C6523528

MODEL 700™ M24

Model SWS ™

Action

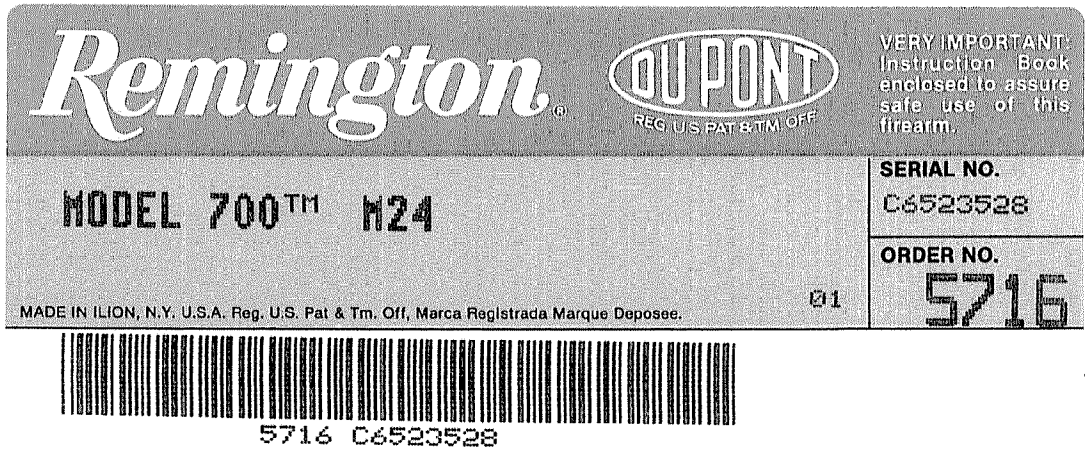
Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

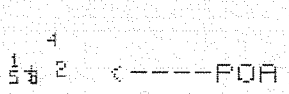
Remington



CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523528
16 Sep 1990

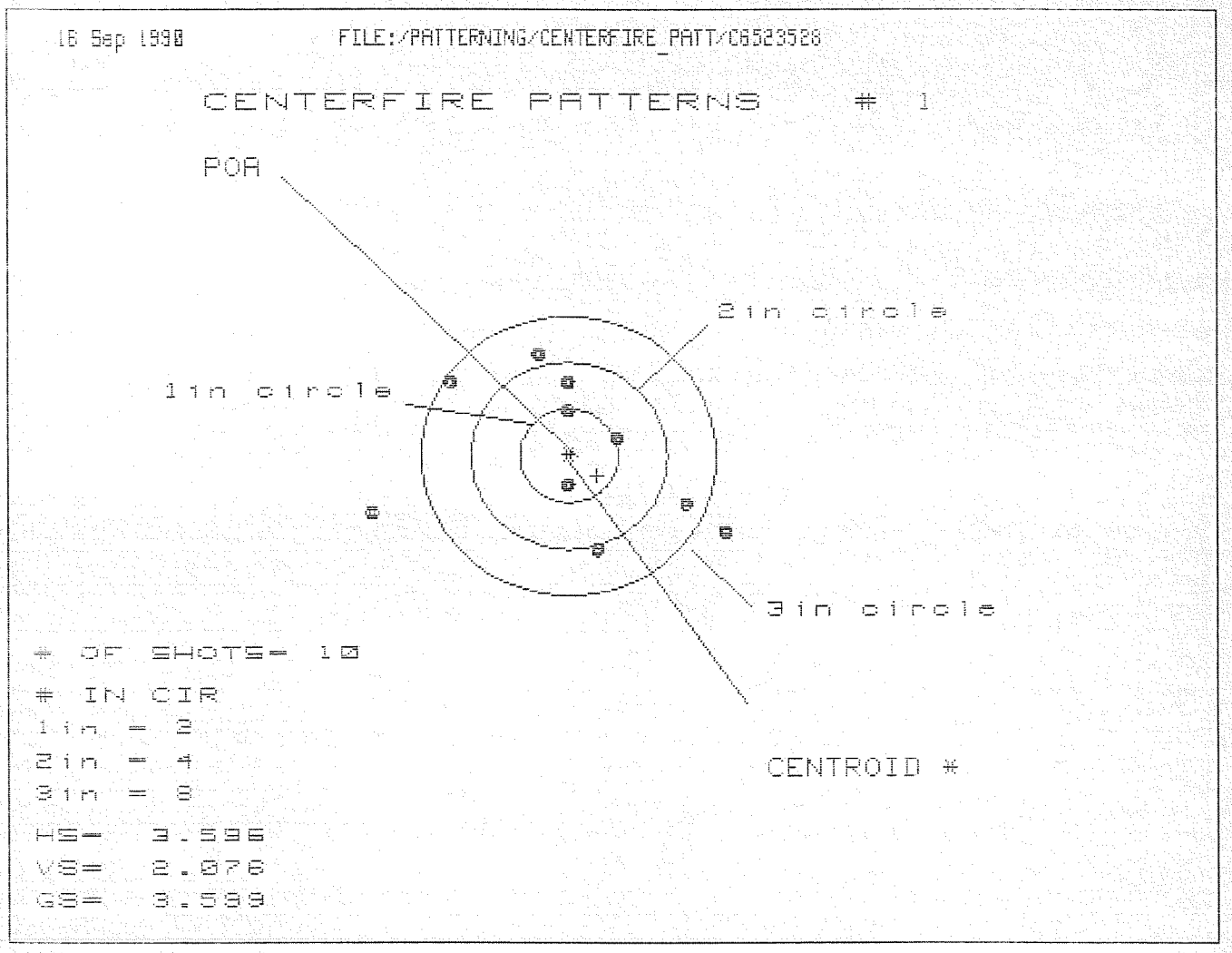
CENTROIDAL DISTANCES

Ø	TO	1	.35805
1	TO	2	.861485
1	TO	3	.456502
1	TO	4	.811819
1	TO	5	.310413

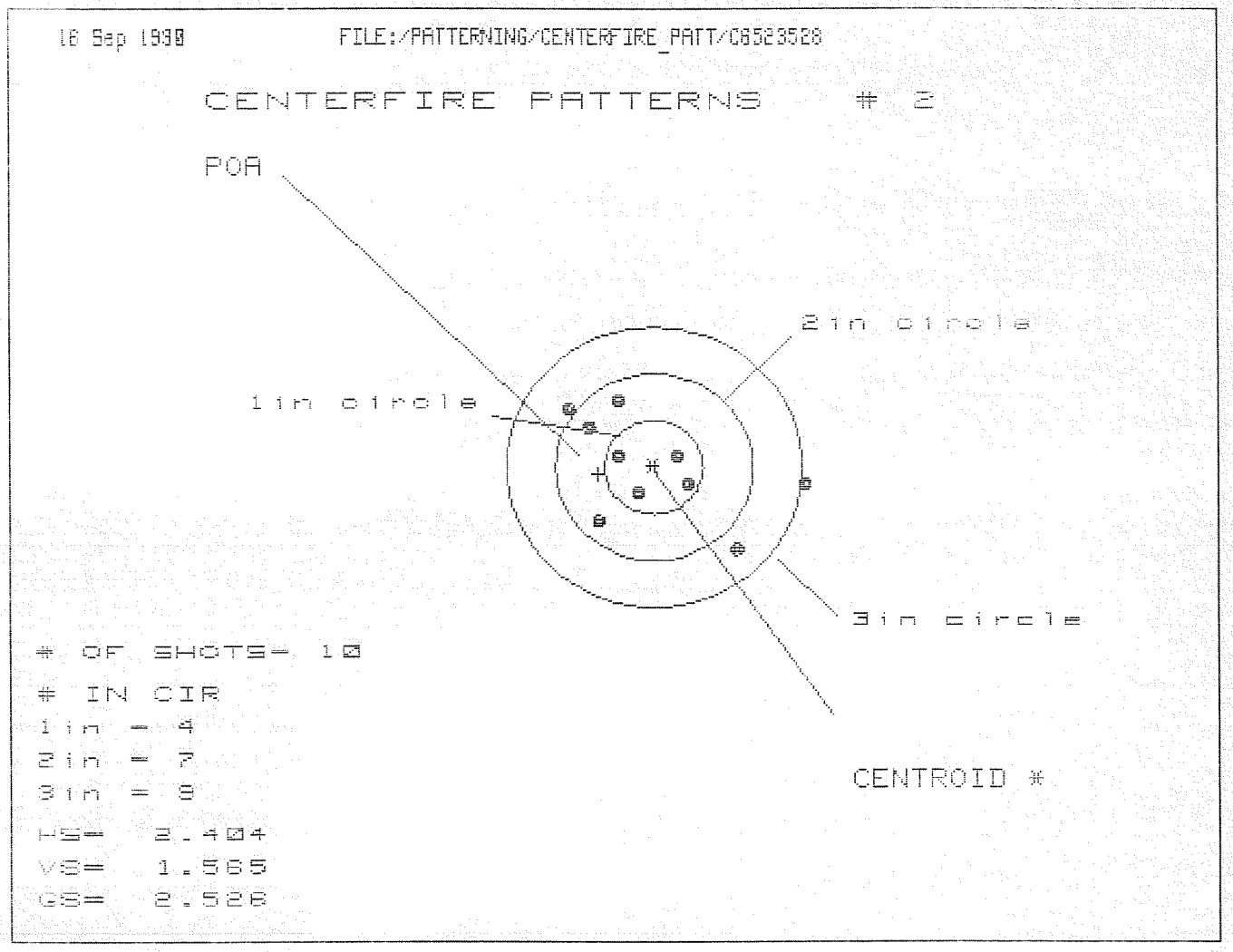


THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0894
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1436
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .169155

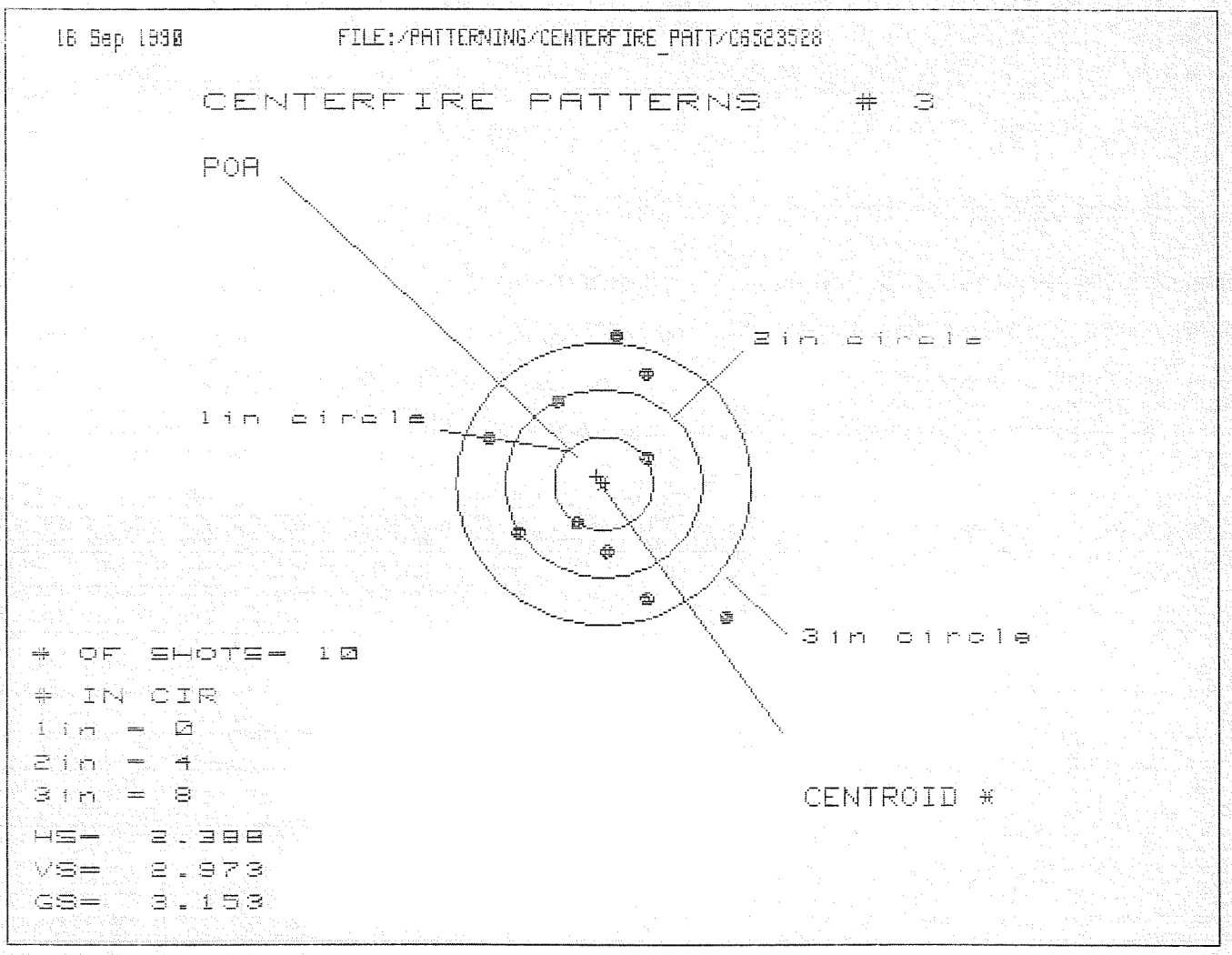
THE AMR FOR THIS RIFLE IS: 1.02



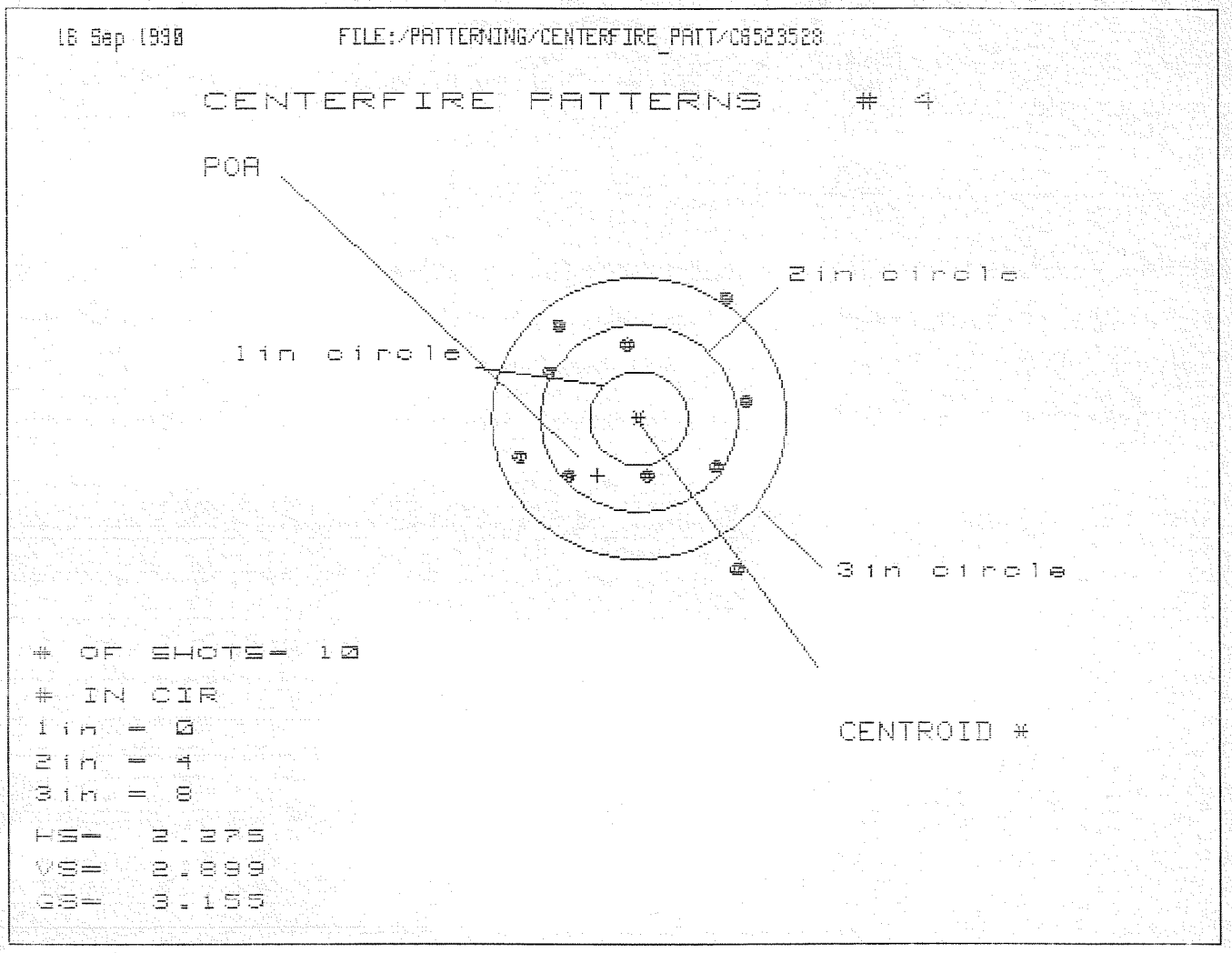
PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.609	1.388	1.107
MINIMUM X	:	-1.987	-1.415	-1.241
MAXIMUM Y	:	1.049	.980	.876
MINIMUM Y	:	-1.026	-1.096	-1.200
CENTROID X	:	-.290	-.069	-.243
CENTROID Y	:	.210	.279	.383
POA TO CENTROID in.	:	.358	.287	.454
MIN RADIUS	:	.312	.317	.292
MEAN RADIUS	:	1.082	.944	.842
MAX RADIUS	:	2.082	1.619	1.403
HORIZONTAL SPREAD	:	3.596	2.803	2.348
VERTICAL SPREAD	:	2.076	2.076	2.076
EXTREME SPREAD	:	3.599	3.224	2.705
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	



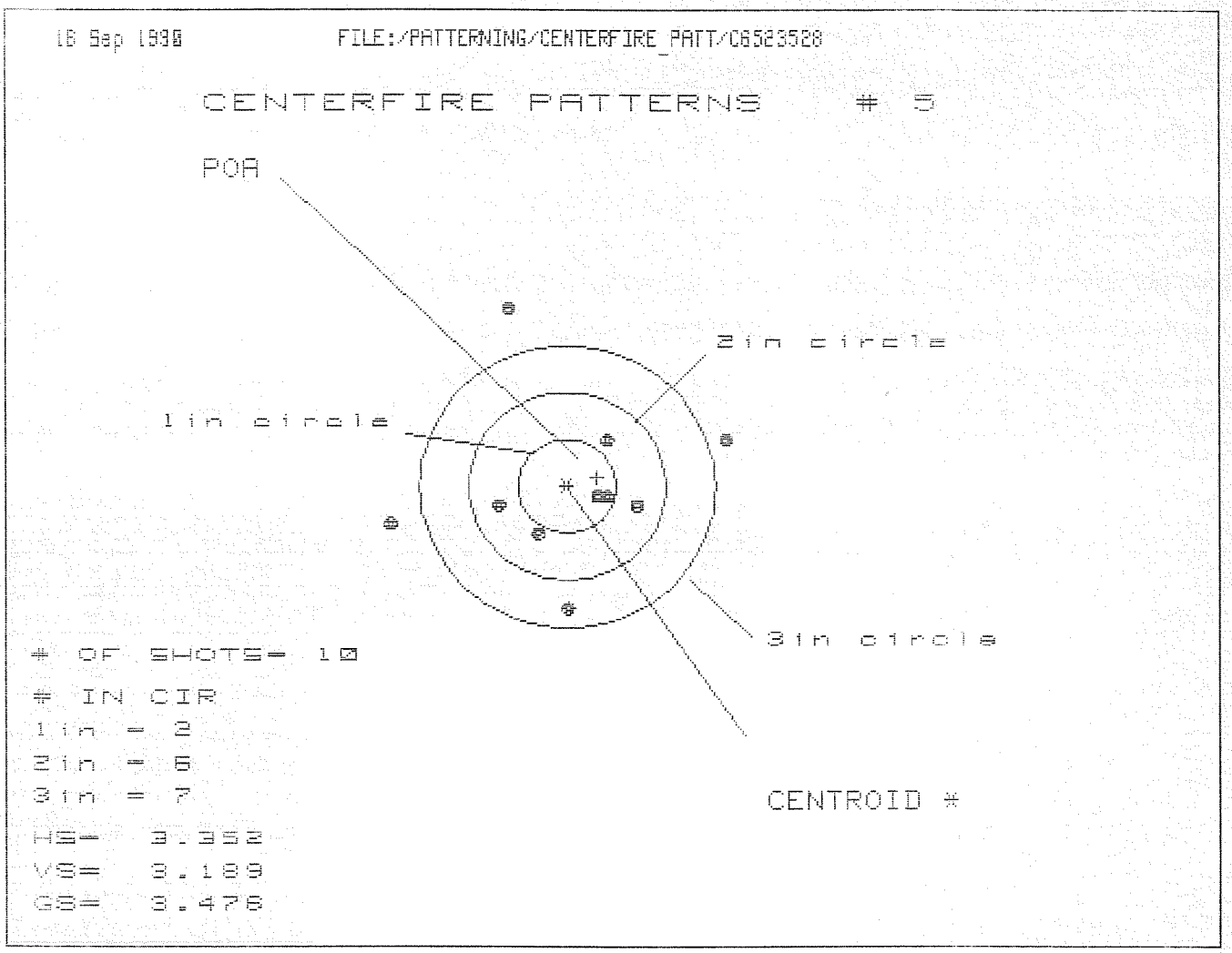
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.545	.969	.641
MINIMUM X	:	-.859	-.687	-.566
MAXIMUM Y	:	.733	.713	.606
MINIMUM Y	:	-.832	-.852	-.701
CENTROID X	:	.561	.389	.268
CENTROID Y	:	.076	.096	.203
POA TO CENTROID in.	:	.566	.401	.336
MIN RADIUS	:	.257	.250	.116
MEAN RADIUS	:	.744	.630	.528
MAX RADIUS	:	1.555	1.290	.737
HORIZONTAL SPREAD	:	2.404	1.656	1.207
VERTICAL SPREAD	:	1.565	1.565	1.307
EXTREME SPREAD	:	2.526	2.189	1.435
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	



PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.225	.608	.647
MINIMUM X	:	-1.163	-1.027	-.988
MAXIMUM Y	:	1.528	1.367	1.201
MINIMUM Y	:	-1.445	-1.405	-1.234
CENTROID X	:	.065	-.071	-.110
CENTROID Y	:	-.077	.084	-.087
POA TO CENTROID in.	:	.101	.110	.140
MIN RADIUS	:	.512	.593	.419
MEAN RADIUS	:	1.107	1.007	.936
MAX RADIUS	:	1.895	1.527	1.389
HORIZONTAL SPREAD	:	2.388	1.635	1.635
VERTICAL SPREAD	:	2.973	2.772	2.435
EXTREME SPREAD	:	3.153	2.787	2.435
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	



PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.069	1.175	1.302
MINIMUM X	:	-1.206	-1.100	-.973
MAXIMUM Y	:	1.304	1.127	.990
MINIMUM Y	:	-1.595	-.835	-.694
CENTROID X	:	.417	.311	.183
CENTROID Y	:	.609	.786	.645
POA TO CENTROID in.	:	.738	.845	.671
MIN RADIUS	:	.590	.585	.691
MEAN RADIUS	:	1.145	1.051	.973
MAX RADIUS	:	1.860	1.519	1.309
HORIZONTAL SPREAD	:	2.275	2.275	2.275
VERTICAL SPREAD	:	2.899	1.962	1.684
EXTREME SPREAD	:	3.155	2.719	2.344
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	



PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.579	1.510	1.279
MINIMUM X	:	-1.773	-1.842	-1.034
MAXIMUM Y	:	1.875	.684	.654
MINIMUM Y	:	-1.314	-1.106	-1.136
CENTROID X	:	-.306	-.237	-.007
CENTROID Y	:	-.100	-.308	-.278
POA TO CENTROID in.	:	.322	.388	.278
MIN RADIUS	:	.338	.304	.124
MEAN RADIUS	:	1.020	.880	.703
MAX RADIUS	:	1.975	1.857	1.437
HORIZONTAL SPREAD	:	3.352	3.352	2.313
VERTICAL SPREAD	:	3.189	1.790	1.790
EXTREME SPREAD	:	3.476	3.476	2.402
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

SWS TRIGGER PULL TEST

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

SERIAL NO. C6523528
DATE 9/15/90
TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.53	2.50	2.26	2.50	MIN. SETTING,
PULL #2	2.46	2.48	2.22	2.50	NO AVG. OF 5
PULL #3	2.53	2.50	2.35	2.18	READINGS ACCEPT-
PULL #4	2.38	2.55	2.37	2.19	ABLE LESS THAN 2#
PULL #5	2.20	2.35	2.18	2.06	
TOTAL	12.10	12.38	11.38	11.43	
AVG.	2.42	2.48	2.27	2.286	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.07	3.01		
PULL #2	3.14	2.90		
PULL #3	3.04	2.95		
PULL #4	3.03	2.80		
PULL #5	3.00	2.85		
TOTAL	15.28	14.51		
AVG.	3.06	2.90		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.35	4.30		4.09
PULL #2	4.36	4.15		4.09
PULL #3	4.35	4.22		4.14
PULL #4	4.36	4.14		4.21
PULL #5	4.24	4.18		4.14
TOTAL	21.66	20.99		20.67
AVG.	4.33	4.20		4.13

CAR - 70C

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523528

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		8-21-90	DB
600	Proof		8-21-90	DB
607	Check Headspace		8-21-90	DB
610	Dis-assemble Gun		8-21-90	DB
612	Magnaflux Barrel Action		8/21/90	KCR
	Magnaflux Bolt		8/21/90	KCR
615	Rollmark Caliber		8/21/90	GS
617	Drill and Tap Sight Holes		8/22/90	WB
618	Polish Barrel RB		8/23/90	WB
620	Apply Coatings (Barrel Action)		8-31-90	TB
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake		9/15/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/2	5 1/2	5 1/2			9/15/90	WB
	G) Safety Off Force	3	3	3			9/15/90	WB
	H) Trigger Pull Test & Retainability						9/15/90	WB
	I) Firing Pin Indent	.025	.025	.025			9/15/90	WB
	J) Assemble Stock						9/5/90	KA
	K) Assemble Swivel Studs						9/17/90	KB
	L) Attach Front and Rear Sight Assemblies						9/15/90	KA
	M) Iron Sight Alignment						9/15/90	KA
	N) Detach Front & Rear Sights & place in numbered container						9/15/90	KA
	O) Attach Scope to Rifle						9/15/90	KA
	P) Detach & Attach Scope 20 Times						9/15/90	KA
640	Gallery Target & Test						9-16-90	DH
	A) Time						9-16-90	DH
	B) Malfunctions						9-16-90	DH
	C) Pierced Primers						9-16-90	DH
	D) Optical Clearity of Scope						9-16-90	DH
645	Inspect for Live Ammo						9-16-90	DH
655	Final Inspection A) Headspace						9/17/90	KB
	B) Trigger Pull	2.50	2.50	2.18	2.19	2.06	9-16-90	DH
	C) Function						9/17/90	KB
660	Pack						9-19-90	DH