

C6636109

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5715**

* Includes 1 in chamber.



M2400037849

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

Call

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

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

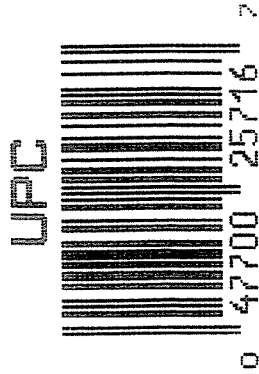
MODEL 700™ M24

SERIAL NO. C6636109

ORDER NO. 5716

20

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



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636109

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	5 2 9 1		RW
600	Proof	5 2 9 1		RW
607	Check Headspace	5 2 9 1		RW
610	Dis-assemble Gun	5 2 9 1		RW
612	Magnaflux Barrel Action	5 8 9 1		KCR
	Magnaflux Bolt	5 8 9 1		KCR
615	Rollmark Caliber	5 8 9 1		CS
617	Drill and Tap Sight Holes	5 15 9 1		EB
618	Polish Barrel	5 15 9 1		WB
620	Apply Coatings (Barrel Action)		5-29-91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/30/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/91	RW
	C) Inspect Ejector Hole for Chamfer		5/30/91	RW
	D) Oil Firing Pin Ass'y		5/30/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		6-4-91	RL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			6-4-91	DH
	G) Safety Off Force	3	3	3			6-4-91	DH
	H) Trigger Pull Test & Retainability						6-4-91	SC
	I) Firing Pin Indent	.020	.021	.020			6-4-91	DH
	J) Assemble Stock						6/5/91	RW
	K) Assemble Swivel Studs						6-8-91	DH
	L) Attach Front and Rear Sight Assemblies						6/5/91	RW
	M) Iron Sight Alignment						6/5/91	RW
	N) Detach Front & Rear Sights & place in numbered container						6/5/91	RW
	O) Attach Scope to Rifle						6/5/91	RW
	P) Detach & Attach Scope 20 Times						6/5/91	RW
640	Gallery Target & Test						6-6-91	DH
	A) Time						6-6-91	DH
	B) Malfunctions						6-6-91	DH
	C) Pierced Primers						6-6-91	DH
	D) Optical Clarity of Scope						6-6-91	DH
645	Inspect for Live Ammo						6-6-91	DH
655	Final Inspection						6-8-91	DH
	A) Headspace						6-8-91	DH
	B) Trigger Pull	2.44	2.37	2.41	2.46	2.45	6/8/91	SC
	C) Function						6-8-91	DH
660	Pack						6-20-91	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6636109

DATE 6-4-91

TESTER JM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.34	2.38	2.44	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.25	2.43	2.40	2.37	
PULL #3	2.22	2.20	2.36	2.41	
PULL #4	2.45	2.37	2.31	2.46	
PULL #5	2.44	2.31	2.31	2.45	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.57	3.64		
PULL #2	3.59	3.56		
PULL #3	3.58	3.55		
PULL #4	3.58	3.52		
PULL #5	3.53	3.58		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.34	4.16		4.26
PULL #2	4.23	4.30		4.39
PULL #3	4.40	4.39		4.44
PULL #4	4.40	4.15		4.41
PULL #5	4.26	4.21		4.44
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636109
6 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.223134
1 TO	2	.045
1 TO	3	.25
1 TO	4	.208125
1 TO	5	.219009

8 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1256
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .059
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .138767

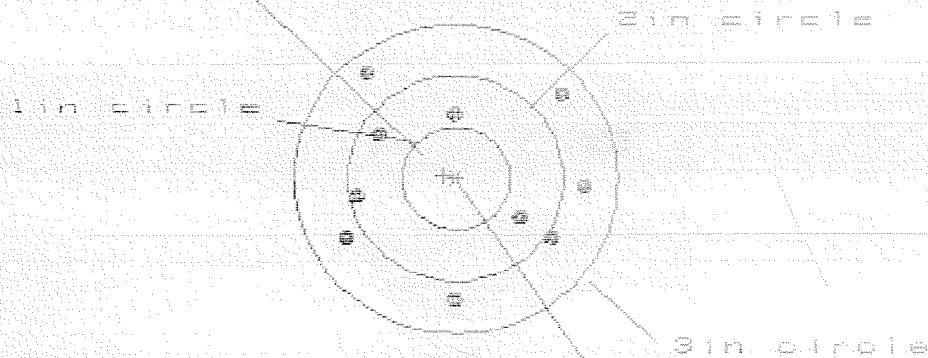
THE AMR FOR THIS RIFLE IS: .9888

6 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636189

CENTERFIRE PATTERNS # 5

POA



OF SHOTS = 10

IN CIR

1in = 0

2in = 4

3in = 10

HS = 2.197

VS = 2.199

GS = 2.515

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.145	1.256	1.165
MINIMUM X	:	-1.052	-.941	-1.032
MAXIMUM Y	:	1.016	1.113	.879
MINIMUM Y	:	-1.183	-1.086	-.947
CENTROID X	:	.115	.004	-.095
CENTROID Y	:	-.029	-.126	-.265
POA TO CENTROID in.	:	.118	.126	.281
MIN RADIUS	:	.645	.743	.662
MEAN RADIUS	:	1.038	.999	.949
MAX RADIUS	:	1.322	1.331	1.176
HORIZONTAL SPREAD	:	2.197	2.197	2.197
VERTICAL SPREAD	:	2.199	2.199	1.826
EXTREME SPREAD	:	2.515	2.348	2.257
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

6 Jun 1991

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CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 4

2 in = 6

3 in = 10

HS= 1.718

VS= 2.123

GS= 2.399

PATTERN #

4

SHOTS (BEST OF)

10

9

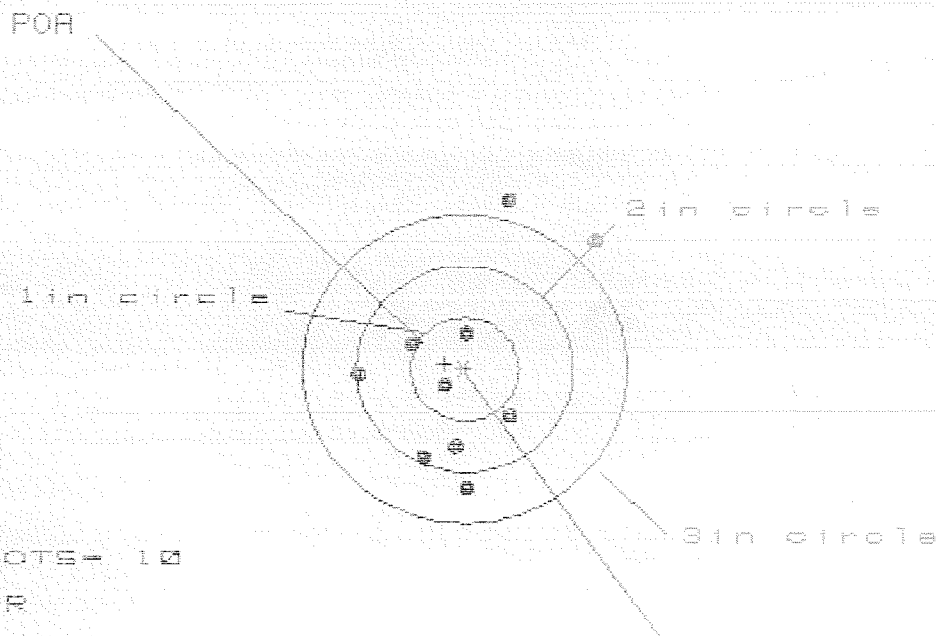
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MAXIMUM X	.877	.784	.886
MINIMUM X	-.841	-.647	-.625
MAXIMUM Y	1.176	1.070	.546
MINIMUM Y	-.947	-.787	-.653
CENTROID X	.047	.140	.118
CENTROID Y	-.006	.100	-.034
POA TO CENTROID in.	.047	.172	.123
MIN RADIUS	.308	.187	.322
MEAN RADIUS	.733	.677	.614
MAX RADIUS	1.267	1.110	1.037
HORIZONTAL SPREAD	1.718	1.431	1.431
VERTICAL SPREAD	2.123	1.857	1.199
EXTREME SPREAD	2.399	1.952	1.683
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

6 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636109

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 8

HS= 2.115

VS= 2.808

GS= 2.842

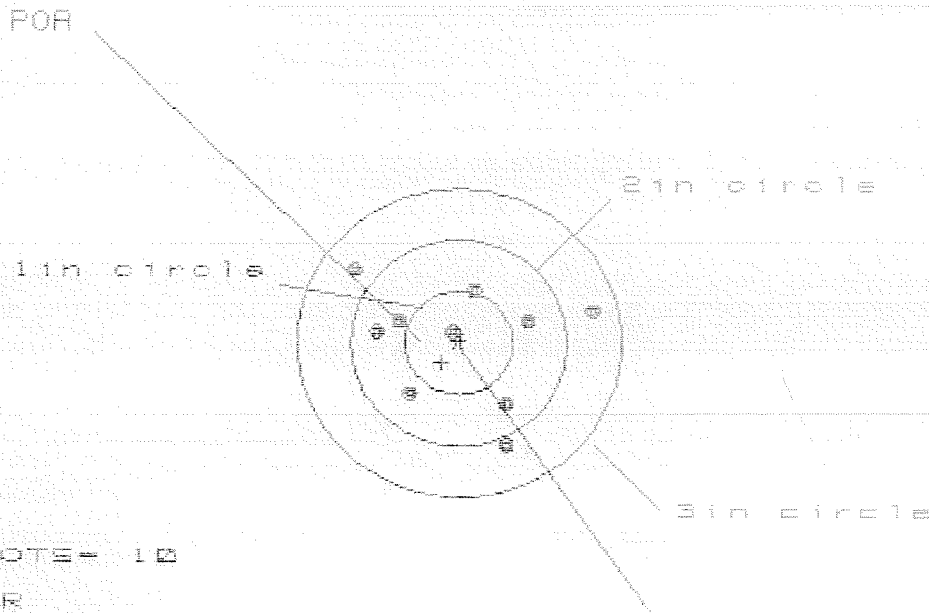
CENTROID #

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.165
MINIMUM X	-.950
MAXIMUM Y	1.631
MINIMUM Y	-1.177
CENTROID X	.187
CENTROID Y	-.050
POA TO CENTROID in.	.193
MIN RADIUS	.233
MEAN RADIUS	.885
MAX RADIUS	1.686
HORIZONTAL SPREAD	2.115
VERTICAL SPREAD	2.808
EXTREME SPREAD	2.842
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	7
NUMBER IN THREE INCH CIRCLE =	8

6 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C06556109

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 10

HS = 2.197

VS = 1.656

GS = 2.219

CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.197	.773	.685
MINIMUM X	:	-1.000	-.867	-.697
MAXIMUM Y	:	.667	.706	.611
MINIMUM Y	:	-.989	-.950	-.862
CENTROID X	:	.162	.029	.137
CENTROID Y	:	.190	.151	.062
POR TO CENTROID in.	:	.250	.154	.151
MIN RADIUS	:	.122	.161	.235
MEAN RADIUS	:	.759	.694	.650
MAX RADIUS	:	1.249	1.118	.962
HORIZONTAL SPREAD	:	2.197	1.640	1.362
VERTICAL SPREAD	:	1.656	1.656	1.472
EXTREME SPREAD	:	2.219	2.170	1.575
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

5 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CG63B189

CENTERFIRE PATTERNS # 1

FOR

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 8

HS= 2.175

VS= 3.072

GS= 3.687

PATTERN #

:

1

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

1.387

.813

.751

MINIMUM X

:

-.788

-.633

-.696

MAXIMUM Y

:

1.662

1.240

1.087

MINIMUM Y

:

-1.410

-1.225

-.967

CENTROID X

:

.117

-.038

.024

CENTROID Y

:

.190

.005

.158

FOR TO CENTROID in.

:

.223

.038

.160

MIN RADIUS

:

.488

.360

.394

MEAN RADIUS

:

1.029

.869

.809

MAX RADIUS

:

2.165

1.387

1.224

HORIZONTAL SPREAD

:

2.175

1.446

1.446

VERTICAL SPREAD

:

3.072

2.465

2.053

EXTREME SPREAD

:

3.687

2.707

2.104

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

6

NUMBER IN THREE INCH CIRCLE =

8