C622523

MODEL 700™ M24

Model SWS™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington®

Scope 0028

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225293

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 12	89	RW
600	Proof	4 12	89	RW
607	Check Headspace	4 12	89	RW
610	Dis-assemble Gun	4 12	89	RW
612	Magnaflux Barrel Action		4/13/89	KCR
	Magnaflux Bolt		4/14/89	KCR
615	Rollmark Caliber			
617	Drill and Tap Sight Holes	4 14	89	YB
618	Polish Barrel RS	4 14	89	BT
620	Apply Coatings (Barrel Action)		4-20-89	TSA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/8/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/8/89	RW
	C) Inspect Ejector Hole for Chamfer		5/8/89	RW
	D) Oil Firing Pin Ass'y		5/8/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/10/89	WB

QUALITY AUDIT

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			5/10/89	JH
	G) Safety Off Force	3	3	3			5/10/89	JH
	H) Trigger Pull Test & Retainability						5/10/89	WB
	I) Firing Pin Indent	.021	.021	.020			5/10/89	JH
	J) Assemble Stock						5/15/89	RW
	K) Assemble Swivel Studs						17 May 89	GS
	L) Attach Front and Rear Sight Assemblies						5/15/89	RW
	M) Iron Sight Alignment						5/15/89	RW
	N) Detach Front & Rear Sights & place in numbered container						5/15/89	RW
	O) Attach Scope to Rifle						5/15/89	JH
	P) Detach & Attach Scope 20 Times						5/15/89	JH
640	Gallery Target & Test	68 d	84 L				5/16/89	DH
	A) Time						5/16/89	DH
	B) Malfunctions						5/16/89	DH
	C) Pierced Primers						5/16/89	DH
	D) Optical Clearity of Scope						5/16/89	DH
645	Inspect for Live Ammo						5/16/89	DH
655	Final Inspection A) Headspace						17 May 89	GS
	B) Trigger Pull	2.23	2.67	2.58	2.55	2.67	17 May 89	GS
	C) Function						17 May 89	GS
660	Pack						26 June 89	GS

SWS TRIGGER PULL TEST

C62252 93

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

SERIAL NO. _____

DATE 5/10/89

TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.50	2.46	2.79	273	MIN. SETTING,
PULL #2	2.54	2.45	2.74	267	NO AVG. OF 5
PULL #3	2.42	2.35	2.70	250	READINGS ACCEPT-
PULL #4	2.61	2.58	2.78	255	ABLE LESS THAN 2#
PULL #5	2.59	2.58	2.66	269	
TOTAL	12.66	12.42	13.67	13.20	
AVG.	2.53	2.48	2.73	2.64	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.24	3.38		
PULL #2	3.27	3.25		
PULL #3	3.31	3.34		
PULL #4	3.07	3.37		
PULL #5	3.36	3.28		
TOTAL	16.25	16.62		
AVG.	3.25	3.32		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.37	4.47		4.19
PULL #2	4.42	4.40		4.29
PULL #3	4.54	4.50		4.39
PULL #4	4.27	4.27		4.32
PULL #5	4.48	4.44		4.28
TOTAL	22.08	22.08		21.47
AVG.	4.41	4.41		4.29

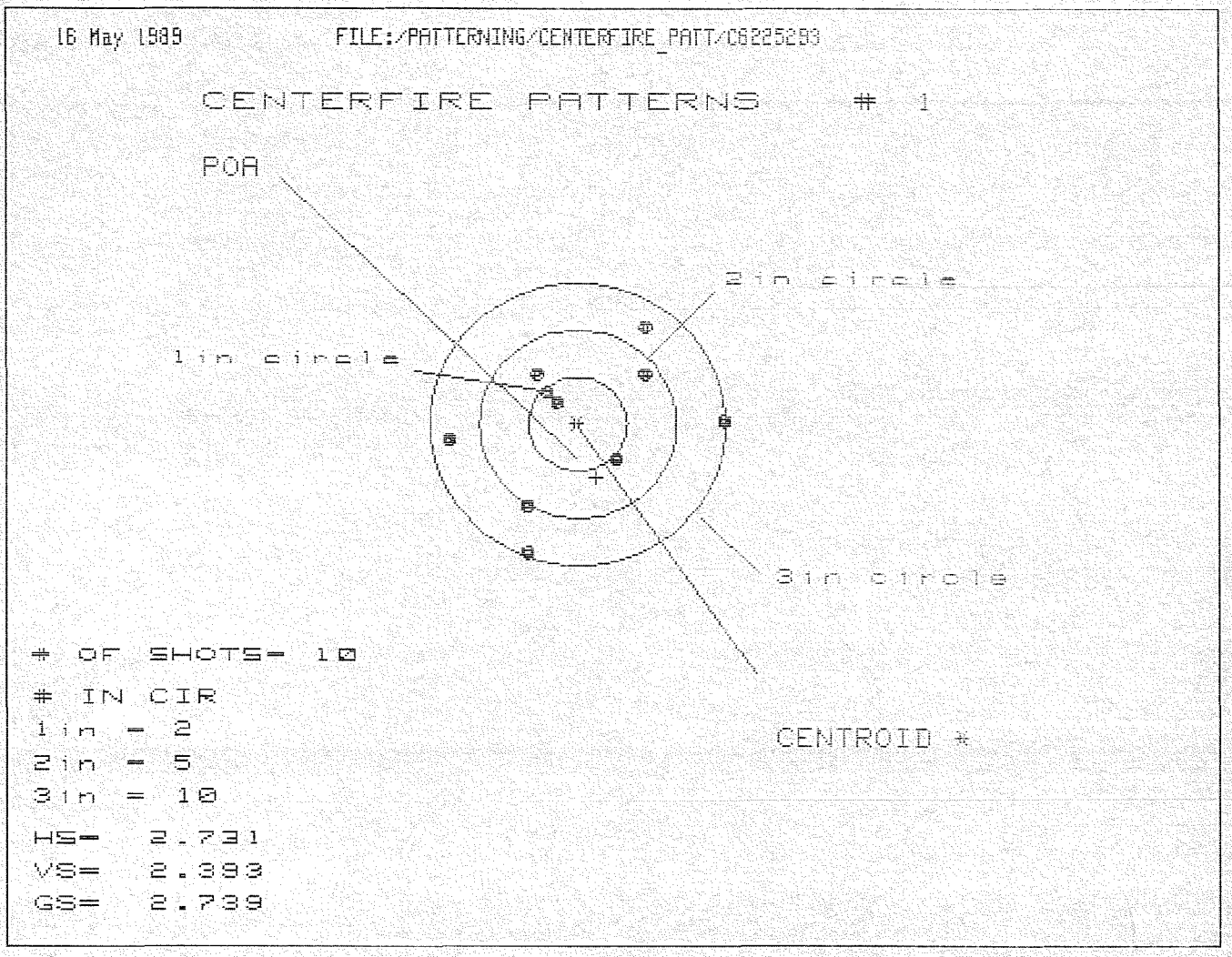
CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225293
17 May 1989

CENTROIDAL DISTANCES

0	TO	1	.595457
1	TO	2	.172386
1	TO	3	.792235
1	TO	4	.726175
1	TO	5	.239767

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0304
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2238
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .225855

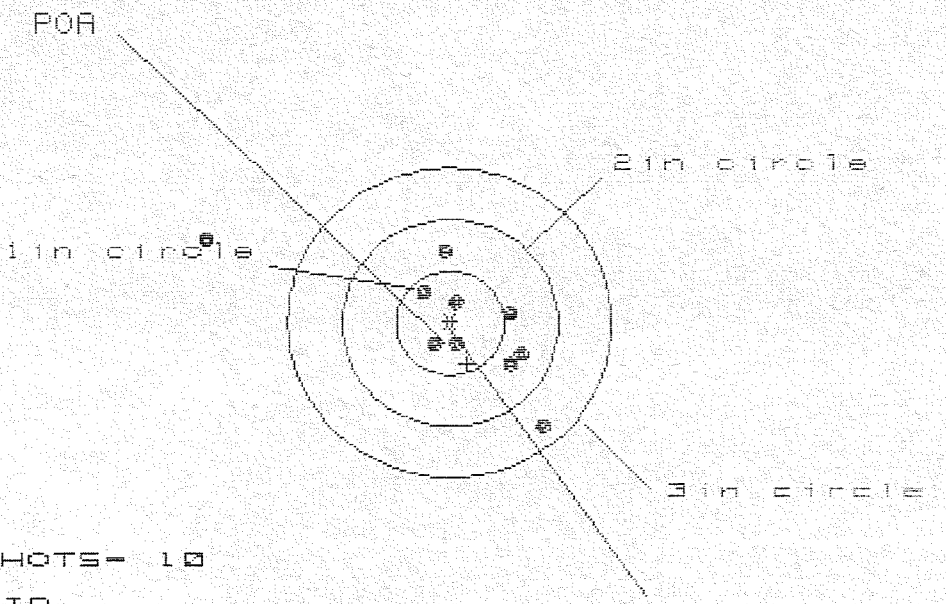
THE AMR FOR THIS RIFLE IS: .8214



PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.453	.876	.834
MINIMUM X	:	-1.278	-1.116	-1.158
MAXIMUM Y	:	1.063	1.066	.900
MINIMUM Y	:	-1.330	-1.327	-1.031
CENTROID X	:	-.188	-.350	-.308
CENTROID Y	:	.565	.562	.728
POA TO CENTROID in.	:	.596	.662	.791
MIN RADIUS	:	.324	.221	.142
MEAN RADIUS	:	.935	.857	.759
MAX RADIUS	:	1.454	1.368	1.208
HORIZONTAL SPREAD	:	2.731	1.992	1.992
VERTICAL SPREAD	:	2.393	2.393	1.931
EXTREME SPREAD	:	2.739	2.652	2.294
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

16 May 1989 FILE:/PATTERNING/CENTERFIRE_PATT/C62252S3

CENTERFIRE PATTERNS # 2

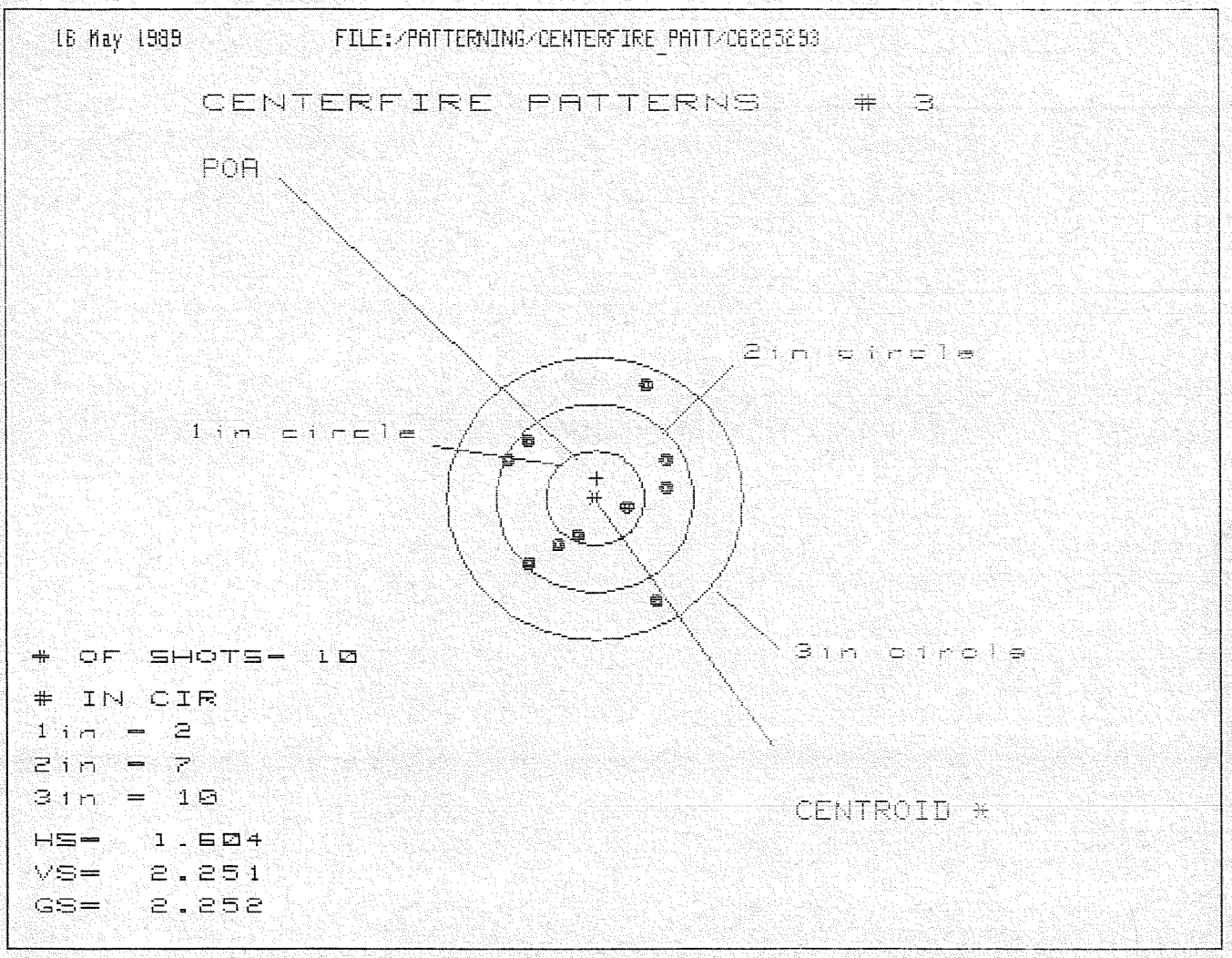


OF SHOTS= 10

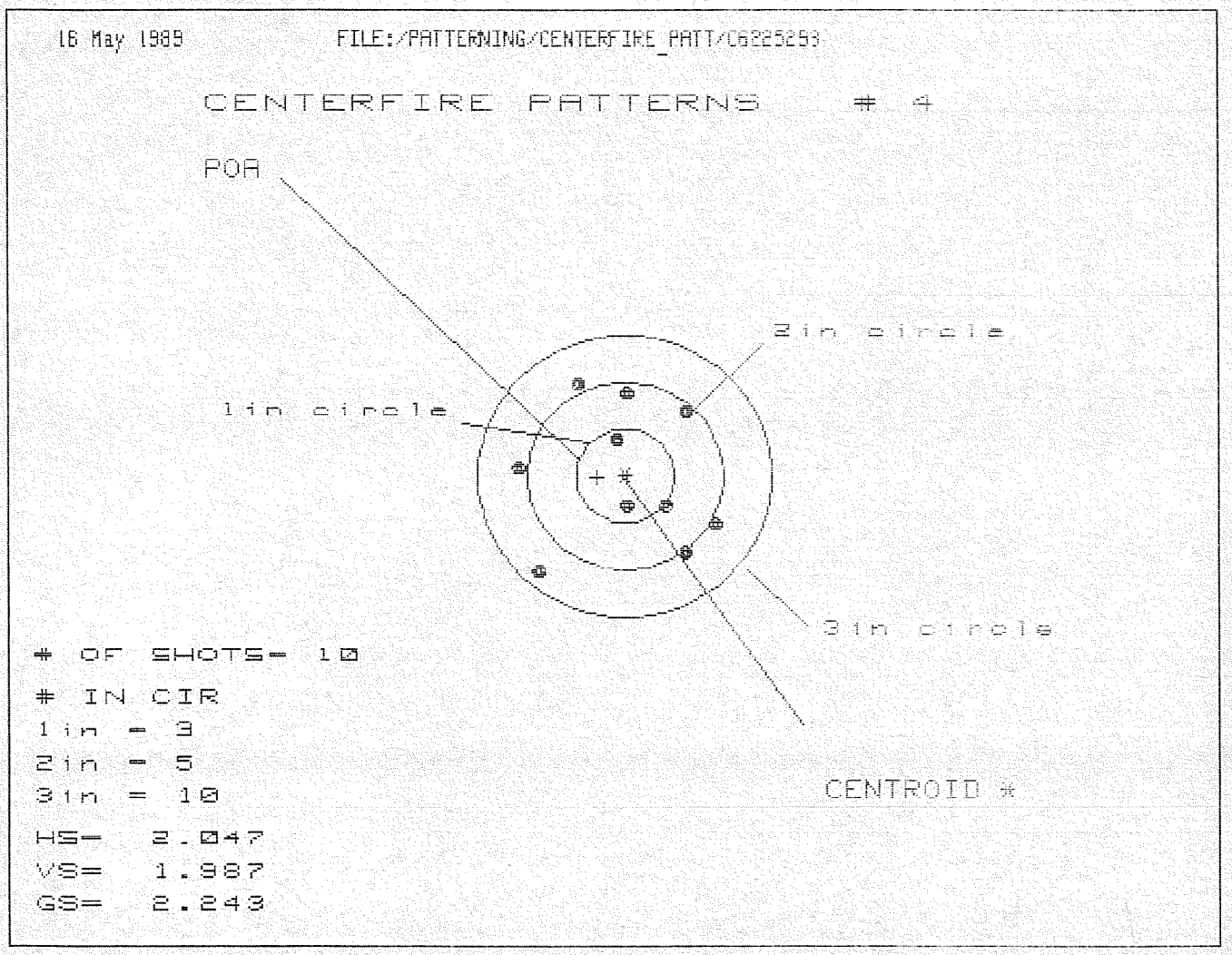
# IN CIR	
1in =	4
2in =	8
3in =	9

HS= 3.126
VS= 1.811
GS= 3.613

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.864	.613	.479
MINIMUM X	:	-2.262	-.450	-.373
MAXIMUM Y	:	.844	.783	.674
MINIMUM Y	:	-.967	-.874	-.459
CENTROID X	:	-.154	.097	.020
CENTROID Y	:	.396	.303	.412
POA TO CENTROID in.	:	.425	.318	.412
MIN RADIUS	:	.225	.283	.262
MEAN RADIUS	:	.749	.543	.464
MAX RADIUS	:	2.414	1.067	.705
HORIZONTAL SPREAD	:	3.126	1.063	.852
VERTICAL SPREAD	:	1.811	1.657	1.133
EXTREME SPREAD	:	3.613	1.883	1.268
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	



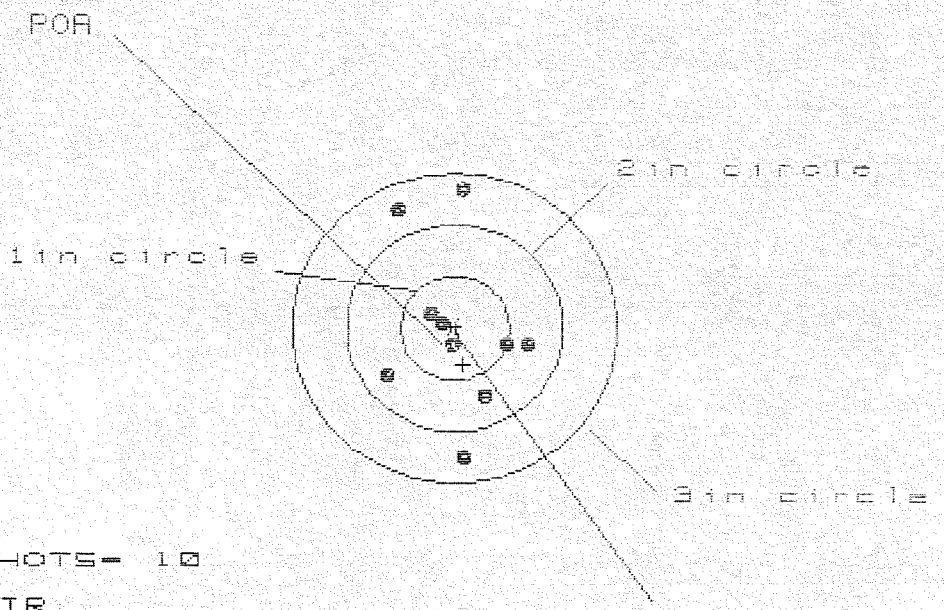
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.683	.744	.829
MINIMUM X	:	-.921	-.860	-.775
MAXIMUM Y	:	1.185	.750	.633
MINIMUM Y	:	-1.066	-.934	-.634
CENTROID X	:	-.019	-.080	-.165
CENTROID Y	:	-.209	-.341	-.224
POA TO CENTROID in.	:	.210	.350	.279
MIN RADIUS	:	.371	.343	.426
MEAN RADIUS	:	.838	.769	.724
MAX RADIUS	:	1.306	1.157	.910
HORIZONTAL SPREAD	:	1.604	1.604	1.604
VERTICAL SPREAD	:	2.251	1.684	1.267
EXTREME SPREAD	:	2.252	2.151	1.710
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	10		



PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.943	.843	.692
MINIMUM X	:	-1.104	-1.204	-.769
MAXIMUM Y	:	.941	.824	.823
MINIMUM Y	:	-1.046	-.980	-.981
CENTROID X	:	.285	.385	.536
CENTROID Y	:	.014	.131	.132
POA TO CENTROID in.	:	.285	.407	.552
MIN RADIUS	:	.279	.307	.413
MEAN RADIUS	:	.863	.792	.733
MAX RADIUS	:	1.383	1.204	1.126
HORIZONTAL SPREAD	:	2.047	2.047	1.461
VERTICAL SPREAD	:	1.987	1.804	1.804
EXTREME SPREAD	:	2.243	2.150	2.150
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

16 May 1989 FILE:/PATTERNING/CENTERFIRE_PATT/06225293

CENTERFIRE PATTERNS # 5



\# OF SHOTS= 10

\# IN CIR
1in = 4
2in = 7
3in = 10

HS= 1.324
VS= 2.674
GS= 2.674

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.667	.679	.615
MINIMUM X	:	-.657	-.645	-.709
MAXIMUM Y	:	1.386	1.346	.507
MINIMUM Y	:	-1.288	-1.135	-.966
CENTROID X	:	-.076	-.088	-.024
CENTROID Y	:	.353	.200	.031
POA TO CENTROID in.	:	.362	.218	.039
MIN RADIUS	:	.120	.044	.195
MEAN RADIUS	:	.722	.629	.540
MAX RADIUS	:	1.390	1.440	.969
HORIZONTAL SPREAD	:	1.324	1.324	1.324
VERTICAL SPREAD	:	2.674	2.481	1.473
EXTREME SPREAD	:	2.674	2.563	1.523
NUMBER IN ONE INCH CIRCLE	=	4		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	10