

C6522231

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

* Includes 1 in chamber.

Remington.

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522231

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/25/90	KA
600	Proof		6/25/90	KA
607	Check Headspace		6/25/90	KA
610	Dis-assemble Gun		6/25/90	KA
612	Magnaflux Barrel Action		7/10/90	KR
	Magnaflux Bolt		7/10/90	KR
615	Rollmark Caliber		7/10/90	GL
617	Drill and Tap Sight Holes		7/11/90	KB
618	Polish Barrel AB		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		8/1/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/1/90	KS
	C) Inspect Ejector Hole for Chamfer		8/1/90	KS
	D) Oil Firing Pin Ass'y		8/1/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		8/25/90	GL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	6	5			7/31/90	SL
	G) Safety Off Force	2	2	2			7/31/90	SL
	H) Trigger Pull Test & Retainability						8/25/90	SL
	I) Firing Pin Indent	.022	.022	.022			7/31/90	SL
	J) Assemble Stock						8/2/90	KS
	K) Assemble Swivel Studs						8/30/90	JDS
	L) Attach Front and Rear Sight Assemblies						8/2/90	KS
	M) Iron Sight Alignment						8/2/90	KS
	N) Detach Front & Rear Sights & place in numbered container						8/2/90	KS
	O) Attach Scope to Rifle						8/2/90	KS
	P) Detach & Attach Scope 20 Times						8/2/90	KS
640	Gallery Target & Test						8/8/90	NF
	A) Time						8/8/90	NF
	B) Malfunctions						8/8/90	NF
	C) Pierced Primers						8/8/90	NF
	D) Optical Clarity of Scope						8/8/90	NF
645	Inspect for Live Ammo						8/8/90	NF
655	Final Inspection							
	A) Headspace						8/30/90	JDS
	B) Trigger Pull	2.40	2.51	2.22	2.21	2.39	8/25/90	SL
	C) Function						8/30/90	JDS
660	Pack						9/19/90	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6522231DATE 8/25/90TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.42	2.34	2.50	2.40	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.49	2.28	2.51	
PULL #3	2.37	2.50	2.21	2.22	
PULL #4	2.39	2.36	2.20	2.21	
PULL #5	2.20	2.38	2.47	2.39	
TOTAL	11.79	12.07	11.66	11.73	
AVG.	2.358	2.414	2.332	2.346	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.45	3.51		
PULL #2	3.40	3.44		
PULL #3	3.46	3.43		
PULL #4	3.40	3.39		
PULL #5	3.47	3.44		
TOTAL	17.18	17.21		
AVG.	3.436	3.442		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.14	4.37		4.17
PULL #2	4.07	4.38		4.45
PULL #3	4.22	4.30		4.39
PULL #4	4.48	4.29		4.35
PULL #5	4.22	4.50		4.37
TOTAL	21.13	21.84		21.73
AVG.	4.226	4.368		4.346

CENTROIDAL DISTANCE CALCULATIONS

FOR RIFLE # 06522231

3 Aug 1990

CENTROIDAL DISTANCES

1 TO 1	1.00498
1 TO 2	.585219
1 TO 3	.993129
1 TO 4	.772513
1 TO 5	1.06897

$\bar{x}$ <----POA
 $\bar{y}$ 43
 1

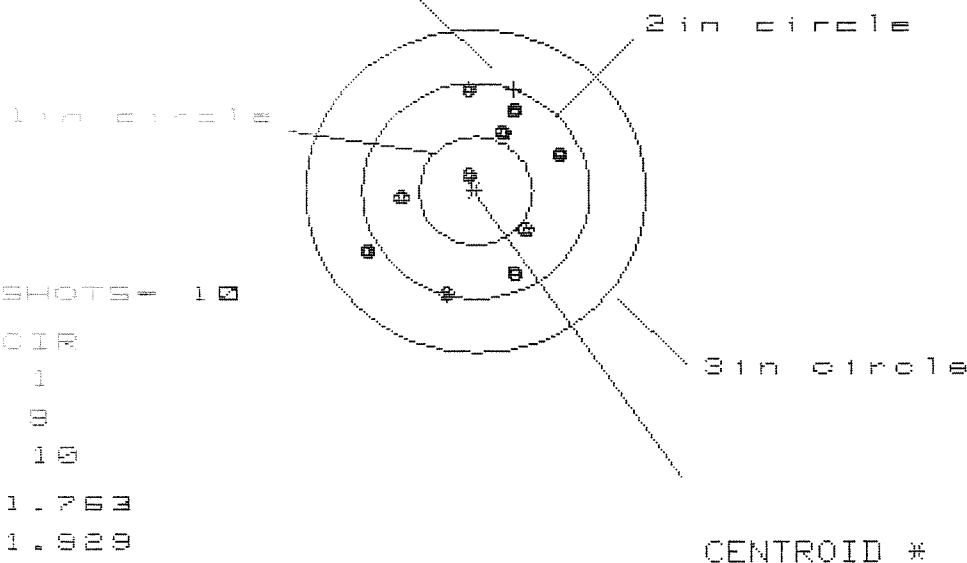
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0056
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.3928
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .39284
 THE AMR FOR THIS RIFLE IS: .891

8 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522231

CENTERFIRE PATTERNS # 1

POA



OF SHOTS= 10

IN CIR

1in = 1

2in = 9

3in = 10

HS= 1.763

VS= 1.929

GS= 2.009

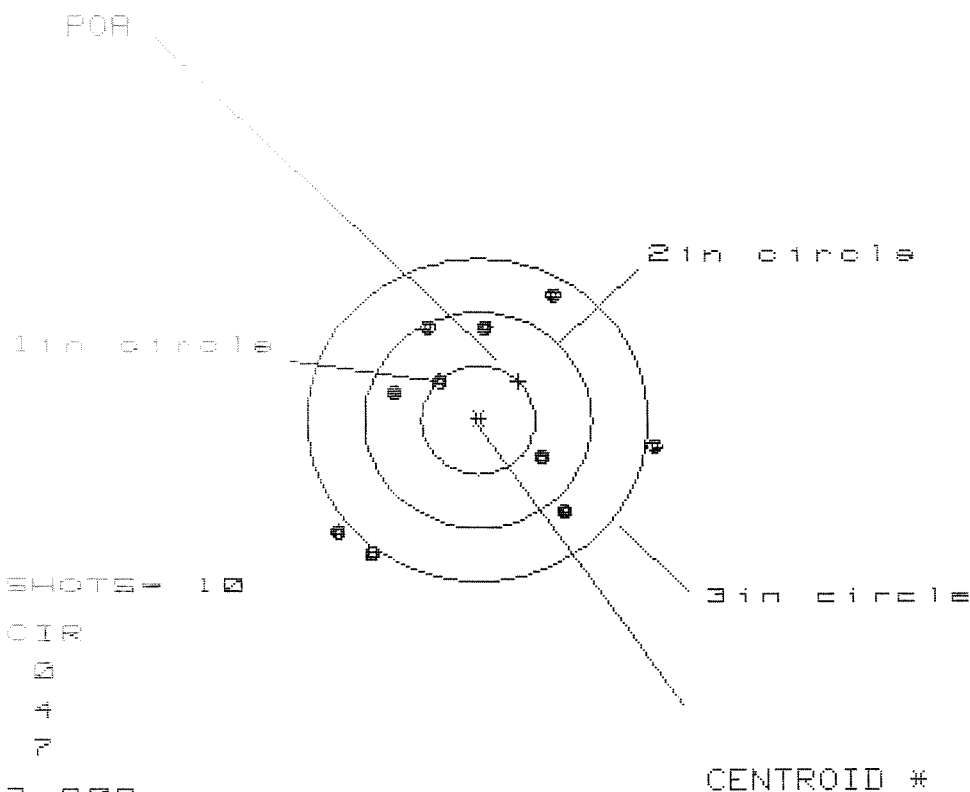
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.763	.652	.608
MINIMUM X	:	-1.000	-.755	-.799
MAXIMUM Y	:	.976	.911	.783
MINIMUM Y	:	-.953	-1.018	-.973
CENTROID X	:	-.342	-.231	-.187
CENTROID Y	:	-.945	-.880	-.752
POA TO CENTROID in.	:	1.005	.909	.775
MIN RADIUS	:	.162	.208	.245
MEAN RADIUS	:	.752	.694	.625
MAX RADIUS	:	1.162	1.077	.985
HORIZONTAL SPREAD	:	1.763	1.407	1.407
VERTICAL SPREAD	:	1.929	1.929	1.756
EXTREME SPREAD	:	2.009	1.935	1.800
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 7

HS= 2.808

VS= 2.363

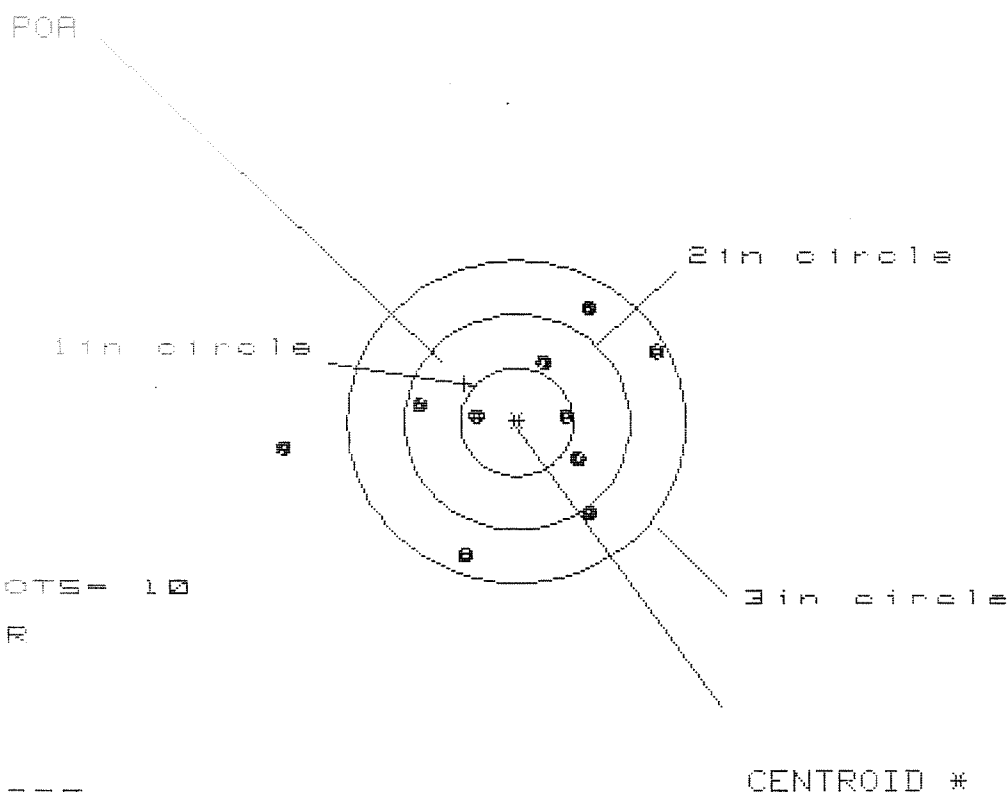
GS= 2.930

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.569	1.431	.835
MINIMUM X	:	-1.239	-1.066	-.887
MAXIMUM Y	:	1.153	1.037	.998
MINIMUM Y	:	-1.210	-1.326	-1.365
CENTROID X	:	-.358	-.220	-.399
CENTROID Y	:	-.360	-.244	-.205
POA TO CENTROID in.	:	.507	.329	.448
MIN RADIUS	:	.509	.542	.372
MEAN RADIUS	:	1.106	1.032	.948
MAX RADIUS	:	1.616	1.701	1.628
HORIZONTAL SPREAD	:	2.808	2.497	1.722
VERTICAL SPREAD	:	2.363	2.363	2.363
EXTREME SPREAD	:	2.930	2.828	2.828
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 3.330

VS= 2.257

GS= 3.462

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.272	1.043	.577
MINIMUM X	:	-2.058	-1.079	-.948
MAXIMUM Y	:	1.043	1.013	1.093
MINIMUM Y	:	-1.214	-1.244	-1.164
CENTROID X	:	.462	.691	.560
CENTROID Y	:	-.362	-.332	-.412
POA TO CENTROID in.	:	.587	.766	.695
MIN RADIUS	:	.366	.221	.364
MEAN RADIUS	:	.997	.838	.797
MAX RADIUS	:	2.076	1.446	1.312
HORIZONTAL SPREAD	:	3.330	2.122	1.525
VERTICAL SPREAD	:	2.257	2.257	2.257
EXTREME SPREAD	:	3.462	2.594	2.526
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 9

HS= 3.160

VS= 2.044

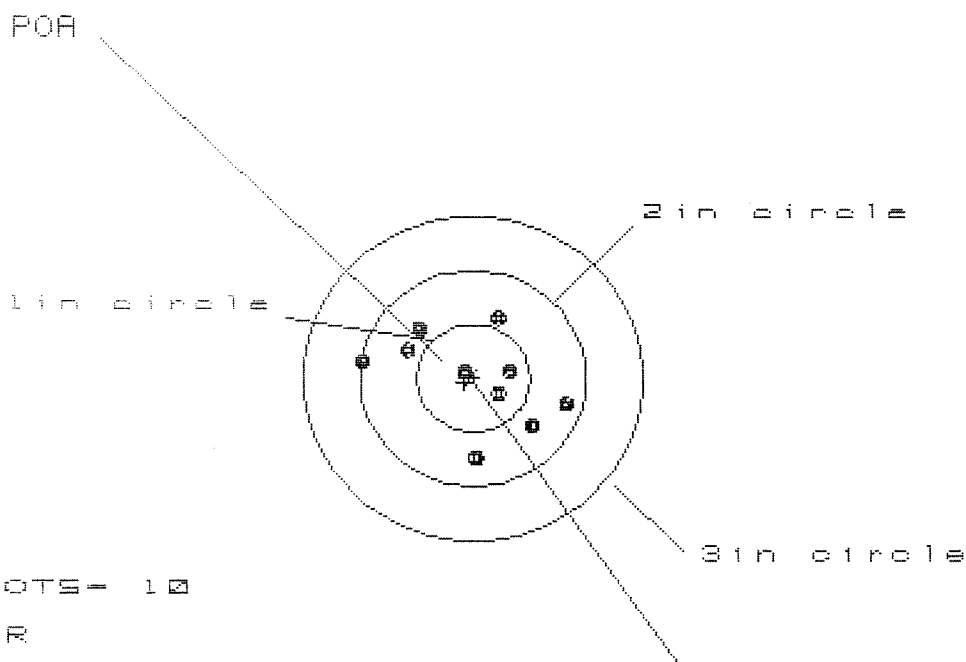
GS= 3.176

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.675	1.454	1.291
MINIMUM X	:	-1.485	-1.298	-1.236
MAXIMUM Y	:	.943	.975	.974
MINIMUM Y	:	-1.101	-1.069	-1.070
CENTROID X	:	.132	-.055	.108
CENTROID Y	:	-.335	-.367	-.366
POA TO CENTROID in.	:	.360	.371	.382
MIN RADIUS	:	.051	.232	.090
MEAN RADIUS	:	1.019	.936	.878
MAX RADIUS	:	1.699	1.551	1.428
HORIZONTAL SPREAD	:	3.160	2.752	2.527
VERTICAL SPREAD	:	2.044	2.044	2.044
EXTREME SPREAD	:	3.176	2.753	2.547
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 3

2in = 3

3in = 10

HS= 1.793

VS= 1.254

GS= 1.839

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.804	.694	.478
MINIMUM X	:	-.989	-.689	-.602
MAXIMUM Y	:	.555	.573	.544
MINIMUM Y	:	-.699	-.681	-.710
CENTROID X	:	.078	.188	.101
CENTROID Y	:	.038	.020	.049
POA TO CENTROID in.	:	.087	.189	.112
MIN RADIUS	:	.122	.161	.126
MEAN RADIUS	:	.581	.520	.494
MAX RADIUS	:	1.002	.741	.710
HORIZONTAL SPREAD	:	1.793	1.383	1.080
VERTICAL SPREAD	:	1.254	1.254	1.254
EXTREME SPREAD	:	1.839	1.472	1.309
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	




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

REG. U.S. PAT. & TM. OFF.

MODEL 700™

H24

SERIAL NO.

C6522231

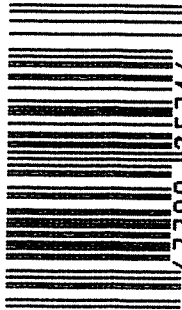
ORDER NO.

5716

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UPC



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