C661576

MODEL 700™ M24

Model SWS™

Action

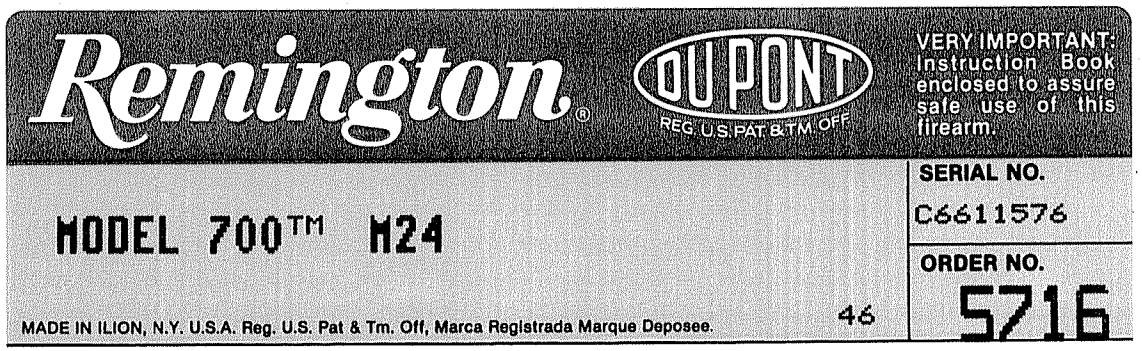
Barrel Length

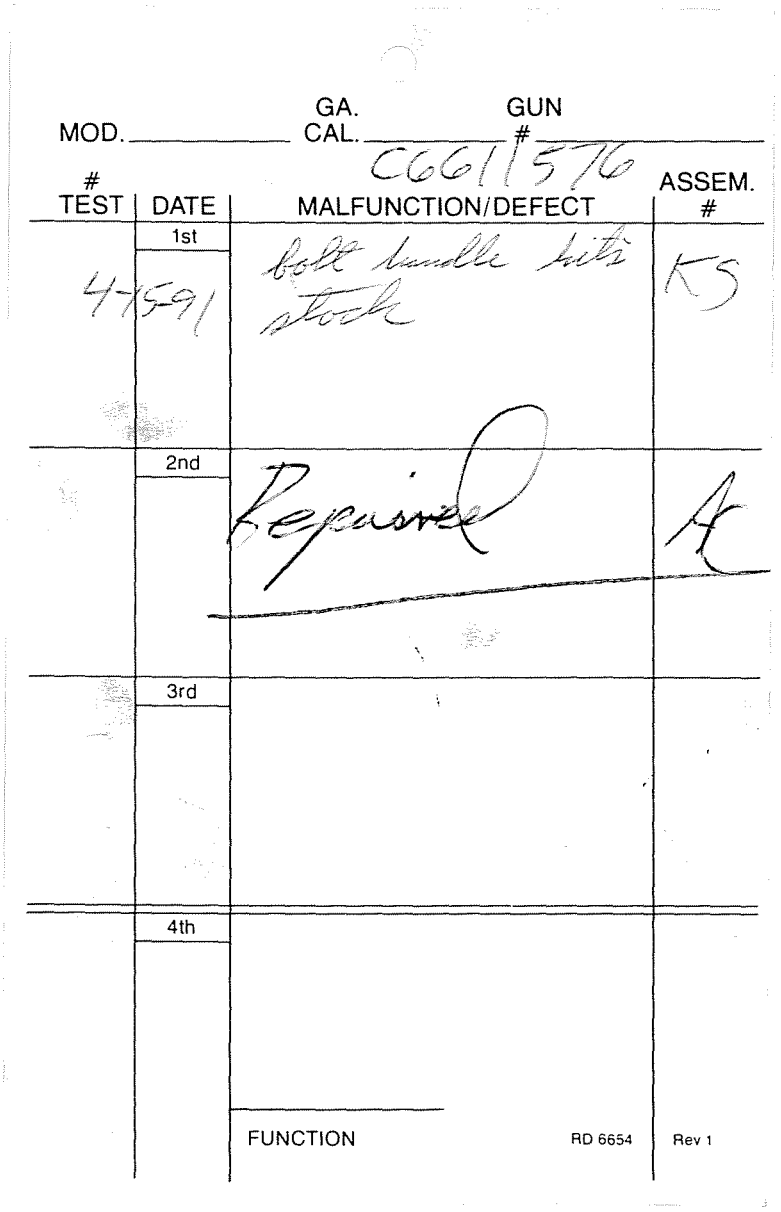
Capacity

Order No. 5716

*Includes 1 in chamber.

Remington®

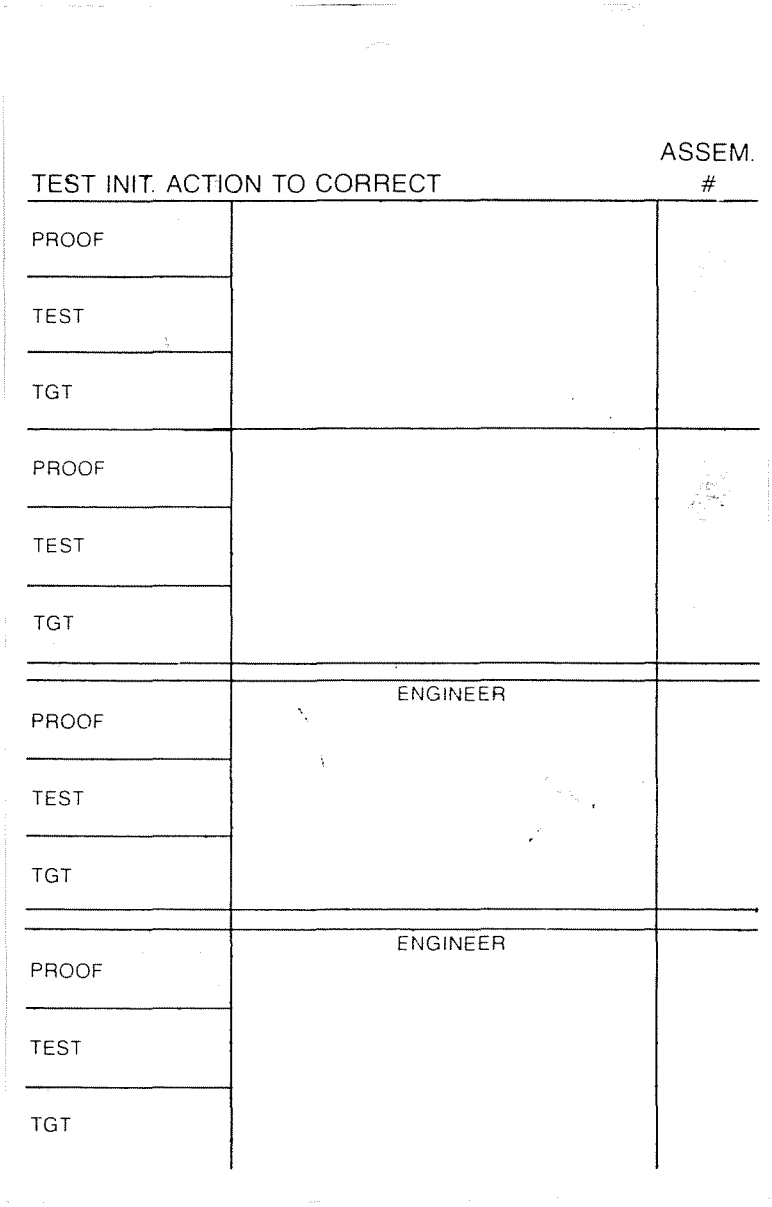




MOD. _____ GA. CAL. _____ GUN # C6611576

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
4-591	1st	bolt handle hits stock	K5
	2nd	Repaired	A
	3rd		
	4th		

FUNCTION RD 6654 Rev 1


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

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611576

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/26/91	K.S.
600	Proof		3/26/91	K.S.
607	Check Headspace		3/26/91	K.S.
610	Dis-assemble Gun		3/26/91	K.S.
612	Magnaflux Barrel Action	APR	2 1991	KR
	Magnaflux Bolt	APR	2 1991	"
615	Rollmark Caliber	APR	2 1991	
617	Drill and Tap Sight Holes	APR	5 1991	
618	Polish Barrel	APR	5 1991	
620	Apply Coatings (Barrel Action)		4-10-91	
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/10/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/10/91	KS
	C) Inspect Ejector Hole for Chamfer		4/10/91	KS
	D) Oil Firing Pin Ass'y		4/10/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		4/11/91	

Op. #	BARBER M24 0079037	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			4/12/91	WB
	G) Safety Off Force	4	3 3/4	4			4/12/91	WB
	H) Trigger Pull Test & Retainability						4/11/91	
	I) Firing Pin Indent	.0225	.0225	.0225			4/12/91	WB
	J) Assemble Stock						4/12/91	KS
	K) Assemble Swivel Studs						4-17-91	
	L) Attach Front and Rear Sight Assemblies						4/12/91	KS
	M) Iron Sight Alignment						4/12/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/12/91	KS
	O) Attach Scope to Rifle						4/12/91	KS
	P) Detach & Attach Scope 20 Times						4/12/91	KS
640	Gallery Target & Test						4-15-91	DH
	A) Time						4-15-91	DH
	B) Malfunctions						4-15-91	DH
	C) Pierced Primers						4-15-91	DH
	D) Optical Clearity of Scope						4-15-91	DH
645	Inspect for Live Ammo						4-15-91	DH
655	Final Inspection A) Headspace						4-17-91	
	B) Trigger Pull	2.48	2.56	2.47	2.47	2.48	2/16/91	
	C) Function						4-17-91	
660	Pack						6-18-91	

SWS TRIGGER PULL TEST

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

SERIAL NO. C66 11576

DATE 4/11/91

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.25	2.46	2.40	2.48	MIN. SETTING,
PULL #2	2.39	2.45	2.46	2.56	NO AVG. OF 5
PULL #3	2.29	2.47	2.48	2.47	READINGS ACCEPT-
PULL #4	2.38	2.42	2.40	2.47	ABLE LESS THAN 2#
PULL #5	2.43	2.45	2.41	2.48	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.51	3.45		
PULL #2	3.50	3.55		
PULL #3	3.45	3.55		
PULL #4	3.35	3.49		
PULL #5	3.52	3.41		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.34	4.31		4.25
PULL #2	4.33	4.27		4.22
PULL #3	4.32	4.27		4.25
PULL #4	4.20	4.25		4.25
PULL #5	4.25	4.20		4.28
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611576
15 Apr 1991

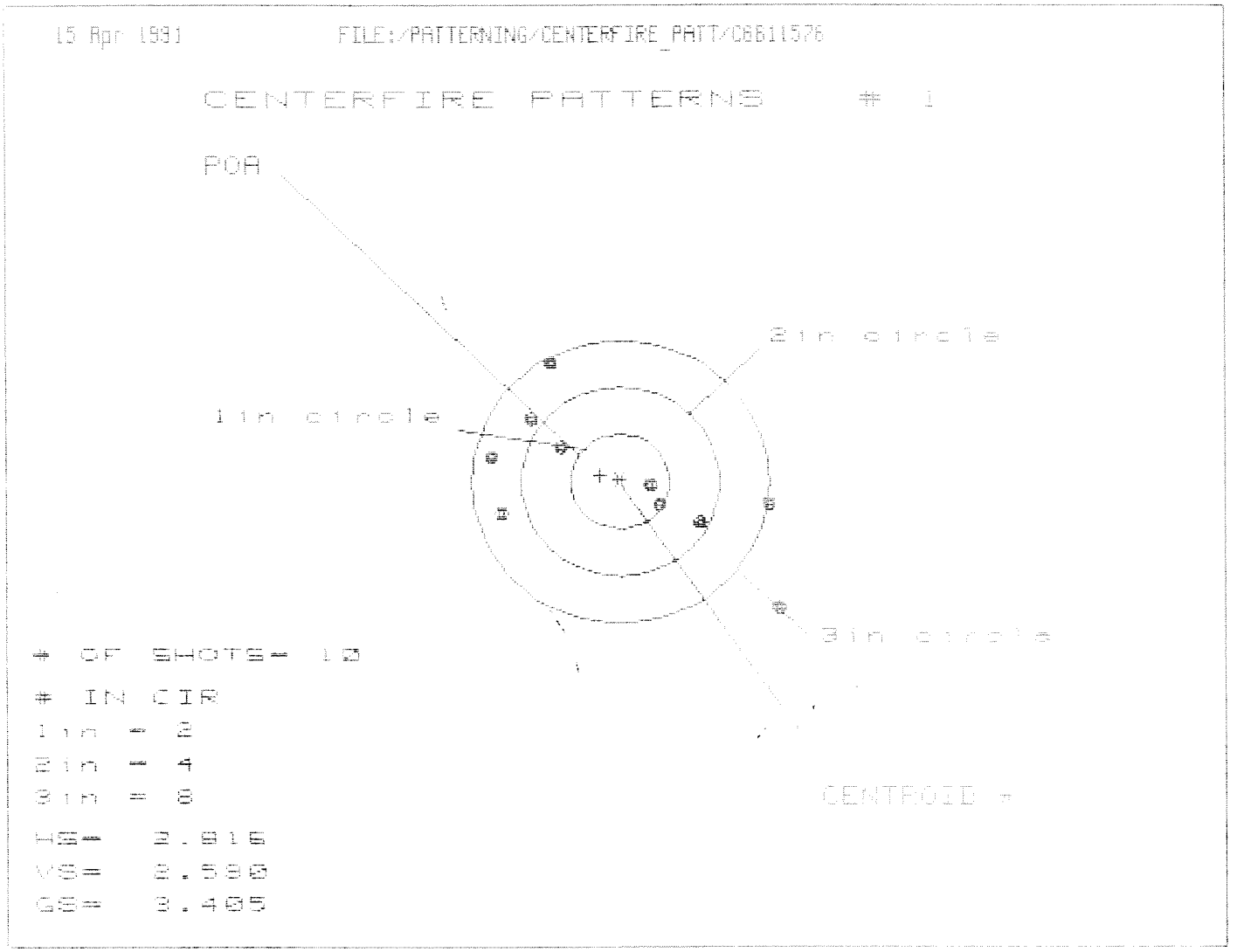
CENTROIDAL DISTANCES

0	TO	1	.211559
1	TO	2	.192606
1	TO	3	.446878
1	TO	4	.407404
1	TO	5	.329952

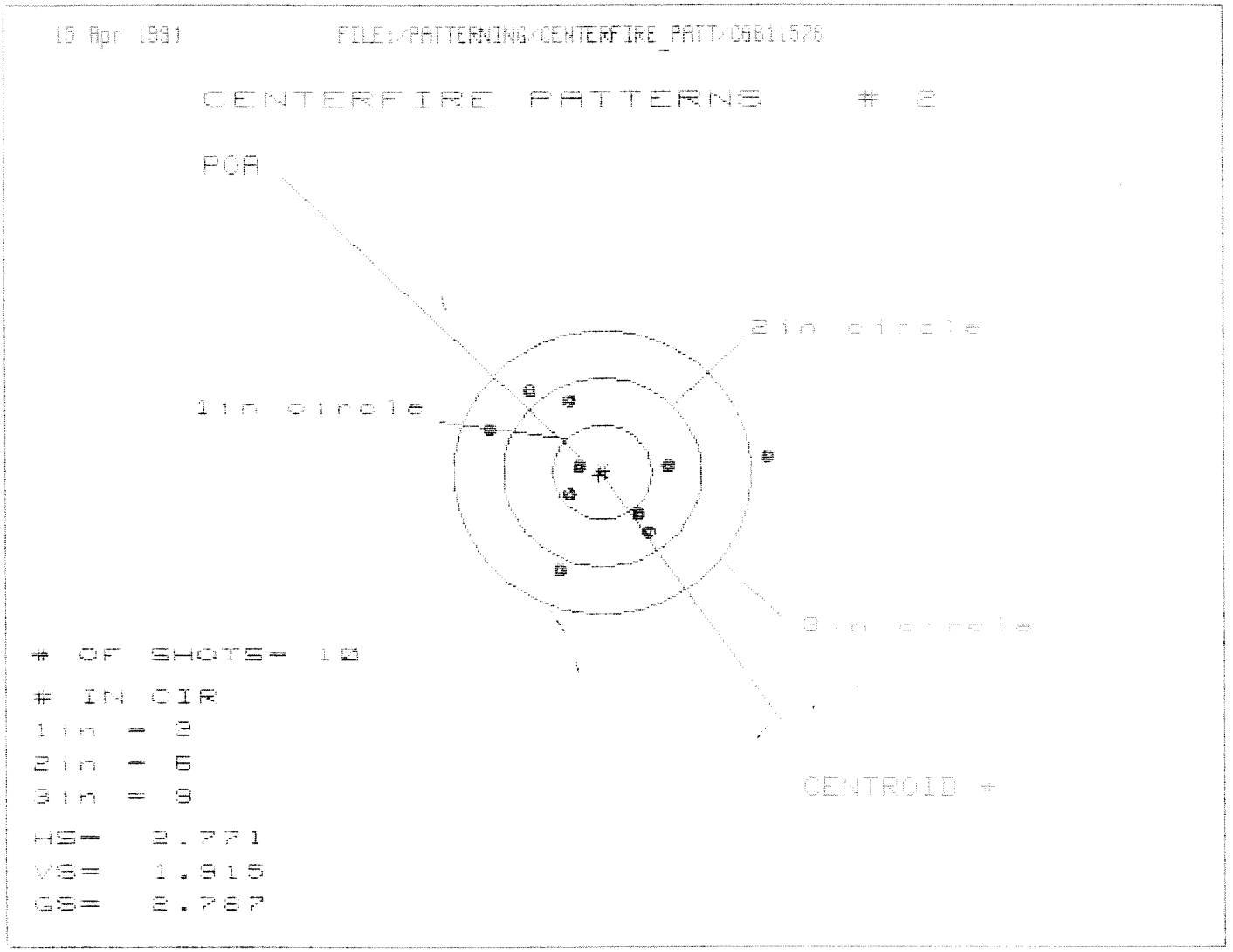
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0012
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0868
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0069083

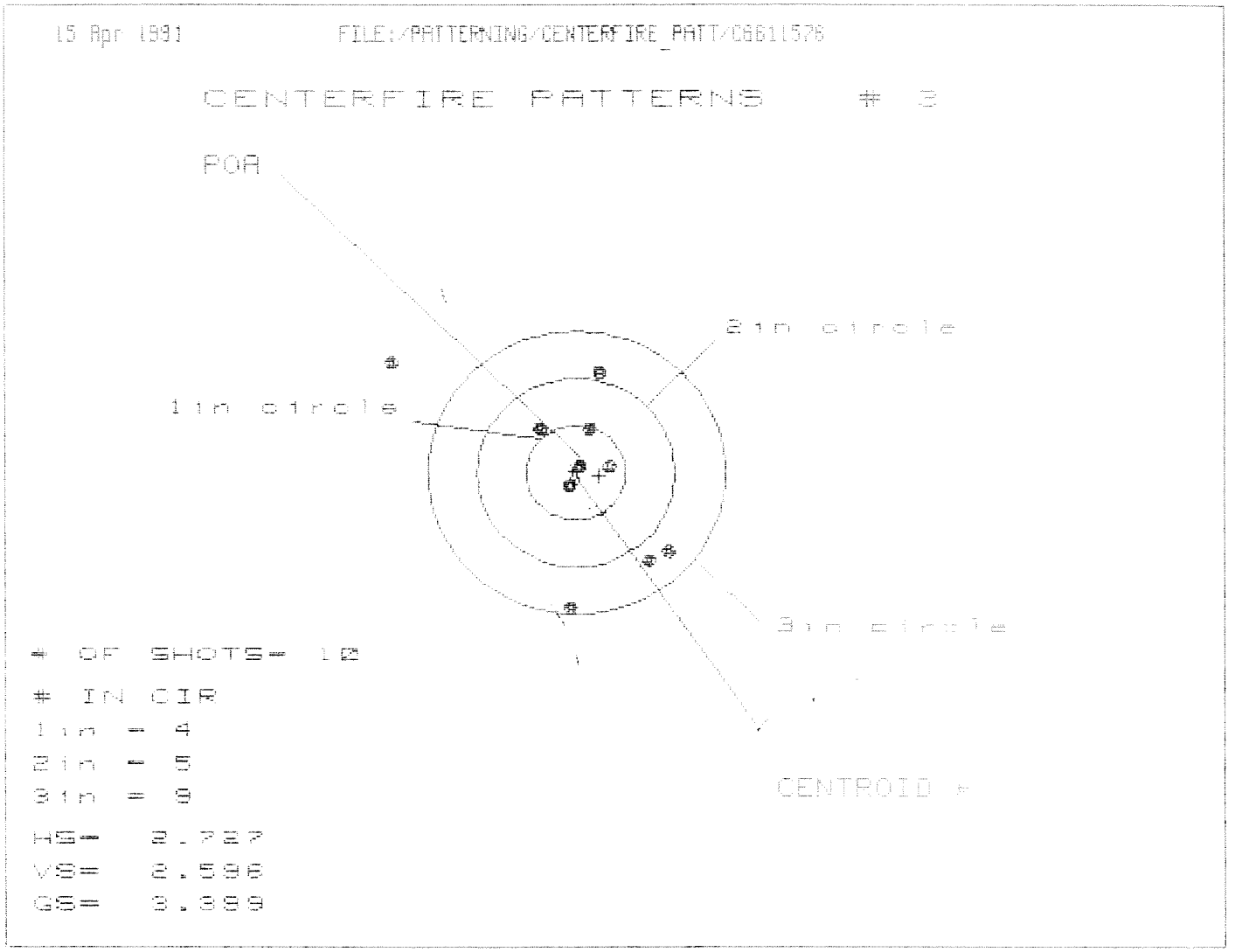
THE AMR FOR THIS RIFLE IS: .8656



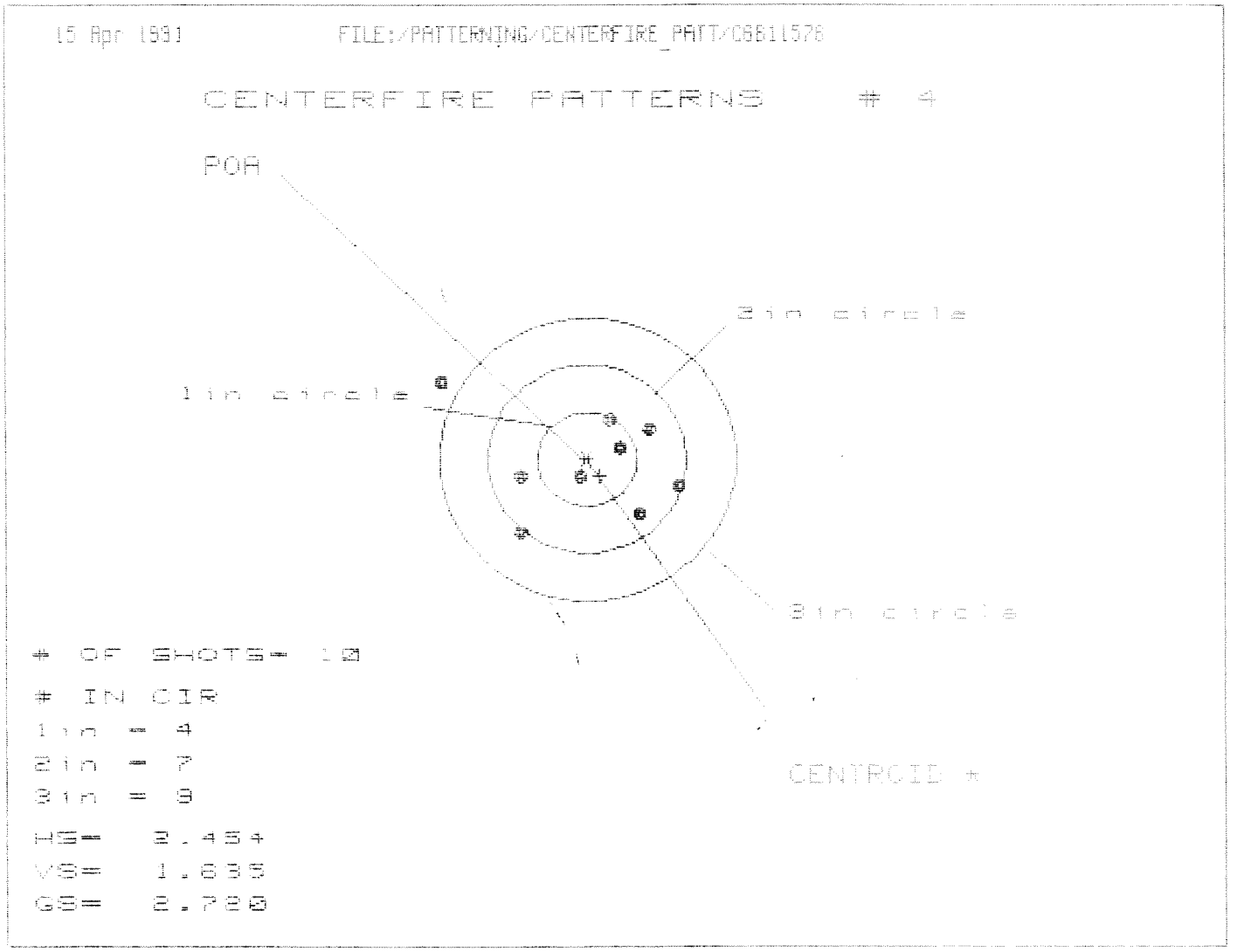
PATTERN #	:	[redacted]		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.560	1.668	1.189
MINIMUM X	:	-1.256	-1.082	-.874
MAXIMUM Y	:	1.270	1.124	1.079
MINIMUM Y	:	-1.320	-.549	-.594
CENTROID X	:	.201	.027	-.181
CENTROID Y	:	-.066	.080	.125
POA TO CENTROID in.	:	.211	.085	.220
MIN RADIUS	:	.319	.461	.269
MEAN RADIUS	:	1.104	.987	.867
MAX RADIUS	:	2.043	1.705	1.329
HORIZONTAL SPREAD	:	2.816	2.750	2.063
VERTICAL SPREAD	:	2.590	1.673	1.673
EXTREME SPREAD	:	3.405	2.799	2.219
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	



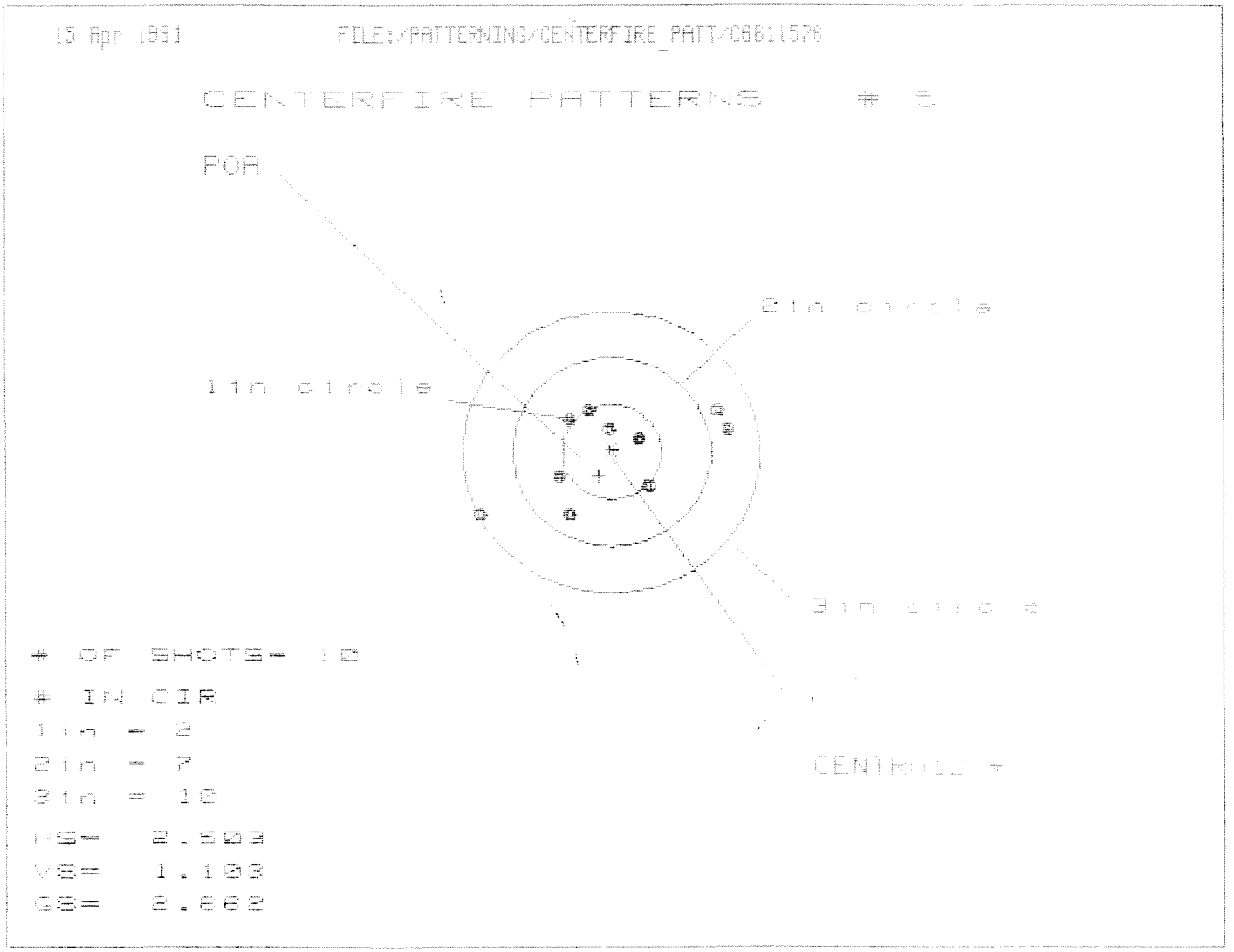
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.674	.889	.775
MINIMUM X	:	-1.097	-.911	-.712
MAXIMUM Y	:	.852	.869	.928
MINIMUM Y	:	-1.063	-1.046	-.987
CENTROID X	:	.037	-.149	-.035
CENTROID Y	:	.035	.018	-.041
POA TO CENTROID in.	:	.051	.150	.054
MIN RADIUS	:	.219	.048	.174
MEAN RADIUS	:	.863	.742	.705
MAX RADIUS	:	1.681	1.082	1.170
HORIZONTAL SPREAD	:	2.771	1.800	1.487
VERTICAL SPREAD	:	1.915	1.915	1.915
EXTREME SPREAD	:	2.787	1.942	1.942
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	



PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.903	.700	.662
MINIMUM X	:	-1.824	-.583	-.621
MAXIMUM Y	:	1.189	1.216	1.056
MINIMUM Y	:	-1.407	-1.275	-.997
CENTROID X	:	-.235	-.032	.006
CENTROID Y	:	.032	-.100	.060
POA TO CENTROID in.	:	.237	.105	.060
MIN RADIUS	:	.083	.231	.119
MEAN RADIUS	:	.887	.753	.682
MAX RADIUS	:	2.178	1.310	1.123
HORIZONTAL SPREAD	:	2.727	1.283	1.283
VERTICAL SPREAD	:	2.596	2.491	2.059
EXTREME SPREAD	:	3.399	2.512	2.121
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	



PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.955	.788	.685
MINIMUM X	:	-1.499	-.889	-.991
MAXIMUM Y	:	.852	.554	.468
MINIMUM Y	:	-.782	-.688	-.540
CENTROID X	:	-.126	.041	.143
CENTROID Y	:	.177	.082	.168
POA TO CENTROID in.	:	.217	.091	.221
MIN RADIUS	:	.164	.255	.184
MEAN RADIUS	:	.740	.604	.511
MAX RADIUS	:	1.724	1.073	1.012
HORIZONTAL SPREAD	:	2.454	1.677	1.677
VERTICAL SPREAD	:	1.635	1.242	1.008
EXTREME SPREAD	:	2.720	1.700	1.680
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	



PATTERN #	:	[redacted]		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.188	1.041	1.101
MINIMUM X	:	-1.315	-.689	-.558
MAXIMUM Y	:	.484	.415	.436
MINIMUM Y	:	-.619	-.583	-.662
CENTROID X	:	.129	.276	.145
CENTROID Y	:	.256	.325	.304
POA TO CENTROID in.	:	.287	.426	.337
MIN RADIUS	:	.208	.100	.161
MEAN RADIUS	:	.734	.642	.576
MAX RADIUS	:	1.454	1.055	1.176
HORIZONTAL SPREAD	:	2.503	1.730	1.659
VERTICAL SPREAD	:	1.103	1.098	1.098
EXTREME SPREAD	:	2.662	1.872	1.872
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	