

C6611554

MODEL 700TM M24

Model SWS TM

Action _____

Barrel Length _____

Capacity _____

Order No. 5716

*Includes 1 in chamber.

Remington

M2400078792

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

Smead®

No. 2-152-5L

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

Remington® **DU PONT**
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 Marquo Deposee.

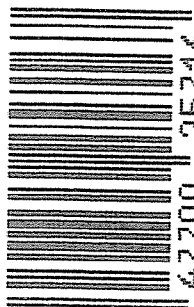
SERIAL NO. C6611554	ORDER NO. 5716
-------------------------------	--------------------------

20



5716 C6611554

LPC



0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611554

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 25 91		RW
600	Proof	3 25 91		RW
607	Check Headspace	3 25 91		RW
610	Dis-assemble Gun	3 25 91		RW
612	Magnaflux Barrel Action	3 28 91		KR
	Magnaflux Bolt	3 28 91		Y
615	Rollmark Caliber	3 28 91		JS
617	Drill and Tap Sight Holes	APR	3.1991	LB
618	Polish Barrel	APR	3 1991	WB
620	Apply Coatings (Barrel Action)		4-11-91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/16/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/16/91	RW
	C) Inspect Ejector Hole for Chamfer		4/16/91	RW
	D) Oil Firing Pin Ass'y		4/16/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5-13-91	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5-14-91	DH
	G) Safety Off Force	3	3	3			5-14-91	DH
	H) Trigger Pull Test & Retainability						5-13-91	DL
	I) Firing Pin Indent	.020	.020	.021			5-14-91	DH
	J) Assemble Stock						5/14/91	Rw
	K) Assemble Swivel Studs						5-21-91	DH
	L) Attach Front and Rear Sight Assemblies						5/14/91	Rw
	M) Iron Sight Alignment						5/14/91	Rw
	N) Detach Front & Rear Sights & place in numbered container						5/14/91	Rw
	O) Attach Scope to Rifle						5/14/91	Rw
	P) Detach & Attach Scope 20 Times						5/14/91	Rw
640	Gallery Target & Test						5-14-91	DH
	A) Time						5-14-91	DH
	B) Malfunctions						5-15-91	DH
	C) Pierced Primers						5-15-91	DH
	D) Optical Clarity of Scope						5-15-91	DH
645	Inspect for Live Ammo						5-15-91	DH
655	Final Inspection							
	A) Headspace						5-21-91	DH
	B) Trigger Pull	2.25	2.16	2.18	2.20	2.25	5-20-90	DL
	C) Function						5-21-91	DH
660	Pack						5-17-91	NF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6611554

DATE 5-13-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.37	2.32	2.33	2.25	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.56	2.15	2.28	2.16	
PULL #3	2.49	2.23	2.28	2.18	
PULL #4	2.30	2.33	2.35	2.20	
PULL #5	2.50	2.30	2.33	2.25	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.47		
PULL #2	3.44	3.42		
PULL #3	3.49	3.48		
PULL #4	3.49	3.36		
PULL #5	3.54	3.47		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.58	4.21		4.22
PULL #2	4.34	4.21		4.21
PULL #3	4.30	4.23		4.17
PULL #4	4.22	4.15		4.19
PULL #5	4.19	4.18		4.20
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611554
15 May 1991

CENTROIDAL DISTANCES

0 TO	1	.317553
1 TO	2	.180942
1 TO	3	.372055
1 TO	4	.4219
1 TO	5	.502021

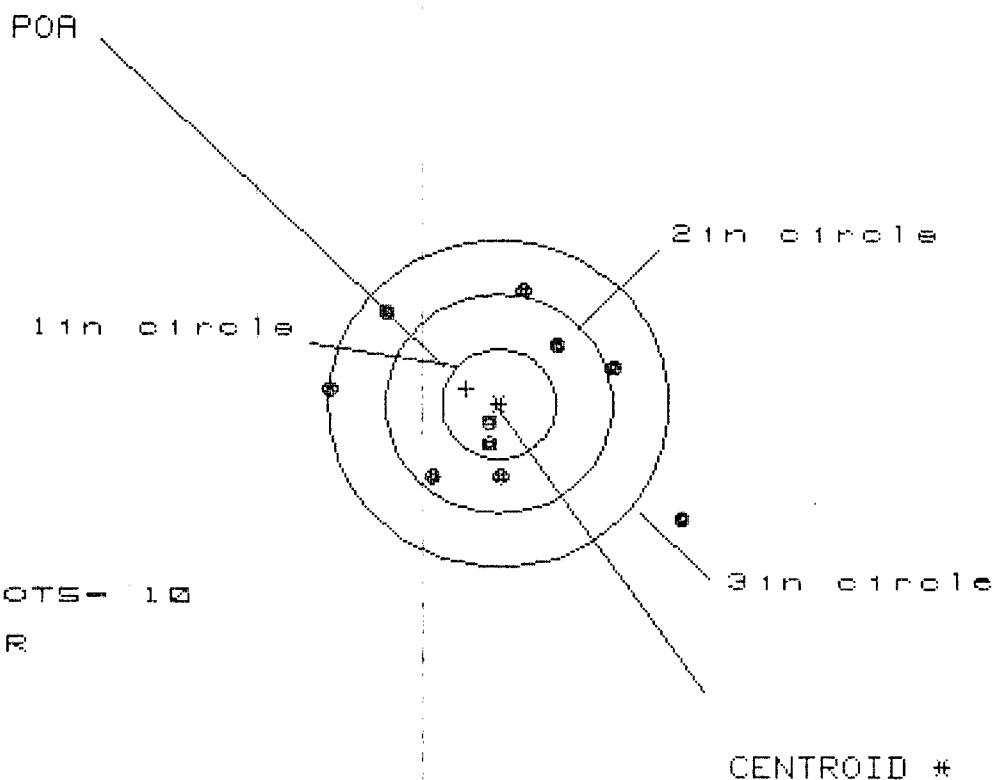
σ_{μ_2} <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0666
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0162
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .068542
THE AMR FOR THIS RIFLE IS: .8604

15 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611554

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 3.037

VS= 2.119

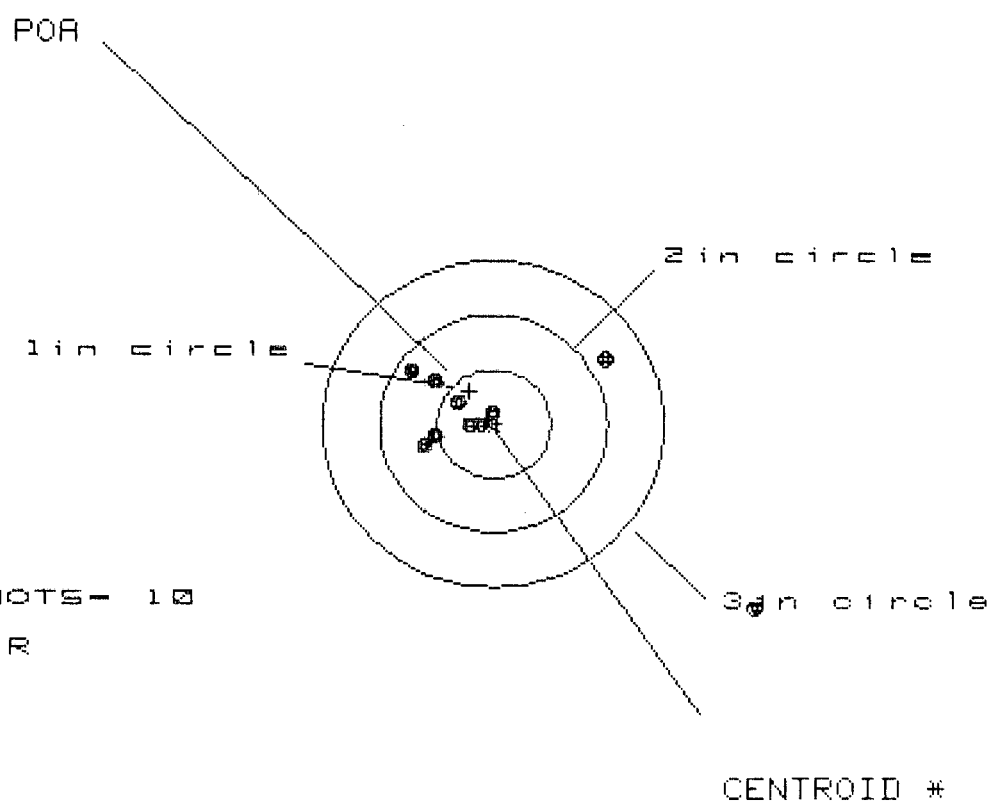
GS= 3.290

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.566	1.144	.982
MINIMUM X	:	-1.471	-1.297	-.996
MAXIMUM Y	:	1.026	.904	.910
MINIMUM Y	:	-1.094	-.813	-.807
CENTROID X	:	.286	.112	.274
CENTROID Y	:	-.138	-.016	-.022
POA TO CENTROID in.	:	.317	.113	.275
MIN RADIUS	:	.170	.302	.278
MEAN RADIUS	:	.959	.865	.791
MAX RADIUS	:	1.910	1.298	1.217
HORIZONTAL SPREAD	:	3.037	2.441	1.978
VERTICAL SPREAD	:	2.119	1.717	1.717
EXTREME SPREAD	:	3.290	2.448	2.031
NUMBER IN ONE INCH CIRCLE =	:	2		
NUMBER IN TWO INCH CIRCLE =	:	5		
NUMBER IN THREE INCH CIRCLE =	:	9		

15 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06611554

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 8

3 in = 9

HS= 2.965

VS= 2.226

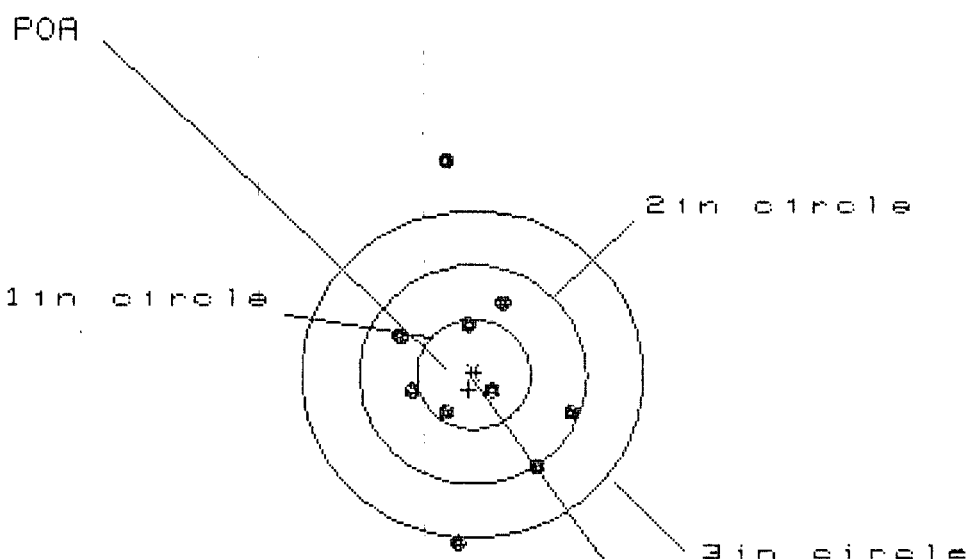
GS= 3.695

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.239	1.191	.402
MINIMUM X	:	-.726	-.477	-.328
MAXIMUM Y	:	.555	.370	.395
MINIMUM Y	:	-1.671	-.390	-.344
CENTROID X	:	.214	-.035	-.184
CENTROID Y	:	-.304	-.119	-.165
POA TO CENTROID in.	:	.372	.124	.247
MIN RADIUS	:	.152	.093	.097
MEAN RADIUS	:	.766	.427	.306
MAX RADIUS	:	2.794	1.247	.514
HORIZONTAL SPREAD	:	2.965	1.668	.730
VERTICAL SPREAD	:	2.226	.760	.739
EXTREME SPREAD	:	3.695	1.767	.824
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

15 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611554

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 8

HS= 1.498

VS= 3.570

GS= 3.574

CENTROID *

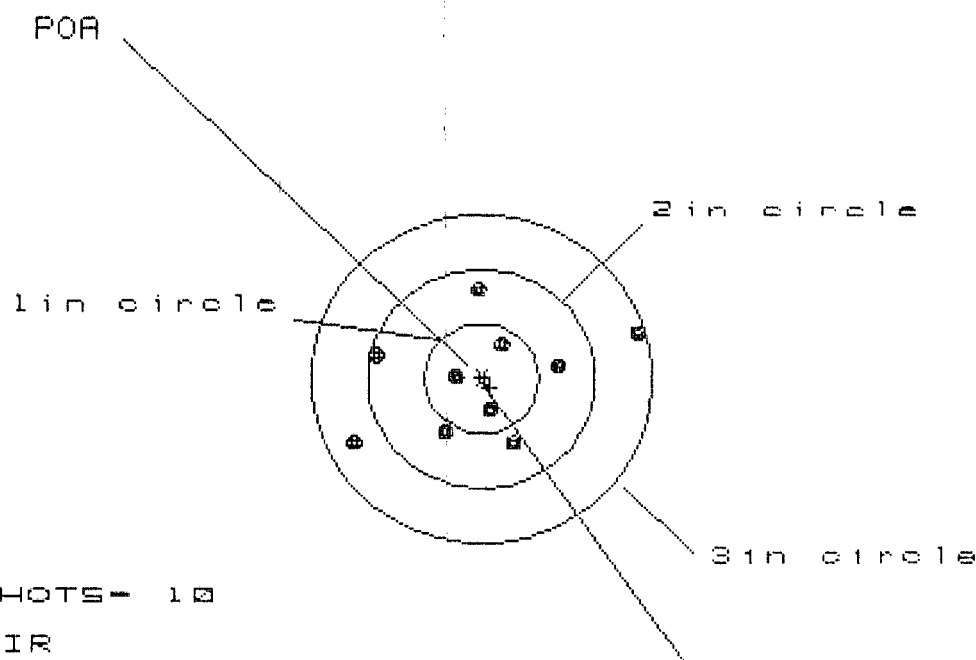
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.877	.845	.827
MINIMUM X	:	-.621	-.653	-.671
MAXIMUM Y	:	1.999	.861	.693
MINIMUM Y	:	-1.571	-1.349	-.755
CENTROID X	:	.041	.073	.091
CENTROID Y	:	.142	-.080	.088
POA TO CENTROID in.	:	.148	.109	.127
MIN RADIUS	:	.275	.178	.203
MEAN RADIUS	:	.862	.718	.625
MAX RADIUS	:	2.020	1.356	.892
HORIZONTAL SPREAD	:	1.498	1.498	1.498
VERTICAL SPREAD	:	3.570	2.210	1.448
EXTREME SPREAD	:	3.574	2.234	1.683
NUMBER IN ONE INCH CIRCLE =	:		3	
NUMBER IN TWO INCH CIRCLE =	:		8	
NUMBER IN THREE INCH CIRCLE =	:		8	

15 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611554

CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1 in - 3

2 in - 8

3 in - 10

HS- 2.473

VS- 1.378

GS- 2.656

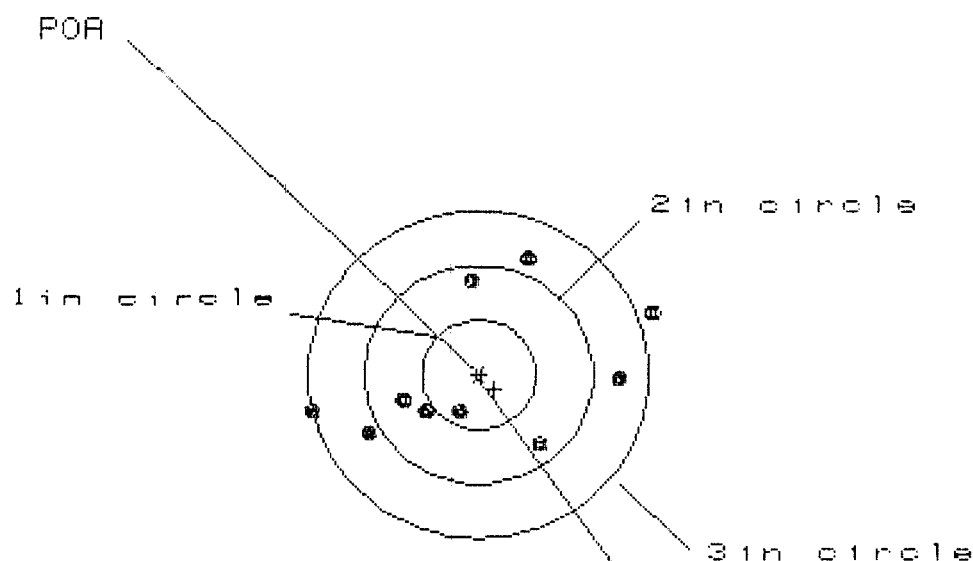
CENTROID #

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.336	.857	.733
MINIMUM X	:	-1.137	-.988	-.886
MAXIMUM Y	:	.798	.845	.783
MINIMUM Y	:	-.580	-.533	-.595
CENTROID X	:	-.074	-.223	-.099
CENTROID Y	:	.082	.035	.097
POA TO CENTROID in.	:	.111	.225	.138
MIN RADIUS	:	.199	.116	.171
MEAN RADIUS	:	.721	.637	.568
MAX RADIUS	:	1.402	1.106	.921
HORIZONTAL SPREAD	:	2.473	1.845	1.619
VERTICAL SPREAD	:	1.378	1.378	1.378
EXTREME SPREAD	:	2.656	1.944	1.631
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

15 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611554

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 2.964

VS= 1.749

GS= 3.115

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.528
MINIMUM X	-1.436
MAXIMUM Y	1.101
MINIMUM Y	-.647
CENTROID X	-.134
CENTROID Y	.137
POA TO CENTROID in.	.191
MIN RADIUS	.377
MEAN RADIUS	.994
MAX RADIUS	1.641
HORIZONTAL SPREAD	2.964
VERTICAL SPREAD	1.749
EXTREME SPREAD	3.115
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	9