

C6523534

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Smead[®]

M2400029867

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

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

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

MODEL 700™ H24

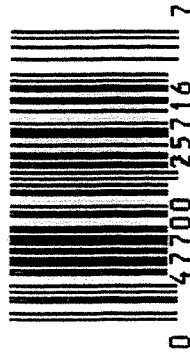
SERIAL NO. C6523534

ORDER NO. 5716

Ø1

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

UPC



5716 C6523534

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523534

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10 2	90	RW
600	Proof	10 2	90	RW
607	Check Headspace	10 2	90	RW
610	Dis-assemble Gun	10 2	90	RW
612	Magnaflux Barrel Action		10-2-90	KR
	Magnaflux Bolt		10-2-90	KR
615	Rollmark Caliber		10-2-90	Y.S.
617	Drill and Tap Sight Holes		10/4/90	KB
618	Polish Barrel <i>PB</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		10/22/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/22/90	RW
	C) Inspect Ejector Hole for Chamfer		10/22/90	RW
	D) Oil Firing Pin Ass'y		10/22/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11/1/90	JK

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	3 1/2	3 1/2	3 1/2			11/1/90	WB
	G) Safety Off Force	2 1/4	2 1/4	2 1/4			11/1/90	WB
	H) Trigger Pull Test & Retainability						11/1/90	JH
	I) Firing Pin Indent	.021	.021	.021			11/1/90	WB
	J) Assemble Stock						11/2/90	RW
	K) Assemble Swivel Studs						11-20-90	DH
	L) Attach Front and Rear Sight Assemblies						11/2/90	RW
	M) Iron Sight Alignment						11/2/90	RW
	N) Detach Front & Rear Sights & place in numbered container						11/2/90	RW
	O) Attach Scope to Rifle						11/2/90	RW
	P) Detach & Attach Scope 20 Times						11/2/90	RW
640	Gallery Target & Test						11-3-90	KT
	A) Time						11-3-90	KT
	B) Malfunctions						11-3-90	KT
	C) Pierced Primers						11-3-90	KT
	D) Optical Clarity of Scope						11-3-90	KT
645	Inspect for Live Ammo						11-3-90	KT
655	Final Inspection							
	A) Headspace						11-20-90	DH
	B) Trigger Pull	2.91	2.87	2.84	2.84	2.90	11-20-90	DH
	C) Function						11-20-90	DH
660	Pack						12/14/90	VF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6523534
DATE 11/1/90
TESTER [Signature]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.32	2.44	2.36	2.91	MIN. SETTING,
PULL #2	2.43	2.46	2.38	2.87	NO AVG. OF 5
PULL #3	2.43	2.48	2.43	2.84	READINGS ACCEPT-
PULL #4	2.45	2.54	2.50	2.84	ABLE LESS THAN 2#
PULL #5	2.51	2.33	2.44	2.90	
TOTAL	12.14	12.25	12.11		
AVG.	2.428	2.45	2.422		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.35	3.50		
PULL #2	3.44	3.25		
PULL #3	3.36	3.29		
PULL #4	3.49	3.36		
PULL #5	3.48	3.47		
TOTAL	17.12	16.87		
AVG.	3.424	3.374		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.28	4.37		4.44
PULL #2	4.36	4.60		4.42
PULL #3	4.34	4.45		4.51
PULL #4	4.38	4.40		4.49
PULL #5	4.39	4.45		4.48
TOTAL	21.75	22.11		22.34
AVG.	4.35	4.434		4.468

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523534
3 Nov 1990

CENTROIDAL DISTANCES

0 TO	1	.236239
1 TO	2	.278927
1 TO	3	.33744
1 TO	4	.269774
1 TO	5	.183861

←----POA

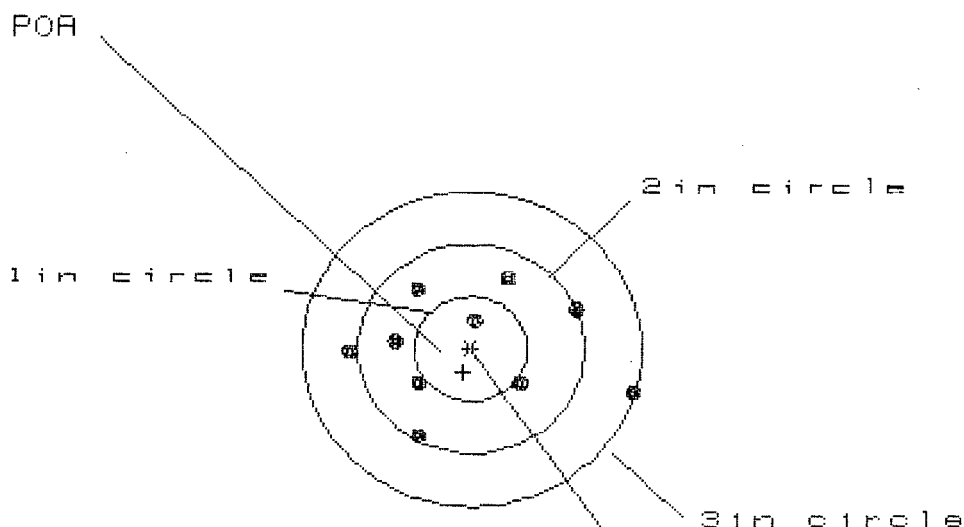
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0604
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0376
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .

THE AMR FOR THIS RIFLE IS: .8926

3 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523534

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS = 2.504

VS = 1.466

GS = 2.532

CENTROID #

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.450	1.100	.988
MINIMUM X	-1.054	-.893	-.605
MAXIMUM Y	.685	.639	.627
MINIMUM Y	-.781	-.827	-.839
CENTROID X	.072	-.089	.023
CENTROID Y	.225	.271	.283
POA TO CENTROID in.	.236	.286	.284
MIN RADIUS	.230	.269	.190
MEAN RADIUS	.803	.702	.674
MAX RADIUS	1.510	1.148	1.038
HORIZONTAL SPREAD	2.504	1.993	1.593
VERTICAL SPREAD	1.466	1.466	1.466
EXTREME SPREAD	2.532	2.038	1.861
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

3 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523534

CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 2

2in = 8

3in = 8

HS= 3.598

VS= 3.021

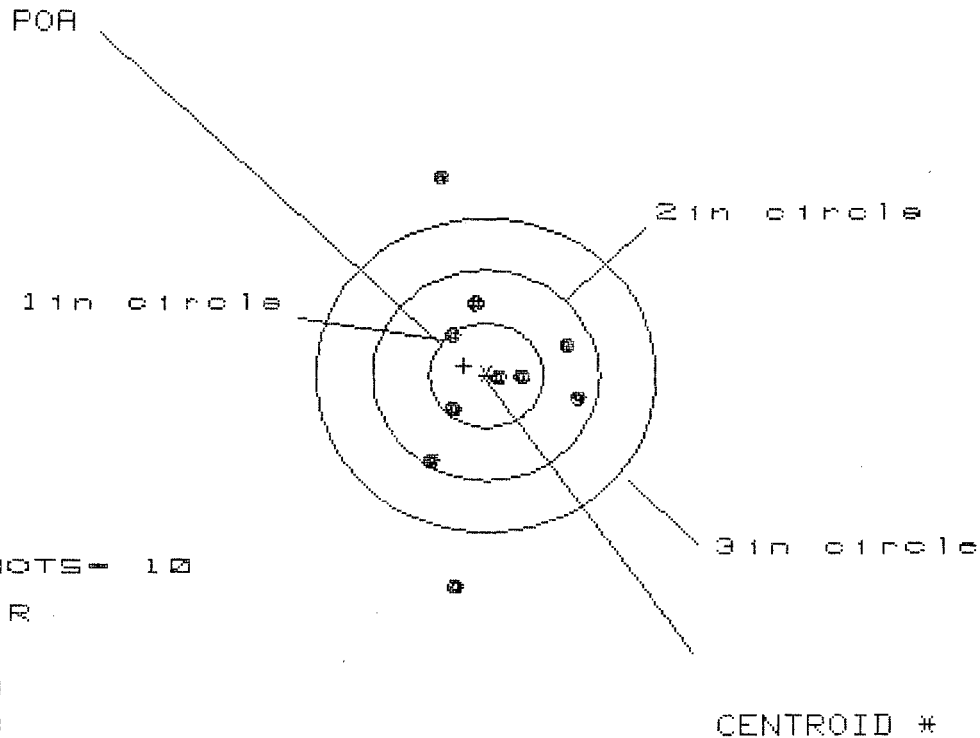
GS= 4.533

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.407	2.275	.776
MINIMUM X	:	-1.191	-.989	-.704
MAXIMUM Y	:	2.212	1.044	1.007
MINIMUM Y	:	-.809	-.564	-.601
CENTROID X	:	.142	.275	-.010
CENTROID Y	:	-.045	-.290	-.253
POA TO CENTROID in.	:	.149	.400	.253
MIN RADIUS	:	.132	.339	.244
MEAN RADIUS	:	1.008	.841	.596
MAX RADIUS	:	2.512	2.295	1.040
HORIZONTAL SPREAD	:	3.598	3.264	1.480
VERTICAL SPREAD	:	3.021	1.608	1.608
EXTREME SPREAD	:	4.533	3.266	1.685
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		8	

3 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523534

CENTERFIRE PATTERNS # 3



OF SHOTS - 10
 # IN CIR
 1in = 4
 2in = 8
 3in = 8
 HS = 1.279
 VS = 3.895
 GS = 3.896

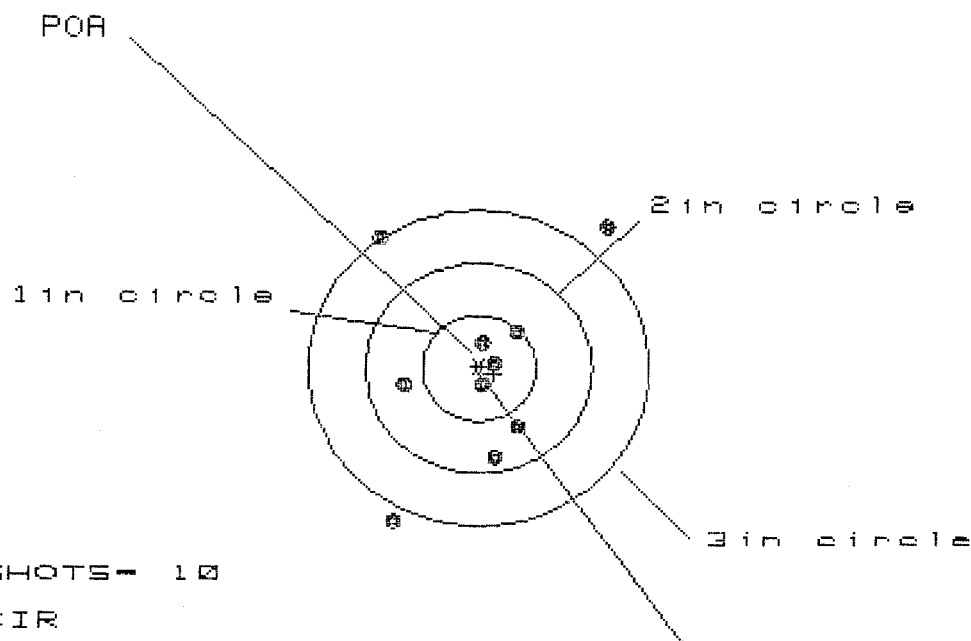
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.774	.740	.684
MINIMUM X	:	-.505	-.539	-.595
MAXIMUM Y	:	1.913	1.693	.725
MINIMUM Y	:	-1.982	-.999	-.788
CENTROID X	:	.193	.227	.283
CENTROID Y	:	-.090	.130	-.081
POA TO CENTROID in.	:	.213	.262	.294
MIN RADIUS	:	.094	.240	.021
MEAN RADIUS	:	.845	.719	.543
MAX RADIUS	:	2.005	1.750	.987
HORIZONTAL SPREAD	:	1.279	1.279	1.279
VERTICAL SPREAD	:	3.895	2.692	1.513
EXTREME SPREAD	:	3.896	2.694	1.626
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		8	

3 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523534

CENTERFIRE PATTERNS

4



OF SHOTS - 10

IN CIR

1in = 4

2in = 7

3in = 7

HS = 2.010

VS = 2.763

GS = 3.348

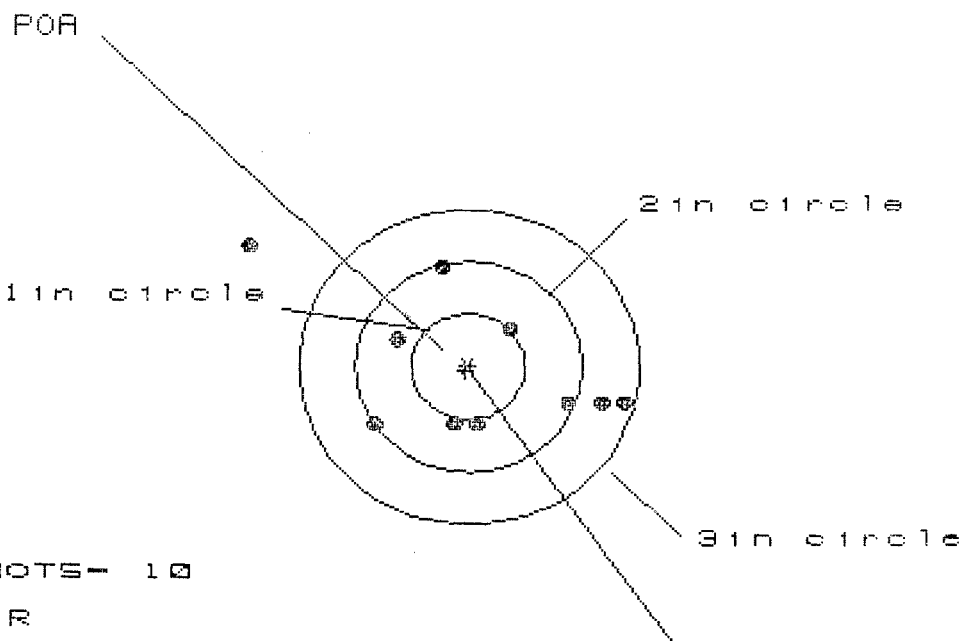
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.159	.502	.426
MINIMUM X	:	-.851	-.722	-.797
MAXIMUM Y	:	1.323	1.384	1.222
MINIMUM Y	:	-1.440	-1.293	-.818
CENTROID X	:	-.135	-.264	-.189
CENTROID Y	:	.052	-.095	.066
POA TO CENTROID in.	:	.145	.280	.200
MIN RADIUS	:	.153	.187	.207
MEAN RADIUS	:	.810	.719	.604
MAX RADIUS	:	1.759	1.561	1.460
HORIZONTAL SPREAD	:	2.010	1.224	1.224
VERTICAL SPREAD	:	2.763	2.677	2.040
EXTREME SPREAD	:	3.348	2.680	2.253
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		7	

3 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06523534

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 9

HS= 3.214

VS= 1.694

GS= 3.522

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.320	1.109	1.103
MINIMUM X	:	-1.894	-1.006	-.867
MAXIMUM Y	:	1.135	1.066	1.044
MINIMUM Y	:	-.559	-.433	-.455
CENTROID X	:	.030	.241	.102
CENTROID Y	:	.046	-.080	-.058
POA TO CENTROID in.	:	.055	.254	.117
MIN RADIUS	:	.477	.407	.399
MEAN RADIUS	:	.997	.833	.787
MAX RADIUS	:	2.208	1.169	1.133
HORIZONTAL SPREAD	:	3.214	2.115	1.970
VERTICAL SPREAD	:	1.694	1.499	1.499
EXTREME SPREAD	:	3.522	2.128	1.978
NUMBER IN ONE INCH CIRCLE	=		1	?
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6523534

DATE 2-8-96

TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.64	2.23	2.56	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.70	2.21	2.54	
PULL #3	2.56	2.22	2.48	
PULL #4	2.56	2.25	2.51	
PULL #5	2.51	2.20	2.47	
TOTAL	12.97	11.11	12.56	
AVG.	2.59	2.22	2.51	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.24	3.03	
PULL #2	3.02	3.00	
PULL #3	3.31	3.03	
PULL #4	3.05	3.01	
PULL #5	3.13	3.02	
TOTAL	15.75	15.09	
AVG.	3.15	3.01	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.32	4.26		4.04
PULL #2	4.38	4.31		4.02
PULL #3	4.27	4.21		4.03
PULL #4	4.03	4.02		4.17
PULL #5	4.33	4.25		4.18
TOTAL	21.33	21.05		20.44
AVG.	4.26	4.21		4.08

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6523534

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	5	5	5			2/23/96	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			2/23/96	WB
	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							
	A) Headspace						2/24/96	RW
	B) Trigger Pull	2.36	2.31	2.33	2.33	2.31	2/23/96	WB
	C) Function						2/24/96	RW
660	Pack							