

C6611691

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



M2400034424

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

Remington[®]

MODEL 700TM H24

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

UPPONT
REG. U.S. PAT. & T.M. OFF.

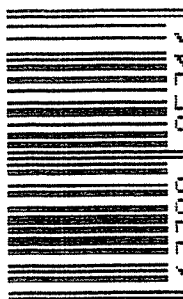
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

SERIAL NO. C6611691	ORDER NO. 5716
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5716 C6611691

UPC



0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611691

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 28	91	RW
600	Proof	3 28	91	RW
607	Check Headspace	3 28	91	RW
610	Dis-assemble Gun	3 28		RW
612	Magnaflux Barrel Action	APR	2 1991	KR
	Magnaflux Bolt	APR	2 1991	U
615	Rollmark Caliber	APR	2 1991	JS
617	Drill and Tap Sight Holes	APR	5 1991	FB
618	Polish Barrel	APR	5 1991	WB
620	Apply Coatings (Barrel Action)			JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/16/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/16/91	RW
	C) Inspect Ejector Hole for Chamfer		4/16/91	RW
	D) Oil Firing Pin Ass'y		4/16/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/1/91	JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5/1/91	JK
	G) Safety Off Force	4	4	4			5/1/91	JK
	H) Trigger Pull Test & Retainability						5/1/91	JK
	I) Firing Pin Indent	.0205	.021	.021			5/1/91	JK
	J) Assemble Stock						5/2/91	RW
	K) Assemble Swivel Studs						5/6-91	D/H
	L) Attach Front and Rear Sight Assemblies						5/2/91	RW
	M) Iron Sight Alignment						5/2/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/2/91	RW
	O) Attach Scope to Rifle						5/2/91	RW
	P) Detach & Attach Scope 20 Times						5/2/91	RW
640	Gallery Target & Test						5/2/91	KT
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	KT
645	Inspect for Live Ammo						5/2/91	KT
655	Final Inspection							
	A) Headspace						5/6-91	D/H
	B) Trigger Pull	2.33	2.32	2.37	2.37	2.40	5/10/91	JK
	C) Function						5/6-91	D/H
660	Pack						6-18-91	N-

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6611891

DATE 5/1/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.52	2.35	2.48	2.33	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.37	2.46	2.51	2.32	
PULL #3	2.18	2.48	2.43	2.37	
PULL #4	2.36	2.51	2.50	2.37	
PULL #5	2.46	2.50	2.51	2.40	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.22	3.30		
PULL #2	3.21	3.30		
PULL #3	3.21	3.40		
PULL #4	3.27	3.44		
PULL #5	3.26	3.44		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.33	4.29		4.36
PULL #2	4.29	4.27		4.34
PULL #3	4.29	4.34		4.30
PULL #4	4.31	4.28		4.26
PULL #5	4.11	4.36		4.36
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611691
2 May 1991

CENTROIDAL DISTANCES

0 TO 1	.17429
1 TO 2	.224415
1 TO 3	.138311
1 TO 4	.139435
1 TO 5	.0900222

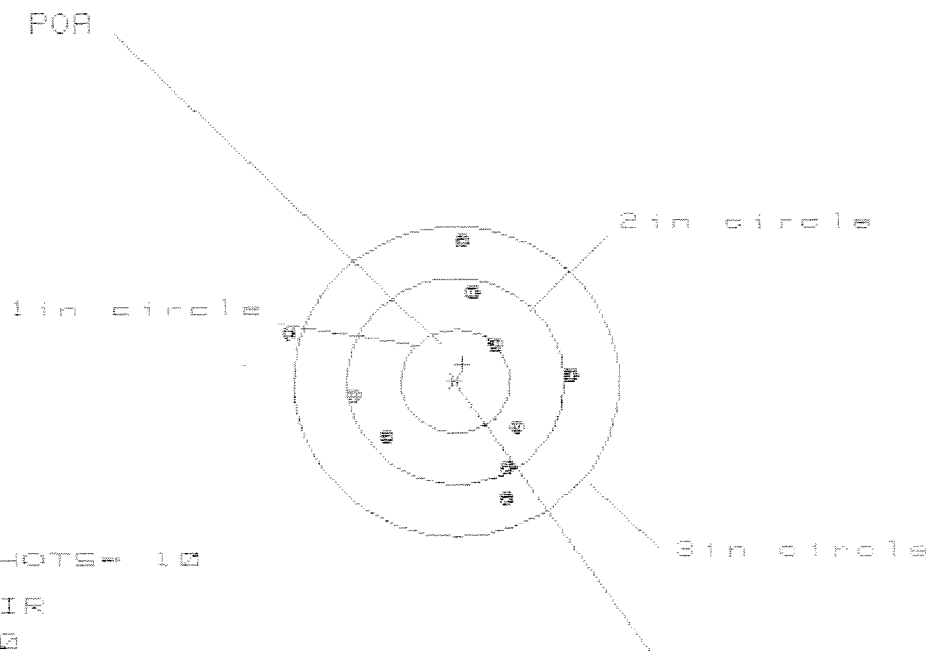
☒ <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0432
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0854
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0957048
THE AMR FOR THIS RIFLE IS: .9544

2 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611691

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 0

2in = 5

3in = 9

HS= 2.656

VS= 2.486

GS= 2.688

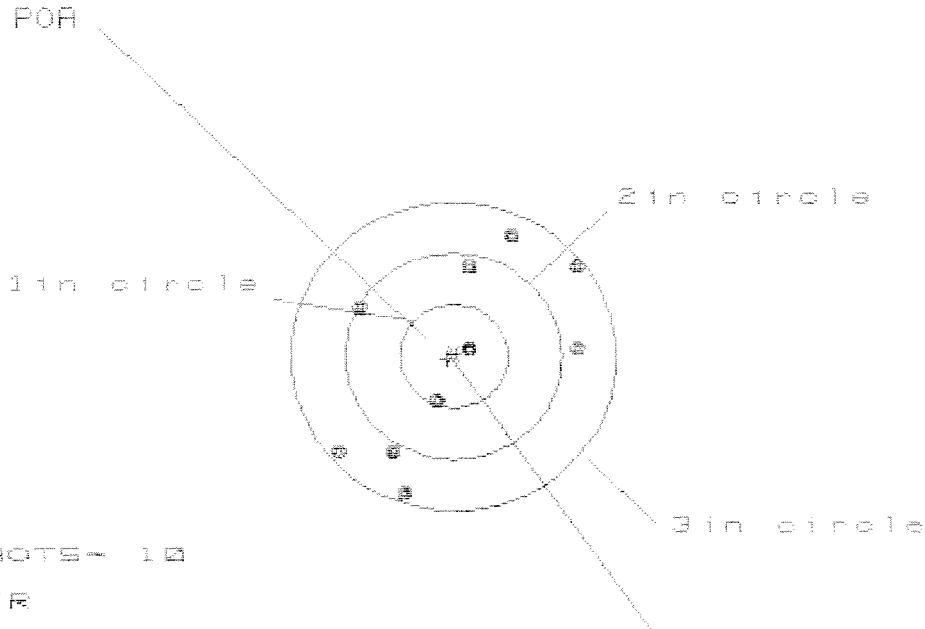
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.077	.902	.893
MINIMUM X	:	-1.579	-1.141	-1.150
MAXIMUM Y	:	1.326	1.374	1.043
MINIMUM Y	:	-1.160	-1.112	-.940
CENTROID X	:	-.059	.116	.126
CENTROID Y	:	-.164	-.212	-.384
POA TO CENTROID in.	:	.174	.242	.404
MIN RADIUS	:	.518	.473	.385
MEAN RADIUS	:	.999	.900	.823
MAX RADIUS	:	1.638	1.376	1.154
HORIZONTAL SPREAD	:	2.656	2.043	2.043
VERTICAL SPREAD	:	2.486	2.486	1.983
EXTREME SPREAD	:	2.688	2.515	2.049
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

2 May 1981

FILE:/PATTERNING/CENTERFIRE_PATT/C6611691

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 10

HS= 2.138

VS= 2.417

GS= 2.794

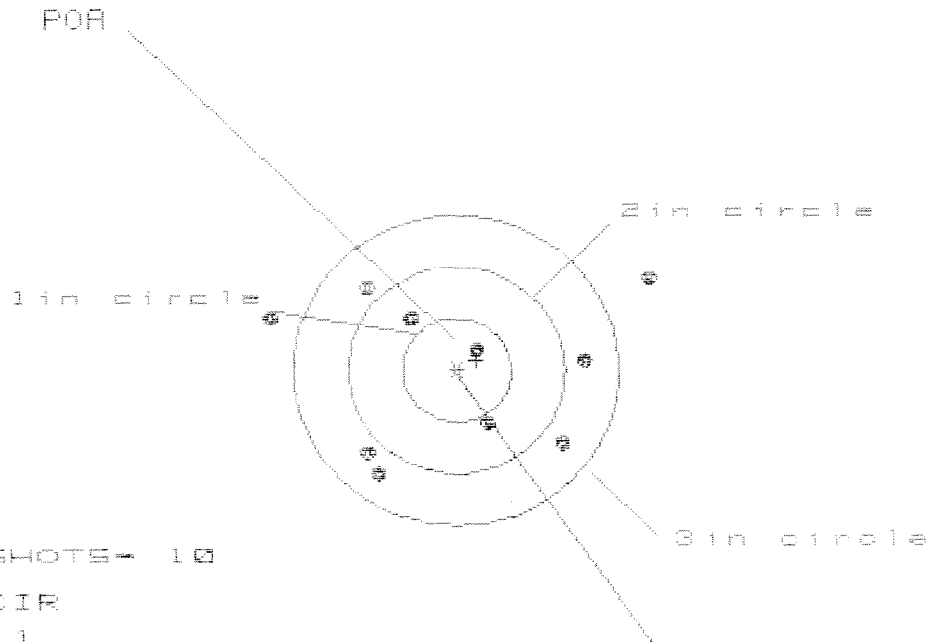
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.095	.979	1.099
MINIMUM X	:	-1.043	-.940	-.818
MAXIMUM Y	:	1.138	1.034	1.130
MINIMUM Y	:	-1.279	-1.383	-1.287
CENTROID X	:	.062	.178	.056
CENTROID Y	:	.025	.129	.033
POA TO CENTROID in.	:	.067	.220	.065
MIN RADIUS	:	.188	.060	.191
MEAN RADIUS	:	1.005	.943	.907
MAX RADIUS	:	1.398	1.494	1.362
HORIZONTAL SPREAD	:	2.138	1.919	1.917
VERTICAL SPREAD	:	2.417	2.417	2.417
EXTREME SPREAD	:	2.794	2.645	2.625
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

2 May 1991

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CENTERFIRE PATTERNS # 3



HS= 3.552
VS= 1.960
GS= 3.580

PATTERN #	1	3	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.817	1.424	1.232
MINIMUM X	-1.735	-1.533	-0.856
MAXIMUM Y	.919	.907	.978
MINIMUM Y	-1.041	-.938	-.867
CENTROID X	-.180	-.382	-.190
CENTROID Y	-.097	-.280	-.271
POA TO CENTROID IN.	.205	.431	.331
MIN RADIUS	.273	.492	.422
MEAN RADIUS	1.123	1.022	.921
MAX RADIUS	2.036	1.637	1.300
HORIZONTAL SPREAD	3.552	2.957	2.088
VERTICAL SPREAD	1.960	1.845	1.845
EXTREME SPREAD	3.580	2.981	2.340
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =			8

2 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CGB11691

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 0

2in = 7

3in = 10

HS= 1.478

VS= 2.240

GS= 2.244

CENTROID #

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.781

.755

.787

MINIMUM X

-.697

-.723

-.771

MAXIMUM Y

1.204

.695

.583

MINIMUM Y

-1.036

-.903

-.628

CENTROID X

-.070

-.044

.004

CENTROID Y

-.025

-.158

-.046

POA TO CENTROID in.

.074

.164

.046

MIN RADIUS

.581

.665

.546

MEAN RADIUS

.827

.781

.741

MAX RADIUS

1.226

.981

.946

HORIZONTAL SPREAD

1.478

1.478

1.478

VERTICAL SPREAD

2.240

1.598

1.210

EXTREME SPREAD

2.244

1.755

1.754

NUMBER IN ONE INCH CIRCLE =

0

NUMBER IN TWO INCH CIRCLE =

7

NUMBER IN THREE INCH CIRCLE =

10

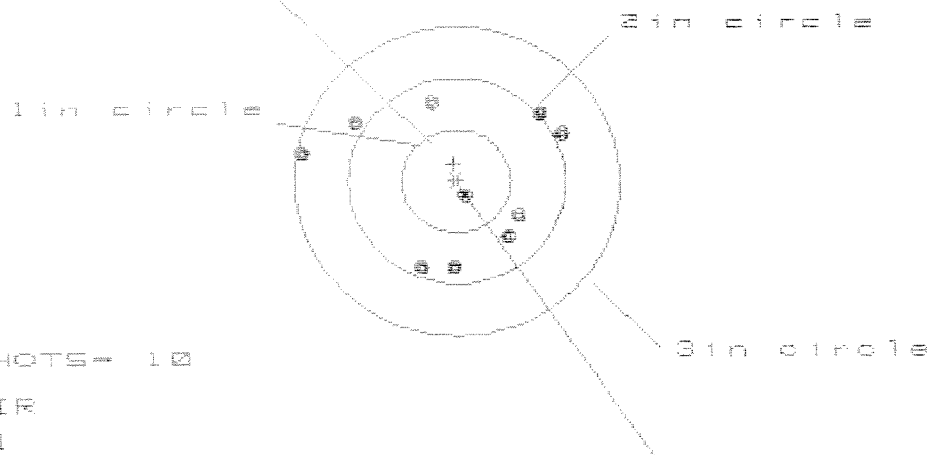
2 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08611691

CENTERFIRE PATTERNS

5

POA



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 7

3 in = 10

HS= 2.458

VS= 1.594

GS= 2.468

CENTROID #

PATTERN #

5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.013	.852	.697
MINIMUM X	-1.445	-1.083	-.976
MAXIMUM Y	.749	.779	.844
MINIMUM Y	-.845	-.815	-.749
CENTROID X	.031	.192	.085
CENTROID Y	-.166	-.196	-.261
POA TO CENTROID in.	.169	.274	.275
MIN RADIUS	.149	.125	.040
MEAN RADIUS	.868	.775	.731
MAX RADIUS	1.470	1.215	1.154
HORIZONTAL SPREAD	2.458	1.935	1.673
VERTICAL SPREAD	1.594	1.594	1.594
EXTREME SPREAD	2.468	1.935	1.796
NUMBER IN ONE INCH CIRCLE	= 1		
NUMBER IN TWO INCH CIRCLE	= 7		
NUMBER IN THREE INCH CIRCLE	= 10		