C6498772

MODEL 700™ M24

Model SWS™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington®


3.28

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6498772

| OP. # | OP. NAME | READINGS | DATE | INIT |
|---|---|---|---|---|
| 575 & 580 | Assemble Action and Stock | 4 12 | 90 | RW |
| 600 | Proof | 4 12 | 90 | [illegible] |
| 607 | Check Headspace | 4 12 | 90 | [illegible] |
| 610 | Dis-assemble Gun | 4 12 | 90 | RW |
| 612 | Magnaflux Barrel Action | 4-19-90 | | KCK |
| | Magnaflux Bolt | 4-19-90 | | KCK |
| 615 | Rollmark Caliber | 4-19-90 | | [illegible] |
| 617 | Drill and Tap Sight Holes | | 4/27/90 | [illegible] |
| 618 | Polish Barrel RB | | 4/27/90 | [illegible] |
| 620 | Apply Coatings (Barrel Action) | | 4-30-90 | [illegible] |
| | Apply Coating (Bolt) | | | [illegible] |
| 625 | Final Assembly A) Clean inside of Bolt Assembly | | 5/1/90 | RW |
| | B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head | | 5/1/90 | RW |
| | C) Inspect Ejector Hole for Chamfer | | 5/1/90 | RW |
| | D) Oil Firing Pin Ass'y | | 5/1/90 | RW |
| | E) Adjust Trigger Pull to Min Setting and Stake | | 5/16/90 | [illegible] |

| op. # | OP. NAME | READINGS | | | | | DATE | INIT |
|---|---|---|---|---|---|---|---|---|
| 625 cont. | F) Safety On Force | 4 | 4 | 4 | | | 5/17/90 | |
| | G) Safety Off Force | 2 | 2 | 2 | | | 5/17/90 | |
| | H) Trigger Pull Test & Retainability | | | | | | 5/16/90 | |
| | I) Firing Pin Indent | .023 | .023 | .023 | | | 5/17/90 | |
| | J) Assemble Stock | | | | | | 5/17/90 | |
| | K) Assemble Swivel Studs | | | | | | 25 May 90 | |
| | L) Attach Front and Rear Sight Assemblies | | | | | | 5/17/90 | |
| | M) Iron Sight Alignment | | | | | | 5/17/90 | |
| | N) Detach Front & Rear Sights & place in numbered container | | | | | | 5/17/90 | |
| | O) Attach Scope to Rifle | | | | | | 5/17/90 | |
| | P) Detach & Attach Scope 20 Times | | | | | | 5/17/90 | |
| 640 | Gallery Target & Test | | | | | | 5-17-90 | DH |
| | A) Time | | | | | | 5-17-90 | DH |
| | B) Malfunctions | | | | | | 5-17-90 | DH |
| | C) Pierced Primers | | | | | | 5-17-90 | DH |
| | D) Optical Clearity of Scope | | | | | | 5-17-90 | DH |
| 645 | Inspect for Live Ammo | | | | | | 5-17-90 | DH |
| 655 | Final Inspection A) Headspace | | | | | | 25 May 90 | |
| | B) Trigger Pull | ~~2.19~~ 2.31 | ~~2.16~~ 2.31 | ~~2.17~~ 2.30 | ~~2.24~~ 2.23 | ~~2.34~~ 2.30 | 5/21/90 | |
| | C) Function | | | | | | 25 May 90 | |
| 660 | Pack | | | | | | 5-19-90 | DH |

# SWS TRIGGER PULL TEST

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

SERIAL NO. C6498772

DATE 5/16/90

TESTER JR

| | 2.50# INITIAL | 2.50# AFTER 50 CYCLES | FINAL TEST & TO RESET 2.50# | | COMMENTS |
|---|---|---|---|---|---|
| PULL #1 | 2.41 | 2.23 | 2.30 | 231 | MIN. SETTING, |
| PULL #2 | 2.47 | 2.35 | 2.31 | 231 | NO AVG. OF 5 |
| PULL #3 | 2.51 | 2.27 | 2.42 | 230 | READINGS ACCEPT- |
| PULL #4 | 2.42 | 2.28 | 2.36 | 223 | ABLE LESS THAN 2# |
| PULL #5 | 2.54 | 2.36 | 2.22 | 230 | |
| TOTAL | 12.35 | 11.49 | 11.61 | | |
| AVG. | 2.47 | 2.298 | 2.322 | | |

| | 3.00# INITIAL | 3.00# AFTER 20 CYCLES | | COMMENTS |
|---|---|---|---|---|
| PULL #1 | 3.37 | 3.21 | | |
| PULL #2 | 3.47 | 3.21 | | |
| PULL #3 | 3.53 | 3.17 | | |
| PULL #4 | 3.22 | 3.19 | | |
| PULL #5 | 3.29 | 3.17 | | |
| TOTAL | 16.88 | 15.95 | | |
| AVG. | 3.376 | 3.19 | | |

| | 4.00# INITIAL | 4.00# AFTER 20 CYCLES | MAX SETTING GREATER THAN 4# | RESET TO 4# FOR TARGET & ACCURACY |
|---|---|---|---|---|
| PULL #1 | 4.39 | 4.39 | | 4.38 |
| PULL #2 | 4.50 | 4.40 | | 4.39 |
| PULL #3 | 4.38 | 4.35 | | 4.34 |
| PULL #4 | 4.27 | 4.49 | | 4.32 |
| PULL #5 | 4.31 | 4.41 | | 4.37 |
| TOTAL | 21.85 | 22.04 | | 21.78 |
| AVG. | 4.37 | 4.408 | | 4.356 |

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6498772
18 May 1990

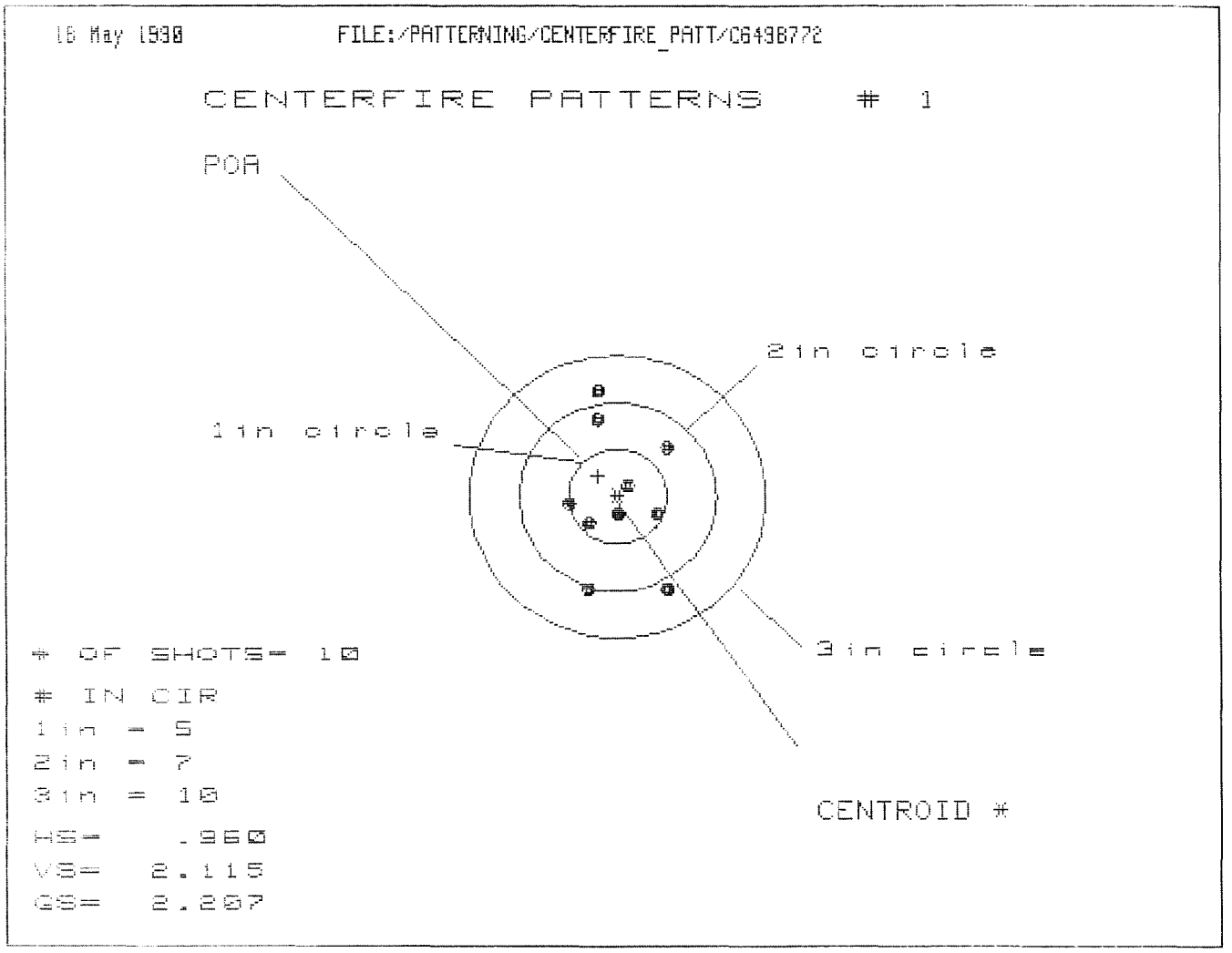
CENTROIDAL DISTANCES

| | | | |
|---|---|---|---|
| 0 | TO | 1 | .293319 |
| 1 | TO | 2 | .420011 |
| 1 | TO | 3 | .21281 |
| 1 | TO | 4 | .488807 |
| 1 | TO | 5 | .621884 |

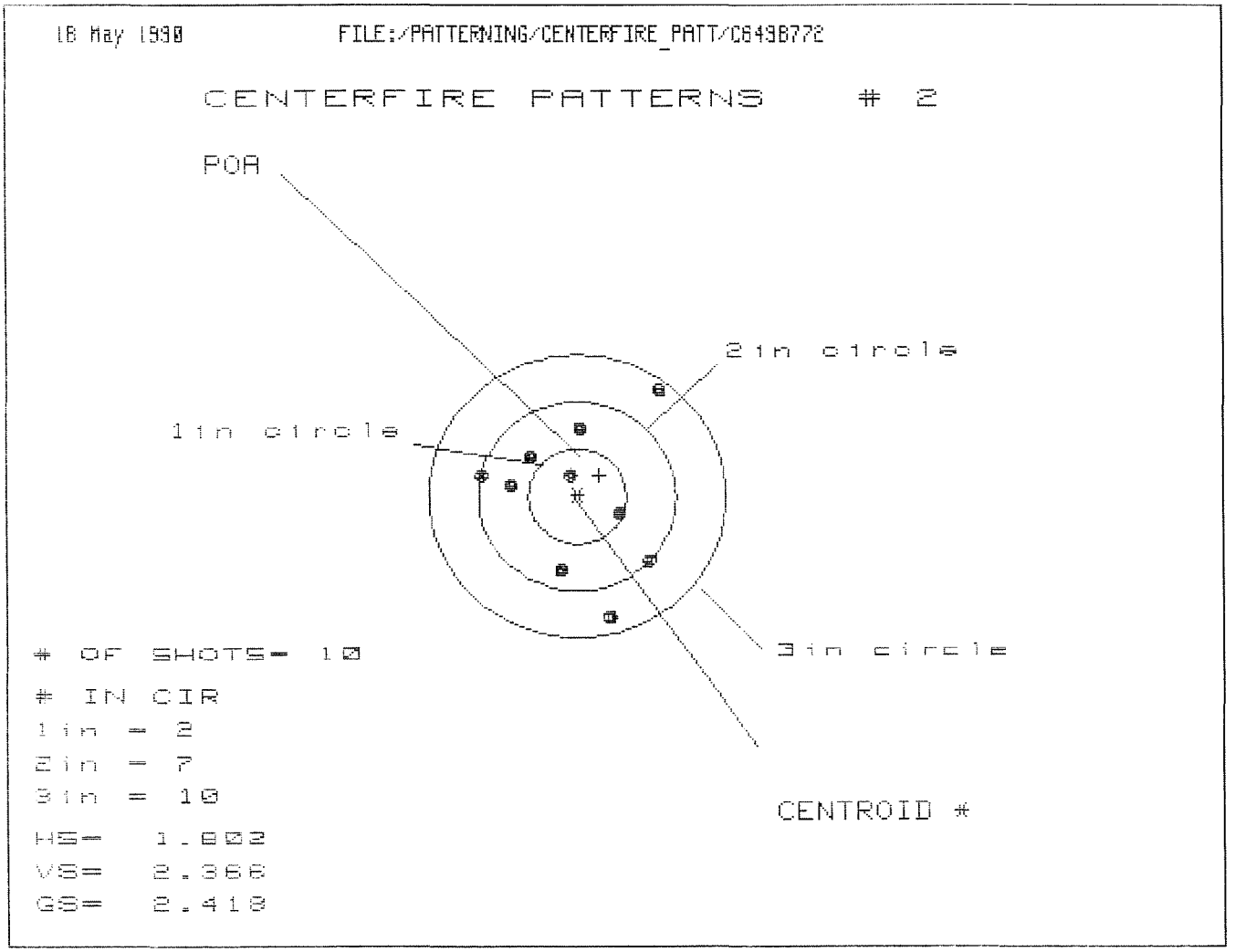
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0452
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0646
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0788429

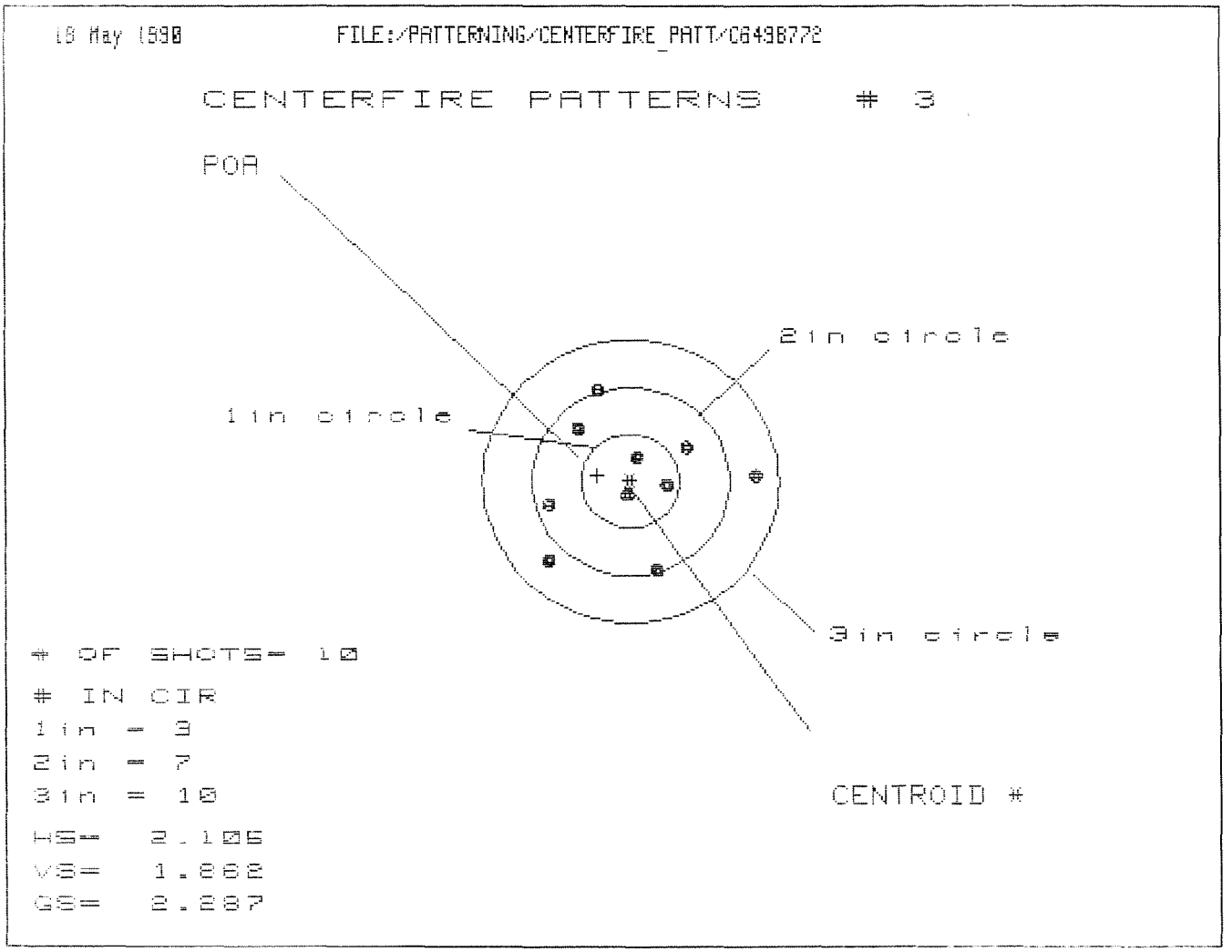
THE AMR FOR THIS RIFLE IS: .7882



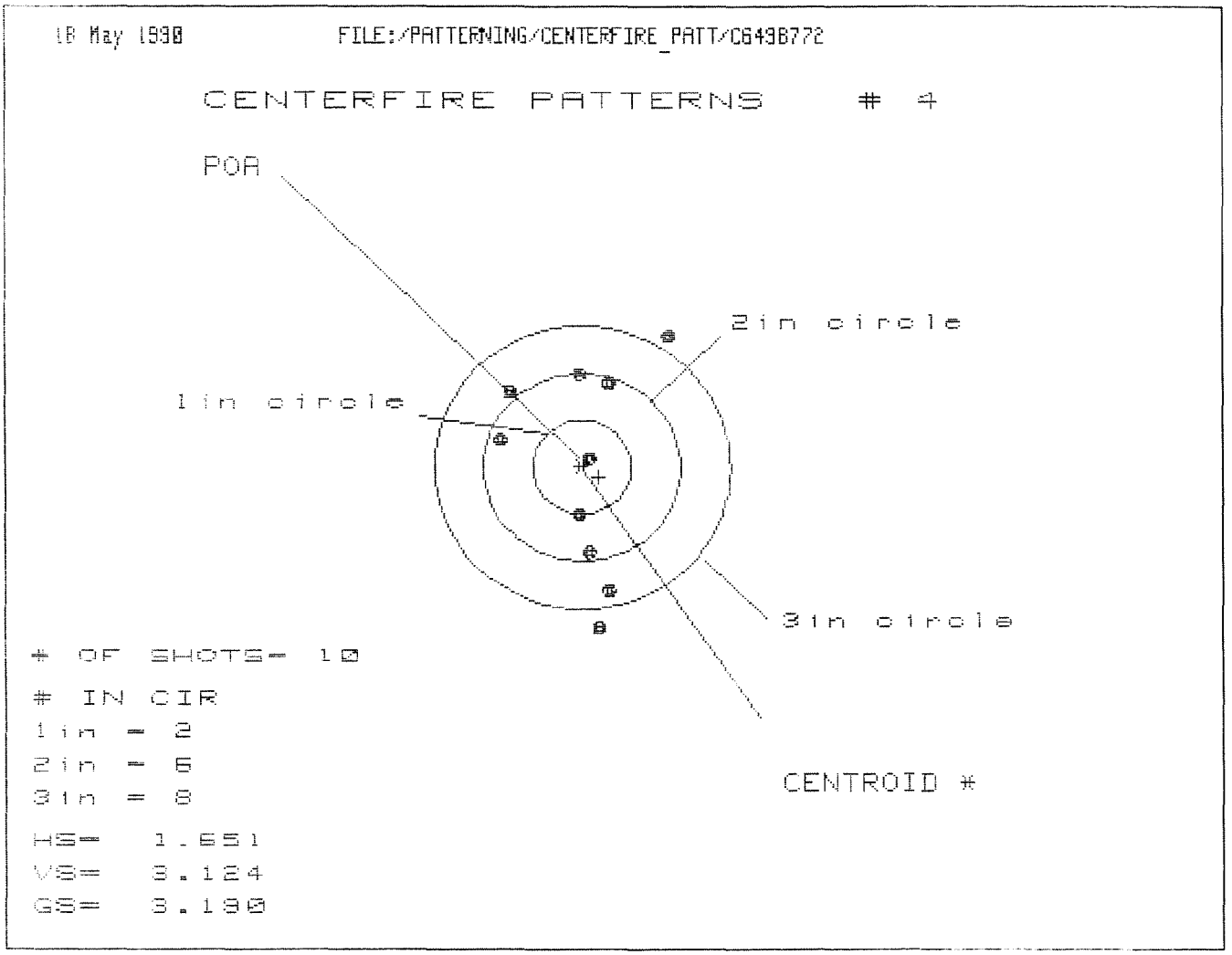

| PATTERN # | : | 1 | | |
|---|---|---|---|---|
| SHOTS (BEST OF) | : | 10 | 9 | 8 |
| MAXIMUM X | : | .474 | .456 | .511 |
| MINIMUM X | : | -.486 | -.504 | -.447 |
| MAXIMUM Y | : | 1.142 | .980 | .874 |
| MINIMUM Y | : | -.973 | -.846 | -.932 |
| CENTROID X | : | .194 | .212 | .155 |
| CENTROID Y | : | -.220 | -.347 | -.241 |
| POA TO CENTROID in. | : | .293 | .406 | .286 |
| MIN RADIUS | : | .177 | .085 | .182 |
| MEAN RADIUS | : | .662 | .594 | .546 |
| MAX RADIUS | : | 1.153 | 1.007 | .969 |
| HORIZONTAL SPREAD | : | .960 | .960 | .958 |
| VERTICAL SPREAD | : | 2.115 | 1.826 | 1.806 |
| EXTREME SPREAD | : | 2.207 | 1.951 | 1.888 |
| NUMBER IN ONE INCH CIRCLE | = | | 5 | |
| NUMBER IN TWO INCH CIRCLE | = | | 7 | |
| NUMBER IN THREE INCH CIRCLE | = | | 10 | |



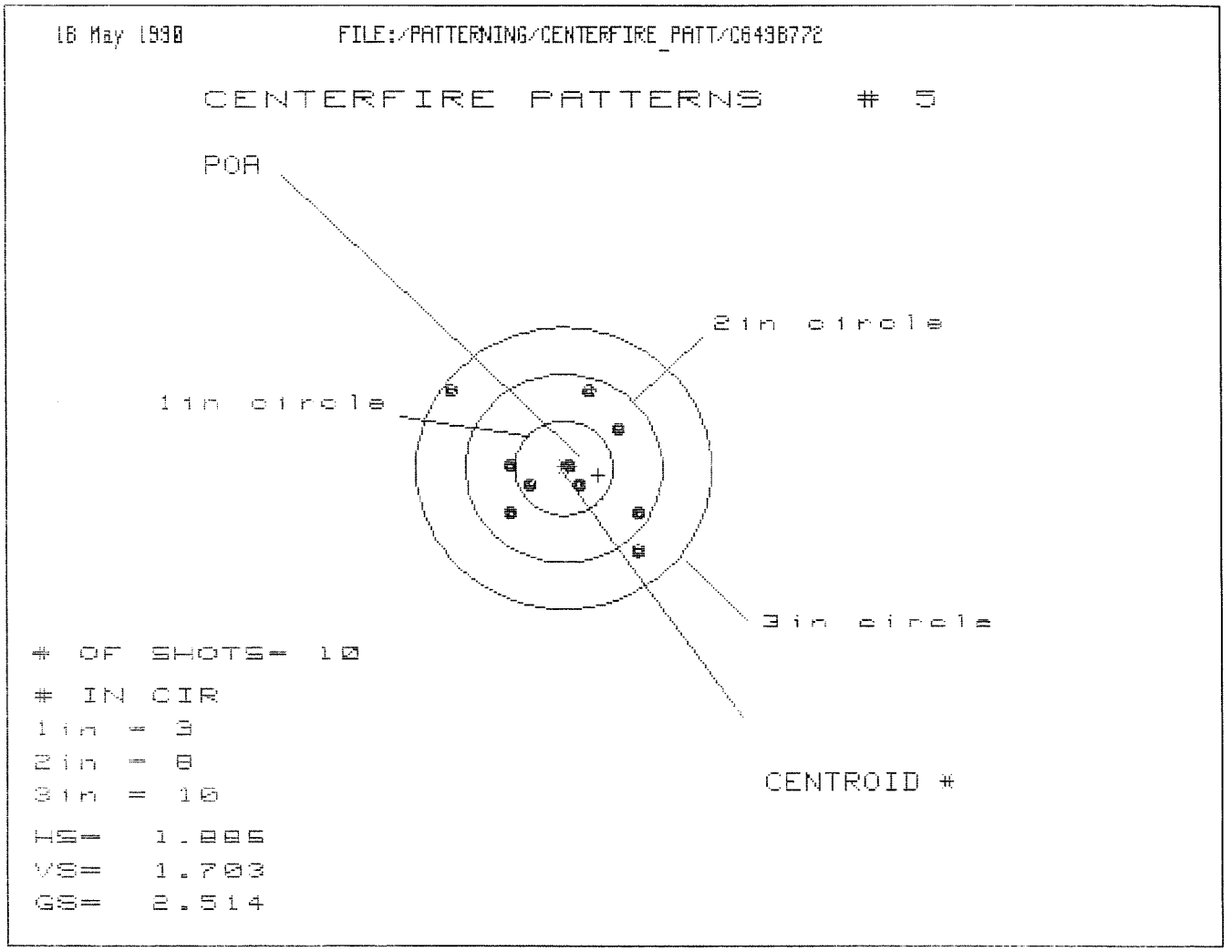

| | | | | |
|---|---|---|---|---|
| PATTERN # | : | 2 | | |
| SHOTS (BEST OF) | : | 10 | 9 | 8 |
| MAXIMUM X | : | .814 | .843 | .893 |
| MINIMUM X | : | -.988 | -.897 | -.847 |
| MAXIMUM Y | : | 1.073 | .855 | .708 |
| MINIMUM Y | : | -1.293 | -1.174 | -.815 |
| CENTROID X | : | -.226 | -.317 | -.367 |
| CENTROID Y | : | -.223 | -.342 | -.195 |
| POA TO CENTROID in. | : | .318 | .466 | .416 |
| MIN RADIUS | : | .201 | .324 | .205 |
| MEAN RADIUS | : | .819 | .764 | .674 |
| MAX RADIUS | : | 1.347 | 1.242 | 1.108 |
| HORIZONTAL SPREAD | : | 1.802 | 1.740 | 1.740 |
| VERTICAL SPREAD | : | 2.366 | 2.029 | 1.523 |
| EXTREME SPREAD | : | 2.418 | 2.044 | 1.946 |
| NUMBER IN ONE INCH CIRCLE | = | | 2 | |
| NUMBER IN TWO INCH CIRCLE | = | | 7 | |
| NUMBER IN THREE INCH CIRCLE | = | | 10 | |




| | | | | |
|---|---|---|---|---|
| PATTERN # | : | 3 | | |
| SHOTS (BEST OF) | : | 10 | 9 | 8 |
| MAXIMUM X | : | 1.272 | .746 | .664 |
| MINIMUM X | : | -.834 | -.693 | -.775 |
| MAXIMUM Y | : | .952 | .962 | .853 |
| MINIMUM Y | : | -.910 | -.900 | -1.009 |
| CENTROID X | : | .332 | .191 | .273 |
| CENTROID Y | : | -.058 | -.068 | .041 |
| POA TO CENTROID in. | : | .337 | .203 | .276 |
| MIN RADIUS | : | .157 | .137 | .218 |
| MEAN RADIUS | : | .756 | .699 | .631 |
| MAX RADIUS | : | 1.275 | 1.092 | 1.076 |
| HORIZONTAL SPREAD | : | 2.106 | 1.439 | 1.439 |
| VERTICAL SPREAD | : | 1.862 | 1.862 | 1.862 |
| EXTREME SPREAD | : | 2.287 | 1.983 | 1.983 |
| NUMBER IN ONE INCH CIRCLE | = | | 3 | |
| NUMBER IN TWO INCH CIRCLE | = | | 7 | |
| NUMBER IN THREE INCH CIRCLE | = | | 10 | |




| | | | | |
|---|---|---|---|---|
| PATTERN # | : | 4 | | |
| SHOTS (BEST OF) | : | 10 | 9 | 8 |
| MAXIMUM X | : | .861 | .884 | .416 |
| MINIMUM X | : | -.790 | -.767 | -.656 |
| MAXIMUM Y | : | 1.377 | 1.183 | .930 |
| MINIMUM Y | : | -1.747 | -1.498 | -1.351 |
| CENTROID X | : | -.172 | -.195 | -.306 |
| CENTROID Y | : | .104 | .298 | .151 |
| POA TO CENTROID in. | : | .201 | .357 | .341 |
| MIN RADIUS | : | .137 | .076 | .181 |
| MEAN RADIUS | : | 1.010 | .903 | .829 |
| MAX RADIUS | : | 1.760 | 1.521 | 1.401 |
| HORIZONTAL SPREAD | : | 1.651 | 1.651 | 1.072 |
| VERTICAL SPREAD | : | 3.124 | 2.681 | 2.281 |
| EXTREME SPREAD | : | 3.190 | 2.752 | 2.312 |
| NUMBER IN ONE INCH CIRCLE | = | | 2 | |
| NUMBER IN TWO INCH CIRCLE | = | | 6 | |
| NUMBER IN THREE INCH CIRCLE | = | | 8 | |




| | | | | |
|---|---|---|---|---|
| PATTERN # | : | 5 | | |
| SHOTS (BEST OF) | : | 10 | 9 | 8 |
| MAXIMUM X | : | .780 | .657 | .679 |
| MINIMUM X | : | -1.106 | -.699 | -.617 |
| MAXIMUM Y | : | .847 | .937 | .841 |
| MINIMUM Y | : | -.856 | -.766 | -.505 |
| CENTROID X | : | -.354 | -.231 | -.313 |
| CENTROID Y | : | .074 | -.016 | .080 |
| POA TO CENTROID in. | : | .361 | .231 | .323 |
| MIN RADIUS | : | .041 | .116 | .015 |
| MEAN RADIUS | : | .694 | .613 | .549 |
| MAX RADIUS | : | 1.369 | 1.009 | .859 |
| HORIZONTAL SPREAD | : | 1.886 | 1.356 | 1.296 |
| VERTICAL SPREAD | : | 1.703 | 1.703 | 1.346 |
| EXTREME SPREAD | : | 2.514 | 1.794 | 1.526 |
| NUMBER IN ONE INCH CIRCLE | = | | 3 | |
| NUMBER IN TWO INCH CIRCLE | = | | 8 | |
| NUMBER IN THREE INCH CIRCLE | = | | 10 | |