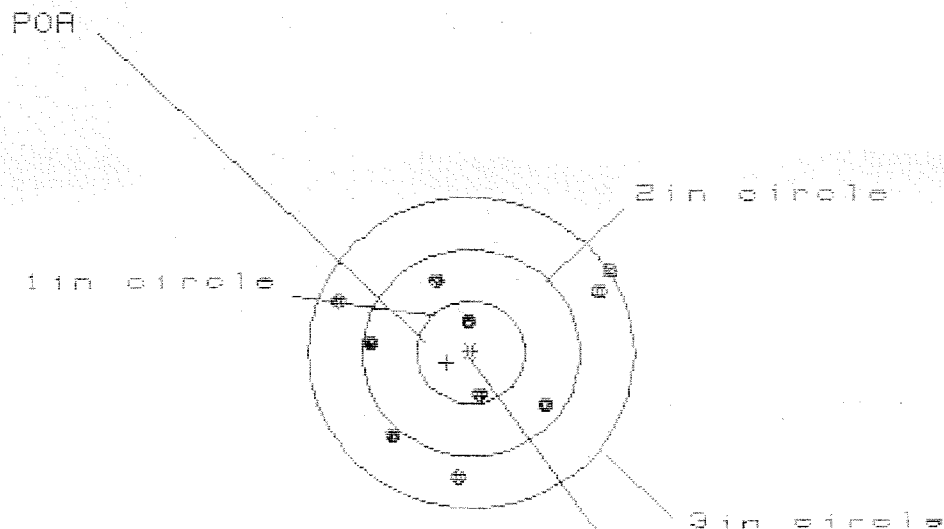
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.909	.876	.938
MINIMUM X	:	-.702	-.735	-.673
MAXIMUM Y	:	1.394	1.208	.692
MINIMUM Y	:	-1.667	-1.121	-.970
CENTROID X	:	.001	.034	-.028
CENTROID Y	:	.167	.353	.201
POA TO CENTROID in.	:	.167	.354	.203
MIN RADIUS	:	.415	.538	.412
MEAN RADIUS	:	.907	.810	.734
MAX RADIUS	:	1.694	1.306	.986
HORIZONTAL SPREAD	:	1.611	1.611	1.611
VERTICAL SPREAD	:	3.061	2.329	1.652
EXTREME SPREAD	:	3.171	2.443	1.655
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

28 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06534503

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 2.478

VS= 1.962

GS= 2.493

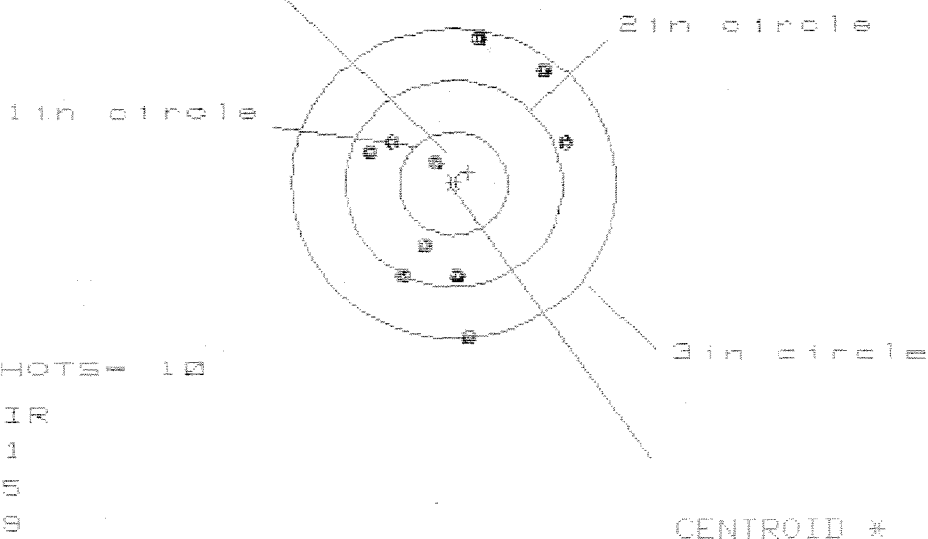
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.260	1.321	1.186
MINIMUM X	:	-1.218	-1.078	-1.895
MAXIMUM Y	:	.760	.743	.814
MINIMUM Y	:	-1.202	-1.117	-1.046
CENTROID X	:	.221	.081	.216
CENTROID Y	:	.103	.018	-.053
POA TO CENTROID in.	:	.244	.093	.222
MIN RADIUS	:	.307	.354	.234
MEAN RADIUS	:	.948	.980	.825
MAX RADIUS	:	1.472	1.465	1.380
HORIZONTAL SPREAD	:	2.478	2.399	2.081
VERTICAL SPREAD	:	1.962	1.860	1.860
EXTREME SPREAD	:	2.493	2.400	2.298
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

28 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CG594583

CENTERFIRE PATTERNS # 4

FOR



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 1.795

VS= 2.948

GS= 2.952

PATTERN #

4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.048	1.058	1.088
MINIMUM X	-.747	-.737	-.707
MAXIMUM Y	1.417	1.246	1.067
MINIMUM Y	-1.531	-1.086	-.930
CENTROID X	-.132	-.142	-.172
CENTROID Y	-.106	.064	-.092
POA TO CENTROID in.	.170	.155	.195
MIN RADIUS	.294	.200	.257
MEAN RADIUS	.982	.908	.848
MAX RADIUS	1.534	1.270	1.387
HORIZONTAL SPREAD	1.795	1.795	1.795
VERTICAL SPREAD	2.948	2.332	1.997
EXTREME SPREAD	2.952	2.435	2.388
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

28 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08594503

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 5

2 in = 9

3 in = 10

HS= 1.108

VS= 1.818

GS= 2.078

CENTROID *

PATTERN #

5

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.548	.575	.508
MINIMUM X	:	-.560	-.533	-.345
MAXIMUM Y	:	.792	.667	.468
MINIMUM Y	:	-1.126	-.717	-.634
CENTROID X	:	-.011	-.038	.029
CENTROID Y	:	.145	.270	.187
POA TO CENTROID in.	:	.145	.273	.189
MIN RADIUS	:	.159	.133	.101
MEAN RADIUS	:	.536	.447	.393
MAX RADIUS	:	1.151	.854	.721
HORIZONTAL SPREAD	:	1.108	1.108	.953
VERTICAL SPREAD	:	1.918	1.384	1.102
EXTREME SPREAD	:	2.078	1.407	1.233
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER

R 94-18761

INITIAL CUSTOMER ORDER NO.

JJM DAAA09-92-C-0834

W/10X SCOPE M-24 SNIPER W/DEPLOYMENT KIT

ATTN FRED MARTIN

Scope 90-0903

DATE RECEIVED DATE OPENED DATE CODE

06/14/94

06/15/94

SERIAL NUMBER

C6594503

NEW SERIAL NUMBER

MODEL AND GRADE

700 7.62

NATO

ACCESSORIES

HARD CASE

SCOPE MNTS

SCOPE BASE

SLING STRAP

FROM:

SHIP TO:

COMMANDER (W52H094138H226)
DEFENSE DIST DEPOT ANNISTON
ATTN DDAA-UR BLDG 112
ANNISTON

AL 36201-5025

COMMANDER (W52H094138H226)
DEFENSE DIST DEPOT ANNISTON
ATTN DDAA-UR BLDG 112
ANNISTON

AL
36201-5025

ACCOUNT NUMBER

ACCOUNT NUMBER N/C

CUST NO: 098397 C.O.D.

WRITE

PROM. DATE

ESTIMATED

VIA

UPS

GUN CONDITION

- ☐ NEW
- ☐ LIGHTLY WORN
- ☐ WORN
- ☐ VERY WORN
- ☐ UNREPAIRABLE
- ☐ MARRED

REPAIR CHARGE

EXCISE

TAX

INSURANCE

UPS

PARCEL POST

TOTAL

CUSTOMER CONCERN

AMMO

FUNCTION

FINISH

ACCURACY

FIT

INSPECT

CYCLE

A

B1

TRIGGER GROUP

B2

E1

F1

BOLT ASSY.

B3

E2

F2

BARREL ASSY.

B4

D1

E3

F3

REC. ASSY.

B5

D2

E4

F4

WOOD

C1

D3

E5

F5

METAL

C2

MAIN FAULT

PARTS

COMMENTS

Trigger Assy \$193.31
Mag. follower 6.12
CTI 30.00
229.43

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

GALLERY TESTER

DATE

DATE

DATE

DATE

DATE

OFFICE COPY

RD6925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400018299

SWS TRIGGER PULL TEST

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

SERIAL NO. C654503

DATE 2-8-96

TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.71	2.87	2.77		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.79	2.56	2.63		
PULL #3	2.74	2.74	2.70		
PULL #4	2.74	2.83	2.63		
PULL #5	2.90	2.58	2.66		
TOTAL	13.88	13.58	13.39		
AVG.	2.77	2.71	2.67		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.11	3.17		
PULL #2	3.00	3.14		
PULL #3	3.28	3.00		
PULL #4	3.31	3.05		
PULL #5	3.27	3.05		
TOTAL	15.97	15.41		
AVG.	3.19	3.08		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.37	4.30		4.09
PULL #2	4.26	4.19		4.03
PULL #3	4.17	4.25		4.00
PULL #4	4.21	4.00		4.09
PULL #5	4.19	4.17		4.05
TOTAL	21.20	20.91		20.26
AVG.	4.24	4.18		4.05

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6594503

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

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/4			2/26/96	WLB
	G) Safety Off Force	2 1/4	2 1/4	2 1/4			2/26/96	WLB
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent							
	J) Assemble Stock							
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies							
	M) Iron Sight Alignment							
	N) Detach Front & Rear Sights & place in numbered container							
	O) Attach Scope to Rifle							
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test						2/23/96	AC
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection						2/24/96	RW
	A) Headspace						2/28/96	WLB
	B) Trigger Pull	2.61	2.63	2.46	2.51	2.50	2/24/96	RW
	C) Function							
660	Pack							