

C5348961

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington



RECORDS CONTROL SCHEDULE

RECORDS CATEGORY OR TITLE:

128 - FINISHED GUN QUALITY - 1981

COPY "O" (OFFICIAL) ☐ "X" (EXTRA) ☒

TOTAL RETENTION: MAX. 1 YEAR

GS-11050 Rev. 8/78

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400042669

QUALITY
1981




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

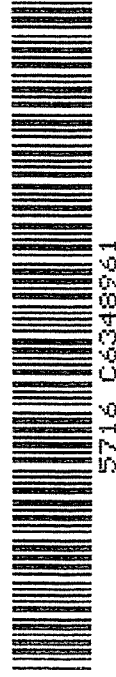
REG. U.S. PAT. & TM. OFF.

MODEL 700™ H24

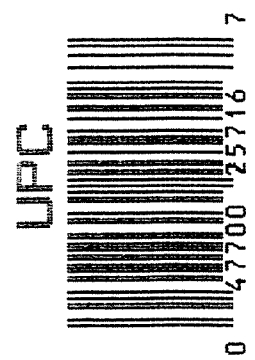
SERIAL NO. C6348961

ORDER NO. 5716

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



5716 C6348961



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6348961

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 14	89	RW
600	Proof	9 14	89	RW
607	Check Headspace	9 14	89	RW
610	Dis-assemble Gun	9 14	89	RW
612	Magnaflux Barrel Action	9-14-89		KCR
	Magnaflux Bolt	9-14-89		KCR
615	Rollmark Caliber		9-15-89	GS
7	Drill and Tap Sight Holes	9 15	89	EB
618	Polish Barrel	9 15	89	BT
620	Apply Coatings (Barrel Action)		9-25-89	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		9/26/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/26/89	RW
	C) Inspect Ejector Hole for Chamfer		9/26/89	RW
	D) Oil Firing Pin Ass'y		9/26/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		28 Sept 89	GS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			10/4/89	92/
	G) Safety Off Force	3	3	3			10/4/89	92/
	H) Trigger Pull Test & Retainability						28 Sept 89	928
	I) Firing Pin Indent	.021	.021	.021			10/4/89	92/
	J) Assemble Stock						10/31/89	RW
	K) Assemble Swivel Studs						6 Nov 89	928
	L) Attach Front and Rear Sight Assemblies						10/31/89	RW
	M) Iron Sight Alignment						10/31/89	RW
	N) Detach Front & Rear Sights & place in numbered container						10/31/89	RW
	O) Attach Scope to Rifle						11/1/89	92/
	P) Detach & Attach Scope 20 Times						11/1/89	92/
640	Gallery Target & Test						11-2-89	DH
	A) Time						11-2-89	DH
	B) Malfunctions						11-2-89	DH
	C) Pierced Primers						11-2-89	DH
	D) Optical Clarity of Scope						11-2-89	DH
645	Inspect for Live Ammo						11-2-89	DH
655	Final Inspection							
	A) Headspace						6 Nov 89	928
	B) Trigger Pull	2.51	2.40	2.56	2.55	2.67	6 Nov 89	928
	C) Function						6 Nov 89	928
660	Pack						1-10-89	928

SWS TRIGGER PULL TEST

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

SERIAL NO. 24348961

DATE 4-3-90

TESTER JG

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.47	2.47		2.60	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.50	2.50		2.50	
PULL #3	2.46	2.51		2.48	
PULL #4	2.51	2.30		2.43	
PULL #5	2.48	2.49		2.50	
TOTAL	12.42	12.27		12.51	
AVG.	2.484	2.454		2.502	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.39	3.48		
PULL #2	3.26	3.48		
PULL #3	3.45	3.49		
PULL #4	3.47	3.52		
PULL #5	3.41	3.55		
TOTAL	16.98	17.52		
AVG.	3.396	3.504		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.25	4.32		
PULL #2	4.39	4.08		
PULL #3	4.39	4.22		
PULL #4	4.32	4.30		
PULL #5	4.30	4.32		
TOTAL	21.65	21.24		
AVG.	4.33	4.248		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06348961
2 Nov 1989

CENTROIDAL DISTANCES

0 TO	1	1.44661
1 TO	2	.945838
1 TO	3	1.02846
1 TO	4	1.20969
1 TO	5	.712265

1
+ 5 <----POB

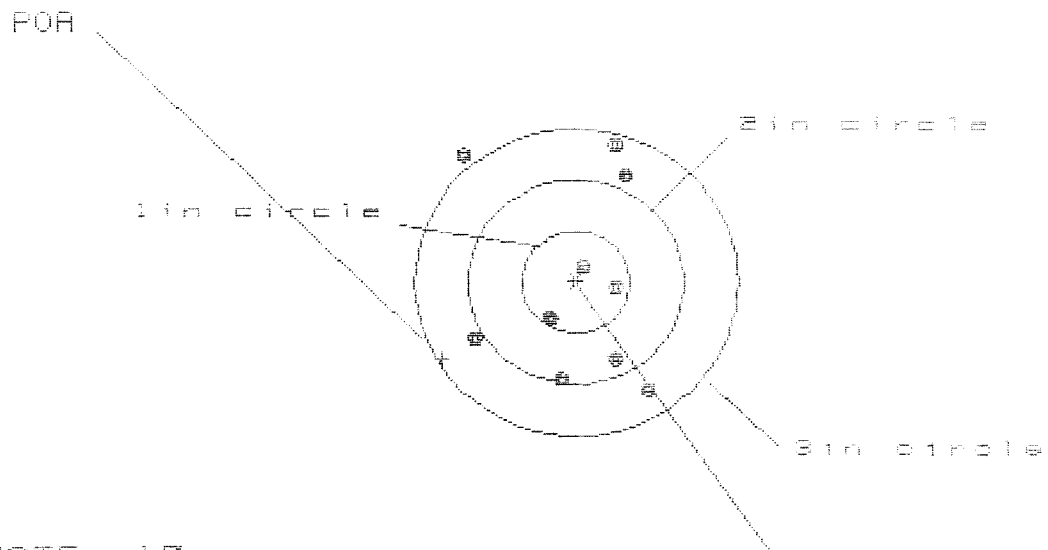
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .6562
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2544
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .705653

THE AMR FOR THIS RIFLE IS: .978

2 Nov 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C8348381

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 9

HS= 1.780

VS= 2.356

GS= 2.892

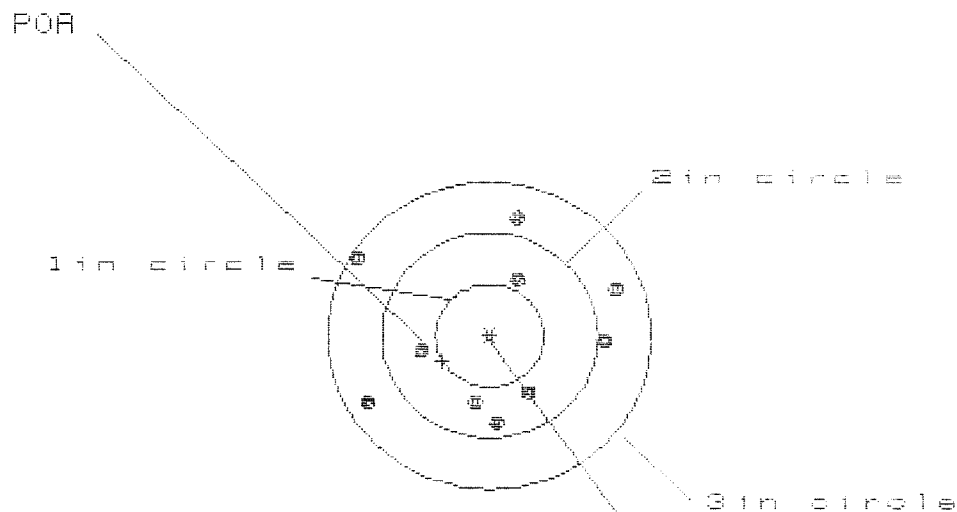
CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.695	.576	.610
MINIMUM X	:	-1.065	-1.033	-.999
MAXIMUM Y	:	1.302	1.439	1.366
MINIMUM Y	:	-1.054	-.917	-.737
CENTROID X	:	1.237	1.356	1.322
CENTROID Y	:	.750	.613	.433
POA TO CENTROID in.	:	1.447	1.488	1.391
MIN RADIUS	:	.177	.255	.279
MEAN RADIUS	:	.921	.812	.709
MAX RADIUS	:	1.635	1.464	1.419
HORIZONTAL SPREAD	:	1.760	1.609	1.609
VERTICAL SPREAD	:	2.356	2.356	2.103
EXTREME SPREAD	:	2.892	2.376	2.115
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	9		

2 May 1989

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 5

3 in = 10

HS= 2.398

VS= 2.027

CS= 2.501

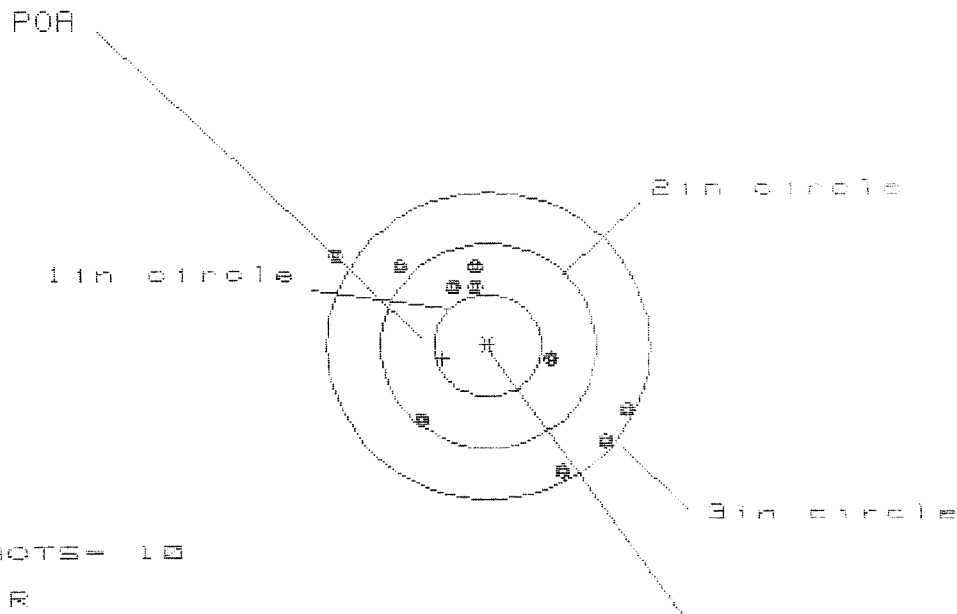
CENTROID *

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.127	.986	.828
MINIMUM X	-1.271	-1.263	-.961
MAXIMUM Y	1.183	1.272	1.200
MINIMUM Y	-.844	-.755	-.827
CENTROID X	.436	.577	.735
CENTROID Y	.247	.158	.230
FOR TO CENTROID in.	.501	.599	.770
MIN RADIUS	.595	.529	.526
MEAN RADIUS	.970	.889	.819
MAX RADIUS	1.498	1.389	1.200
HORIZONTAL SPREAD	2.398	2.249	1.789
VERTICAL SPREAD	2.027	2.027	2.027
EXTREME SPREAD	2.501	2.501	2.041
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	5	
NUMBER IN THREE INCH CIRCLE	=	10	

2 Nov 1988

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 5

3 in = 9

HS= 2.704

VS= 2.117

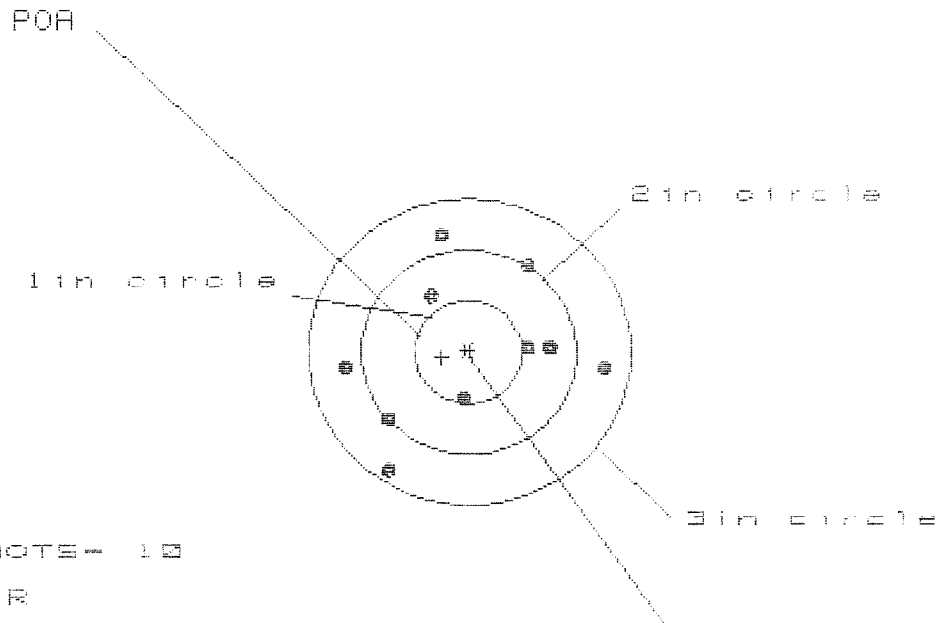
GS= 3.161

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.247
MINIMUM X	-1.457
MAXIMUM Y	.917
MINIMUM Y	-1.200
CENTROID X	.421
CENTROID Y	.124
POA TO CENTROID in.	.439
MIN RADIUS	.564
MEAN RADIUS	1.072
MAX RADIUS	1.721
HORIZONTAL SPREAD	2.704
VERTICAL SPREAD	2.117
EXTREME SPREAD	3.161
NUMBER IN ONE INCH CIRCLE	0
NUMBER IN TWO INCH CIRCLE	5
NUMBER IN THREE INCH CIRCLE	9

2 Nov 1989

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10
IN CIR
1 in = 1
2 in = 5
3 in = 10
HS = 2.353
VS = 2.342
GS = 2.436

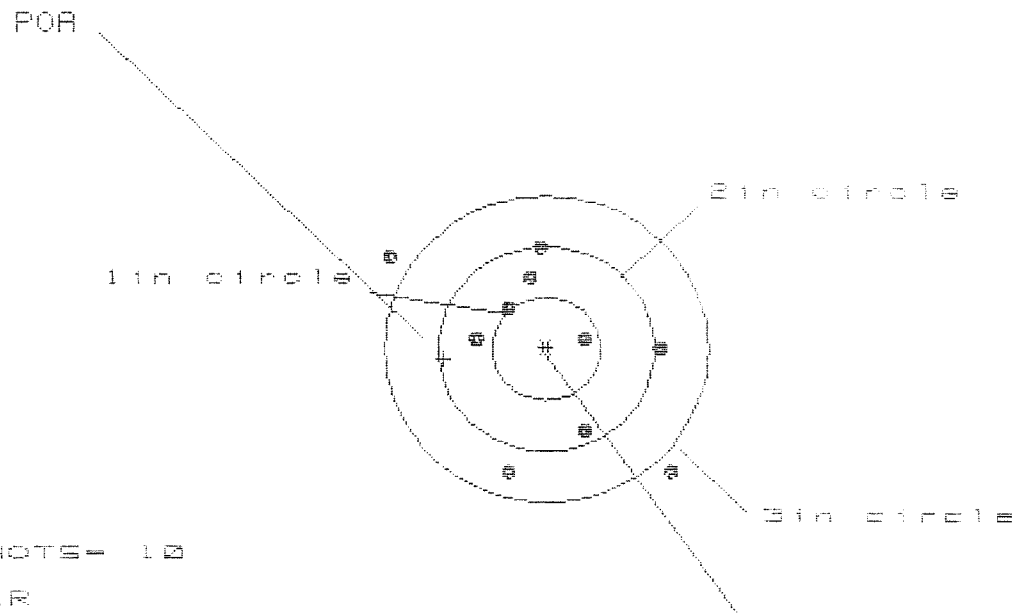
CENTROID *

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.235	1.154	.908
MINIMUM X	-1.118	-1.199	-1.055
MAXIMUM Y	1.166	1.035	1.001
MINIMUM Y	-1.176	-.791	-.825
CENTROID X	.249	.330	.186
CENTROID Y	.052	.183	.217
POA TO CENTROID in.	.254	.378	.286
MIN RADIUS	.483	.474	.487
MEAN RADIUS	.939	.875	.838
MAX RADIUS	1.387	1.233	1.103
HORIZONTAL SPREAD	2.353	2.353	1.863
VERTICAL SPREAD	2.342	1.826	1.826
EXTREME SPREAD	2.436	2.353	2.007
NUMBER IN ONE INCH CIRCLE	= 1		
NUMBER IN TWO INCH CIRCLE	= 5		
NUMBER IN THREE INCH CIRCLE	= 10		

2 Nov 1989

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CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 0

3 in = 0

HW = 0.889

VS = 2.195

GS = 0.900

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.114	.953	1.048
MINIMUM X	:	-1.445	-.831	-.712
MAXIMUM Y	:	.966	1.066	.931
MINIMUM Y	:	-1.229	-1.129	-1.264
CENTROID X	:	.948	1.109	.990
CENTROID Y	:	.099	-.001	.134
POA TO CENTROID in.	:	.954	1.109	.999
MIN RADIUS	:	.400	.324	.349
MEAN RADIUS	:	.988	.909	.812
MAX RADIUS	:	1.706	1.445	1.310
HORIZONTAL SPREAD	:	2.559	1.784	1.760
VERTICAL SPREAD	:	2.195	2.195	2.195
EXTREME SPREAD	:	3.306	2.437	2.212
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	