

C6611539

MODEL 700TM M24

Model SWS TM

Action _____

Barrel Length _____

Capacity _____

Order No. 5715

*Includes 1 in chamber.






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

MODEL 700TM H24

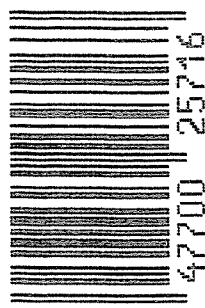
SERIAL NO.
C6611539

ORDER NO.
5716

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

46

LPC



0 47700 25716 7



5716 C6611539

MOD. _____ GA. _____ GUN # 1539
CAL. _____ # _____

INSP. #	DATE	MALFUNCTION/DEFECT	ASSEM. #
<i>AC</i>	1st	<i>Stock Split</i>	<i>RW</i>
	2nd		
	3rd		
	4th		

FINAL INSPECTION RD 6657 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611539

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	2 1	91	RW
600	Proof	2 1	91	RW
607	Check Headspace	2 1	91	RW
610	Dis-assemble Gun	2 1	91	RW
612	Magnaflux Barrel Action	2 11	91	Ked
	Magnaflux Bolt	2 11	91	Ked
615	Rollmark Caliber	2 11	91	CS
617	Drill and Tap Sight Holes	2 13	91	LB
618	Polish Barrel RBB	2 13	91	WB
620	Apply Coatings (Barrel Action)		3/22/91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		3/25/91	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		3/25/91	WB
	C) Inspect Ejector Hole for Chamfer		3/25/91	WB
	D) Oil Firing Pin Ass'y		3/25/91	WB
	E) Adjust Trigger Pull to Min Setting and Stake		4/8/91	JH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			4/10/91	JP
	G) Safety Off Force	3	3	3			4/10/91	JP
	H) Trigger Pull Test & Retainability						4/8/91	JP
	I) Firing Pin Indent	.023	.023	.023			4/10/91	JP
	J) Assemble Stock						4/10/91	RW
	K) Assemble Swivel Studs						4-16-91	K
	L) Attach Front and Rear Sight Assemblies						4/10/91	RW
	M) Iron Sight Alignment						4/10/91	RW
	N) Detach Front & Rear Sights & place in numbered container						4/10/91	RW
	O) Attach Scope to Rifle						4/10/91	RW
	P) Detach & Attach Scope 20 Times						4/10/91	RW
640	Gallery Target & Test						4-11-91	AC
	A) Time						4-11-91	AC
	B) Malfunctions						4-11-91	AC
	C) Pierced Primers						4-11-91	AC
	D) Optical Clarity of Scope						4-11-91	AC
645	Inspect for Live Ammo						4-11-91	AC
655	Final Inspection							
	A) Headspace						4-16-91	K
	B) Trigger Pull	2.15	2.15	2.13	2.15	2.16	4/16/91	JP
	C) Function						4-16-91	K
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. C6611539

DATE 4/8/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.31	2.45	2.46	2.15	MIN. SETTING,
PULL #2	2.42	2.41	2.42	2.15	NO AVG. OF 5
PULL #3	2.42	2.44	2.45	2.13	READINGS ACCEPT-
PULL #4	2.43	2.45	2.43	2.15	ABLE LESS THAN 2#
PULL #5	2.45	2.50	2.45	2.16	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.21	3.28		
PULL #2	3.22	3.33		
PULL #3	3.26	3.36		
PULL #4	3.32	3.26		
PULL #5	3.27	3.28		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.33	4.55		4.60
PULL #2	4.29	4.49		4.39
PULL #3	4.33	4.59		4.30
PULL #4	4.44	4.50		4.44
PULL #5	4.41	4.53		4.38
TOTAL				
AVG.				

CENTROIDAL DISTANCES

Ø	TO	1	.408873
1	TO	2	.102
1	TO	3	.565533
1	TO	4	.410343
1	TO	5	.155653

5
4
3
2
1
0

←----POR

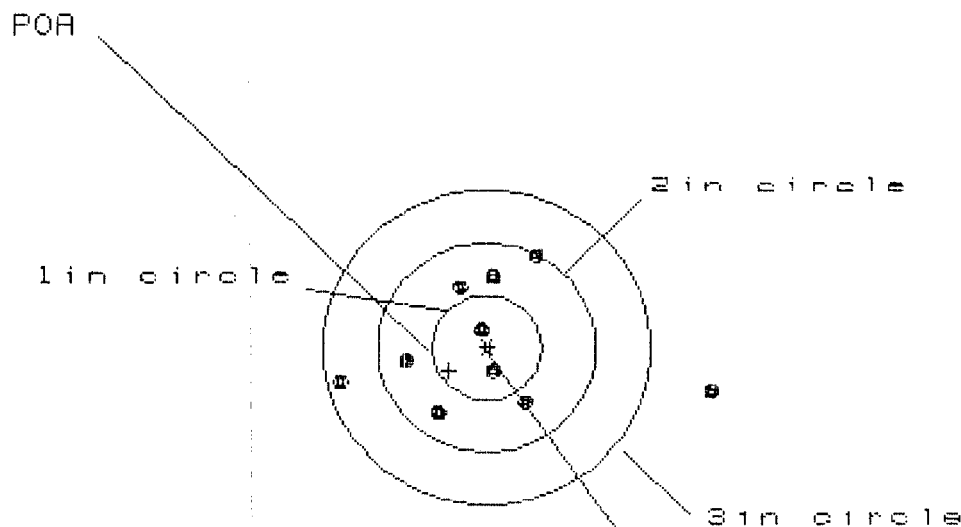
CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400078507

11 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611539

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 8

3 in = 9

HS= 3.384

VS= 1.464

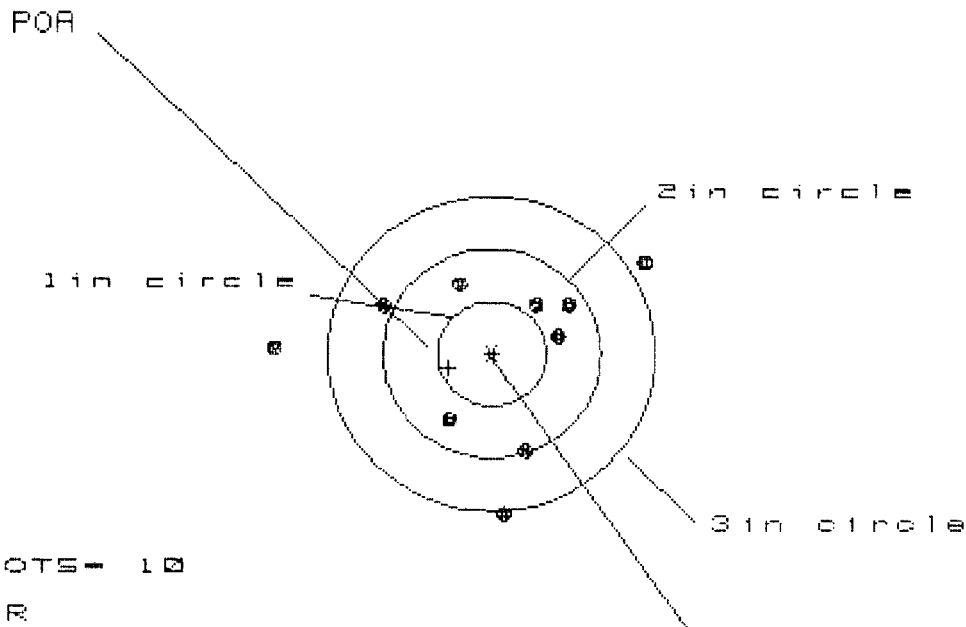
GS= 3.385

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.038	.667	.527
MINIMUM X	-1.346	-1.120	-.672
MAXIMUM Y	.860	.818	.773
MINIMUM Y	-.605	-.646	-.691
CENTROID X	.344	.118	.258
CENTROID Y	.221	.262	.307
POA TO CENTROID in.	.409	.288	.401
MIN RADIUS	.160	.209	.076
MEAN RADIUS	.818	.666	.577
MAX RADIUS	2.072	1.175	.936
HORIZONTAL SPREAD	3.384	1.787	1.199
VERTICAL SPREAD	1.464	1.464	1.464
EXTREME SPREAD	3.385	2.138	1.731
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	9		

11 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611539

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 0

2in = 6

3in = 7

HS= 3.397

VS= 2.409

GS= 3.490

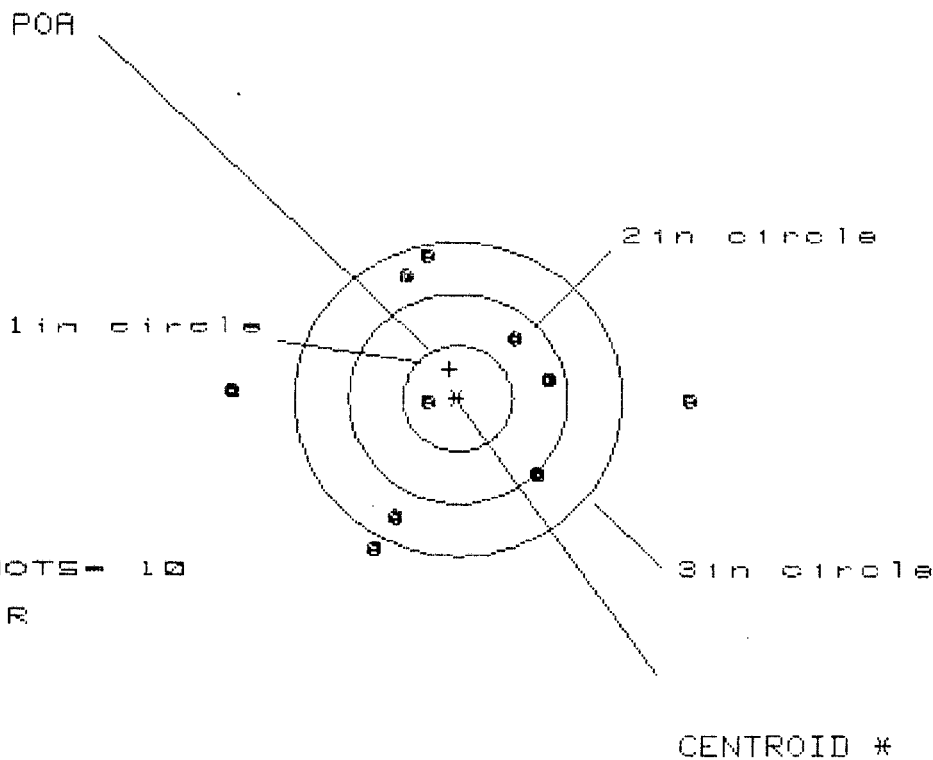
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.437	1.219	.630
MINIMUM X	:	-1.960	-1.252	-1.100
MAXIMUM Y	:	.858	.864	.778
MINIMUM Y	:	-1.551	-1.545	-1.437
CENTROID X	:	.392	.610	.458
CENTROID Y	:	.131	.125	.017
POA TO CENTROID in.	:	.414	.623	.458
MIN RADIUS	:	.592	.435	.616
MEAN RADIUS	:	1.083	.952	.896
MAX RADIUS	:	1.961	1.546	1.439
HORIZONTAL SPREAD	:	3.397	2.471	1.730
VERTICAL SPREAD	:	2.409	2.409	2.215
EXTREME SPREAD	:	3.490	2.734	2.360
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

(1 Apr 1991)

FILE:/PATTERNING/CENTERFIRE_PATT/C6611539

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 7

HSI = 4.219

VS = 2.850

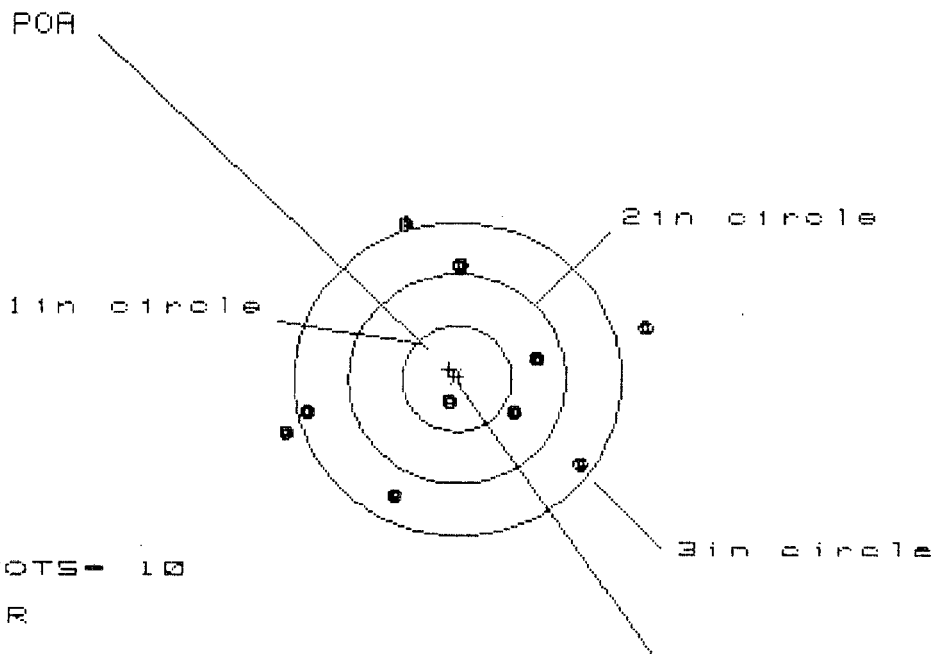
GS = 4.220

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.173	1.082	.857
MINIMUM X	:	-2.046	-1.805	-.742
MAXIMUM Y	:	1.404	1.400	1.409
MINIMUM Y	:	-1.446	-1.450	-1.441
CENTROID X	:	.076	-.165	.060
CENTROID Y	:	-.277	-.273	-.282
POA TO CENTROID in.	:	.287	.319	.288
MIN RADIUS	:	.238	.065	.221
MEAN RADIUS	:	1.268	1.158	1.058
MAX RADIUS	:	2.173	1.806	1.621
HORIZONTAL SPREAD	:	4.219	2.887	1.599
VERTICAL SPREAD	:	2.850	2.850	2.850
EXTREME SPREAD	:	4.220	2.908	2.886
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		7	

11 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CSS11539

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 7

HS= 3.265

VS= 2.601

GS= 3.405

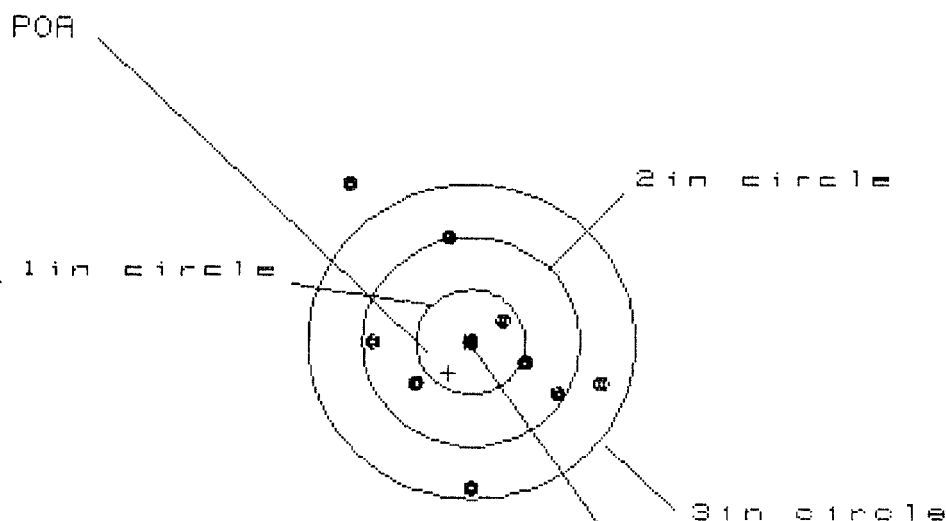
CENTROID *

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.705	1.329	1.158
MINIMUM X	:	-1.560	-1.371	-1.348
MAXIMUM Y	:	1.444	1.498	1.445
MINIMUM Y	:	-1.157	-1.103	-1.156
CENTROID X	:	.074	-.115	.056
CENTROID Y	:	-.088	-.142	-.089
POA TO CENTROID in.	:	.115	.183	.105
MIN RADIUS	:	.217	.160	.207
MEAN RADIUS	:	1.157	1.087	1.021
MAX RADIUS	:	1.774	1.527	1.519
HORIZONTAL SPREAD	:	3.265	2.700	2.506
VERTICAL SPREAD	:	2.601	2.601	2.601
EXTREME SPREAD	:	3.405	2.745	2.745
NUMBER IN ONE INCH CIRCLE =	:	1		
NUMBER IN TWO INCH CIRCLE =	:	3		
NUMBER IN THREE INCH CIRCLE =	:	7		

11 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611539

CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS = 2.263

VS = 2.914

GS = 3.110

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.191
MINIMUM X	-1.072
MAXIMUM Y	1.554
MINIMUM Y	-1.360
CENTROID X	.206
CENTROID Y	.293
POA TO CENTROID in.	.358
MIN RADIUS	.018
MEAN RADIUS	.908
MAX RADIUS	1.887
HORIZONTAL SPREAD	2.263
VERTICAL SPREAD	2.914
EXTREME SPREAD	3.110
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	9

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611539
17 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.300508
1 TO	2	.134164
1 TO	3	.389514
1 TO	4	.544266
1 TO	5	.293847

44 <----POB

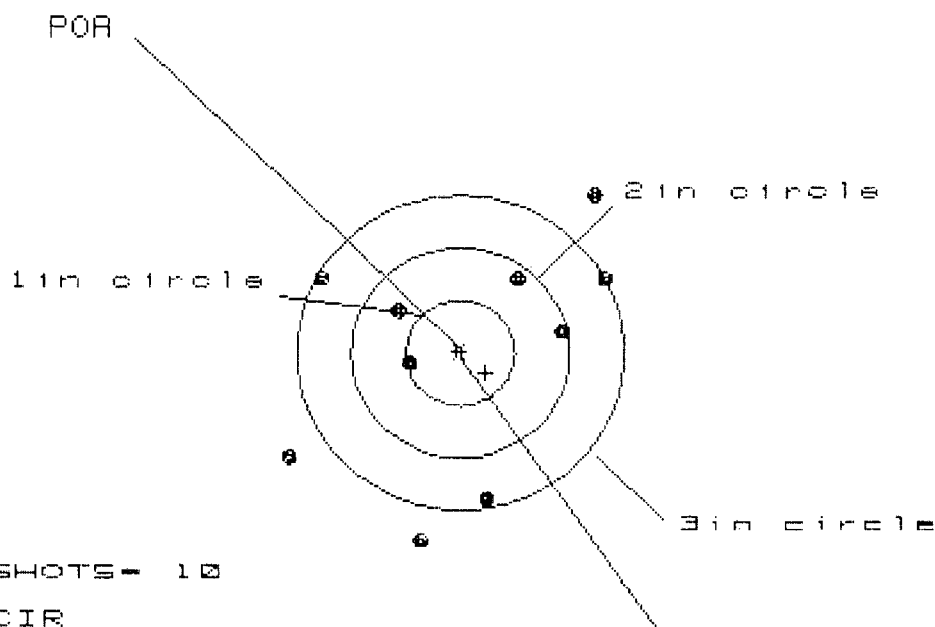
Reshot - New Stock

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1262
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0316
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .130096
THE AMR FOR THIS RIFLE IS: .9666

17 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8B11539.1

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 7

HS= 2.852

VS= 3.307

GS= 3.762

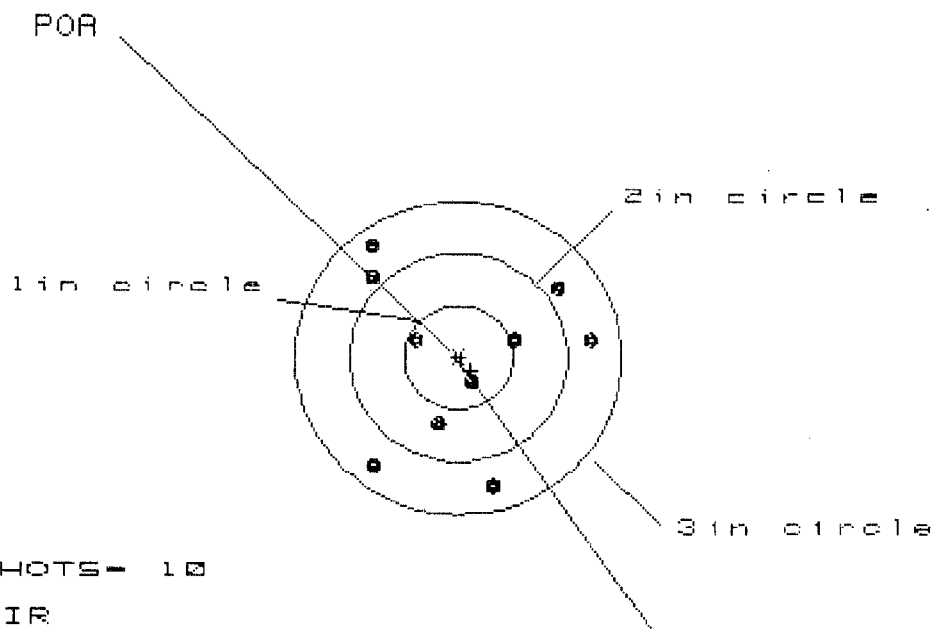
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.301	1.442	1.266
MINIMUM X	:	-1.551	-1.410	-1.347
MAXIMUM Y	:	1.542	.890	.793
MINIMUM Y	:	-1.766	-1.594	-1.691
CENTROID X	:	-.232	-.373	-.197
CENTROID Y	:	.191	.020	.117
POR TO CENTROID in.	:	.301	.374	.229
MIN RADIUS	:	.476	.316	.494
MEAN RADIUS	:	1.305	1.218	1.161
MAX RADIUS	:	1.999	1.672	1.750
HORIZONTAL SPREAD	:	2.852	2.852	2.613
VERTICAL SPREAD	:	3.307	2.484	2.484
EXTREME SPREAD	:	3.762	3.279	2.985
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

17 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B11539.1

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 10

HS= 1.993

VS= 2.233

GS= 2.479

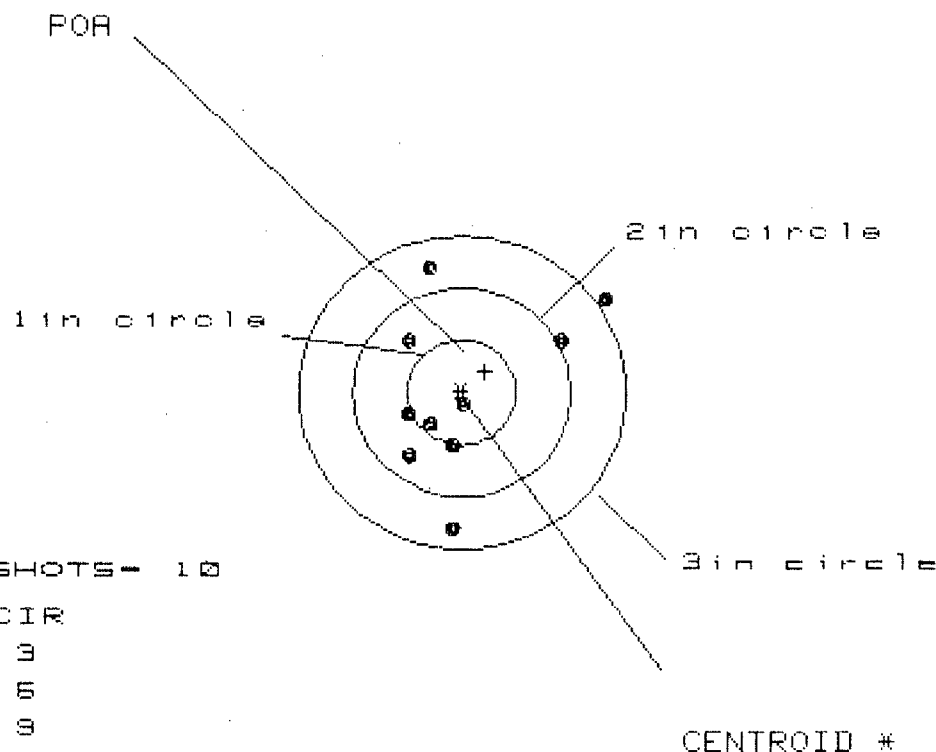
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.183	1.093	.982
MINIMUM X	:	-.810	-.884	-.977
MAXIMUM Y	:	1.046	.919	.810
MINIMUM Y	:	-1.187	-1.071	-1.180
CENTROID X	:	-.112	-.022	.089
CENTROID Y	:	.131	.015	.124
POA TO CENTROID in.	:	.172	.026	.153
MIN RADIUS	:	.230	.097	.236
MEAN RADIUS	:	.903	.837	.788
MAX RADIUS	:	1.323	1.263	1.269
HORIZONTAL SPREAD	:	1.993	1.977	1.959
VERTICAL SPREAD	:	2.233	1.990	1.990
EXTREME SPREAD	:	2.479	2.387	2.246
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

17 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611533.1

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 9

HS= 1.834

VS= 2.480

GS= 2.596

CENTROID #

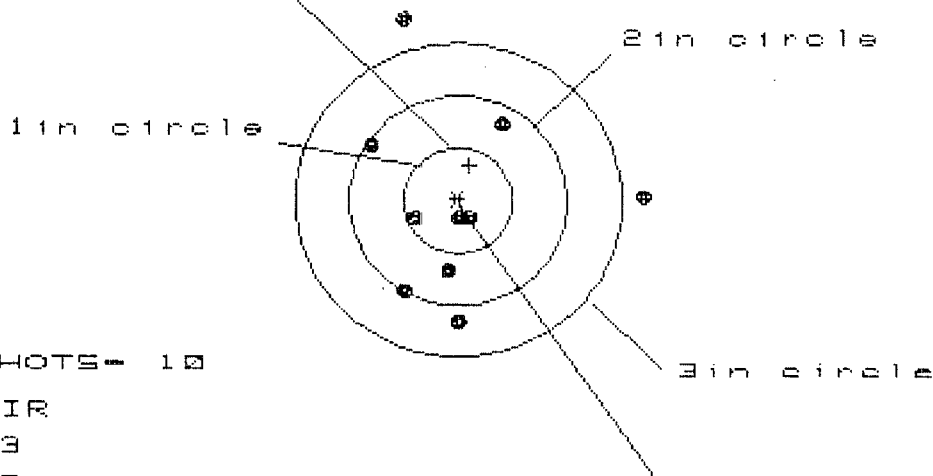
PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.308	1.073	1.078
MINIMUM X	:	-.526	-.381	-.376
MAXIMUM Y	:	1.161	1.257	1.104
MINIMUM Y	:	-1.319	-1.223	-.677
CENTROID X	:	-.212	-.357	-.362
CENTROID Y	:	-.198	-.294	-.141
POA TO CENTROID in.	:	.290	.462	.389
MIN RADIUS	:	.123	.206	.267
MEAN RADIUS	:	.820	.693	.652
MAX RADIUS	:	1.565	1.263	1.149
HORIZONTAL SPREAD	:	1.834	1.454	1.454
VERTICAL SPREAD	:	2.480	2.480	1.781
EXTREME SPREAD	:	2.596	2.486	1.808
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	9		

17 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611539.1

CENTERFIRE PATTERNS # 4

POA



OF SHOTS = 10

IN CIR

1in = 3

2in = 7

3in = 8

HS = 2.511

VS = 2.925

GS = 2.869

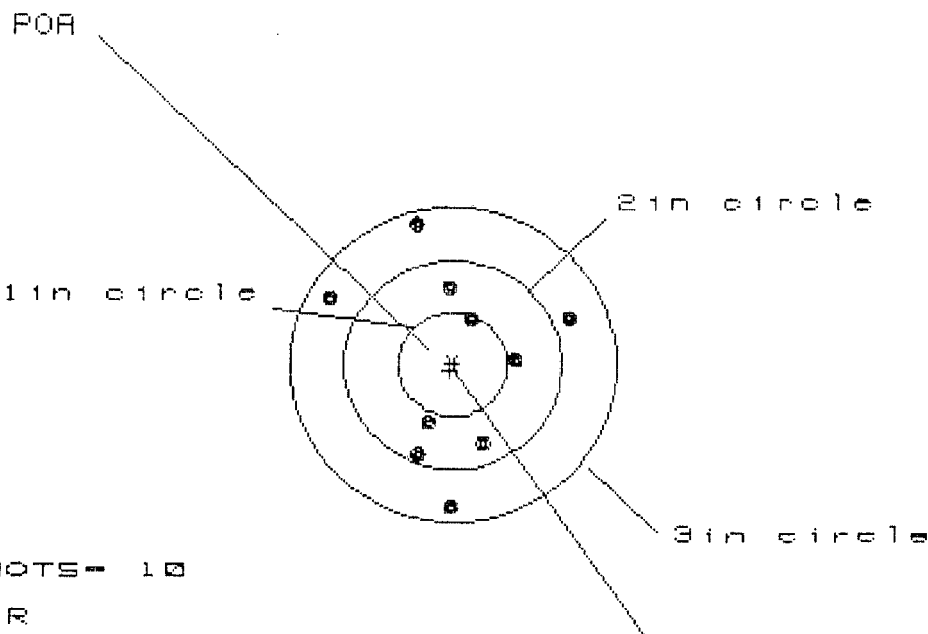
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.692	1.637	.580
MINIMUM X	:	-.819	-.874	-.669
MAXIMUM Y	:	1.778	.963	.988
MINIMUM Y	:	-1.147	-.949	-.924
CENTROID X	:	-.104	-.049	-.254
CENTROID Y	:	-.338	-.536	-.561
POA TO CENTROID in.	:	.354	.538	.616
MIN RADIUS	:	.116	.069	.189
MEAN RADIUS	:	.890	.744	.617
MAX RADIUS	:	1.845	1.650	1.146
HORIZONTAL SPREAD	:	2.511	2.511	1.249
VERTICAL SPREAD	:	2.925	1.912	1.912
EXTREME SPREAD	:	2.969	2.568	1.956
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			8	

17 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611539.1

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 10

HS= 2.234

VS= 2.634

GS= 2.645

CENTROID #

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.061	1.055	1.018
MINIMUM X	:	-1.173	-1.179	-1.216
MAXIMUM Y	:	1.297	1.148	.730
MINIMUM Y	:	-1.337	-.970	-.827
CENTROID X	:	.029	.035	.072
CENTROID Y	:	.056	.205	.062
POA TO CENTROID in.	:	.063	.208	.095
MIN RADIUS	:	.429	.290	.412
MEAN RADIUS	:	.915	.855	.805
MAX RADIUS	:	1.338	1.261	1.353
HORIZONTAL SPREAD	:	2.234	2.234	2.234
VERTICAL SPREAD	:	2.634	2.118	1.556
EXTREME SPREAD	:	2.645	2.242	2.242
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	10		