C6348727

MODEL 700™ M24

Model SWS™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington®

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M-24

Scott 0555

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348727

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10-9	89	RW
600	Proof	10-9	89	[illegible]
607	Check Headspace	10-9	89	RW
610	Dis-assemble Gun	10-9	[illegible]	RW
612	Magnaflux Barrel Action	REJECTED	11/2/89	KCR
	Magnaflux Bolt		11/2/89	KCR
615	Rollmark Caliber			
7	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)		[illegible]	[illegible]
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake			

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

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M2400062496

Scott 0555

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348727

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	11-8	89	RW
600	Proof	11-8	89	RW
607	Check Headspace	11-8	89	RW
610	Dis-assemble Gun	11-8	89	RW
612	Magnaflux Barrel Action	11-9-89		KCK
	Magnaflux Bolt	11-9-89		KCK
615	Rollmark Caliber			
617	Drill and Tap Sight Holes	11 9	89	TB
618	Polish Barrel RB	11 9	89	BT
620	Apply Coatings (Barrel Action)		11-11-89	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/27/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/27/89	RW
	C) Inspect Ejector Hole for Chamfer		11/27/89	RW
	D) Oil Firing Pin Ass'y		11/27/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5 Dec 89	DS

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op. #	OP. NAME	READINGS			DATE	INIT
625 cont.	F) Safety On Force	5	5	5	5Dec89	GS
	G) Safety Off Force	3	3	3	5Dec89	GS
	H) Trigger Pull Test & Retainability				5Dec89	GS
	I) Firing Pin Indent	.0225	.0225	.0225	5Dec89	GS
	J) Assemble Stock				12/8/89	RW
	K) Assemble Swivel Studs				8Dec89	GS
	L) Attach Front and Rear Sight Assemblies				12/8/89	RW
	M) Iron Sight Alignment				12/8/89	RW
	N) Detach Front & Rear Sights & place in numbered container				12/8/89	RW
	O) Attach Scope to Rifle				8Dec89	GS
	P) Detach & Attach Scope 20 Times				8Dec89	GS
640	Gallery Target & Test				12-8-89	A
	A) Time				12-8-89	A
	B) Malfunctions				12-8-89	A
	C) Pierced Primers				12-8-89	A
	D) Optical Clearity of Scope				12-8-89	A
645	Inspect for Live Ammo				12-8-89	A
655	Final Inspection A) Headspace				8Dec89	GS
	B) Trigger Pull	2.50	2.44	2.46	2.43 2.45	8Dec89 GS
	C) Function				8Dec89	GS
660	Pack				15Dec89	GS

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M2400062498

SWS TRIGGER PULL TEST

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

SERIAL NO. CG348727
DATE 13 MAR 90
TESTER GSB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.32		2.21	MIN. SETTING,
PULL #2	2.46	2.40		2.41	NO AVG. OF 5
PULL #3	2.36	2.41		2.38	READINGS ACCEPT-
PULL #4	2.46	2.41		2.39	ABLE LESS THAN 2#
PULL #5	2.43	2.36		2.31	
TOTAL	12.18	11.90			
AVG.	2.436	2.38			

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	2.83	2.96		
PULL #2	2.95	2.97		
PULL #3	2.99	2.90		
PULL #4	2.96	2.93		
PULL #5	3.04	2.96		
TOTAL	14.77	14.72		
AVG.	2.954	2.944		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.00	3.86		
PULL #2	3.92	3.94		
PULL #3	3.94	3.86		
PULL #4	3.91	3.83		
PULL #5	3.92	3.85		
TOTAL	19.69	19.34		
AVG.	3.938	3.868		

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CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348727
8 Dec 1989

CENTROIDAL DISTANCES

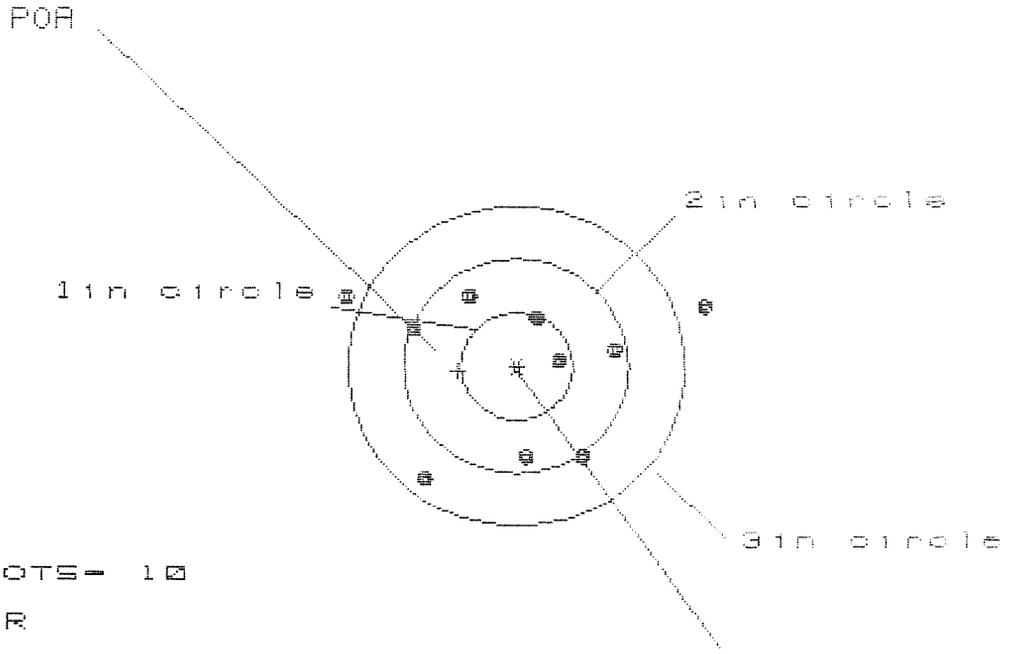
0	TO	1	.524023
1	TO	2	.386456
1	TO	3	.625374
1	TO	4	.646803
1	TO	5	.549102

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0914
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0918
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .129542

THE AMR FOR THIS RIFLE IS: .961

8 Dec 1989 FILE:/PATTERNING/CENTERFIRE_PATT/C8348727

CENTERFIRE PATTERNS # 1



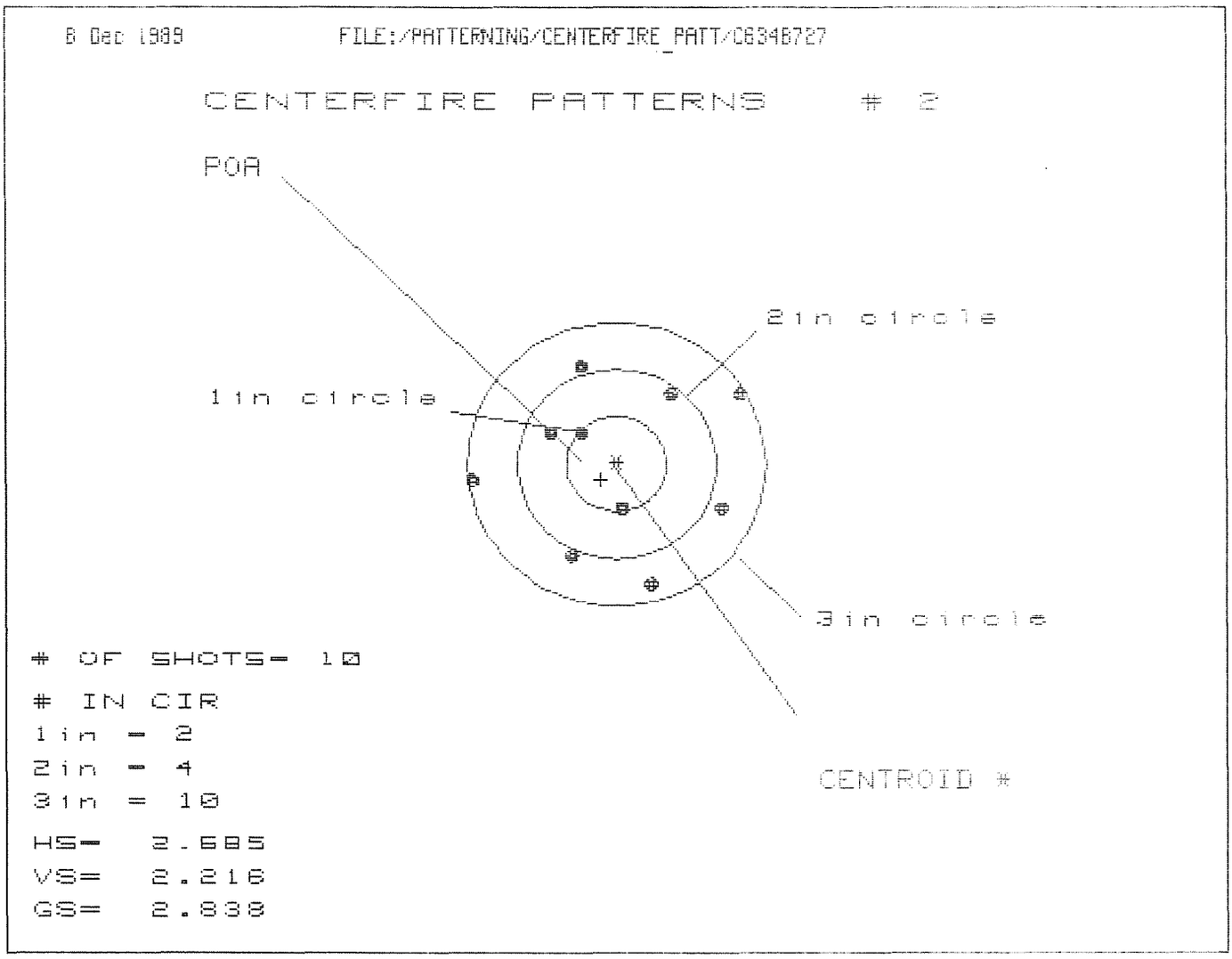
OF SHOTS= 10

# IN CIR	
1in =	2
2in =	7
3in =	8

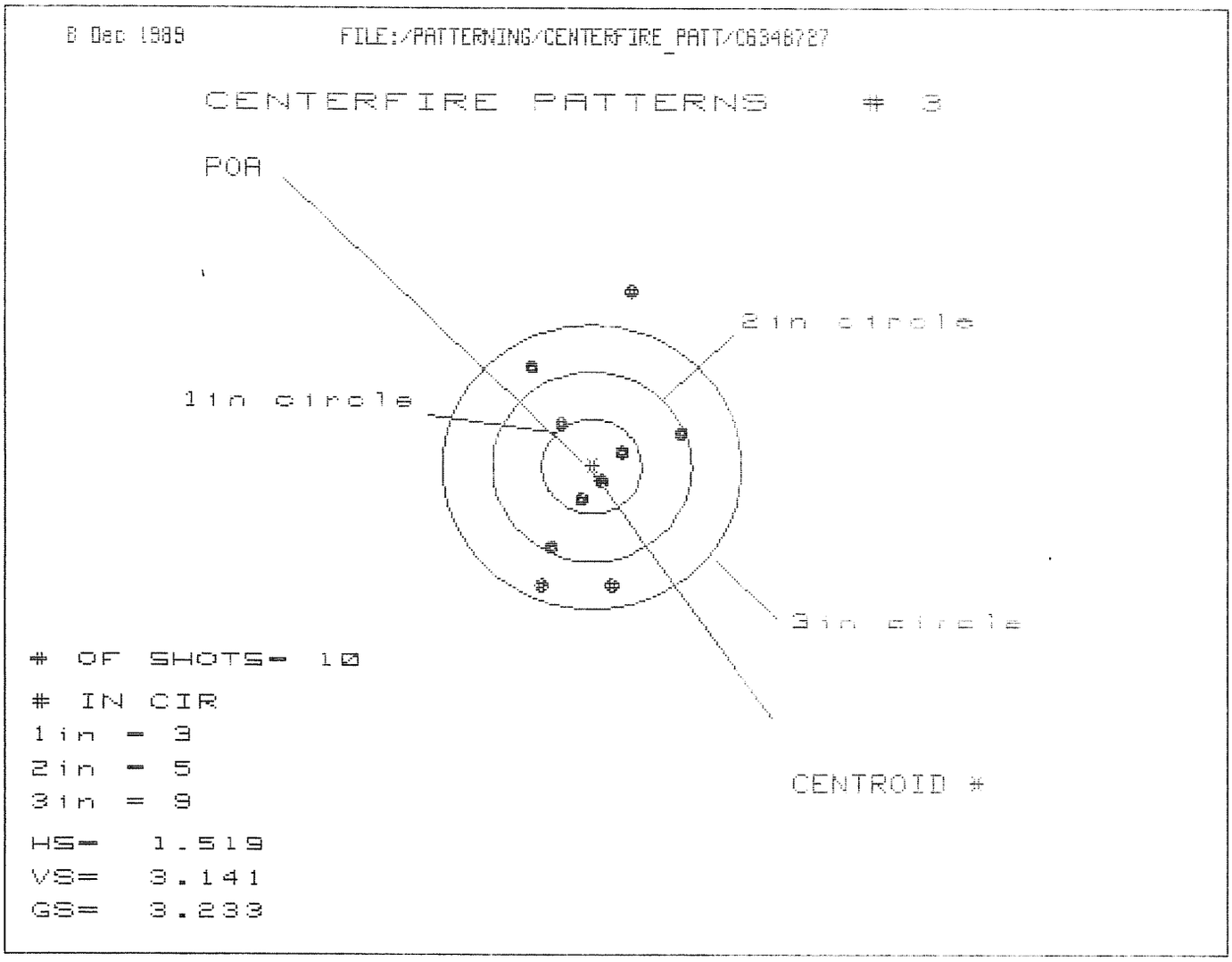
HS= 3.121
VS= 1.763
GS= 3.123

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.634	1.028	.865
MINIMUM X	:	-1.487	-1.306	-.862
MAXIMUM Y	:	.696	.757	.847
MINIMUM Y	:	-1.067	-1.006	-.916
CENTROID X	:	.522	.341	.504
CENTROID Y	:	.046	-.015	-.105
POA TO CENTROID in.	:	.525	.341	.515
MIN RADIUS	:	.395	.574	.445
MEAN RADIUS	:	1.001	.931	.837
MAX RADIUS	:	1.724	1.490	1.194
HORIZONTAL SPREAD	:	3.121	2.334	1.727
VERTICAL SPREAD	:	1.763	1.763	1.763
EXTREME SPREAD	:	3.123	2.523	2.024

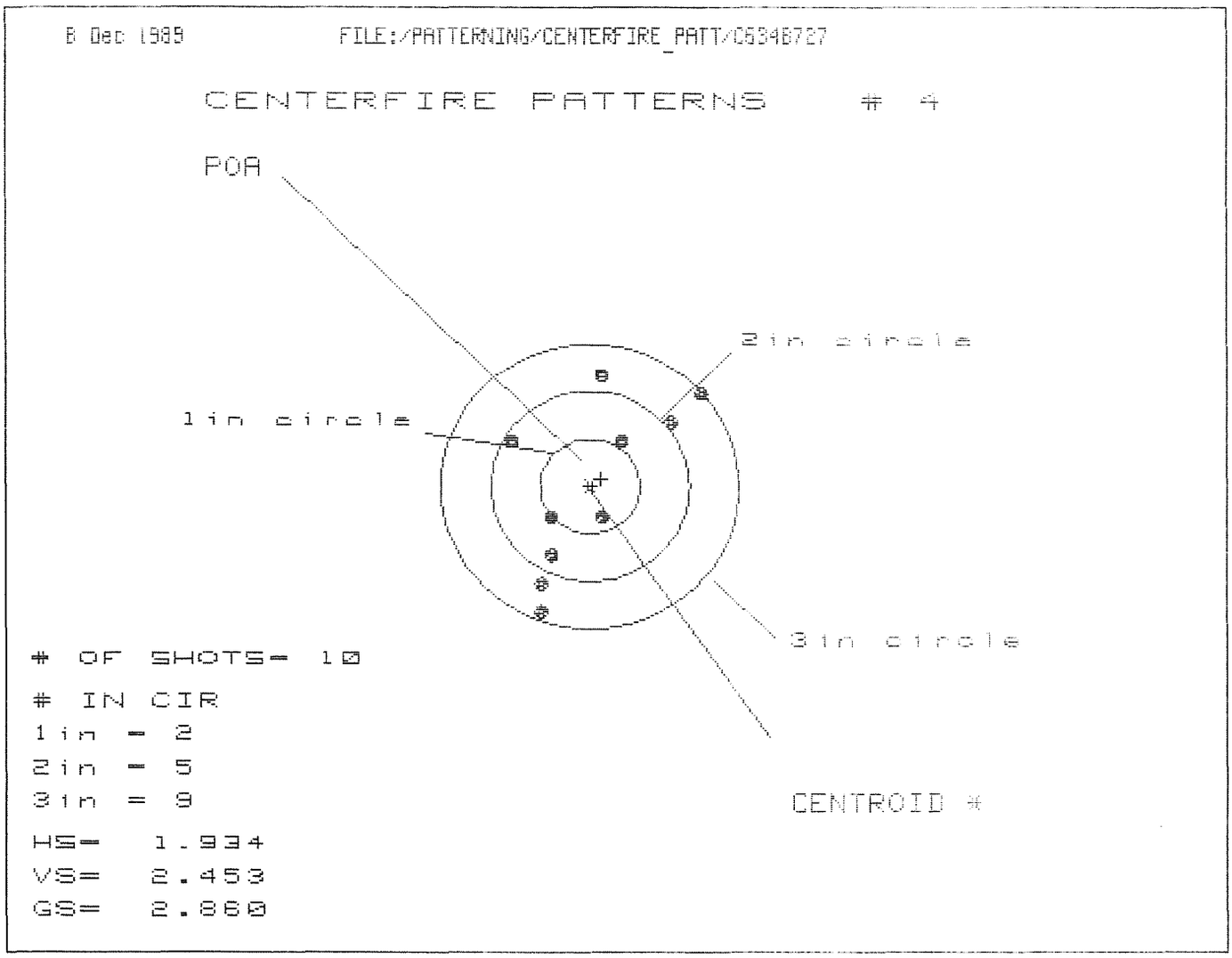
NUMBER IN ONE INCH CIRCLE = 2
NUMBER IN TWO INCH CIRCLE = 7
NUMBER IN THREE INCH CIRCLE = 8



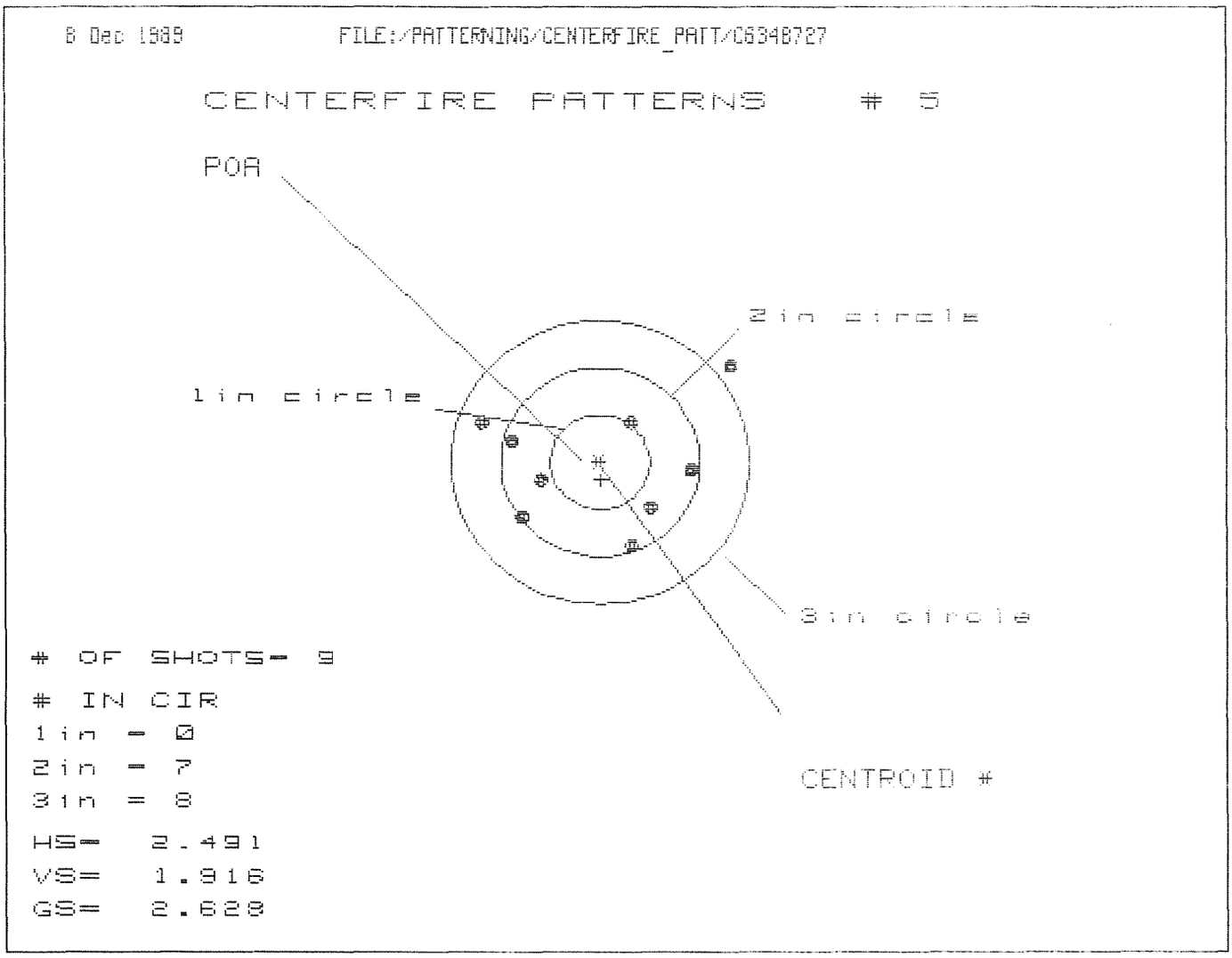
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.204	1.039	1.044
MINIMUM X	:	-1.481	-.794	-.664
MAXIMUM Y	:	.990	.970	1.060
MINIMUM Y	:	-1.226	-1.246	-1.156
CENTROID X	:	.154	.319	.189
CENTROID Y	:	.164	.184	.094
POA TO CENTROID in.	:	.225	.368	.211
MIN RADIUS	:	.446	.490	.377
MEAN RADIUS	:	1.003	.952	.892
MAX RADIUS	:	1.492	1.266	1.209
HORIZONTAL SPREAD	:	2.685	1.833	1.708
VERTICAL SPREAD	:	2.216	2.216	2.216
EXTREME SPREAD	:	2.838	2.368	2.329
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	10		



PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.933	.982	.923
MINIMUM X	:	-.586	-.537	-.596
MAXIMUM Y	:	1.848	1.253	1.123
MINIMUM Y	:	-1.293	-1.088	-1.218
CENTROID X	:	-.095	-.144	-.086
CENTROID Y	:	.148	-.058	.072
POA TO CENTROID in.	:	.175	.155	.112
MIN RADIUS	:	.158	.144	.092
MEAN RADIUS	:	.915	.783	.729
MAX RADIUS	:	1.900	1.363	1.271
HORIZONTAL SPREAD	:	1.519	1.519	1.519
VERTICAL SPREAD	:	3.141	2.341	2.341
EXTREME SPREAD	:	3.233	2.456	2.456
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	



PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.147	.933	.885
MINIMUM X	:	-.787	-.659	-.707
MAXIMUM Y	:	1.131	1.243	1.092
MINIMUM Y	:	-1.322	-1.210	-1.038
CENTROID X	:	-.113	-.241	-.194
CENTROID Y	:	-.077	-.189	-.038
POA TO CENTROID in.	:	.137	.306	.197
MIN RADIUS	:	.377	.294	.437
MEAN RADIUS	:	.946	.855	.813
MAX RADIUS	:	1.529	1.274	1.116
HORIZONTAL SPREAD	:	1.934	1.592	1.592
VERTICAL SPREAD	:	2.453	2.453	2.130
EXTREME SPREAD	:	2.860	2.540	2.223
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	9		



PATTERN #	:	5		
SHOTS (BEST OF)	:	9	8	7
MAXIMUM X	:	1.349	1.055	.916
MINIMUM X	:	-1.142	-.974	-.849
MAXIMUM Y	:	1.013	.595	.673
MINIMUM Y	:	-.903	-.776	-.691
CENTROID X	:	-.011	-.179	-.049
CENTROID Y	:	.178	.051	-.034
POA TO CENTROID in.	:	.178	.187	.053
MIN RADIUS	:	.530	.405	.537
MEAN RADIUS	:	.940	.820	.766
MAX RADIUS	:	1.687	1.141	.975
HORIZONTAL SPREAD	:	2.491	2.029	1.765
VERTICAL SPREAD	:	1.916	1.371	1.364
EXTREME SPREAD	:	2.628	2.114	1.808
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	8		

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KINZER V. REMINGTON

Remington®

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

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

MODEL 700™ M24

SERIAL NO. C6348727

ORDER NO. 5716

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

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5716 C6348727

UPC

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