

C6523532

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

M2400029819

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

Smeal®
M. 2199 KI

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

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

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

MODEL 700™ H24

SERIAL NO.
C6523532

ORDER NO.
5716

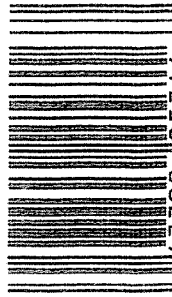
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

01



5716 C6523532

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6523532

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/1/90	LS
600	Proof		10/1/90	LS
607	Check Headspace		10/1/90	LS
610	Dis-assemble Gun		10/1/90	LS
612	Magnaflux Barrel Action		10/3/90	KR
	Magnaflux Bolt		10/3/90	KR
615	Rollmark Caliber		10/3/90	LS
617	Drill and Tap Sight Holes		10/4/90	FB
618	Polish Barrel <i>AB</i>		10/5/90	WB
620	Apply Coatings (Barrel Action)		10-20-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/7/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/7/90	KS
	C) Inspect Ejector Hole for Chamfer		11/7/90	KS
	D) Oil Firing Pin Ass'y		11/7/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		11-9-90	JA

op. #	OP. NAME	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	4	4	4	11/9/90	WB		
	G) Safety Off Force	2	2	2	11/9/90	WB		
	H) Trigger Pull Test & Retainability				11-9-90	W		
	I) Firing Pin Indent	.021	.021	.021	11/9/90	WB		
	J) Assemble Stock				11/9/90	KS		
	K) Assemble Swivel Studs				11/14/90	928		
	L) Attach Front and Rear Sight Assemblies				11/9/90	KS		
	M) Iron Sight Alignment				11/9/90	KS		
	N) Detach Front & Rear Sights & place in numbered container				11/9/90	KS		
	O) Attach Scope to Rifle				11/9/90	KS		
	P) Detach & Attach Scope 20 Times				11/9/90	KS		
640	Gallery Target & Test				11/12/90	NF		
	A) Time				"	NF		
	B) Malfunctions				"	NF		
	C) Pierced Primers				"	NF		
	D) Optical Clarity of Scope				"	NF		
645	Inspect for Live Ammo				11/12/90	NF		
655	Final Inspection							
	A) Headspace				11/19/90	928		
	B) Trigger Pull	273	281	288	272	270	11/19/90	928
	C) Function						11/19/90	928
660	Pack						12-17-90	DH

SWS TRIGGER PULL TEST

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

SERIAL NO. C6523532
DATE 11-9-80
TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.14	2.40	2.39	2.73	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.35	2.45	2.41	2.81	
PULL #3	2.25	2.50	2.34	2.88	
PULL #4	2.40	2.49	2.39	2.72	
PULL #5	2.34	2.34	2.35	2.70	
TOTAL	11.48	12.88	11.88		
AVG.	2.296	2.536	2.376		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.41	3.32		
PULL #2	3.36	3.29		
PULL #3	3.19	3.20		
PULL #4	3.30	3.24		
PULL #5	3.30	3.17		
TOTAL	16.56	16.22		
AVG.	3.312	3.244		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.34	4.41		4.49
PULL #2	4.34	4.45		4.47
PULL #3	4.18	4.35		4.51
PULL #4	4.32	4.49		4.47
PULL #5	4.33	4.23		4.46
TOTAL	21.51	21.93		22.40
AVG.	4.302	4.386		4.48

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06523532
13 Nov 1990

CENTROIDAL DISTANCES

0 TO	1	.329439
1 TO	2	.371872
1 TO	3	.401528
1 TO	4	.37184
1 TO	5	.164712

451 <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0842
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0592
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .102929
THE AMR FOR THIS RIFLE IS: .8594

13 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523532

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 2.372

VS= 3.531

GS= 3.733

CENTROID *

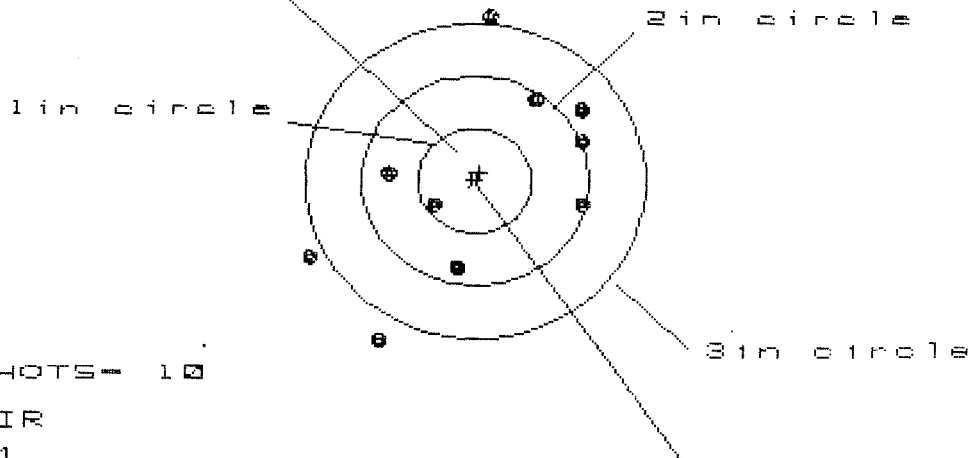
PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.850	.799	.602
MINIMUM X	-1.522	-1.573	-1.373
MAXIMUM Y	1.222	.965	.916
MINIMUM Y	-2.309	-1.044	-1.093
CENTROID X	.329	.380	.577
CENTROID Y	-.017	.240	.289
POA TO CENTROID in.	.329	.449	.645
MIN RADIUS	.266	.199	.156
MEAN RADIUS	1.028	.805	.646
MAX RADIUS	2.355	1.622	1.755
HORIZONTAL SPREAD	2.372	2.372	1.975
VERTICAL SPREAD	3.531	2.009	2.009
EXTREME SPREAD	3.733	2.748	2.748
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

13 Nov 1938

FILE:/PATTERNING/CENTERFIRE_PATT/C6523532

CENTERFIRE PATTERNS # 2

POA



OF SHOTS - 10

IN CIR

1in = 1

2in = 5

3in = 7

HS= 2.383

VS= 3.047

GS= 3.210

CENTROID #

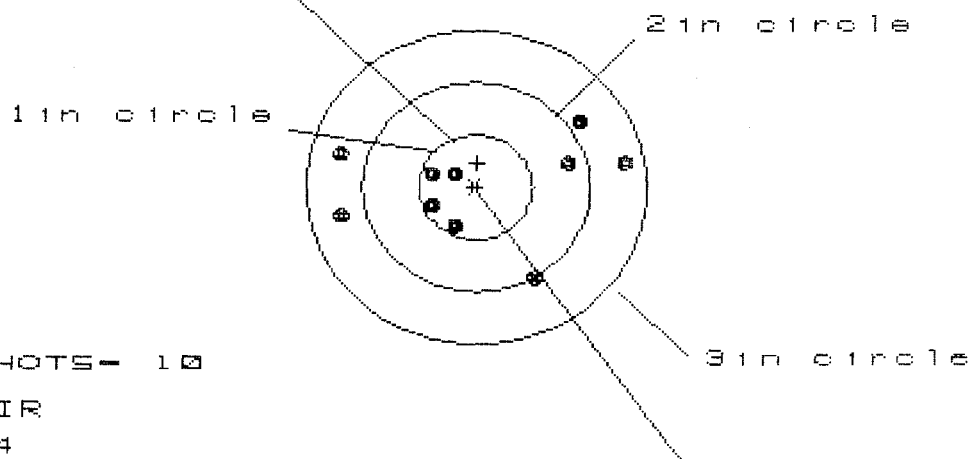
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.967	.875	.686
MINIMUM X	:	-1.416	-1.508	-1.053
MAXIMUM Y	:	1.527	1.358	1.248
MINIMUM Y	:	-1.520	-1.036	-1.146
CENTROID X	:	-.038	.054	.243
CENTROID Y	:	-.077	.092	.202
POA TO CENTROID in.	:	.086	.107	.316
MIN RADIUS	:	.403	.572	.616
MEAN RADIUS	:	1.097	1.015	.891
MAX RADIUS	:	1.730	1.745	1.252
HORIZONTAL SPREAD	:	2.383	2.383	1.739
VERTICAL SPREAD	:	3.047	2.394	2.394
EXTREME SPREAD	:	3.210	2.749	2.417
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

13 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523532

CENTERFIRE PATTERNS # 3

POA



OF SHOTS- 10

IN CIR

1in = 4

2in = 5

3in = 10

HS= 2.498

VS= 1.503

GS= 2.551

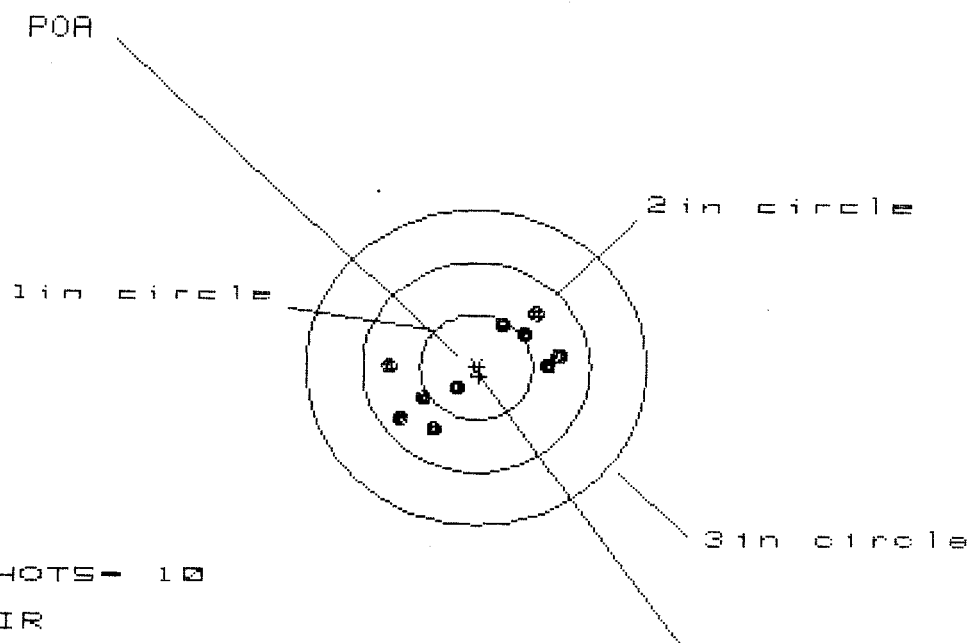
CENTROID #

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.289	1.061	.928
MINIMUM X	:	-1.209	-1.066	-1.149
MAXIMUM Y	:	.638	.664	.633
MINIMUM Y	:	-.865	-.839	-.870
CENTROID X	:	-.012	-.155	-.022
CENTROID Y	:	-.229	-.255	-.224
POA TO CENTROID in.	:	.229	.299	.225
MIN RADIUS	:	.189	.130	.178
MEAN RADIUS	:	.812	.720	.693
MAX RADIUS	:	1.312	1.252	1.195
HORIZONTAL SPREAD	:	2.498	2.127	2.077
VERTICAL SPREAD	:	1.503	1.503	1.503
EXTREME SPREAD	:	2.551	2.315	2.099
NUMBER IN ONE INCH CIRCLE =	:	4	5	10
NUMBER IN TWO INCH CIRCLE =	:	5	5	10
NUMBER IN THREE INCH CIRCLE =	:	10	5	10

13 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06523532

CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 10

3 in = 10

HS = 1.520

VS = 1.107

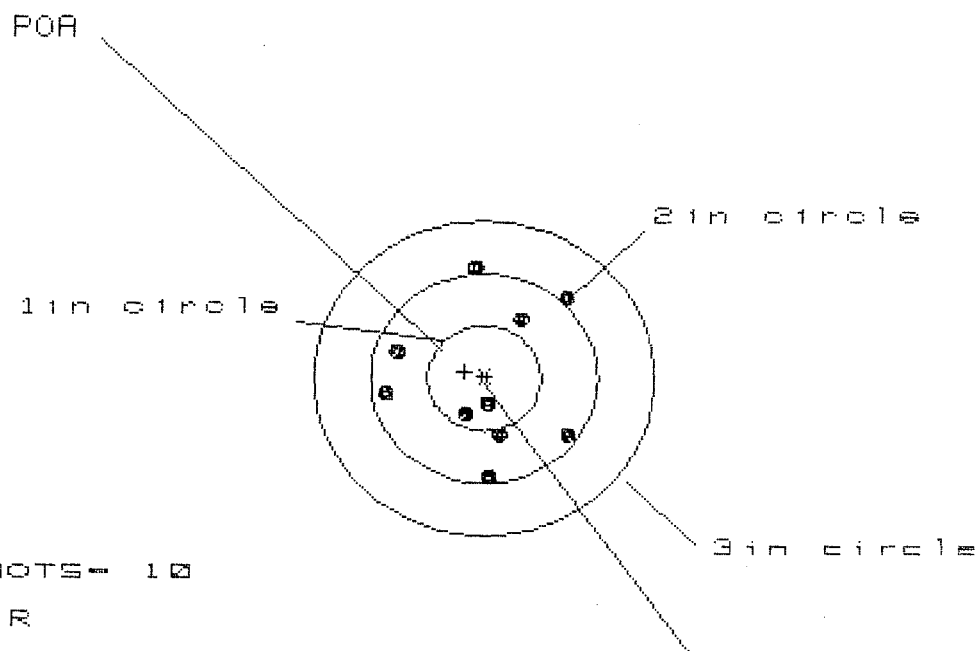
GS = 1.587

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.748	.673	.567
MINIMUM X	:	-.772	-.847	-.631
MAXIMUM Y	:	.557	.504	.496
MINIMUM Y	:	-.550	-.603	-.611
CENTROID X	:	-.028	.047	.153
CENTROID Y	:	.087	.140	.148
POA TO CENTROID in.	:	.091	.148	.213
MIN RADIUS	:	.290	.381	.344
MEAN RADIUS	:	.622	.591	.542
MAX RADIUS	:	.831	.850	.820
HORIZONTAL SPREAD	:	1.520	1.520	1.198
VERTICAL SPREAD	:	1.107	1.107	1.107
EXTREME SPREAD	:	1.587	1.527	1.419
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	10		
NUMBER IN THREE INCH CIRCLE	=	10		

13 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523532

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 8

3in = 10

HS= 1.608

VS= 1.970

GS= 1.972

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.743	.732	.788
MINIMUM X	-.865	-.876	-.784
MAXIMUM Y	1.071	.865	.776
MINIMUM Y	-.899	-.780	-.671
CENTROID X	.170	.181	.089
CENTROID Y	-.060	-.179	-.288
POA TO CENTROID in.	.180	.255	.301
MIN RADIUS	.263	.146	.144
MEAN RADIUS	.738	.671	.583
MAX RADIUS	1.076	1.134	.869
HORIZONTAL SPREAD	1.608	1.608	1.572
VERTICAL SPREAD	1.970	1.645	1.447
EXTREME SPREAD	1.972	1.855	1.670
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		