C6649083

MODEL 700™ M24

Model SWS ™

Action

Barrel Length

Capacity

Order No. 5716

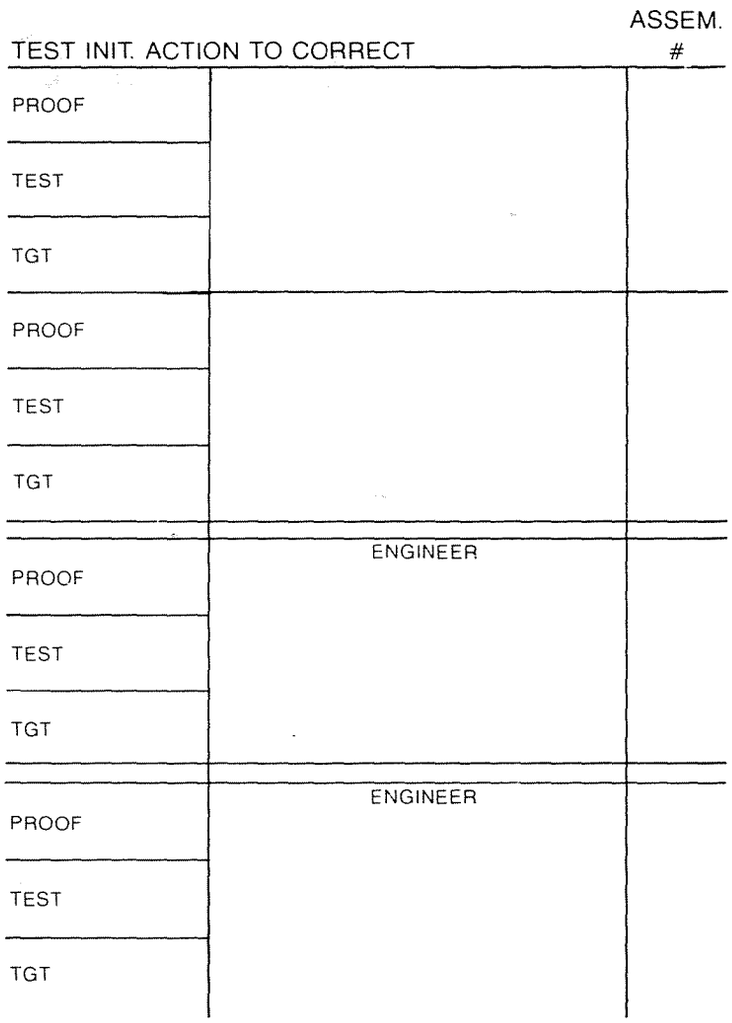
*Includes 1 in chamber.

Remington

MOD. _____ GA. CAL. _____ GUN # 9083

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
RA	1st 9/3/91	Trigger creeps	KS
	2nd 9/9/91	Repaired A.C. (creep)	KS
	3rd		
	4th		

FUNCTION RD 6654 Rev 1


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

D

M-24

CONTRACT # DAAA21-87-C-0086

GTM

GUN SERIAL # C6649083

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		7/24/91	KL
600	Proof		7/24/91	KL
607	Check Headspace		7/24/91	KL
610	Dis-assemble Gun		7/24/91	KL
612	Magnaflux Barrel Action	AUG 7 1991		KR
	Magnaflux Bolt	AUG 7 1991		KR
615	Rollmark Caliber	AUG 7 1991		DB
617	Drill and Tap Sight Holes	AUG 7 1991		LB
618	Polish Barrel	AUG 13 1991		WB
620	Apply Coatings (Barrel Action)		7-27-91	KL
	Apply Coating (Bolt)		7-27-91	KL
625	Final Assembly A) Clean inside of Bolt Assembly		8/29/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/29/91	KL
	C) Inspect Ejector Hole for Chamfer		8/29/91	KL
	D) Oil Firing Pin Ass'y		8/29/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		8/31/91	KL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8-31-91	DH
	G) Safety Off Force	3	3	2½			8-31-91	DH
	H) Trigger Pull Test & Retainability						8/31/91	DH
	I) Firing Pin Indent	.021	.020	.022			8-31-91	DH
	J) Assemble Stock						8/31/91	KK
	K) Assemble Swivel Studs						9-10-91	DH
	L) Attach Front and Rear Sight Assemblies						8/31/91	KK
	M) Iron Sight Alignment						8/31/91	KK
	N) Detach Front & Rear Sights & place in numbered container						8/31/91	KK
	O) Attach Scope to Rifle						8/31/91	KK
	P) Detach & Attach Scope 20 Times						8/31/91	KK
640	Gallery Target & Test						9/3/91	KT
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clearity of Scope						"	KT
645	Inspect for Live Ammo						9/3/91	KT
655	Final Inspection A) Headspace						9-10-91	DH
	B) Trigger Pull	264	259	269	264	265	9/6/91	DH
	C) Function						9-10-91	DH
660	Pack						9-18-91	AF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6649083

DATE 8/31/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.49	2.40	2.44	2.64	MIN. SETTING,
PULL #2	2.61	2.46	2.46	2.59	NO AVG. OF 5
PULL #3	2.61	2.49	2.43	2.69	READINGS ACCEPT-
PULL #4	2.30	2.34	2.50	2.64	ABLE LESS THAN 2#
PULL #5	2.52	2.45	2.48	2.65	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.27	3.52		
PULL #2	3.27	3.40		
PULL #3	3.28	3.59		
PULL #4	3.60	3.39		
PULL #5	3.61	3.20		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.14		4.44
PULL #2	4.52	4.54		4.56
PULL #3	4.44	4.47		4.57
PULL #4	4.44	4.51		4.57
PULL #5	4.51	4.52		4.21
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649083
4 Sep 1991

CENTROIDAL DISTANCES

0	TO	1	.115447
1	TO	2	.106
1	TO	3	.571909
1	TO	4	.457161
1	TO	5	.359124

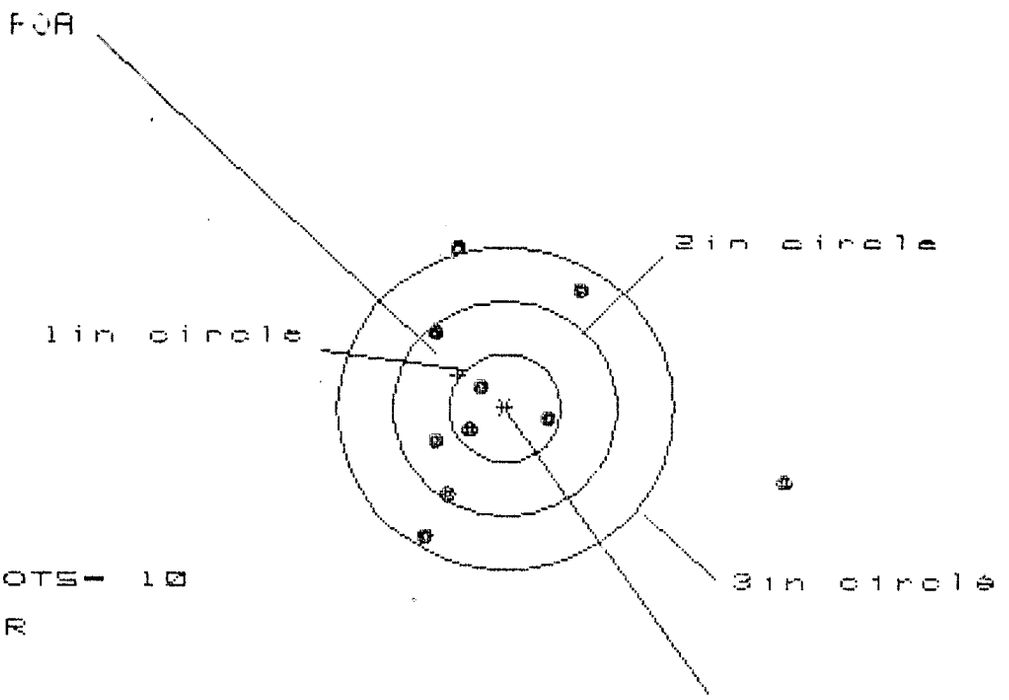
3 4 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0642
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.145
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .1595

[illegible] FOR THIS RIFLE IS: 1.024

(93) FILE:/PATTERNING/CENTERFIRE_PATT/C6649083

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

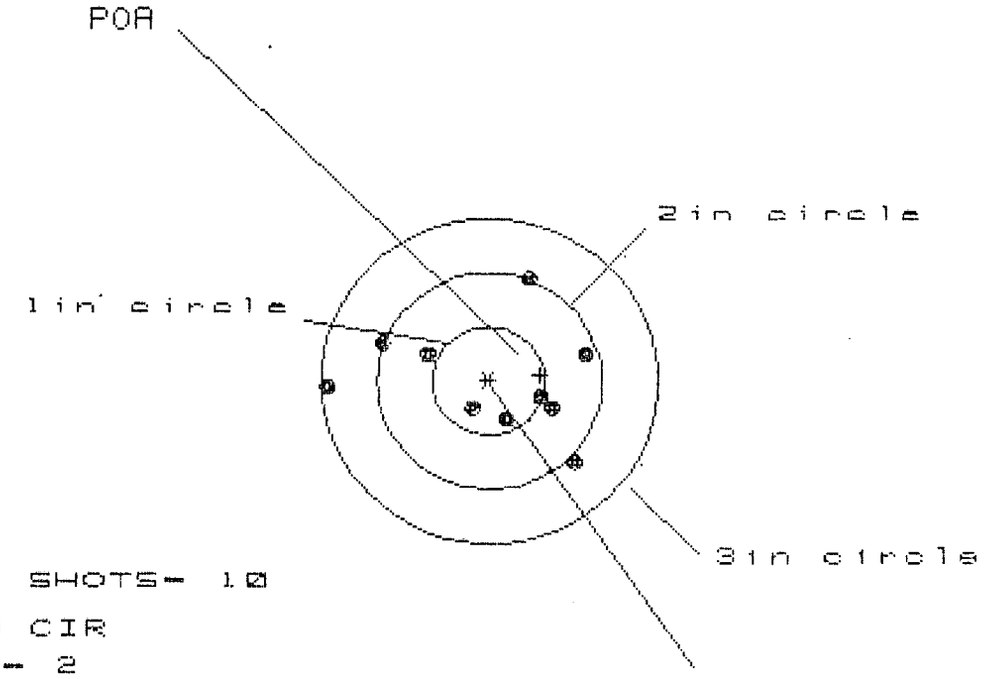
# IN CIR
1in = 3
2in = 6
3in = 8

HS= 3.261
VS= 2.731
GS= 3.639

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.494	.953	.940
MINIMUM X	:	-.767	-.490	-.503
MAXIMUM Y	:	1.499	1.417	1.207
MINIMUM Y	:	-1.232	-1.314	-1.137
CENTROID X	:	.422	.145	.158
CENTROID Y	:	-.308	-.226	-.403
POA TO CENTROID in.	:	.522	.268	.433
MIN RADIUS	:	.298	.090	.167
MEAN RADIUS	:	1.065	.834	.739
MAX RADIUS	:	2.600	1.421	1.530
HORIZONTAL SPREAD	:	3.261	1.443	1.443
VERTICAL SPREAD	:	2.731	2.731	2.344
EXTREME SPREAD	:	3.639	2.758	2.753
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

3 Sep 1991 FILE:/PATTERNING/CENTERFIRE_PATT/C6649003

CENTERFIRE PATTERNS # 3

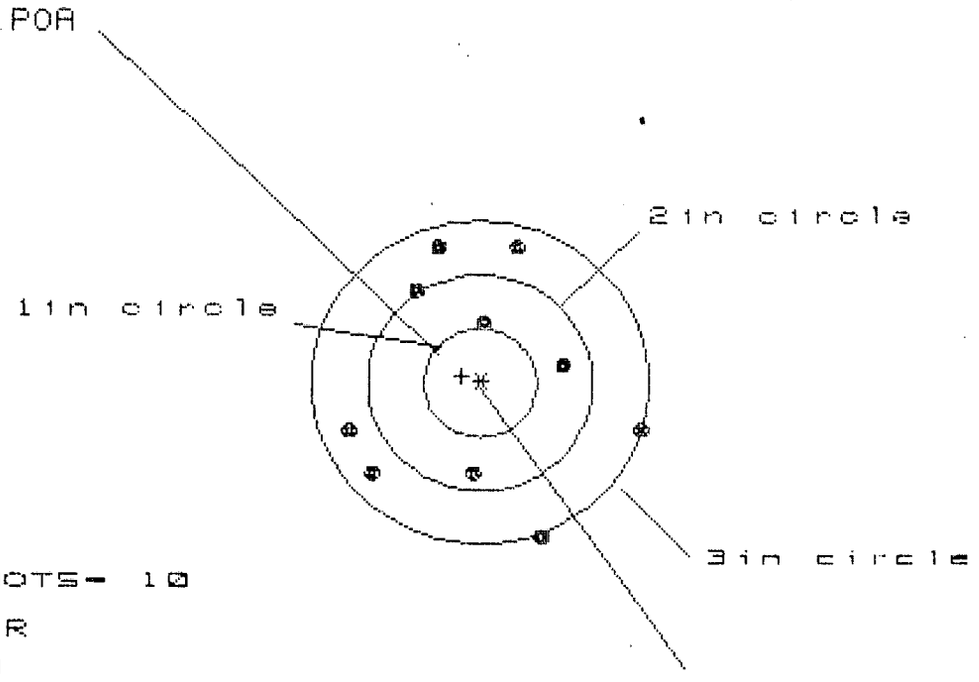


# OF SHOTS= 10
# IN CIR
1in = 2
2in = 7
3in = 10
HS= 2.293
VS= 1.605
GS= 2.308

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.882	.725	.582
MINIMUM X	:	-1.411	-1.144	-.804
MAXIMUM Y	:	.908	.906	.946
MINIMUM Y	:	-.697	-.699	-.659
CENTROID X	:	-.454	-.297	-.154
CENTROID Y	:	-.054	-.052	-.092
POA TO CENTROID in.	:	.457	.302	.179
MIN RADIUS	:	.337	.362	.217
MEAN RADIUS	:	.775	.682	.589
MAX RADIUS	:	1.411	1.187	.946
HORIZONTAL SPREAD	:	2.293	1.869	1.386
VERTICAL SPREAD	:	1.605	1.605	1.605
EXTREME SPREAD	:	2.308	2.015	1.661
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	10		

3 Sep 1991 FILE:/PATTERNING/CENTERFIRE_PATT/C6B490B3

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

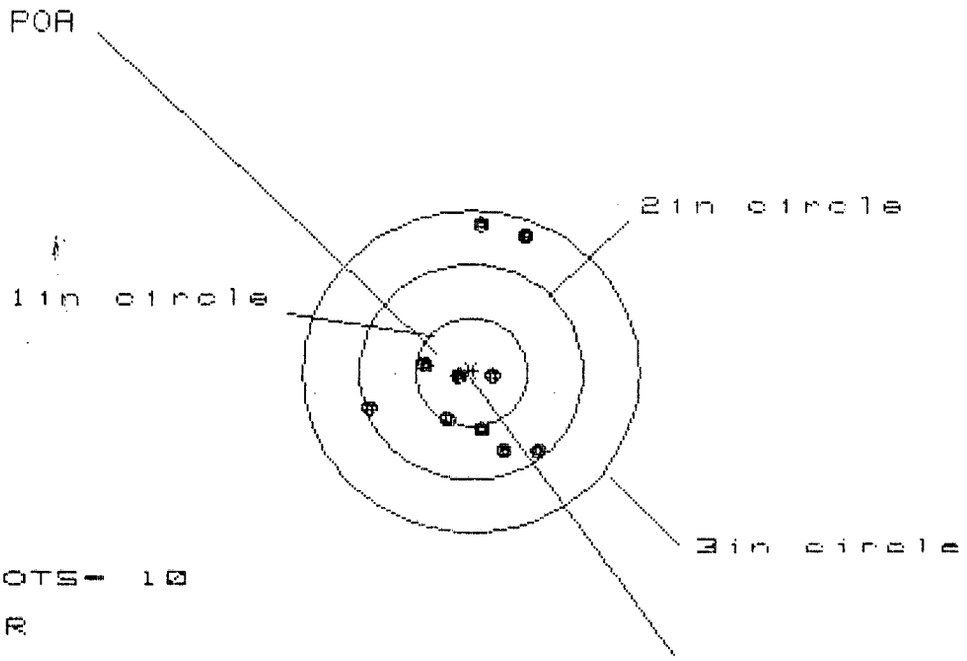
# IN CIR	
1in	= 0
2in	= 3
3in	= 8

HS= 2.608
VS= 2.744
GS= 2.828

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.470	1.529	.956
MINIMUM X	:	-1.138	-1.079	-.888
MAXIMUM Y	:	1.274	1.110	1.036
MINIMUM Y	:	-1.470	-1.027	-1.101
CENTROID X	:	.168	.109	-.082
CENTROID Y	:	-.062	.102	.176
POA TO CENTROID in.	:	.179	.149	.194
MIN RADIUS	:	.525	.366	.382
MEAN RADIUS	:	1.130	1.055	.966
MAX RADIUS	:	1.564	1.640	1.323
HORIZONTAL SPREAD	:	2.608	2.608	1.844
VERTICAL SPREAD	:	2.744	2.137	2.137
EXTREME SPREAD	:	2.828	2.608	2.526
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

3 Sep 1991 FILE:/PATTERNING/CENTERFIRE_PATT/C6649003

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

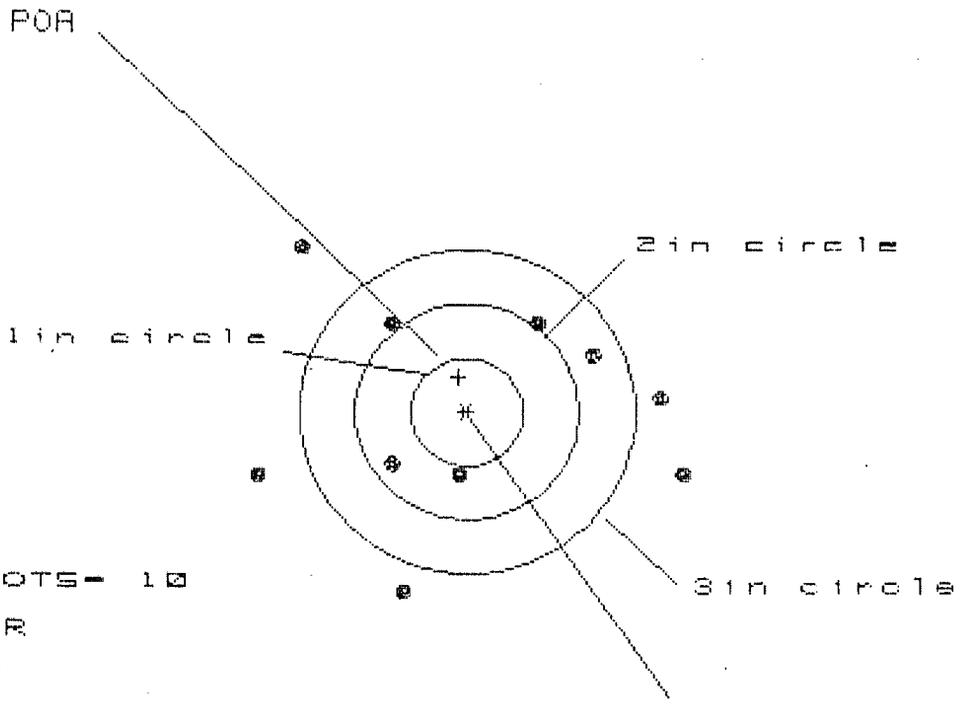
# IN CIR
1in = 4
2in = 8
3in = 10

HS= 1.438
VS= 2.102
GS= 2.162

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.553	.559	.624
MINIMUM X	:	-.885	-.879	-.814
MAXIMUM Y	:	1.393	1.404	.437
MINIMUM Y	:	-.709	-.554	-.378
CENTROID X	:	.112	.106	.041
CENTROID Y	:	.028	-.126	-.302
POA TO CENTROID in.	:	.115	.165	.305
MIN RADIUS	:	.121	.157	.176
MEAN RADIUS	:	.706	.595	.459
MAX RADIUS	:	1.394	1.498	.816
HORIZONTAL SPREAD	:	1.438	1.438	1.438
VERTICAL SPREAD	:	2.102	1.958	.815
EXTREME SPREAD	:	2.162	2.073	1.501
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

3 Sep 1991 FILE:/PATTERNING/CENTERFIRE_PATT/C6649083

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

# IN CIR	
1in =	0
2in =	2
3in =	5

HS= 3.860
VS= 3.193
GS= 4.065

PATTERN # :	5		
SHOTS (BEST OF) :	10	9	8
MAXIMUM X :	1.956	1.790	1.810
MINIMUM X :	-1.904	-2.070	-1.847
MAXIMUM Y :	1.567	1.003	.953
MINIMUM Y :	-1.626	-1.452	-1.502
CENTROID X :	.073	.239	.016
CENTROID Y :	-.329	-.503	-.453
POA TO CENTROID in.:	.337	.557	.453
MIN RADIUS :	.526	.405	.401
MEAN RADIUS :	1.444	1.348	1.267
MAX RADIUS :	2.169	2.116	1.909
HORIZONTAL SPREAD :	3.860	3.860	3.657
VERTICAL SPREAD :	3.193	2.455	2.455
EXTREME SPREAD :	4.065	3.860	3.723
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		2	
NUMBER IN THREE INCH CIRCLE =		5	