

C6636224

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

\*Includes 1 in chamber.

*Remington*

M2400031955

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER  
KINZER V. REMINGTON

# Remington®



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

MODEL 700™ H24

SERIAL NO.  
C6636224

ORDER NO.  
5716

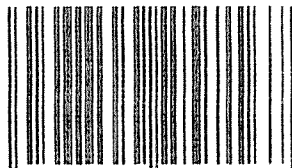
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.

20



5716 C6636224

UPC



0 47700 25716 7

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER  
KINZER V. REMINGTON

M2400031956

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636224

| OP. #        | OP. NAME                                                       | READINGS | DATE       | INIT |
|--------------|----------------------------------------------------------------|----------|------------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   | 6 25 9 1 |            | PW   |
| 600          | Proof                                                          | 6 25 9 1 |            | PW   |
| 607          | Check Headspace                                                | 6 25 9 1 |            | PW   |
| 610          | Dis-assemble Gun                                               | 6 25 9 1 |            | PW   |
| 612          | Magnaflux Barrel<br>Action                                     |          | JUL 1 1991 | KR   |
|              | Magnaflux Bolt                                                 |          | JUL 1 1991 | KR   |
| 615          | Rollmark Caliber                                               |          | JUL 1 1991 | JS   |
| 617          | Drill and Tap Sight Holes                                      |          | JUL 1 1991 | LB   |
| 618          | Polish Barrel                                                  |          | JUL 2 1991 | WB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 8/27/91    | WB   |
|              | Apply Coating (Bolt)                                           |          | 8/27/91    | WB   |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 8/28/91    | WB   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 8/28/91    | WB   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 8/28/91    | WB   |
|              | D) Oil Firing Pin Ass'y                                        |          | 8/28/91    | WB   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 8/28/91    | WB   |

| op. #        | OP. NAME                                                    | READINGS |      |       |      |      | DATE    | INIT    |
|--------------|-------------------------------------------------------------|----------|------|-------|------|------|---------|---------|
| 625<br>cont. | F) Safety On Force                                          | 5 1/2    | 5    | 4 1/2 |      |      | 8/26/91 | DH      |
|              | G) Safety Off Force                                         | 3        | 3    | 3     |      |      | 8/26/91 | DH      |
|              | H) Trigger Pull Test & Retainability                        |          |      |       |      |      | 8/26/91 | JV      |
|              | I) Firing Pin Indent                                        | .022     | .022 | .022  |      |      | 8/26/91 | DH      |
|              | J) Assemble Stock                                           |          |      |       |      |      | 8/29/91 | RW      |
|              | K) Assemble Swivel Studs                                    |          |      |       |      |      | 8-31-91 | DH      |
|              | L) Attach Front and Rear Sight Assemblies                   |          |      |       |      |      | 8/29/91 | RW      |
|              | M) Iron Sight Alignment                                     |          |      |       |      |      | 8/29/91 | RW      |
|              | N) Detach Front & Rear Sights & place in numbered container |          |      |       |      |      | 8/29/91 | RW      |
|              | O) Attach Scope to Rifle                                    |          |      |       |      |      | 8/29/91 | RW      |
|              | P) Detach & Attach Scope 20 Times                           |          |      |       |      |      | 8/29/91 | RW      |
| 640          | Gallery Target & Test                                       |          |      |       |      |      | 8-31-91 | AC      |
|              | A) Time                                                     |          |      |       |      |      | 8-31-91 | AC      |
|              | B) Malfunctions                                             |          |      |       |      |      | 8-31-91 | AC      |
|              | C) Pierced Primers                                          |          |      |       |      |      | 8-31-91 | AC      |
|              | D) Optical Clarity of Scope                                 |          |      |       |      |      | 8-31-91 | AC      |
| 645          | Inspect for Live Ammo                                       |          |      |       |      |      | 8-31-91 | AC      |
| 655          | Final Inspection                                            |          |      |       |      |      | 8-31-91 | DH      |
|              | A) Headspace                                                |          |      |       |      |      |         |         |
|              | B) Trigger Pull                                             | 2.30     | 2.31 | 2.22  | 2.39 | 2.20 | 2.20    | 8/29/91 |
|              | C) Function                                                 |          |      |       |      |      | 8-31-91 | DH      |
| 660          | Pack                                                        |          |      |       |      |      | 9/17/91 | DH      |

SWS TRIGGER PULL TEST

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

SERIAL NO. C6636224

DATE 8-26-91

TESTER JH.

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.23             | 2.40                     | 2.25                           | 2.30 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.25             | 2.30                     | 2.33                           | 2.31 |                                                                        |
| PULL #3 | 2.50             | 2.31                     | 2.30                           | 2.22 |                                                                        |
| PULL #4 | 2.45             | 2.30                     | 2.32                           | 2.39 |                                                                        |
| PULL #5 | 2.39             | 2.16                     | 2.30                           | 2.20 |                                                                        |
| TOTAL   |                  |                          |                                |      |                                                                        |
| AVG.    |                  |                          |                                |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.30             | 3.18                     |  |          |
| PULL #2 | 3.22             | 3.33                     |  |          |
| PULL #3 | 3.23             | 3.35                     |  |          |
| PULL #4 | 3.32             | 3.36                     |  |          |
| PULL #5 | 3.35             | 3.44                     |  |          |
| TOTAL   |                  |                          |  |          |
| AVG.    |                  |                          |  |          |

|         | 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 | 4.26             | 4.44                     |                                | 4.27                                 |
| PULL #2 | 4.24             | 4.20                     |                                | 4.35                                 |
| PULL #3 | 4.41             | 4.33                     |                                | 4.30                                 |
| PULL #4 | 4.21             | 4.42                     |                                | 4.27                                 |
| PULL #5 | 4.24             | 4.26                     |                                | 4.30                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # 06636224  
27 Aug 1991

CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| 0 TO | 1 | .189737 |
| 1 TO | 2 | .112414 |
| 1 TO | 3 | .570601 |
| 1 TO | 4 | .383209 |
| 1 TO | 5 | .255351 |

$\frac{3}{35}$  <----POB

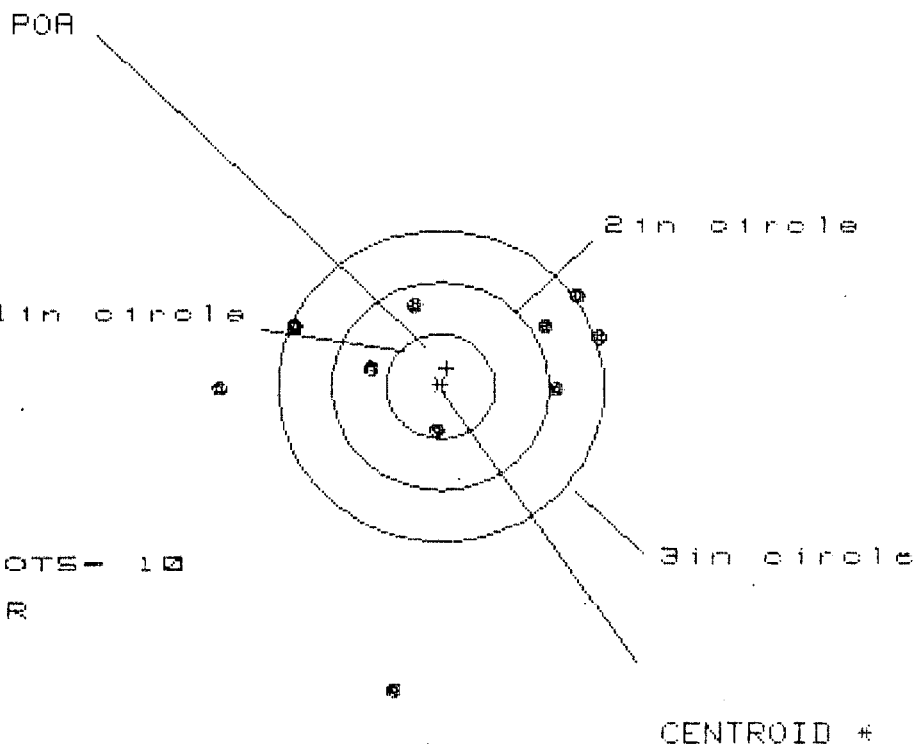
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .055  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0192  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .058255

THE AMR FOR THIS RIFLE IS: .9924

27 Aug 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6636224

# CENTERFIRE PATTERNS # 1



# OF SHOTS- 10

# IN CIR

1in = 1

2in = 3

3in = 6

HS = 3.441

VS = 3.881

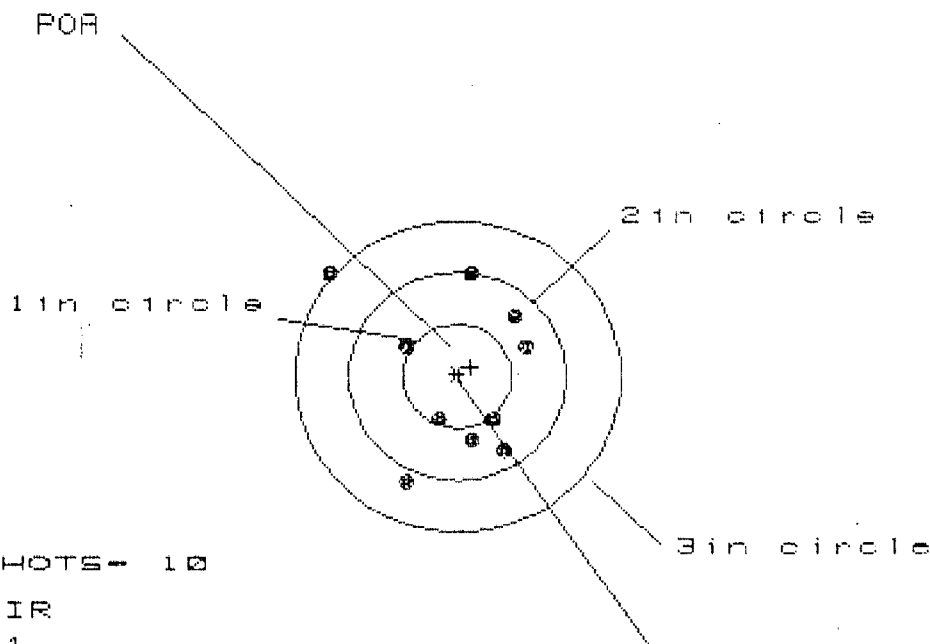
GS = 4.244

|                             |   |        |        |        |
|-----------------------------|---|--------|--------|--------|
| PATTERN #                   | : | 10     | 9      | 8      |
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.430  | 1.379  | 1.121  |
| MINIMUM X                   | : | -2.011 | -2.062 | -1.641 |
| MAXIMUM Y                   | : | .915   | .585   | .541   |
| MINIMUM Y                   | : | -2.966 | -1.752 | -1.796 |
| CENTROID X                  | : | -.060  | -.009  | .249   |
| CENTROID Y                  | : | -.180  | .150   | .194   |
| POA TO CENTROID in.         | : | .190   | .150   | .316   |
| MIN RADIUS                  | : | .422   | .540   | .680   |
| MEAN RADIUS                 | : | 1.361  | 1.140  | .993   |
| MAX RADIUS                  | : | 3.002  | 2.093  | 1.653  |
| HORIZONTAL SPREAD           | : | 3.441  | 3.441  | 2.762  |
| VERTICAL SPREAD             | : | 3.881  | 1.337  | 1.337  |
| EXTREME SPREAD              | : | 4.244  | 3.482  | 2.763  |
| NUMBER IN ONE INCH CIRCLE   | = | 1      |        |        |
| NUMBER IN TWO INCH CIRCLE   | = | 3      |        |        |
| NUMBER IN THREE INCH CIRCLE | = | 6      |        |        |

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# CENTERFIRE PATTERNS # 2



# OF SHOTS- 10

# IN CIR

1in = 1

2in = 8

3in = 10

HS= 1.768

VS= 1.995

GS= 2.255

CENTROID #

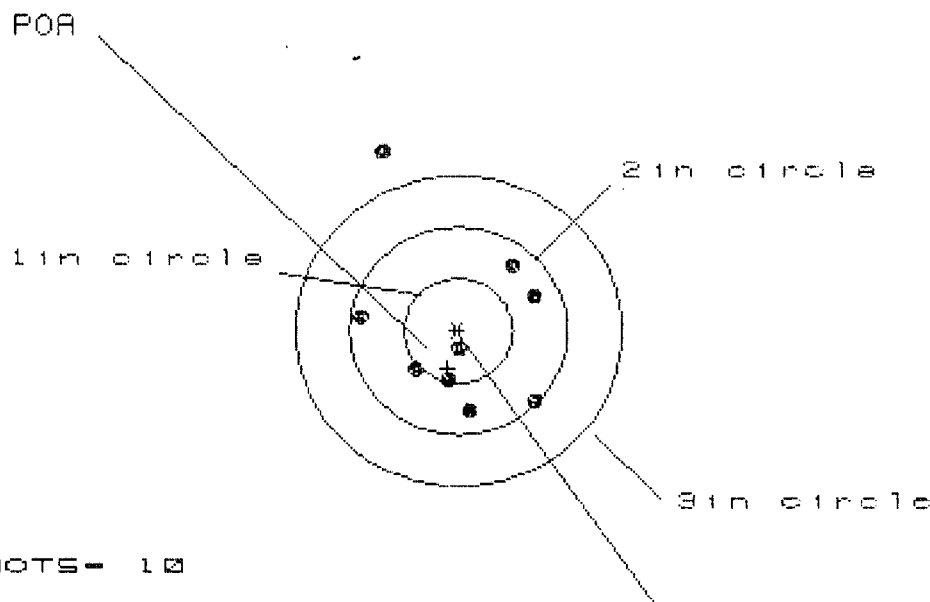
|                             |   |        |       |       |
|-----------------------------|---|--------|-------|-------|
| PATTERN #                   | : | 2      |       |       |
| SHOTS (BEST OF)             | : | 10     | 9     | 8     |
| MAXIMUM X                   | : | .636   | .510  | .432  |
| MINIMUM X                   | : | -1.132 | -.622 | -.650 |
| MAXIMUM Y                   | : | .955   | 1.061 | .944  |
| MINIMUM Y                   | : | -1.040 | -.934 | -.682 |
| CENTROID X                  | : | -.126  | -.000 | .078  |
| CENTROID Y                  | : | -.089  | -.195 | -.078 |
| POA TO CENTROID in.         | : | .154   | .195  | .110  |
| MIN RADIUS                  | : | .414   | .392  | .454  |
| MEAN RADIUS                 | : | .795   | .690  | .637  |
| MAX RADIUS                  | : | 1.477  | 1.122 | .946  |
| HORIZONTAL SPREAD           | : | 1.768  | 1.132 | 1.083 |
| VERTICAL SPREAD             | : | 1.995  | 1.995 | 1.626 |
| EXTREME SPREAD              | : | 2.255  | 2.097 | 1.651 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 1     |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 8     |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 10    |       |



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# CENTERFIRE PATTERNS # 3



# OF SHOTS- 10

# IN CIR

1in = 3

2in = 9

3in = 9

HS= 1.640

VS= 2.484

GS= 2.699

CENTROID \*

|                             |   |       |       |       |
|-----------------------------|---|-------|-------|-------|
| PATTERN #                   | : | 3     |       |       |
| SHOTS (BEST OF)             | : | 10    | 9     | 8     |
| MAXIMUM X                   | : | .749  | .673  | .746  |
| MINIMUM X                   | : | -.891 | -.967 | -.894 |
| MAXIMUM Y                   | : | 1.711 | .849  | .794  |
| MINIMUM Y                   | : | -.773 | -.583 | -.638 |
| CENTROID X                  | : | .099  | .175  | .102  |
| CENTROID Y                  | : | .368  | .178  | .233  |
| POA TO CENTROID in.         | : | .381  | .249  | .254  |
| MIN RADIUS                  | : | .148  | .059  | .039  |
| MEAN RADIUS                 | : | .773  | .592  | .573  |
| MAX RADIUS                  | : | 1.843 | 1.011 | .959  |
| HORIZONTAL SPREAD           | : | 1.640 | 1.640 | 1.640 |
| VERTICAL SPREAD             | : | 2.484 | 1.432 | 1.432 |
| EXTREME SPREAD              | : | 2.699 | 1.713 | 1.662 |
| NUMBER IN ONE INCH CIRCLE   | = |       | 3     |       |
| NUMBER IN TWO INCH CIRCLE   | = |       | 9     |       |
| NUMBER IN THREE INCH CIRCLE | = |       | 9     |       |

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# CENTERFIRE PATTERNS

# 4

POA

1in circle

2in circle

3in circle

# OF SHOTS- 10

# IN CIR

1in = 3

2in = 5

3in = 10

HS= 2.564

VS= 1.547

GS= 2.675

CENTROID #

| PATTERN #                     | 4      | 9      | 8      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.237  | 1.125  | 1.135  |
| MINIMUM X                     | -1.327 | -1.439 | -1.298 |
| MAXIMUM Y                     | .621   | .518   | .571   |
| MINIMUM Y                     | -.926  | -.477  | -.424  |
| CENTROID X                    | .172   | .284   | .143   |
| CENTROID Y                    | .125   | .228   | .175   |
| POA TO CENTROID in.           | .212   | .364   | .227   |
| MIN RADIUS                    | .173   | .226   | .179   |
| MEAN RADIUS                   | .828   | .774   | .686   |
| MAX RADIUS                    | 1.371  | 1.464  | 1.316  |
| HORIZONTAL SPREAD             | 2.564  | 2.564  | 2.433  |
| VERTICAL SPREAD               | 1.547  | .995   | .995   |
| EXTREME SPREAD                | 2.675  | 2.655  | 2.433  |
| NUMBER IN ONE INCH CIRCLE =   | 3      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 5      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 10     |        |        |

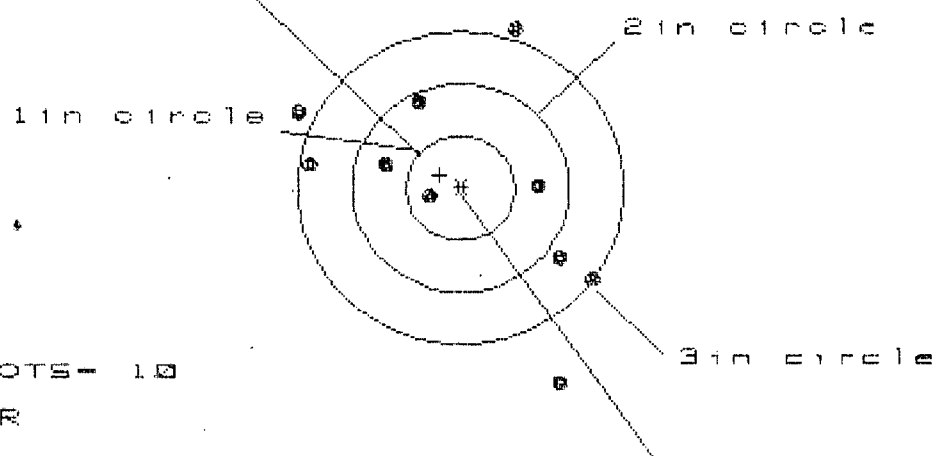
27 Aug 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6636224

# CENTERFIRE PATTERNS

# 5

POA



# OF SHOTS- 10

# IN CIR

1in = 1

2in = 4

3in = 5

HS= 2.784

VS= 3.457

GS= 3.561

CENTROID #

| PATTERN #                   | 5      | 6      | 7      |
|-----------------------------|--------|--------|--------|
| SHOTS (BEST OF)             | 10     | 9      | 8      |
| MAXIMUM X                   | 1.259  | 1.358  | 1.180  |
| MINIMUM X                   | -1.525 | -1.426 | -1.453 |
| MAXIMUM Y                   | 1.539  | 1.326  | 1.387  |
| MINIMUM Y                   | -1.918 | -1.110 | -1.049 |
| CENTROID X                  | .190   | .091   | .269   |
| CENTROID Y                  | -.128  | .085   | .025   |
| POA TO CENTROID in.         | .229   | .125   | .270   |
| MIN RADIUS                  | .255   | .315   | .392   |
| MEAN RADIUS                 | 1.205  | 1.079  | 1.031  |
| MAX RADIUS                  | 2.115  | 1.754  | 1.579  |
| HORIZONTAL SPREAD           | 2.784  | 2.784  | 2.633  |
| VERTICAL SPREAD             | 3.457  | 2.436  | 2.436  |
| EXTREME SPREAD              | 3.561  | 3.208  | 2.847  |
| NUMBER IN ONE INCH CIRCLE   | = 1    |        |        |
| NUMBER IN TWO INCH CIRCLE   | = 4    |        |        |
| NUMBER IN THREE INCH CIRCLE | = 5    |        |        |