C6522265

MODEL 700™ M24

Model SWS™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington®

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522265

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/24/90	KA
600	Proof		6/26/90	KA
607	Check Headspace		6/24/90	KA
610	Dis-assemble Gun		6/26/90	KA
612	Magnaflux Barrel Action		7/10/90	KR
	Magnaflux Bolt		7/10/90	KR
615	Rollmark Caliber		7/10/90	D.S.
617	Drill and Tap Sight Holes		7/11/90	WB
618	Polish Barrel RB		7/13/90	WB
620	Apply Coatings (Barrel Action)		7/23/90	KA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/23/90	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/23/90	KA
	C) Inspect Ejector Hole for Chamfer		7/23/90	KA
	D) Oil Firing Pin Ass'y		7/23/90	KA
	E) Adjust Trigger Pull to Min Setting and Stake		8/22/90	DH

op. #	OP. NAME	READINGS	DATE	INIT
625 cont.	F) Safety On Force	4 4 4	7/25/90	[illegible]
	G) Safety Off Force	3 3 3	7/25/90	[illegible]
	H) Trigger Pull Test & Retainability		8/22/90	[illegible]
	I) Firing Pin Indent	.0225 .022 .022	7/25/90	[illegible]
	J) Assemble Stock		7/25/90	[illegible]
	K) Assemble Swivel Studs		8/29/90	[illegible]
	L) Attach Front and Rear Sight Assemblies		7/25/90	[illegible]
	M) Iron Sight Alignment		7/25/90	[illegible]
	N) Detach Front & Rear Sights & place in numbered container		7/25/90	[illegible]
	O) Attach Scope to Rifle		7/25/90	[illegible]
	P) Detach & Attach Scope 20 Times		7/27/90	[illegible]
640	Gallery Target & Test		7-31-90	DH
	A) Time		7-31-90	DH
	B) Malfunctions		7-31-90	DH
	C) Pierced Primers		7-31-90	DH
	D) Optical Clearity of Scope		7-31-90	DH
645	Inspect for Live Ammo		7-31-90	DH
655	Final Inspection A) Headspace		8/29/90	[illegible]
	B) Trigger Pull	2.40 2.32 2.40 2.34 2.33	8/22/90	[illegible]
	C) Function		8/29/90	[illegible]
660	Pack		9/20/90	[illegible]

SWS TRIGGER PULL TEST

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

SERIAL NO. C6522265

DATE 8/22/90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.38	2.36	2.40	MIN. SETTING,
PULL #2	2.40	2.35	2.41	2.32	NO AVG. OF 5
PULL #3	2.37	2.35	2.39	2.40	READINGS ACCEPT-
PULL #4	2.35	2.39	2.39	2.34	ABLE LESS THAN 2#
PULL #5	2.35	2.39	2.37	2.33	
TOTAL	11.90	11.86	11.92	11.79	
AVG.	2.38	2.372	2.384	2.358	

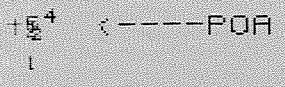
	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.32	3.24		
PULL #2	3.25	3.19		
PULL #3	3.28	3.23		
PULL #4	3.20	3.26		
PULL #5	3.13	3.24		
TOTAL	16.18	16.16		
AVG.	3.236	3.232		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.31	4.34		4.28
PULL #2	4.27	4.22		4.20
PULL #3	4.27	4.26		4.26
PULL #4	4.33	4.28		4.28
PULL #5	4.28	4.30		4.26
TOTAL	21.46	21.40		21.28
AVG.	4.292	4.28		4.256

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522265
31 Jul 1990

CENTROIDAL DISTANCES

0	TO	1	.703466
1	TO	2	.543059
1	TO	3	.508139
1	TO	4	.884494
1	TO	5	.68668

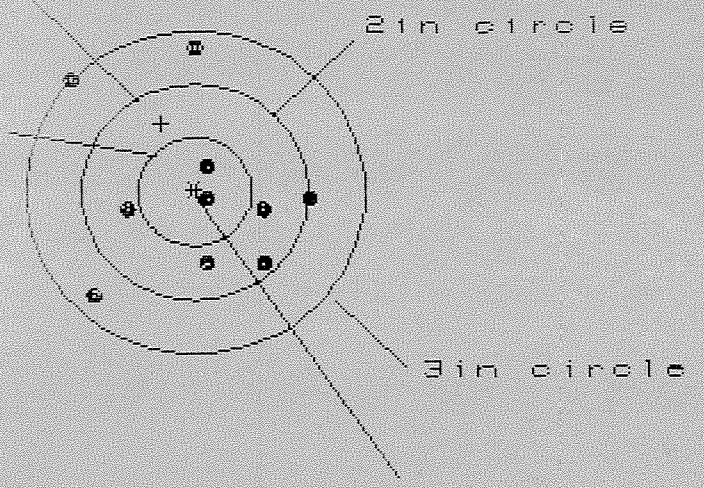


THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .394
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1326
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .415715

THE AMR FOR THIS RIFLE IS: .8502

FILE:/PATTERNING/CENTERFIRE_PATT/C6522265

CENTERFIRE PATTERNS # 1

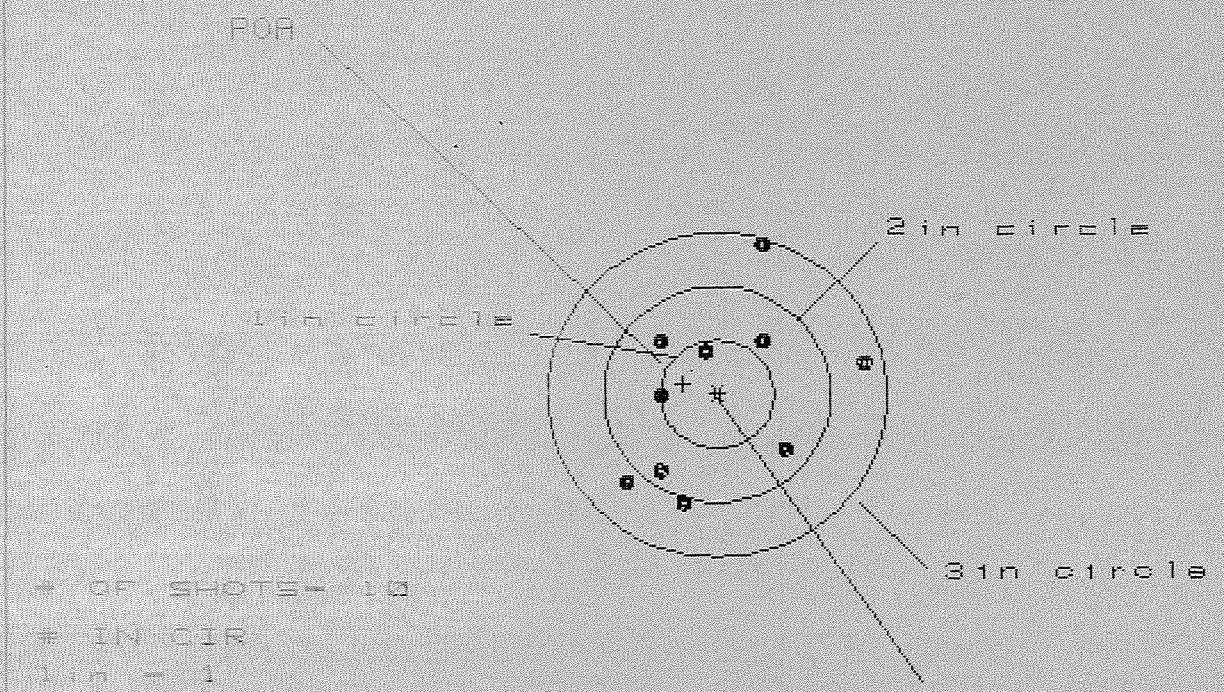


# OF SHOTS= 10
# IN CIR
1in = 2
2in = 7
3in = 9
MST = 2.234
MED = 2.341
LST = 2.501

PATTERN #	:	1	
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.960	.840	.827
MINIMUM X	:	-1.074	-.978	-.991
MAXIMUM Y	:	1.388	1.507	.546
MINIMUM Y	:	-.956	-.837	-.649
CENTROID X	:	.292	.412	.425
CENTROID Y	:	-.640	-.759	-.947
POA TO CENTROID in.	:	.703	.863	1.038
MIN RADIUS	:	.150	.019	.201
MEAN RADIUS	:	.836	.719	.623
MAX RADIUS	:	1.519	1.511	1.184
HORIZONTAL SPREAD	:	2.034	1.818	1.818
VERTICAL SPREAD	:	2.344	2.344	1.195
EXTREME SPREAD	:	2.501	2.501	2.046
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

31 Jul 1998 FILE: /PATTERNING/CENTERFIRE_PATT/CG5222B5

CENTERFIRE PATTERNS # 2



OF SHOTS= 10
IN CIR
1 in = 1
2 in = 6
3 in = 10
HS= 2.153
VS= 2.390
SS= 2.555

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.340	1.386	.784
MINIMUM X	:	-.813	-.767	-.594
MAXIMUM Y	:	1.416	.664	.717
MINIMUM Y	:	-.974	-.817	-.764
CENTROID X	:	.300	.254	.081
CENTROID Y	:	-.097	-.254	-.307
POA TO CENTROID in.	:	.315	.359	.318
MIN RADIUS	:	.367	.520	.394
MEAN RADIUS	:	.886	.815	.711
MAX RADIUS	:	1.475	1.450	.885
HORIZONTAL SPREAD	:	2.153	2.153	1.378
VERTICAL SPREAD	:	2.390	1.481	1.481
EXTREME SPREAD	:	2.555	2.415	1.738
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

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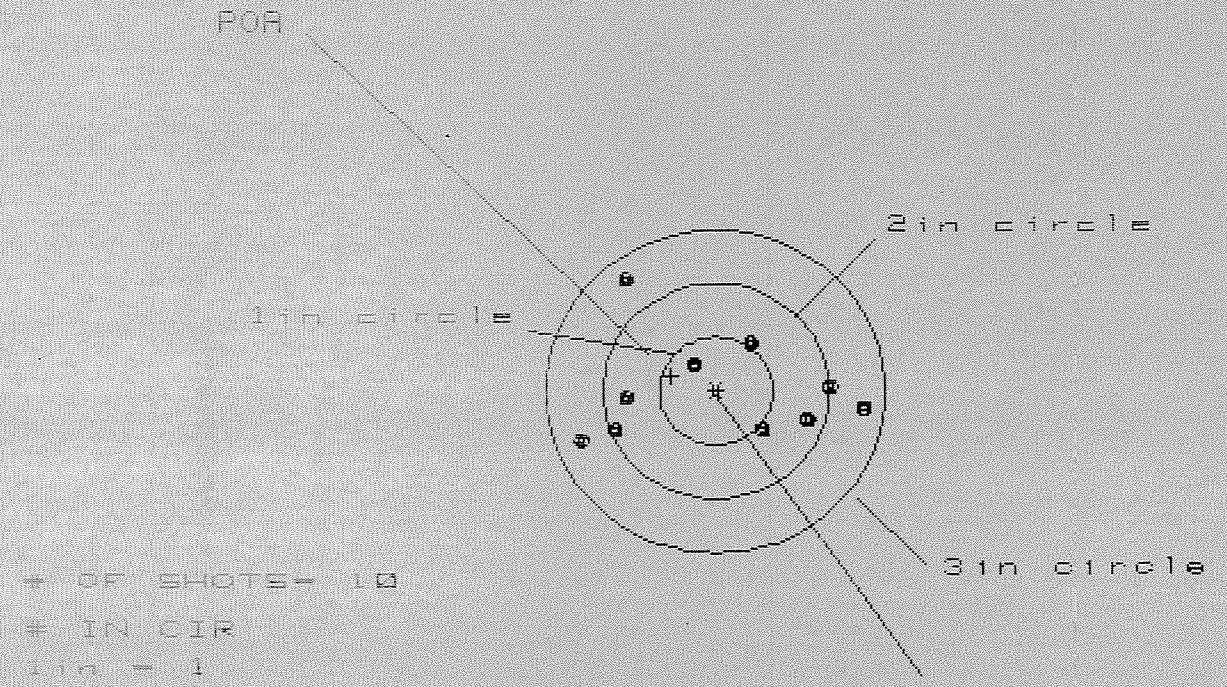
CENTERFIRE PATTERNS # 3



# OF SHOTS= 10
# IN CIR
1in = 1
2in = 6
3in = 10
HS= 2.552
VS= 1.508
GS= 2.569

PATTERN #	:	3	
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.331	1.181	1.100
MINIMUM X	:	-1.221	-1.073	-1.154
MAXIMUM Y	:	1.040	1.020	.575
MINIMUM Y	:	-.468	-.488	-.360
CENTROID X	:	.393	.245	.326
CENTROID Y	:	-.142	-.122	-.250
POA TO CENTROID in.	:	.417	.274	.411
MIN RADIUS	:	.274	.204	.343
MEAN RADIUS	:	.908	.852	.806
MAX RADIUS	:	1.343	1.209	1.208
HORIZONTAL SPREAD	:	2.552	2.254	2.254
VERTICAL SPREAD	:	1.508	1.508	.935
EXTREME SPREAD	:	2.569	2.304	2.304
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

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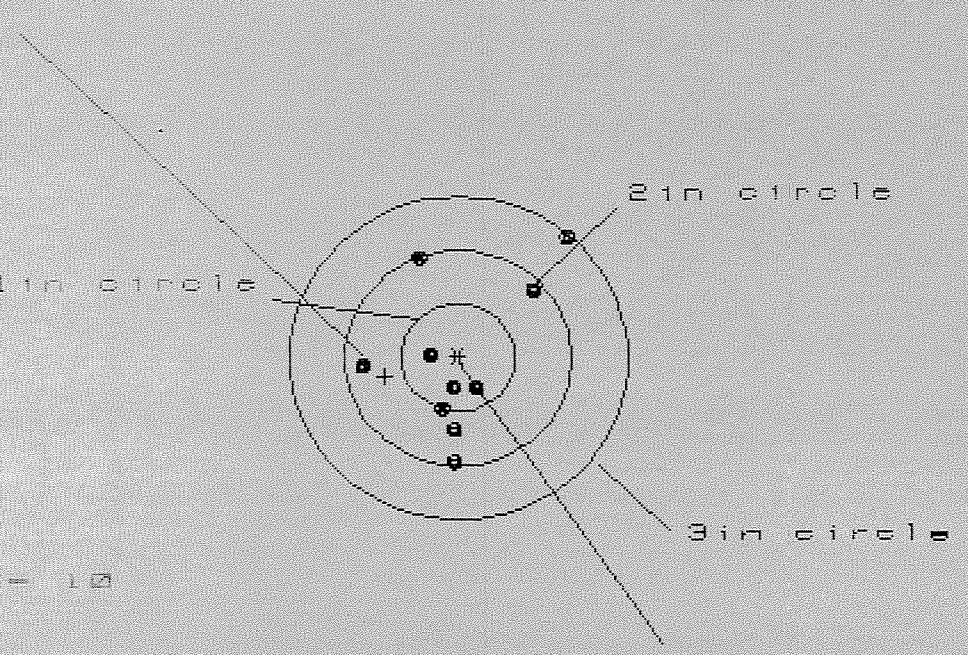
CENTERFIRE PATTERNS # 4



# OF SHOTS= 10
# IN CIR
1in = 4
2in = 9
3in = 10
HS= 1.834
VS= 2.043
GS= 2.282

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.978	.737	.712
MINIMUM X	:	-.856	-.747	-.772
MAXIMUM Y	:	1.098	1.044	.900
MINIMUM Y	:	-.945	-.823	-.692
CENTROID X	:	.645	.536	.561
CENTROID Y	:	.171	.049	-.082
POA TO CENTROID in.	:	.667	.538	.567
MIN RADIUS	:	.210	.171	.040
MEAN RADIUS	:	.712	.583	.484
MAX RADIUS	:	1.471	1.065	1.147
HORIZONTAL SPREAD	:	1.834	1.484	1.484
VERTICAL SPREAD	:	2.043	1.867	1.592
EXTREME SPREAD	:	2.282	1.887	1.726
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

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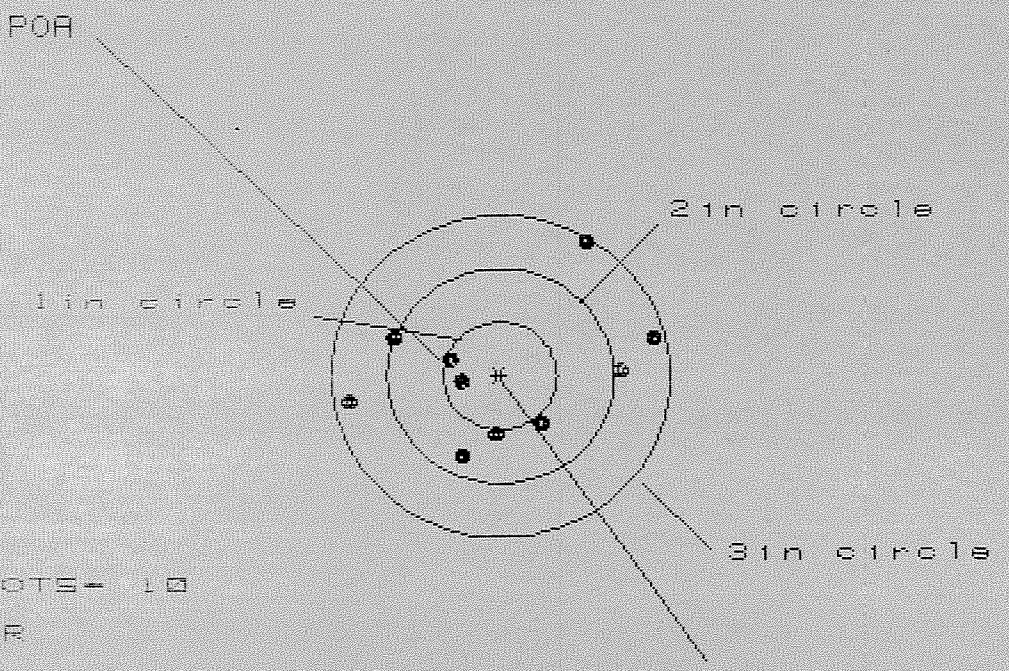
CENTERFIRE PATTERNS # 5



# OF SHOTS= 10
# IN CIR
1in = 2
2in = 5
3in = 10
HS= 2.697
VS= 1.939
ES= 2.757

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.359	1.439	1.271
MINIMUM X	:	-1.338	-1.258	-1.078
MAXIMUM Y	:	1.205	.475	.533
MINIMUM Y	:	-.734	-.600	-.542
CENTROID X	:	.340	.260	.080
CENTROID Y	:	.045	-.089	-.147
POA TO CENTROID in.	:	.343	.275	.167
MIN RADIUS	:	.391	.319	.192
MEAN RADIUS	:	.909	.821	.699
MAX RADIUS	:	1.406	1.512	1.290
HORIZONTAL SPREAD	:	2.697	2.697	2.349
VERTICAL SPREAD	:	1.939	1.075	1.075
EXTREME SPREAD	:	2.757	2.757	2.365
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10