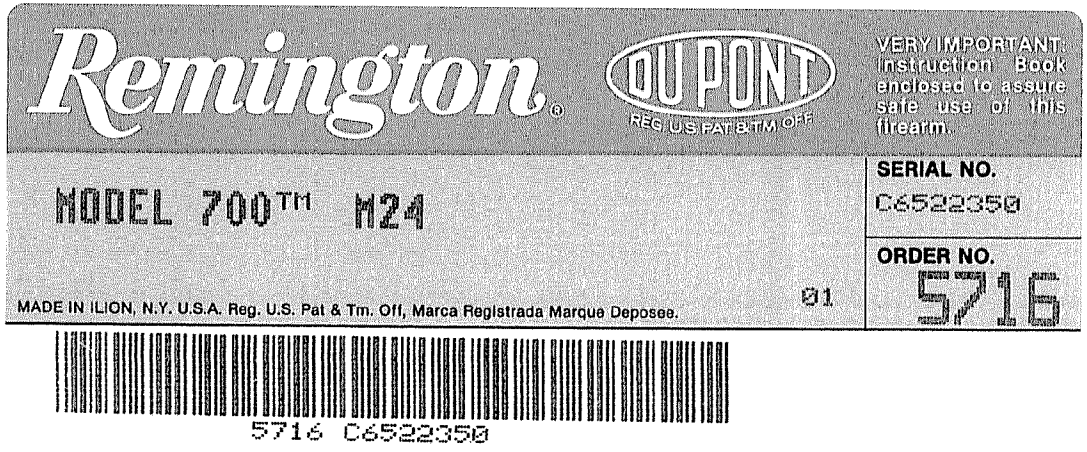
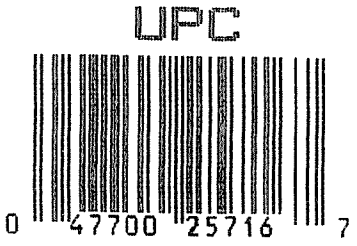
C652350
MODEL 700™ M24
Model SWS™
Action
Barrel Length
Capacity
Order No. 571
*Includes 1 in chamber.
Remington

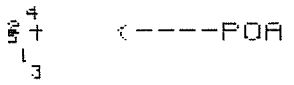




CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522350
14 Aug 1990

CENTROIDAL DISTANCES

0	TO	1	.484232
1	TO	2	.546465
1	TO	3	.403387
1	TO	4	.802002
1	TO	5	.386793

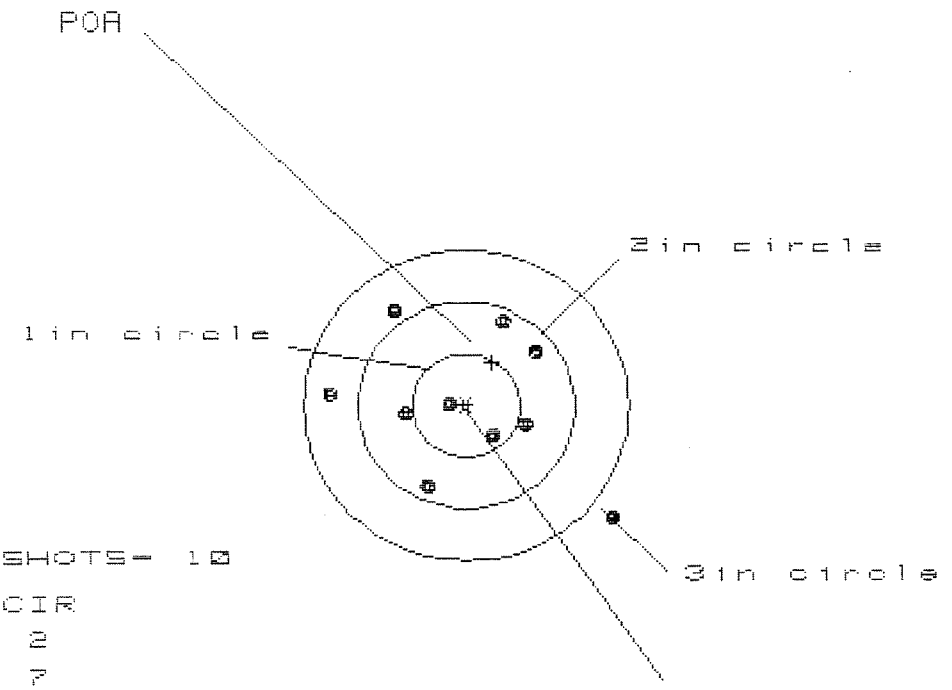


THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2272
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.155
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .275036

THE AMR FOR THIS RIFLE IS: .845

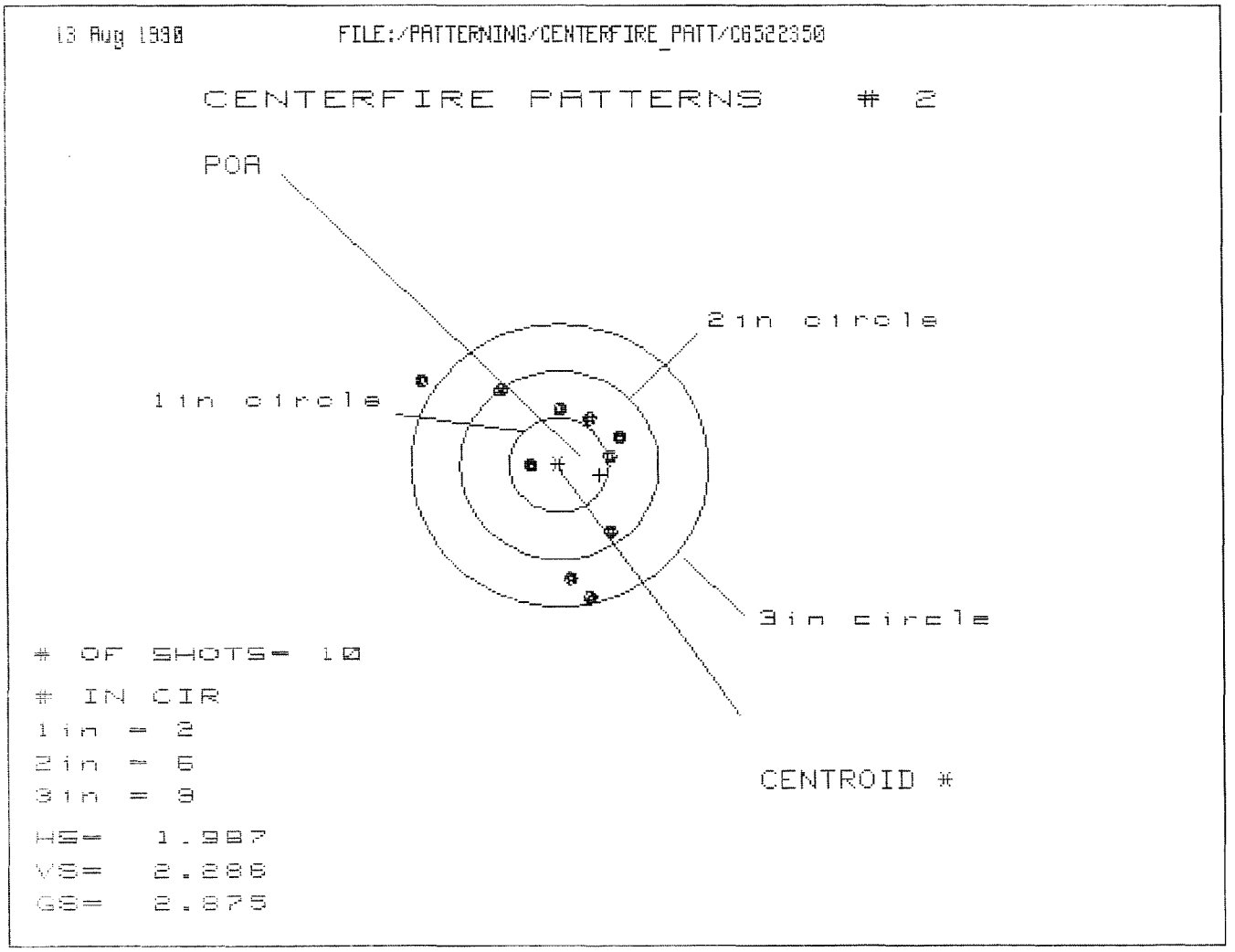
13 Aug 1998 FILE:/PATTERNING/CENTERFIRE_PATT/06522350

CENTERFIRE PATTERNS # 1



# OF SHOTS= 10
# IN CIR
1in = 2
2in = 7
3in = 9
HS= 2.528
VS= 2.064
GS= 2.883

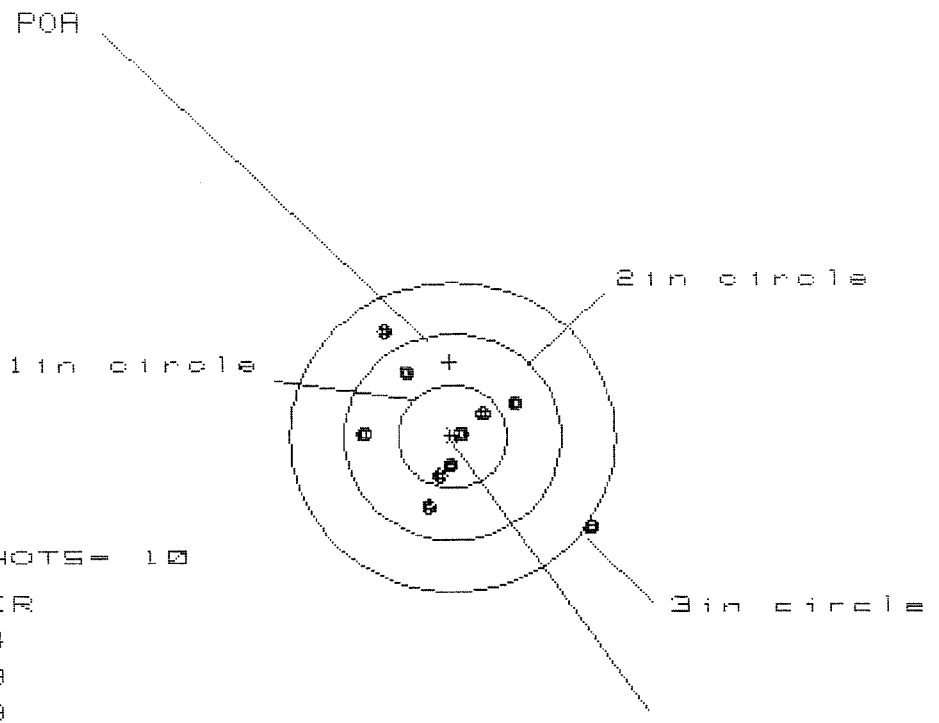
PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.307	.754	.620
MINIMUM X	:	-1.221	-1.076	-.695
MAXIMUM Y	:	.960	.837	.831
MINIMUM Y	:	-1.104	-.864	-.870
CENTROID X	:	-.241	-.386	-.252
CENTROID Y	:	-.420	-.297	-.291
POA TO CENTROID in.	:	.484	.487	.385
MIN RADIUS	:	.129	.131	.180
MEAN RADIUS	:	.811	.711	.653
MAX RADIUS	:	1.711	1.076	1.084
HORIZONTAL SPREAD	:	2.528	1.830	1.315
VERTICAL SPREAD	:	2.064	1.701	1.701
EXTREME SPREAD	:	2.883	1.873	1.729
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	



PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.589	.434	.458
MINIMUM X	:	-1.397	-.773	-.749
MAXIMUM Y	:	.927	.933	.776
MINIMUM Y	:	-1.359	-1.256	-1.248
CENTROID X	:	-.409	-.254	-.278
CENTROID Y	:	.100	-.003	.154
POA TO CENTROID in.	:	.422	.254	.318
MIN RADIUS	:	.251	.364	.336
MEAN RADIUS	:	.866	.767	.670
MAX RADIUS	:	1.677	1.271	1.250
HORIZONTAL SPREAD	:	1.987	1.207	1.207
VERTICAL SPREAD	:	2.286	2.189	2.024
EXTREME SPREAD	:	2.875	2.391	2.135
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

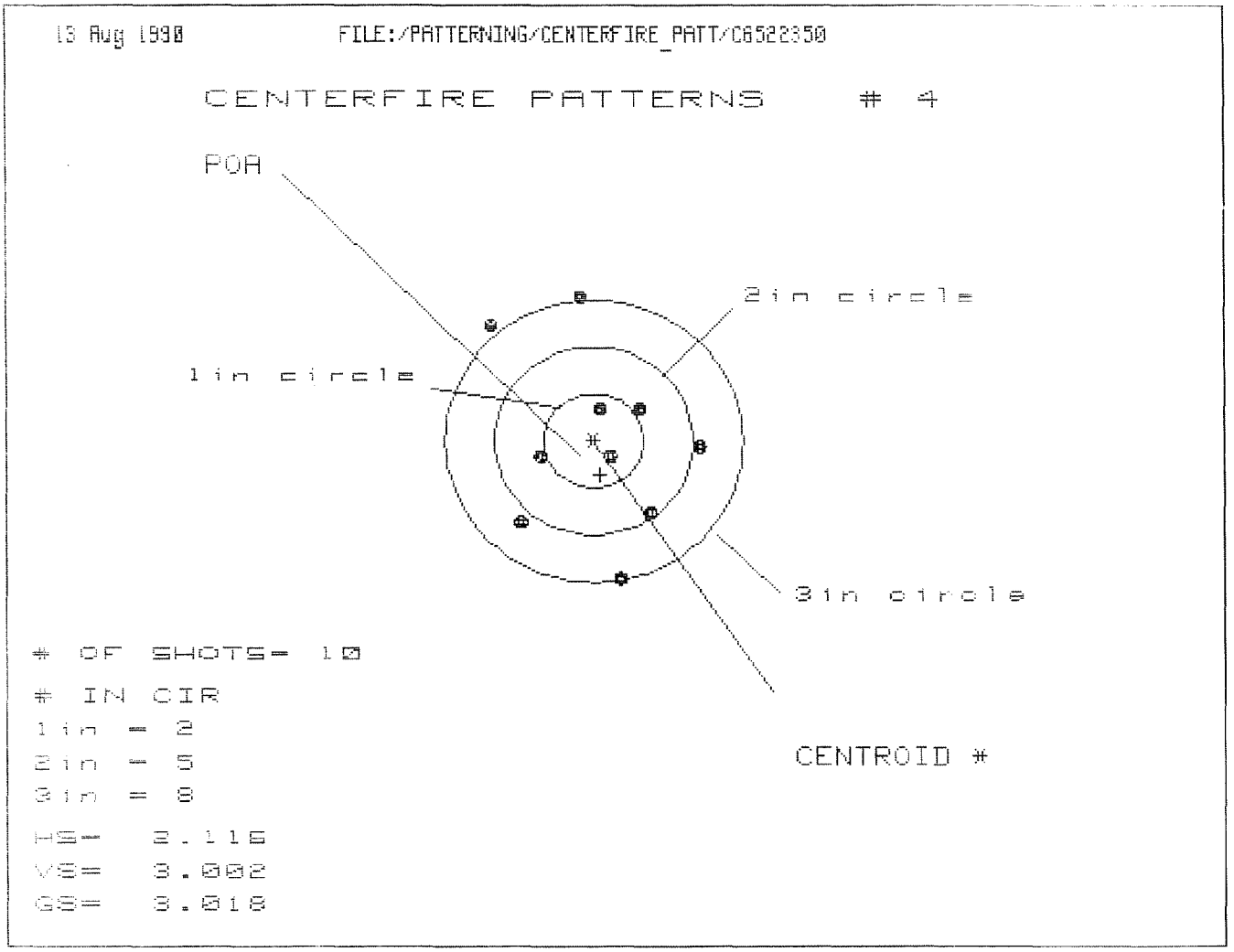
13 Aug 1998 FILE:/PATTERNING/CENTERFIRE_PATT/C6522350

CENTERFIRE PATTERNS # 3

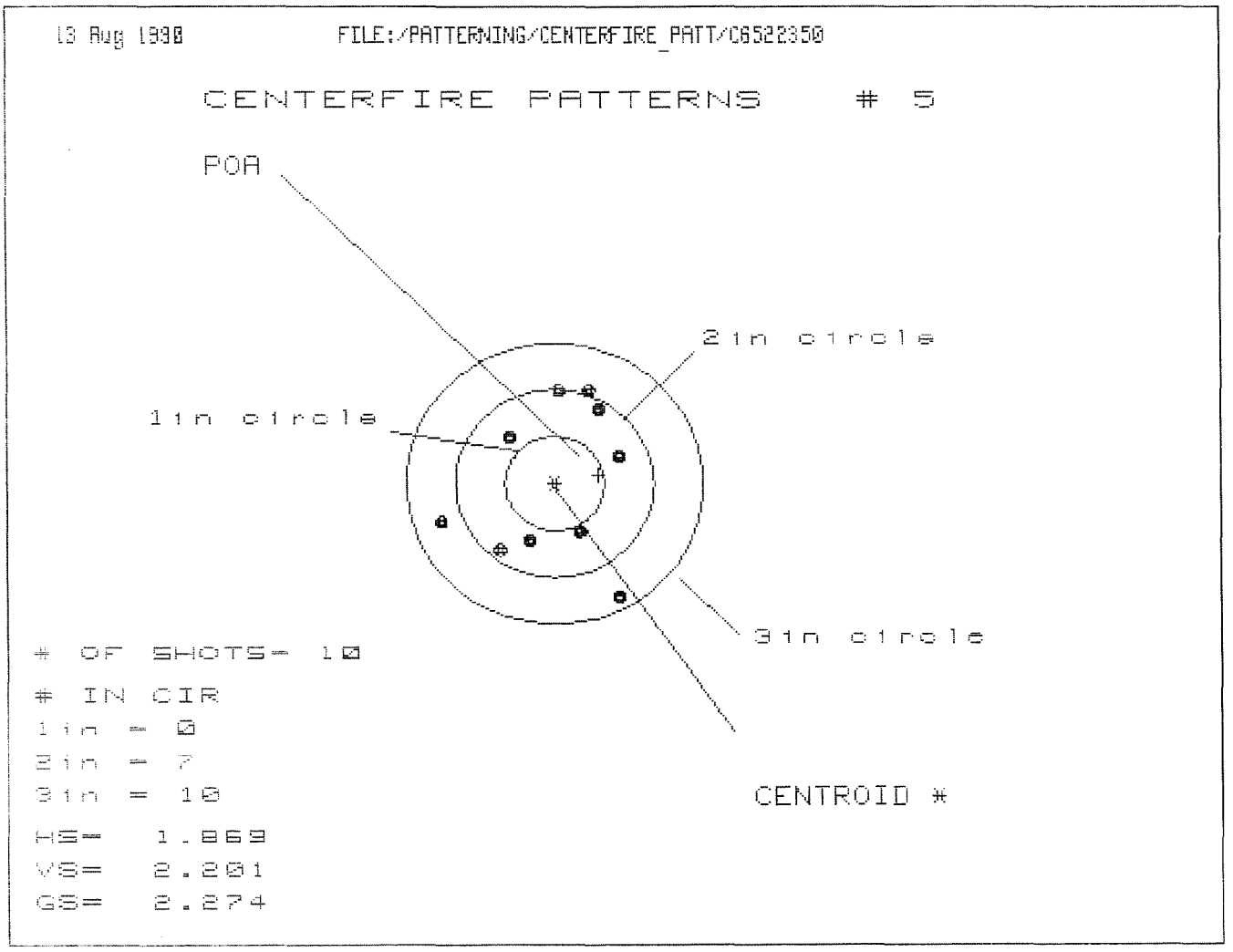


# OF SHOTS= 10
# IN CIR
1in = 4
2in = 8
3in = 9
HS= 2.068
VS= 1.863
GS= 2.645

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.262	.697	.637
MINIMUM X	:	-.806	-.666	-.726
MAXIMUM Y	:	1.036	.944	.701
MINIMUM Y	:	-.827	-.814	-.696
CENTROID X	:	.023	-.117	-.057
CENTROID Y	:	-.725	-.633	-.752
POA TO CENTROID in.	:	.726	.644	.754
MIN RADIUS	:	.125	.287	.204
MEAN RADIUS	:	.688	.615	.525
MAX RADIUS	:	1.508	1.058	.779
HORIZONTAL SPREAD	:	2.068	1.363	1.363
VERTICAL SPREAD	:	1.863	1.758	1.396
EXTREME SPREAD	:	2.645	1.793	1.405
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	



PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.042	.923	.896
MINIMUM X	:	-1.074	-.894	-.921
MAXIMUM Y	:	1.541	1.679	.710
MINIMUM Y	:	-1.461	-1.323	-1.113
CENTROID X	:	-.063	.056	.083
CENTROID Y	:	.362	.224	.014
POA TO CENTROID in.	:	.367	.231	.084
MIN RADIUS	:	.231	.071	.222
MEAN RADIUS	:	.956	.856	.764
MAX RADIUS	:	1.641	1.693	1.115
HORIZONTAL SPREAD	:	2.116	1.817	1.817
VERTICAL SPREAD	:	3.002	3.002	1.823
EXTREME SPREAD	:	3.018	3.018	1.974
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	:	.685	.679	.540
MINIMUM X	:	-1.184	-1.107	-.587
MAXIMUM Y	:	.950	.811	.745
MINIMUM Y	:	-1.251	-.811	-.877
CENTROID X	:	-.446	-.523	-.384
CENTROID Y	:	-.092	.047	.113
POA TO CENTROID in.	:	.456	.525	.400
MIN RADIUS	:	.616	.544	.546
MEAN RADIUS	:	.904	.835	.766
MAX RADIUS	:	1.427	1.226	1.055
HORIZONTAL SPREAD	:	1.869	1.786	1.127
VERTICAL SPREAD	:	2.201	1.622	1.622
EXTREME SPREAD	:	2.274	2.055	1.856
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

SWS TRIGGER PULL TEST

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

SERIAL NO. C6522350

DATE 9-12-90

TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.36	2.36	2.41	2.30	MIN. SETTING,
PULL #2	2.21	2.36	2.43	2.15	NO AVG. OF 5
PULL #3	2.30	2.37	2.49	2.20	READINGS ACCEPT-
PULL #4	2.40	2.31	2.40	2.27	ABLE LESS THAN 2#
PULL #5	2.46	2.32	2.30	2.30	
TOTAL	11.73	11.72	12.03	11.22	
AVG.	2.346	2.344	2.406	2.244	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.50	3.33		
PULL #2	3.49	3.50		
PULL #3	3.42	3.31		
PULL #4	3.49	3.29		
PULL #5	3.45	3.21		
TOTAL	17.35	16.64		
AVG.	3.47	3.328		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.14	4.36		4.36
PULL #2	4.17	4.40		4.33
PULL #3	4.17	4.38		4.45
PULL #4	4.15	4.48		4.35
PULL #5	4.36	4.42		4.47
TOTAL	20.99	22.04		21.96
AVG.	4.198	4.408		4.392

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522350

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	D.S.
617	Drill and Tap Sight Holes		7/13/90	WB
618	Polish Barrel RB		7/16/90	WB
620	Apply Coatings (Barrel Action)		7-23-90	DA
	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		9-12-90	DA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			7/30/90	JLL
	G) Safety Off Force	3	3	3			7/30/90	JLL
	H) Trigger Pull Test & Retainability						9-12-90	JLL
	I) Firing Pin Indent	.023	.023	.023			7/30/90	JLL
	J) Assemble Stock						8/7/90	RW
	K) Assemble Swivel Studs						9/13/90	gss
	L) Attach Front and Rear Sight Assemblies						8/7/90	RW
	M) Iron Sight Alignment						8/7/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/7/90	RW
	O) Attach Scope to Rifle						8/7/90	RW
	P) Detach & Attach Scope 20 Times						8/7/90	RW
640	Gallery Target & Test						8/13/90	NF
	A) Time						8/13/90	NF
	B) Malfunctions						8/13/90	NF
	C) Pierced Primers						8/13/90	NF
	D) Optical Clearity of Scope						8/13/90	NF
645	Inspect for Live Ammo						8/13/90	NF
655	Final Inspection A) Headspace						9/13/90	gss
	B) Trigger Pull	2.30	2.15	2.20	2.27	2.30	9-12-90	JLL
	C) Function						9/13/90	gss
660	Pack						9/19/90	NF