

C6611748

MODEL 700™ M24

Model SWS™

Action _____

Barrel Length _____

Capacity _____

Order No. 5715

*Includes 1 in chamber.

Remington

M2400035309

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON



MODEL 700™ H24



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

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

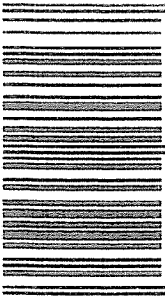
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

4.6

SERIAL NO.
C6611748

ORDER NO.
5716

UPC



0 47700 25716 7



5716 C6611748

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611748

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 10 91		RW
600	Proof	1 10 91		RW
607	Check Headspace	1 10 91		RW
610	Dis-assemble Gun	1 10 91		RW
612	Magnaflux Barrel Action		1/14/91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	LS.
617	Drill and Tap Sight Holes	1 17 91		LB
618	Polish Barrel	1 17 91		WB
620	Apply Coatings (Barrel Action)		2-18-91	LB
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/10/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/10/91	RW
	C) Inspect Ejector Hole for Chamfer		4/10/91	RW
	D) Oil Firing Pin Ass'y		4/10/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4/24/91	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			4/24/91	RU
	G) Safety Off Force	4	4	4			4/24/91	RU
	H) Trigger Pull Test & Retainability						4/24/91	RU
	I) Firing Pin Indent	.022	.0225	.0225			4/24/91	RU
	J) Assemble Stock						4/25/91	RW
	K) Assemble Swivel Studs						4-30-91	DH
	L) Attach Front and Rear Sight Assemblies						4/25/91	RW
	M) Iron Sight Alignment						4/25/91	RW
	N) Detach Front & Rear Sights & place in numbered container						4/25/91	RW
	O) Attach Scope to Rifle						4/25/91	RW
	P) Detach & Attach Scope 20 Times						4/25/91	RW
640	Gallery Target & Test						4-25-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						4-25-91	AF
655	Final Inspection							
	A) Headspace						4-30-91	DH
	B) Trigger Pull	2.57	2.55	2.55	2.60	2.64	4/26/91	RU
	C) Function						4-30-91	DH
660	Pack						6-18-91	AF

SWS TRIGGER PULL TEST

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

SERIAL NO. C 6611748
DATE 4/24/91
TESTER [Signature]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.30	2.48	2.57	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.35	2.36	2.35	2.55	
PULL #3	2.41	2.50	2.48	2.55	
PULL #4	2.28	2.26	2.36	2.60	
PULL #5	2.34	2.35	2.36	2.64	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.57	3.38		
PULL #2	3.56	3.45		
PULL #3	3.55	3.32		
PULL #4	3.48	3.48		
PULL #5	3.53	3.43		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.20	4.36		4.49
PULL #2	4.53	4.53		4.28
PULL #3	4.38	4.41		4.56
PULL #4	4.30	4.56		4.58
PULL #5	4.40	4.46		4.49
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611748
25 Apr 1991

CENTROIDAL DISTANCES

0 TO 1	.178466
1 TO 2	.198595
1 TO 3	.0863771
1 TO 4	.12256
1 TO 5	.0674463

< ---- POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0714
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0548
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0900036

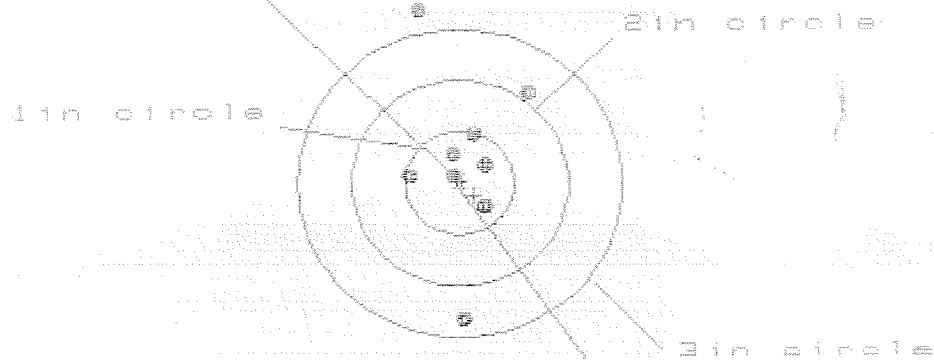
THE RMR FOR THIS RIFLE IS: .6629

25 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611748

CENTERFIRE PATTERNS # 1

POA



OF SHOTS- 10

IN CIR

1in = 6

2in = 6

3in = 8

HS= 1.027

VS= 3.923

GS= 3.925

CENTROID #

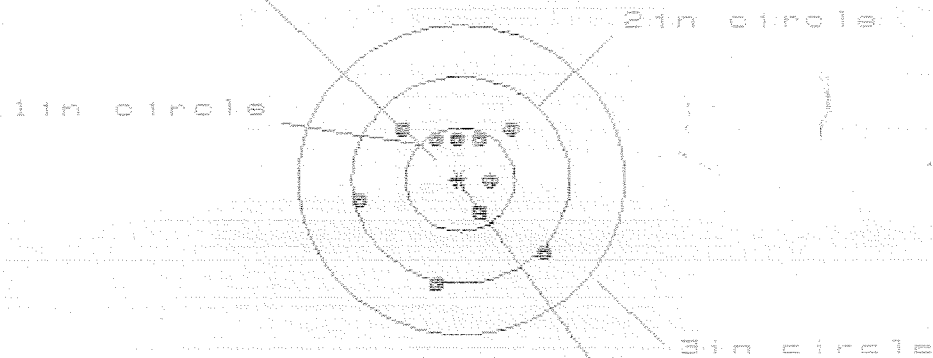
PATTERN #			
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.605	.574	.519
MINIMUM X	-.422	-.453	-.508
MAXIMUM Y	1.720	1.475	.835
MINIMUM Y	-2.203	-1.522	-1.337
CENTROID X	-.133	-.102	-.047
CENTROID Y	.119	.364	.179
POA TO CENTROID in.	.178	.378	.196
MIN RADIUS	.071	.127	.108
MEAN RADIUS	.820	.629	.510
MAX RADIUS	2.221	1.538	1.340
HORIZONTAL SPREAD	1.027	1.027	1.027
VERTICAL SPREAD	3.923	2.997	2.173
EXTREME SPREAD	3.925	3.024	2.255
NUMBER IN ONE INCH CIRCLE =		6	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

25 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8511748

CENTERFIRE PATTERNS # 2

POA



OF SHOTS- 10

IN CIR

1in - 5

2in - 8

3in - 10

HS= 1.692

VS= 1.470

GS= 1.760

CENTROID #

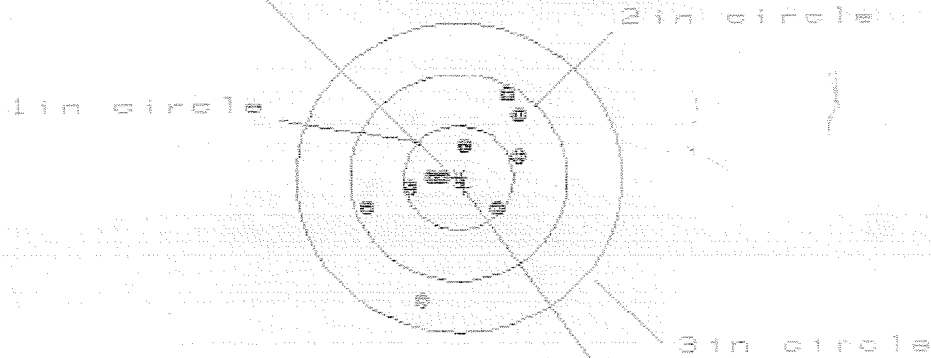
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.807	.556	.534
MINIMUM X	:	-.885	-.795	-.817
MAXIMUM Y	:	.500	.424	.293
MINIMUM Y	:	-.970	-1.046	-.529
CENTROID X	:	.031	-.059	-.037
CENTROID Y	:	.007	.083	.213
POA TO CENTROID in.	:	.032	.102	.217
MIN RADIUS	:	.278	.319	.189
MEAN RADIUS	:	.629	.571	.475
MAX RADIUS	:	1.055	1.061	.922
HORIZONTAL SPREAD	:	1.692	1.351	1.351
VERTICAL SPREAD	:	1.470	1.470	.823
EXTREME SPREAD	:	1.760	1.543	1.531
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

25 Apr 1991

FILE: \PATTERNING\CENTERFIRE_PATT\CG511748

CENTERFIRE PATTERNS # 3

POA



OF SHOTS = 10

IN CIR

1in = 5

2in = 9

3in = 10

HS = 1.402

VS = 2.014

GS = 2.160

CENTROID *

PATTERN #

3

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.569

.527

.417

MINIMUM X

-.833

-.875

-.555

MAXIMUM Y

.793

.657

.601

MINIMUM Y

-1.221

-.450

-.471

CENTROID X

-.052

-.010

.100

CENTROID Y

.089

.225

.281

POA TO CENTROID in.

.103

.225

.299

MIN RADIUS

.104

.199

.181

MEAN RADIUS

.597

.516

.459

MAX RADIUS

1.279

.984

.651

HORIZONTAL SPREAD

1.402

1.402

.972

VERTICAL SPREAD

2.014

1.107

1.072

EXTREME SPREAD

2.160

1.665

1.162

NUMBER IN ONE INCH CIRCLE =

5

NUMBER IN TWO INCH CIRCLE =

9

NUMBER IN THREE INCH CIRCLE =

10

25 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611748

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 6

2in = 9

3in = 10

HS = 1.490

VS = 1.500

GS = 1.739

CENTROID #

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.715

.699

.612

MINIMUM X

-.775

-.696

-.465

MAXIMUM Y

.566

.462

.444

MINIMUM Y

-.934

-.544

-.562

CENTROID X

-.088

-.167

-.080

CENTROID Y

.005

.109

.127

POA TO CENTROID in.

.088

.199

.150

MIN RADIUS

.240

.244

.207

MEAN RADIUS

.562

.476

.439

MAX RADIUS

1.176

.710

.615

HORIZONTAL SPREAD

1.490

1.395

1.077

VERTICAL SPREAD

1.500

1.006

1.006

EXTREME SPREAD

1.739

1.412

1.156

NUMBER IN ONE INCH CIRCLE =

6

NUMBER IN TWO INCH CIRCLE =

9

NUMBER IN THREE INCH CIRCLE =

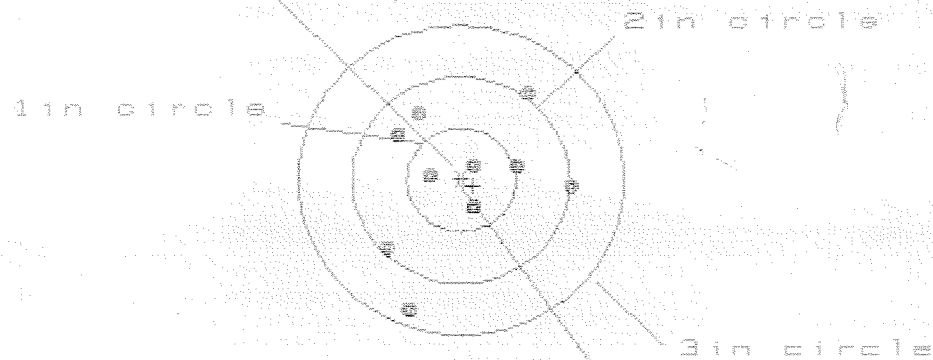
10

25 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CG611748

CENTERFIRE PATTERNS # 5

FOR



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.603

VS= 2.086

GS= 2.404

CENTROID *

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.968

.989

.984

MINIMUM X

-.635

-.694

-.619

MAXIMUM Y

.835

.696

.636

MINIMUM Y

-1.251

-.827

-.740

CENTROID X

-.115

-.056

-.131

CENTROID Y

.054

.193

.106

FOR TO CENTROID in.

.127

.201

.169

MIN RADIUS

.160

.077

.149

MEAN RADIUS

.706

.621

.577

MAX RADIUS

1.360

1.080

.990

HORIZONTAL SPREAD

1.603

1.603

1.603

VERTICAL SPREAD

2.086

1.523

1.376

EXTREME SPREAD

2.404

2.000

1.722

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

8

NUMBER IN THREE INCH CIRCLE =

10