

C6523479

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

M2400028841

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

Smead

Remington[®]

MODEL 700TM M24

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

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

SERIAL NO.
C6523479

ORDER NO.
5716

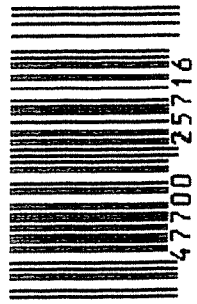
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



5716 C6523479

UPC



0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523479

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/2/90	KJ
600	Proof		10/2/90	KJ
607	Check Headspace		10/2/90	KJ
610	Dis-assemble Gun		10/2/90	KJ
612	Magnaflux Barrel Action		10/5/90	KR
	Magnaflux Bolt		10/5/90	KR
615	Rollmark Caliber		10/5/90	SL
617	Drill and Tap Sight Holes		10/5/90	KB
618	Polish Barrel RB		10/9/90	WB
620	Apply Coatings (Barrel Action)		10-20-90	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/21/90	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/21/90	WB
	C) Inspect Ejector Hole for Chamfer		10/21/90	WB
	D) Oil Firing Pin Ass'y		10/21/90	WB
	E) Adjust Trigger Pull to Min Setting and Stake		10/25/90	GH

op. #	OP. NAME	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2	10/26/90	WB		
	G) Safety Off Force	3	3	3	10/26/90	WB		
	H) Trigger Pull Test & Retainability				10/25/90	JL		
	I) Firing Pin Indent	.022	.0225	.022	10/26/90	WB		
	J) Assemble Stock				10/26/90	KJ		
	K) Assemble Swivel Studs				3/20/91	928		
	L) Attach Front and Rear Sight Assemblies				10/26/90	KJ		
	M) Iron Sight Alignment				10/26/90	KJ		
	N) Detach Front & Rear Sights & place in numbered container				10/26/90	KJ		
	O) Attach Scope to Rifle				10/26/90	KJ		
P) Detach & Attach Scope 20 Times				10/26/90	KJ			
640	Gallery Target & Test				10-27-90	KJ		
	A) Time				10-27-90	KJ		
	B) Malfunctions				10-27-90	KJ		
	C) Pierced Primers				10-27-90	KJ		
	D) Optical Clarity of Scope				10-27-90	KJ		
645	Inspect for Live Ammo				10-27-90	KJ		
655	Final Inspection							
	A) Headspace				3/20/91	928		
	B) Trigger Pull	248	249	237	253	245	3/20/91	928
	C) Function						3/20/91	928
660	Pack						12/19/90	W

SWS TRIGGER PULL TEST

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

SERIAL NO. C6523479
DATE 10/25/98
TESTER JSP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.23	2.35	2.32	2.48	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.39	2.30	2.30	2.49	
PULL #3	2.34	2.32	2.51	2.37	
PULL #4	2.41	2.50	2.32	2.53	
PULL #5	2.23	2.35	2.32	2.45	
TOTAL	11.6	11.82	11.77		
AVG.	2.32	2.364	2.354		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.39	3.26		
PULL #2	3.40	3.23		
PULL #3	3.48	3.30		
PULL #4	3.50	3.32		
PULL #5	3.50	3.30		
TOTAL	17.27	16.41		
AVG.	3.454	3.282		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.23	4.25		4.25
PULL #2	4.13	4.12		4.25
PULL #3	4.20	4.34		4.14
PULL #4	4.15	4.15		4.26
PULL #5	4.23	4.18		4.36
TOTAL	20.94	21.04		21.26
AVG.	4.188	4.208		4.252

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523479
27 Oct 1990

CENTROIDAL DISTANCES

Ø TO	1	.0150333
1 TO	2	.3022
1 TO	3	.215863
1 TO	4	.329706
1 TO	5	.314841

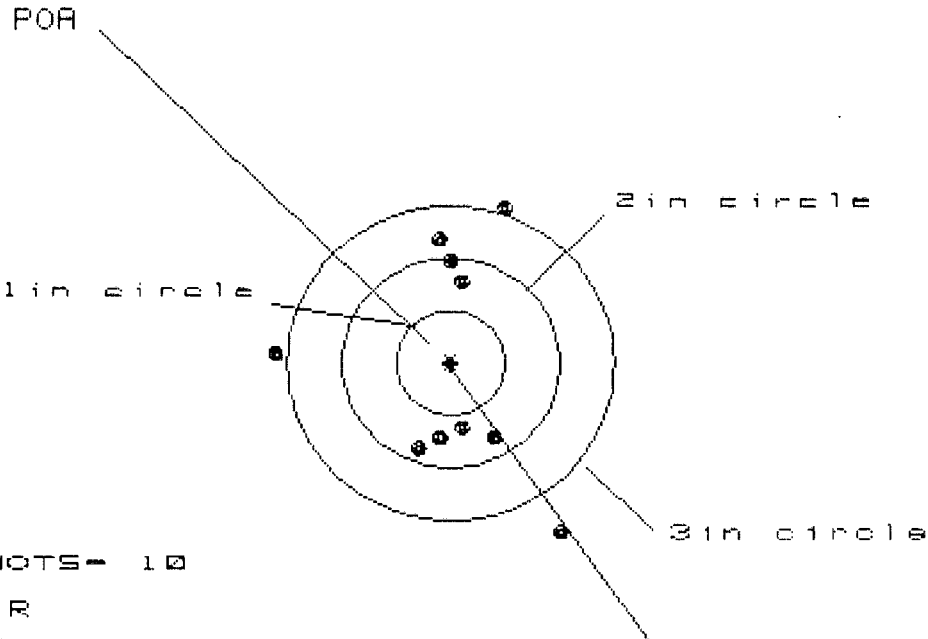
at <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1092
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.169
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .20121
THE AMR FOR THIS RIFLE IS: 1.049

27 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523479

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 6

3 in = 7

HS= 2.620

VS= 3.154

GS= 3.201

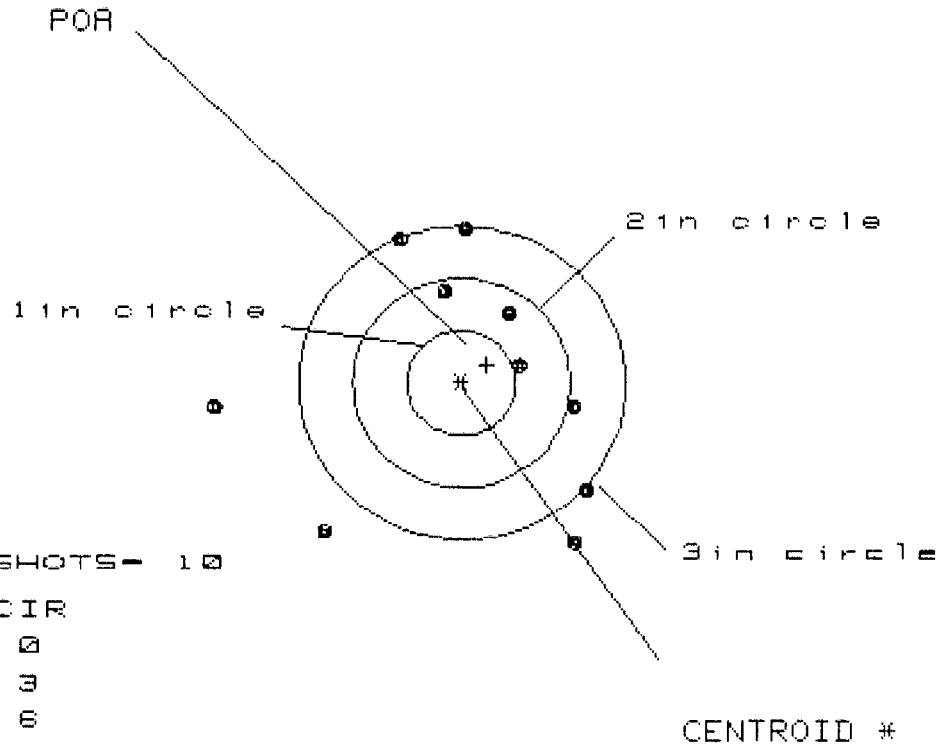
CENTROID #

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.010	.578	.391
MINIMUM X	-1.610	-1.498	-.334
MAXIMUM Y	1.523	1.342	1.327
MINIMUM Y	-1.631	-1.042	-1.057
CENTROID X	.001	-.111	.076
CENTROID Y	.015	.196	.211
POA TO CENTROID in.	.015	.226	.225
MIN RADIUS	.629	.649	.609
MEAN RADIUS	1.123	1.033	.958
MAX RADIUS	1.918	1.503	1.383
HORIZONTAL SPREAD	2.620	2.076	.725
VERTICAL SPREAD	3.154	2.384	2.384
EXTREME SPREAD	3.201	2.540	2.492
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	7		

27 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523479

CENTERFIRE PATTERNS # 2



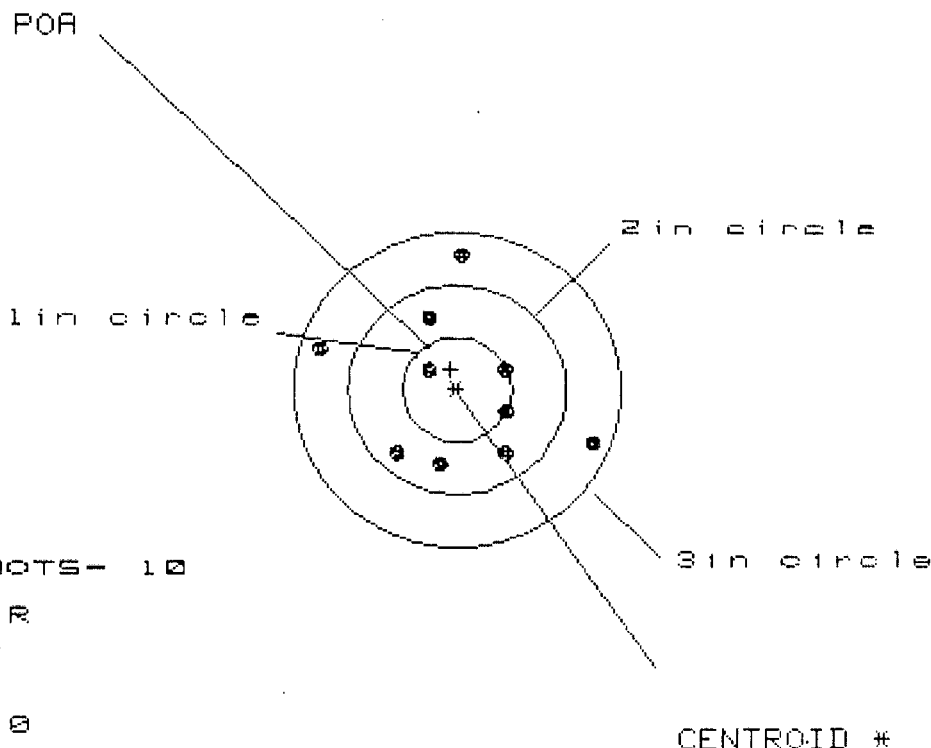
OF SHOTS- 10
IN CIR
1in = 0
2in = 3
3in = 6
HS= 3.401
VS= 3.013
GS= 3.543

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.172	.925	.734
MINIMUM X	:	-2.228	-1.528	-.956
MAXIMUM Y	:	1.454	1.427	1.240
MINIMUM Y	:	-1.559	-1.586	-1.773
CENTROID X	:	-.234	.013	.204
CENTROID Y	:	-.175	-.148	.039
POR TO CENTROID in.	:	.292	.149	.208
MIN RADIUS	:	.530	.287	.105
MEAN RADIUS	:	1.376	1.219	1.032
MAX RADIUS	:	2.241	2.140	1.879
HORIZONTAL SPREAD	:	3.401	2.453	1.690
VERTICAL SPREAD	:	3.013	3.013	3.013
EXTREME SPREAD	:	3.543	3.326	3.326
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		6	

27 Oct 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6523473

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS= 2.459

VS= 1.994

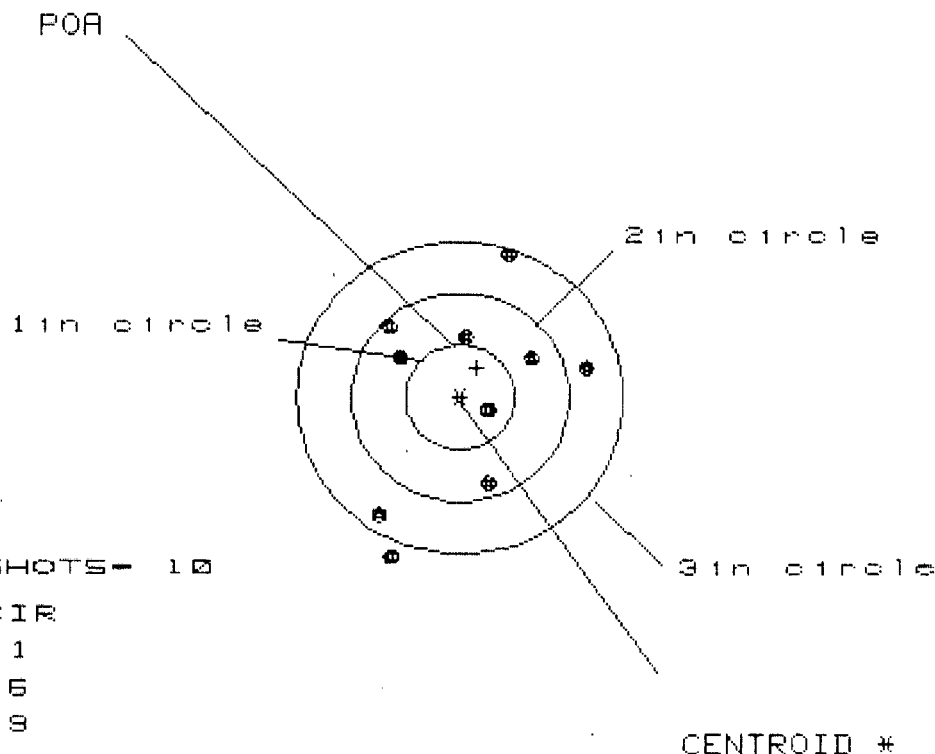
GS= 2.603

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.215	.620	.481
MINIMUM X	:	-1.244	-1.109	-.591
MAXIMUM Y	:	1.254	1.201	1.242
MINIMUM Y	:	-.741	-.793	-.752
CENTROID X	:	.055	-.080	.059
CENTROID Y	:	-.194	-.141	-.182
POA TO CENTROID in.	:	.201	.162	.191
MIN RADIUS	:	.342	.204	.339
MEAN RADIUS	:	.828	.770	.709
MAX RADIUS	:	1.303	1.213	1.243
HORIZONTAL SPREAD	:	2.459	1.729	1.072
VERTICAL SPREAD	:	1.994	1.994	1.994
EXTREME SPREAD	:	2.603	2.005	2.005
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

27 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523479

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 9

IS= 1.938

VS= 2.900

GS= 3.100

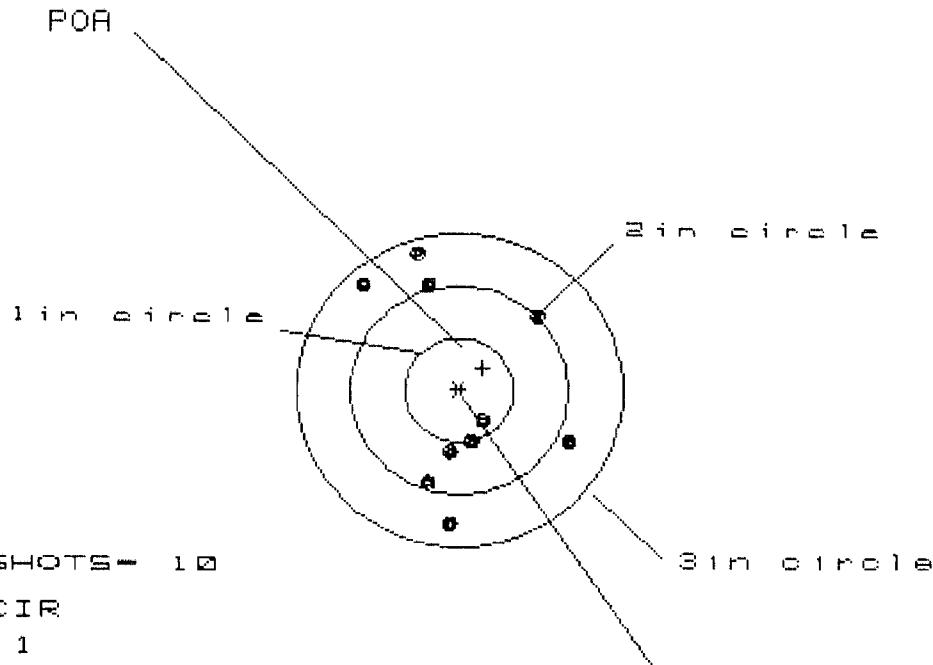
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.171	1.097	1.141
MINIMUM X	:	-.767	-.841	-.797
MAXIMUM Y	:	1.342	1.168	.635
MINIMUM Y	:	-1.558	-1.285	-1.139
CENTROID X	:	-.154	-.080	-.124
CENTROID Y	:	-.276	-.102	-.248
POA TO CENTROID in.	:	.316	.130	.277
MIN RADIUS	:	.238	.309	.225
MEAN RADIUS	:	.966	.859	.814
MAX RADIUS	:	1.697	1.536	1.390
HORIZONTAL SPREAD	:	1.938	1.938	1.938
VERTICAL SPREAD	:	2.900	2.453	1.774
EXTREME SPREAD	:	3.100	2.727	2.363
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

27 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523479

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

HS= 1.898

VS= 2.629

GS= 2.640

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.977	.939	.819
MINIMUM X	-.921	-.959	-.418
MAXIMUM Y	1.343	1.143	1.283
MINIMUM Y	-1.286	-1.137	-.997
CENTROID X	-.214	-.176	-.056
CENTROID Y	-.215	-.364	-.504
POA TO CENTROID in.	.303	.404	.507
MIN RADIUS	.377	.255	.106
MEAN RADIUS	.954	.862	.729
MAX RADIUS	1.387	1.475	1.349
HORIZONTAL SPREAD	1.898	1.898	1.237
VERTICAL SPREAD	2.629	2.280	2.280
EXTREME SPREAD	2.640	2.399	2.285
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523479
5 Nov 1990

CENTROIDAL DISTANCES

0 TO 1	.333294
1 TO 2	.131381
1 TO 3	.169169
1 TO 4	.168345
1 TO 5	.246033

~~POI~~ <----POI

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2266
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0074
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .226721
THE AMR FOR THIS RIFLE IS: .792

5 Nov 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6523479.1

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 4

2 in = 7

3 in = 8

HS= 3.606

VS= .753

GS= 3.607

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.040	.819	.652
MINIMUM X	-1.566	-1.340	-1.026
MAXIMUM Y	.349	.355	.370
MINIMUM Y	-.404	-.398	-.383
CENTROID X	.333	.107	.274
CENTROID Y	.014	.008	-.007
POA TO CENTROID in.	.334	.107	.274
MIN RADIUS	.076	.172	.026
MEAN RADIUS	.730	.622	.465
MAX RADIUS	2.040	1.345	1.028
HORIZONTAL SPREAD	3.606	2.159	1.678
VERTICAL SPREAD	.753	.753	.753
EXTREME SPREAD	3.607	2.172	1.734
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		

5 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523473.1

CENTERFIRE PATTERNS

2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 1.961

VS= 2.393

GS= 2.937

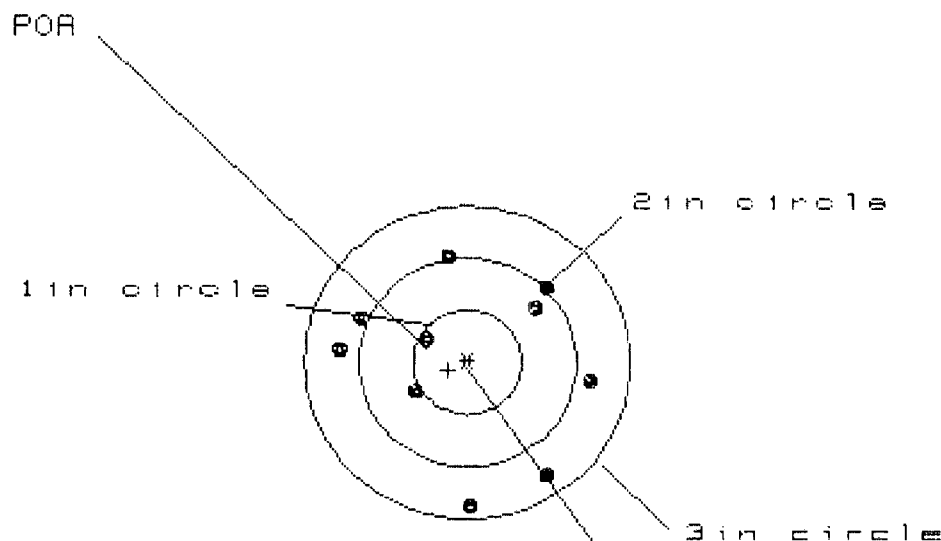
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.808	.680	.733
MINIMUM X	:	-1.153	-.866	-.813
MAXIMUM Y	:	1.037	1.032	.877
MINIMUM Y	:	-1.356	-1.241	-.578
CENTROID X	:	.314	.442	.389
CENTROID Y	:	-.116	-.231	-.076
POA TO CENTROID in.	:	.334	.498	.396
MIN RADIUS	:	.043	.131	.071
MEAN RADIUS	:	.787	.702	.604
MAX RADIUS	:	1.550	1.311	1.011
HORIZONTAL SPREAD	:	1.961	1.546	1.546
VERTICAL SPREAD	:	2.393	2.273	1.455
EXTREME SPREAD	:	2.937	2.273	1.854
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

5 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8523479.1

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 10

HS= 2.329

VS= 2.428

GS= 2.439

CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.140	1.141	1.233
MINIMUM X	:	-1.189	-1.188	-1.096
MAXIMUM Y	:	1.016	.859	.701
MINIMUM Y	:	-1.412	-1.264	-.641
CENTROID X	:	.176	.175	.083
CENTROID Y	:	.077	.234	.392
POA TO CENTROID in.	:	.192	.292	.401
MIN RADIUS	:	.478	.429	.346
MEAN RADIUS	:	1.004	.938	.844
MAX RADIUS	:	1.412	1.464	1.312
HORIZONTAL SPREAD	:	2.329	2.329	2.329
VERTICAL SPREAD	:	2.428	2.123	1.342
EXTREME SPREAD	:	2.439	2.338	2.338
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

5 Nov 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6523479.1

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 3

2in = 9

3in = 10

HS= 1.568

VS= 1.932

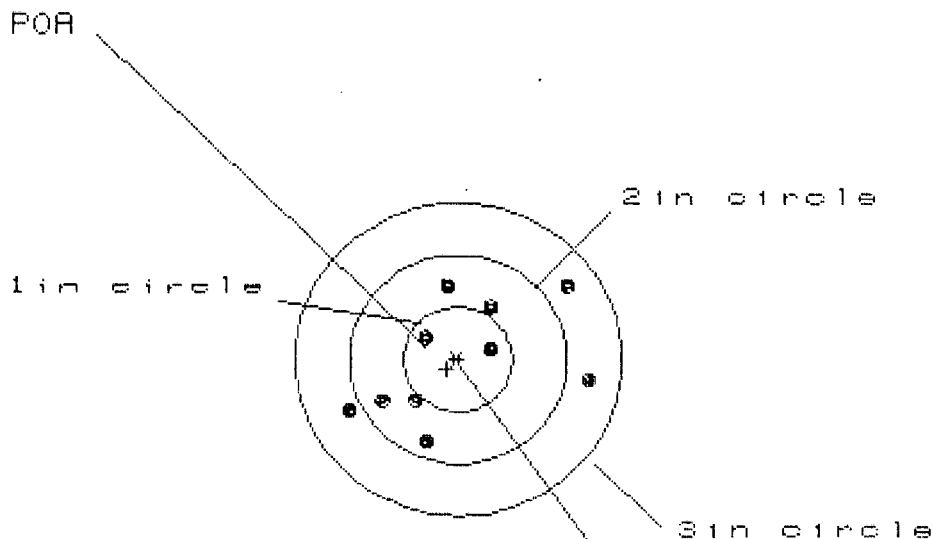
GS= 1.945

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.789	.790	.829
MINIMUM X	-.779	-.778	-.679
MAXIMUM Y	1.260	.801	.765
MINIMUM Y	-.672	-.532	-.568
CENTROID X	.211	.210	.111
CENTROID Y	-.102	-.242	-.206
POA TO CENTROID in.	.234	.320	.234
MIN RADIUS	.172	.127	.031
MEAN RADIUS	.651	.561	.518
MAX RADIUS	1.260	.862	.829
HORIZONTAL SPREAD	1.568	1.568	1.508
VERTICAL SPREAD	1.932	1.333	1.333
EXTREME SPREAD	1.945	1.573	1.519
NUMBER IN ONE INCH CIRCLE	=	3	
NUMBER IN TWO INCH CIRCLE	=	9	
NUMBER IN THREE INCH CIRCLE	=	10	

5 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523479.1

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS= 2.219

VS= 1.575

GS= 2.308

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.241	1.183	.616
MINIMUM X	:	-.978	-.840	-.692
MAXIMUM Y	:	.741	.719	.800
MINIMUM Y	:	-.834	-.856	-.775
CENTROID X	:	.099	-.039	-.187
CENTROID Y	:	.090	.113	.032
FOR TO CENTROID in.	:	.134	.120	.190
MIN RADIUS	:	.299	.252	.270
MEAN RADIUS	:	.788	.718	.623
MAX RADIUS	:	1.257	1.347	.822
HORIZONTAL SPREAD	:	2.219	2.023	1.308
VERTICAL SPREAD	:	1.575	1.575	1.575
EXTREME SPREAD	:	2.308	2.308	1.601
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	