C652335

MODEL 700™ M24

Model SWS™

Action

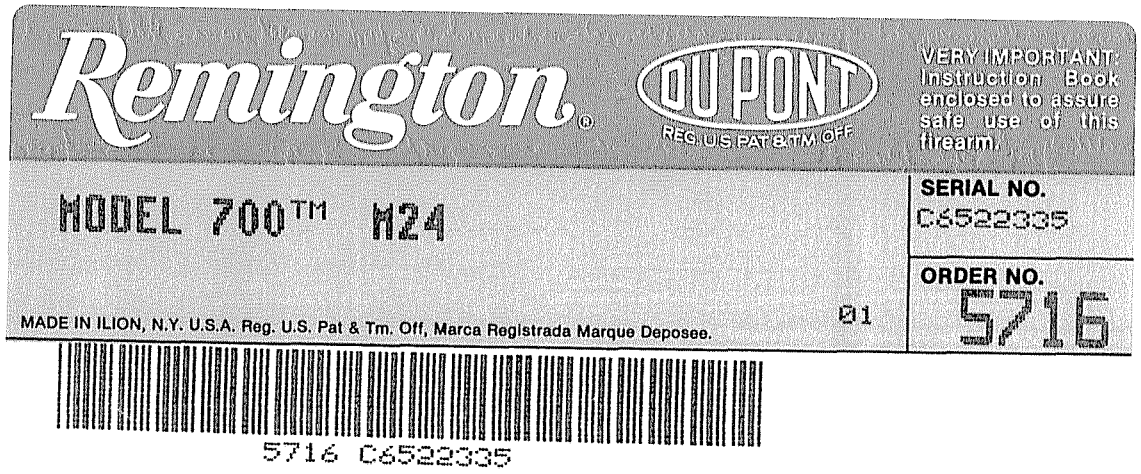
Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

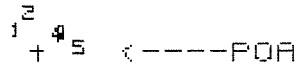
Remington



CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522335
7 Aug 1990

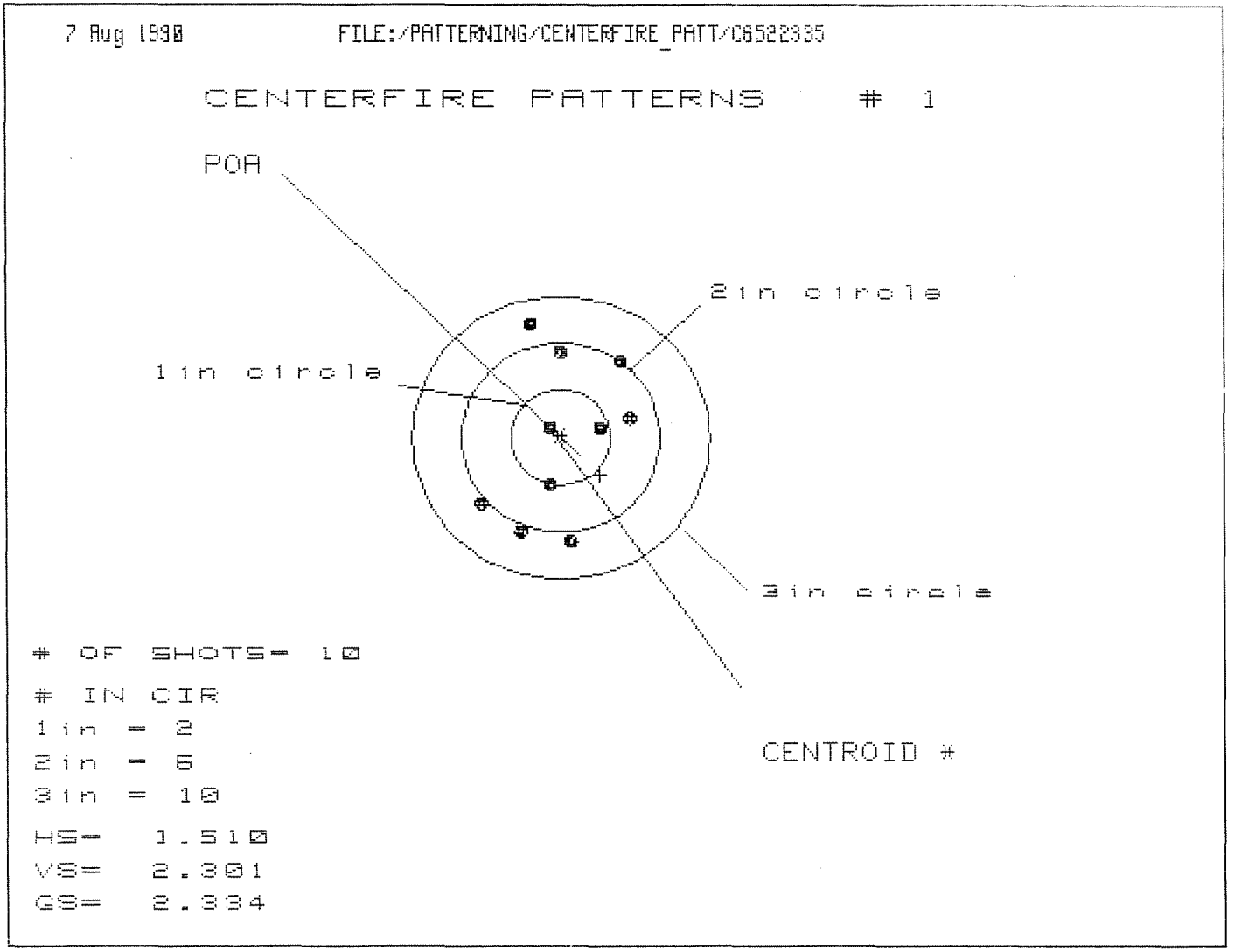
CENTROIDAL DISTANCES

0	TO	1	.5572
1	TO	2	.406808
1	TO	3	.811799
1	TO	4	.740047
1	TO	5	1.16465



THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .189
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .3802
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .424586

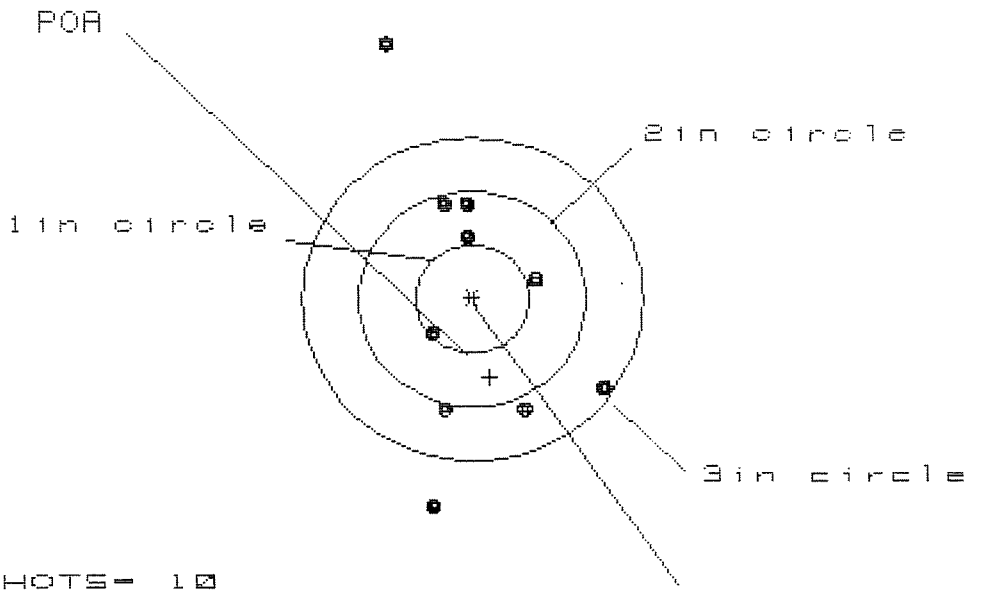
THE AMR FOR THIS RIFLE IS: 1.034



PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.727	.692	.696
MINIMUM X	:	-.783	-.818	-.814
MAXIMUM Y	:	1.199	1.021	.900
MINIMUM Y	:	-1.102	-.969	-.939
CENTROID X	:	-.394	-.359	-.363
CENTROID Y	:	.394	.261	.382
POA TO CENTROID in.	:	.557	.443	.527
MIN RADIUS	:	.196	.317	.228
MEAN RADIUS	:	.820	.769	.731
MAX RADIUS	:	1.241	1.056	1.054
HORIZONTAL SPREAD	:	1.510	1.510	1.510
VERTICAL SPREAD	:	2.301	1.990	1.839
EXTREME SPREAD	:	2.334	1.995	1.995
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

7 Aug 1998 FILE:/PATTERNING/CENTERFIRE_PATT/C6522335

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

# IN CIR	
1in =	1
2in =	5
3in =	8
HS=	1.933
VS=	4.322
GS=	4.342

PATTERN # : 2

SHOTS (BEST OF) :	10	9	8
MAXIMUM X :	1.145	1.057	.999
MINIMUM X :	-.788	-.462	-.482
MAXIMUM Y :	2.419	1.195	.991
MINIMUM Y :	-1.903	-1.634	-.921
CENTROID X :	-.152	-.064	-.006
CENTROID Y :	.721	.452	.656
POA TO CENTROID in.:	.737	.457	.656
MIN RADIUS :	.474	.429	.457
MEAN RADIUS :	1.141	.975	.863
MAX RADIUS :	2.544	1.698	1.250
HORIZONTAL SPREAD :	1.933	1.519	1.481
VERTICAL SPREAD :	4.322	2.829	1.912
EXTREME SPREAD :	4.342	2.831	2.250
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		8	

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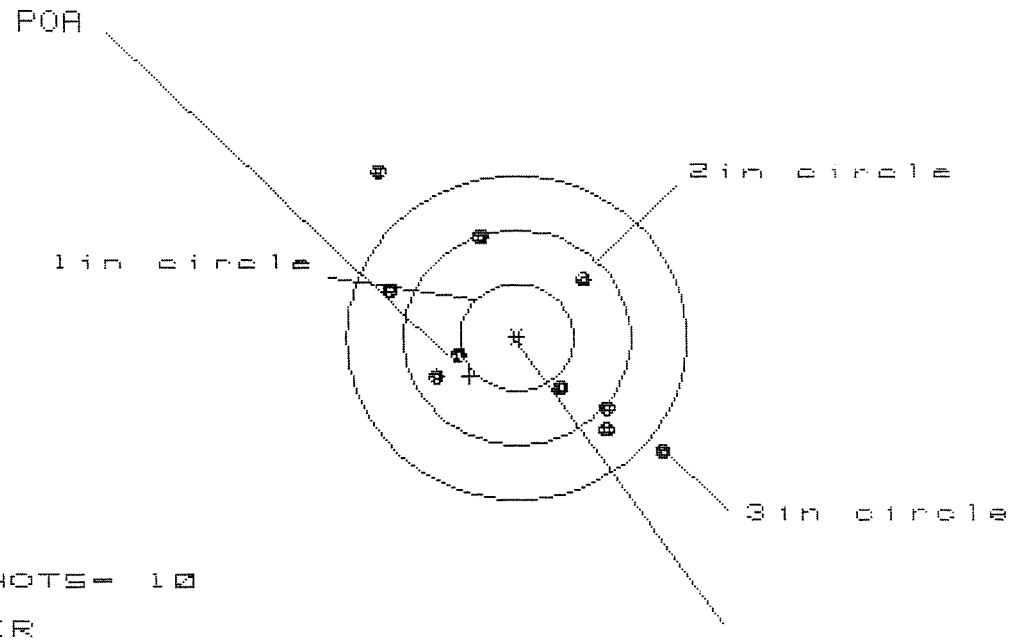
CENTERFIRE PATTERNS # 3



OF SHOTS= 10

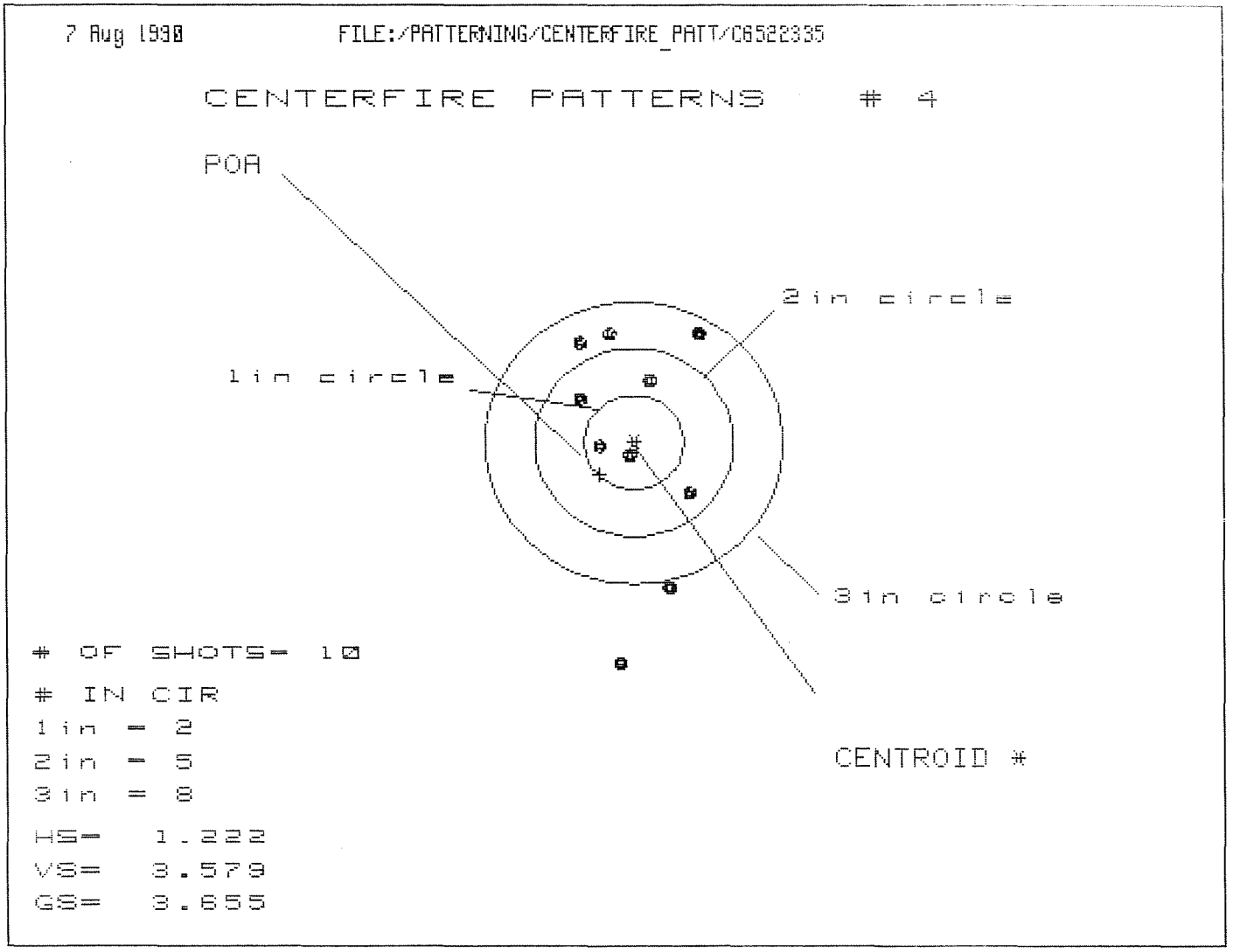
# IN CIR
1in = 0
2in = 6
3in = 8

HS= 2.474
VS= 2.578
GS= 3.573

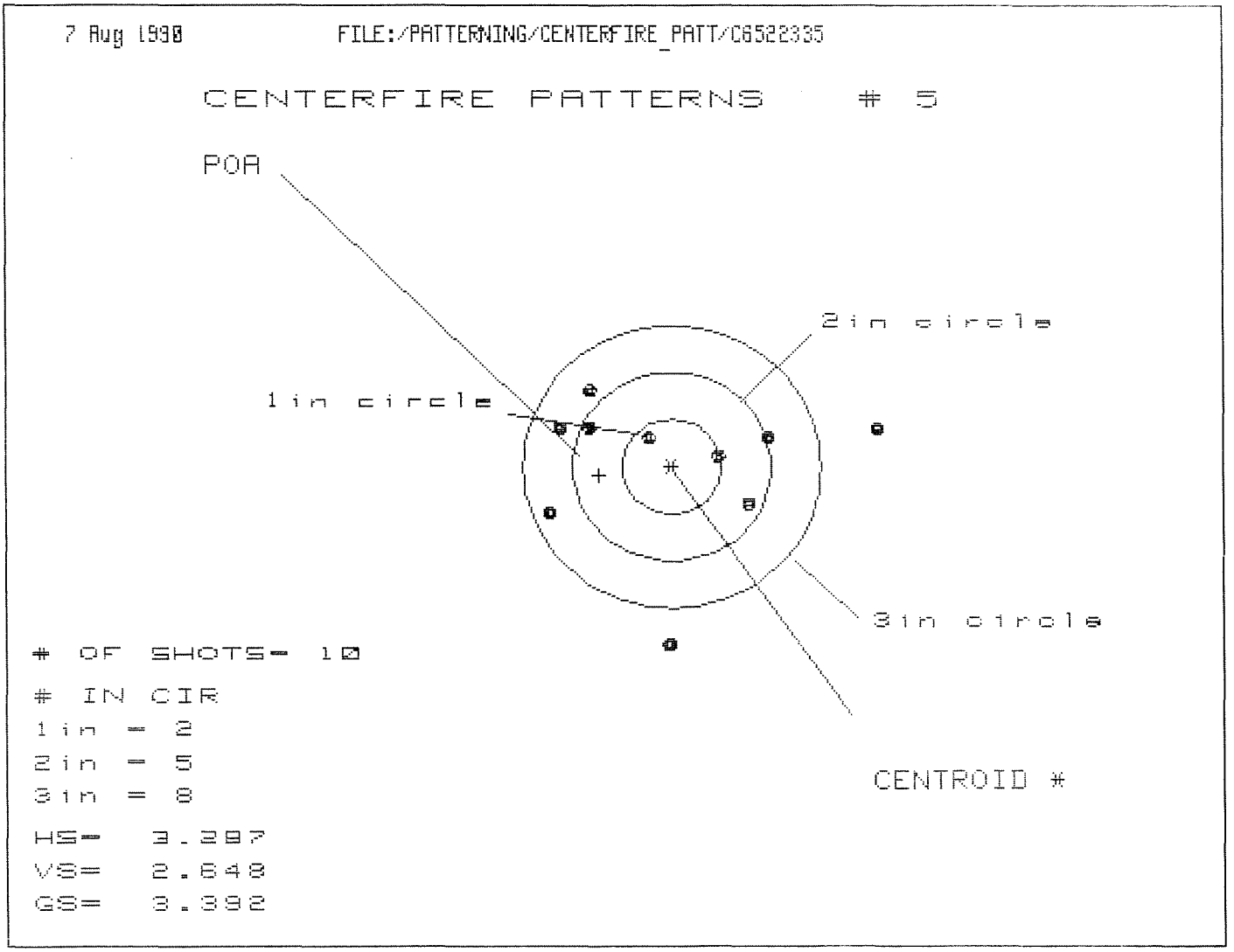
PATTERN # : 3

SHOTS (BEST OF) :	10	9	8
MAXIMUM X :	1.274	1.140	.836
MINIMUM X :	-1.200	-1.201	-1.058
MAXIMUM Y :	1.516	1.067	.955
MINIMUM Y :	-1.061	-.893	-.802
CENTROID X :	.417	.551	.408
CENTROID Y :	.358	.190	.302
POA TO CENTROID in.:	.550	.582	.507
MIN RADIUS :	.570	.374	.549
MEAN RADIUS :	1.064	.944	.876
MAX RADIUS :	1.934	1.448	1.191
HORIZONTAL SPREAD :	2.474	2.341	1.894
VERTICAL SPREAD :	2.578	1.960	1.757
EXTREME SPREAD :	3.573	2.809	2.325

NUMBER IN ONE INCH CIRCLE = 0
NUMBER IN TWO INCH CIRCLE = 6
NUMBER IN THREE INCH CIRCLE = 8



PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.699	.680	.727
MINIMUM X	:	-.523	-.542	-.495
MAXIMUM Y	:	1.197	.932	.713
MINIMUM Y	:	-2.382	-1.756	-1.040
CENTROID X	:	.344	.363	.316
CENTROID Y	:	.339	.604	.823
POA TO CENTROID in.	:	.483	.704	.882
MIN RADIUS	:	.123	.386	.278
MEAN RADIUS	:	1.027	.850	.703
MAX RADIUS	:	2.388	1.796	1.173
HORIZONTAL SPREAD	:	1.222	1.222	1.222
VERTICAL SPREAD	:	3.579	2.688	1.753
EXTREME SPREAD	:	3.655	2.766	1.914
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	



PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.063	1.170	1.200
MINIMUM X	:	-1.224	-.994	-.964
MAXIMUM Y	:	.794	.838	.611
MINIMUM Y	:	-1.854	-1.810	-.631
CENTROID X	:	.730	.500	.470
CENTROID Y	:	.089	.045	.272
POA TO CENTROID in.	:	.735	.502	.543
MIN RADIUS	:	.373	.335	.112
MEAN RADIUS	:	1.120	.997	.837
MAX RADIUS	:	2.100	1.826	1.206
HORIZONTAL SPREAD	:	3.287	2.164	2.164
VERTICAL SPREAD	:	2.648	2.648	1.242
EXTREME SPREAD	:	3.392	2.791	2.293
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

SWS TRIGGER PULL TEST

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

SERIAL NO. C6522335
DATE 8/23/80
TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.34	2.51	2.47	2.32	MIN. SETTING,
PULL #2	2.30	2.38	2.34	2.45	NO AVG. OF 5
PULL #3	2.40	2.42	2.20	2.48	READINGS ACCEPT-
PULL #4	2.41	2.39	2.12	2.50	ABLE LESS THAN 2#
PULL #5	2.39	2.37	2.17	2.50	
TOTAL	11.84	12.07	11.30	12.25	
AVG.	2.368	2.414	2.26	2.45	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.44	3.34		
PULL #2	3.38	3.35		
PULL #3	3.34	3.11		
PULL #4	3.31	3.32		
PULL #5	3.29	3.30		
TOTAL	16.76	16.42		
AVG.	3.352	3.284		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.41	4.33		4.42
PULL #2	4.42	4.40		4.41
PULL #3	4.35	4.42		4.40
PULL #4	4.40	4.33		4.48
PULL #5	4.42	4.40		4.42
TOTAL	22.00	21.88		22.13
AVG.	4.4	4.376		4.426

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522335

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 29	90	RW
600	Proof	6 29	90	RW
607	Check Headspace	6 29	90	RW
610	Dis-assemble Gun	6 29	90	RW
612	Magnaflux Barrel Action		7-12-90	KR
	Magnaflux Bolt		7-12-90	KR
615	Rollmark Caliber		7-12-90	JS
617	Drill and Tap Sight Holes		7/13/90	KB
618	Polish Barrel RB		7/16/90	WB
620	Apply Coatings (Barrel Action)		7-23-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/25/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/25/90	RW
	C) Inspect Ejector Hole for Chamfer		7/25/90	RW
	D) Oil Firing Pin Ass'y		7/25/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/23/90	DL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			7/31/90	JH
	G) Safety Off Force	3	3	3			7/31/90	JH
	H) Trigger Pull Test & Retainability						8/23/90	JH
	I) Firing Pin Indent	.023	.0225	.0225			7/31/90	JH
	J) Assemble Stock						8/1/90	RW
	K) Assemble Swivel Studs						8/29/90	JS
	L) Attach Front and Rear Sight Assemblies						8/1/90	RW
	M) Iron Sight Alignment						8/1/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/1/90	RW
	O) Attach Scope to Rifle						8/6/90	RW
	P) Detach & Attach Scope 20 Times						8/6/90	RW
640	Gallery Target & Test						8-7-90	KT
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clearity of Scope						"	KT
645	Inspect for Live Ammo						8-7-90	KT
655	Final Inspection A) Headspace						8/29/90	JS
	B) Trigger Pull	2.32	2.45	2.48	2.50	2.50	8/23/90	JH
	C) Function						8/29/90	JS
660	Pack						9/20/90	JF