

C6636126

MODEL 700TM M24

Model **SWS**TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

M2400038044

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

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

MODEL 700™ M24

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

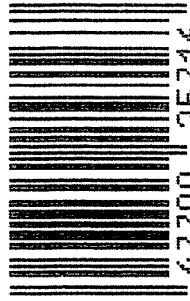
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

SERIAL NO. C6636126	ORDER NO. 5716
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5716 C6636126

UPC



0 47700 25716 7

MOD.		GA. CAL.	GUN #
# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st	EDS	KS
	2nd	Chgd Eye.	KS
	3rd		
	4th		
		FUNCTION	RD 6654 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF	100 Rd test June 12, 1991 OK	KV
TEST AC		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636126

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		4/3/91	K.S.
600	Proof		4/3/91	K.S.
607	Check Headspace		4/3/91	K.S.
610	Dis-assemble Gun		4/3/91	K.S.
612	Magnaflux Barrel Action		4/10/91	KR
	Magnaflux Bolt		4/10/91	Y
615	Rollmark Caliber		4/10/91	LS
617	Drill and Tap Sight Holes		APR 19 1991	EB
618	Polish Barrel		APR 19 1991	WB
620	Apply Coatings (Barrel Action)		5-10-91	AS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/28/91	ICS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/28/91	ICS
	C) Inspect Ejector Hole for Chamfer		5/28/91	ICS
	D) Oil Firing Pin Ass'y		5/28/91	ICS
	E) Adjust Trigger Pull to Min Setting and Stake		5/30/91	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5/30/91	PH
	G) Safety Off Force	4	4	4			5/30/91	PH
	H) Trigger Pull Test & Retainability						6/30/91	PH
	I) Firing Pin Indent	.022	.022	.022			5/30/91	PH
	J) Assemble Stock						4/3/91	KS
	K) Assemble Swivel Studs						6-13-91	A
	L) Attach Front and Rear Sight Assemblies						4/3/91	KS
	M) Iron Sight Alignment						4/3/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/3/91	KS
	O) Attach Scope to Rifle						4/3/91	KS
	P) Detach & Attach Scope 20 Times						4/3/91	KS
640	Gallery Target & Test						6/4/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						6/4/91	KT
655	Final Inspection							
	A) Headspace						6-13-91	A
	B) Trigger Pull	2.74	2.71	2.74	2.72	2.72	6-13-91	PH
	C) Function						6-13-91	A
660	Pack						6-19-91	PH

SWS TRIGGER PULL TEST

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

SERIAL NO. C6636126
DATE 5-30-91
TESTER JAP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.35	2.58	2.54	2.74	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.26	2.51	2.49	2.71	
PULL #3	2.33	2.52	2.56	2.74	
PULL #4	2.33	2.50	2.51	2.72	
PULL #5	2.36	2.50	2.50	2.72	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.41	3.50		
PULL #2	3.27	3.50		
PULL #3	3.28	3.41		
PULL #4	3.25	3.45		
PULL #5	3.25	3.40		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.42	4.38		4.41
PULL #2	4.37	4.39		4.29
PULL #3	4.35	4.29		4.38
PULL #4	4.40	4.36		4.39
PULL #5	4.38	4.28		4.42
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636126
4 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.271803
1 TO	2	.289154
1 TO	3	.330397
1 TO	4	.292043
1 TO	5	.228484

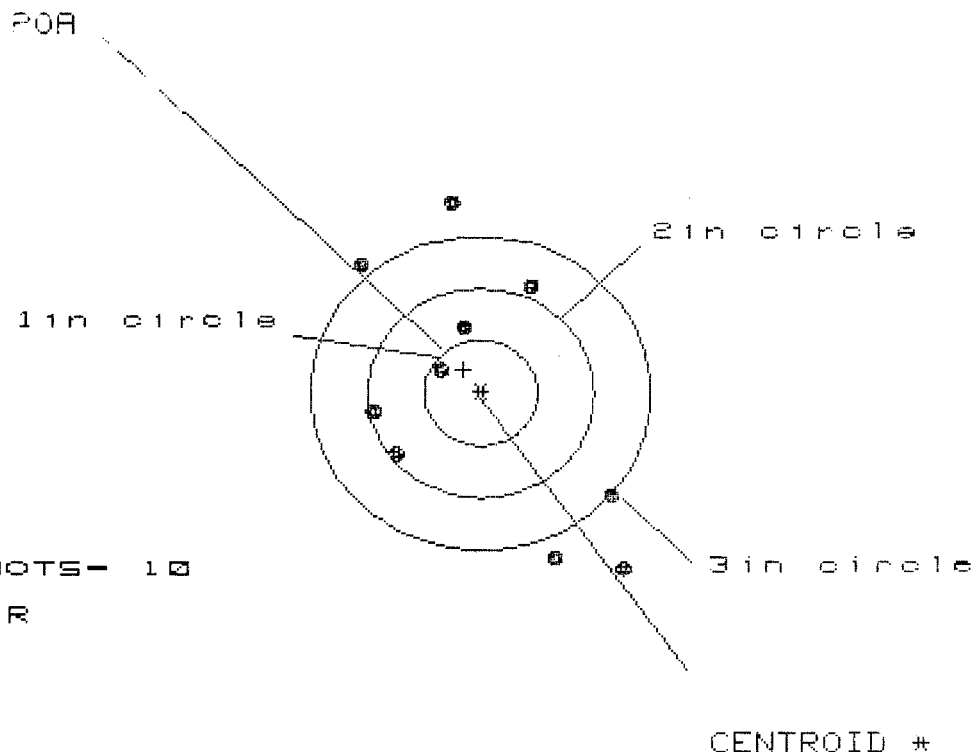
13 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1518
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.074
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .168876
THE AMR FOR THIS RIFLE IS: 1.061

4 JUL 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636126

CENTERFIRE PATTERNS # 1



* OF SHOTS- 10

IN CIR

1in - 1

2in - 4

3in - 6

HS- 2.292

VS- 3.538

GS- 3.854

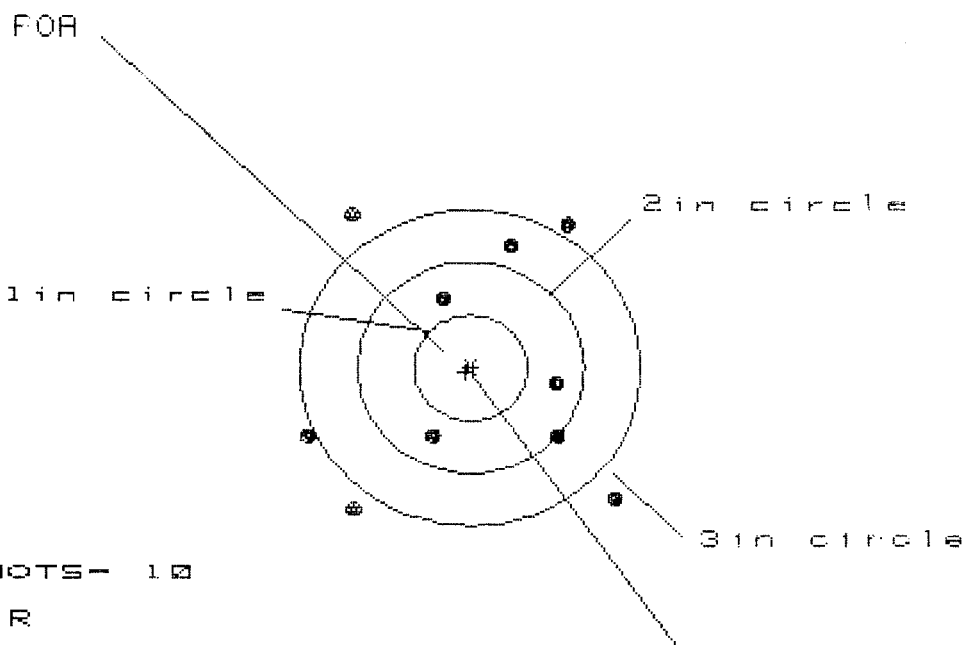
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.261	1.261	1.247
MINIMUM X	-0.882	-0.882	-0.896
MAXIMUM Y	1.655	1.655	1.256
MINIMUM Y	-1.797	-1.797	-1.591
CENTROID X	0.010	0.010	0.024
CENTROID Y	-0.038	-0.038	-0.244
POA TO CENTROID (in.)	0.039	0.039	0.246
MIN RADIUS	1.196	1.196	0.318
MEAN RADIUS	1.142	1.142	1.097
MAX RADIUS	1.959	1.959	1.765
HORIZONTAL SPREAD	2.143	2.143	2.143
VERTICAL SPREAD	3.452	3.452	2.847
EXTREME SPREAD	3.567	3.567	3.296
NUMBER IN ONE INCH CIRCLE =	1	1	1
NUMBER IN TWO INCH CIRCLE =	4	4	4
NUMBER IN THREE INCH CIRCLE =	6	6	6

4 Jun 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 0

2in = 3

3in = 5

HS= 2.704

VS= 2.896

GS= 3.549

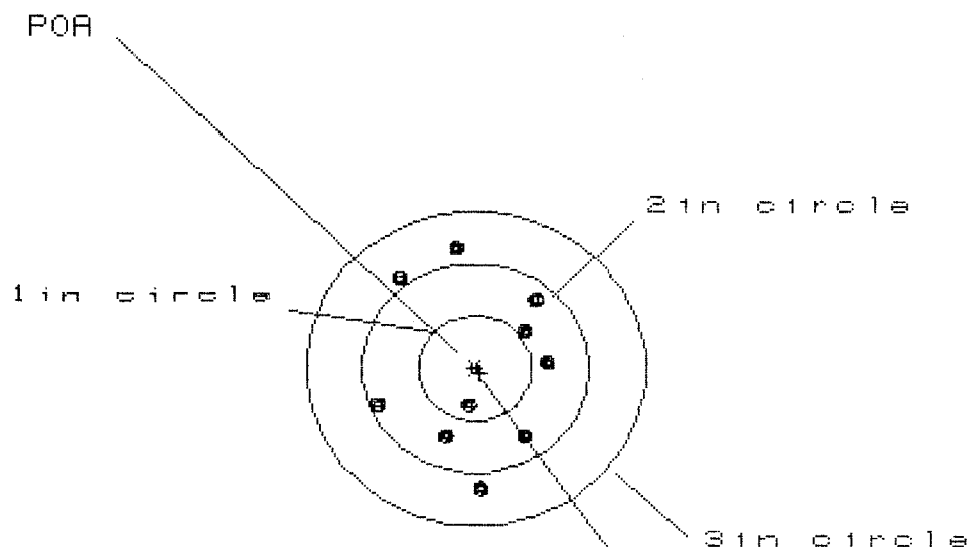
CENTROID #

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.252	1.137	.867
MINIMUM X	:	1.452	-1.567	-1.425
MAXIMUM Y	:	1.503	1.507	1.377
MINIMUM Y	:	1.388	-1.221	-1.351
CENTROID X	:	.040	.155	.013
CENTROID Y	:	.041	.126	.004
POA TO CENTROID in.	:	.050	.200	.013
MIN RADIUS	:	.706	.647	.660
MEAN RADIUS	:	1.294	1.216	1.172
MAX RADIUS	:	1.823	1.673	1.682
HORIZONTAL SPREAD	:	2.704	2.704	2.292
VERTICAL SPREAD	:	2.896	2.728	2.728
EXTREME SPREAD	:	3.549	3.307	3.307
NUMBER IN ONE INCH CIRCLE =	:	0	3	5
NUMBER IN TWO INCH CIRCLE =	:	3	5	8
NUMBER IN THREE INCH CIRCLE =	:	5	8	10

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in - 1

2 in - 7

3 in = 10

HS- 1.497

VS= 2.320

GS= 2.335

CENTROID *

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.599	.577	.582
MINIMUM X	:	-.898	-.920	-.915
MAXIMUM Y	:	1.184	1.009	.883
MINIMUM Y	:	1.136	-1.004	-.663
CENTROID X	:	-.038	-.016	-.021
CENTROID Y	:	.045	-.087	.039
POA TO CENTROID in.	:	.059	.088	.044
MIN RADIUS	:	.345	.221	.342
MEAN RADIUS	:	.830	.766	.742
MAX RADIUS	:	1.202	1.222	1.118
HORIZONTAL SPREAD	:	1.497	1.497	1.497
VERTICAL SPREAD	:	2.320	2.013	1.546
EXTREME SPREAD	:	2.335	2.141	1.918
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			10	

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CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 4

2 in = 5

3 in = 9

HS= 3.619

VS= 1.676

GS= 3.763

CENTROID #

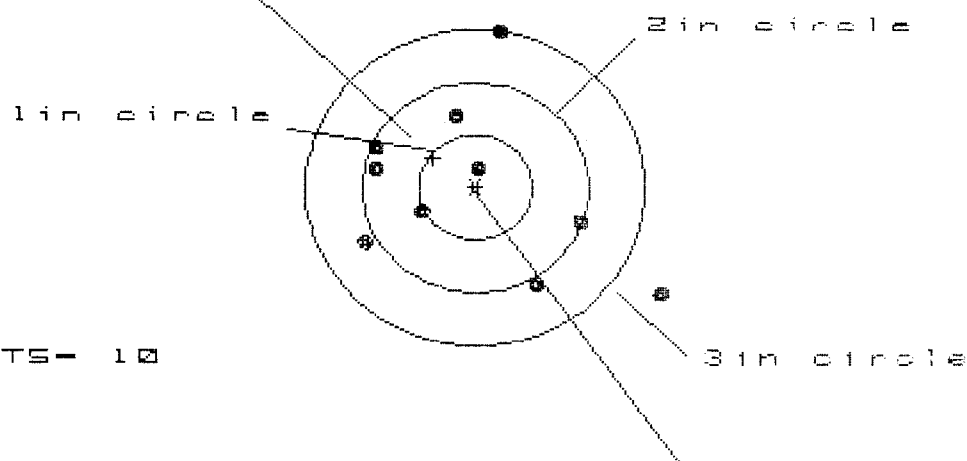
PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.412	1.084	.979
MINIMUM X	:	1.207	-.939	-1.044
MAXIMUM Y	:	.678	.742	.655
MINIMUM Y	:	-.998	-.934	-1.020
CENTROID X	:	.234	-.034	.071
CENTROID Y	:	.054	-.010	.076
POA TO CENTROID in.	:	.240	.036	.104
MIN RADIUS	:	.088	.128	.201
MEAN RADIUS	:	.898	.669	.615
MAX RADIUS	:	2.480	1.431	1.414
HORIZONTAL SPREAD	:	3.619	2.023	2.023
VERTICAL SPREAD	:	1.676	1.676	1.676
EXTREME SPREAD	:	3.763	2.374	2.374
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5

FOR



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 2.594

VS= 2.498

GS= 2.877

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.636	1.117	1.167
MINIMUM X	-.958	-.777	-.727
MAXIMUM Y	1.485	1.372	.738
MINIMUM Y	-1.013	-1.070	-.898
CENTROID X	.372	.191	.141
CENTROID Y	-.284	-.171	-.343
FOR TO CENTROID in.	.468	.256	.371
MIN RADIUS	.235	.250	.282
MEAN RADIUS	.987	.840	.760
MAX RADIUS	1.924	1.428	1.192
HORIZONTAL SPREAD	2.594	1.894	1.894
VERTICAL SPREAD	2.498	2.442	1.636
EXTREME SPREAD	2.877	2.466	1.964
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		