C6348768

MODEL 700™ M24

Model SWS™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington®

Scope 0626

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348768

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10-9 89	RW
600	Proof		10-9 89	AC
607	Check Headspace		10-9 89	RW
610	Dis-assemble Gun		10-9 89	RW
612	Magnaflux Barrel Action		10/13/89	KCR
	Magnaflux Bolt		10/13/89	KCR
615	Rollmark Caliber		10/13/89	GS
7	Drill and Tap Sight Holes		10 1689	TB
618	Polish Barrel RB		10 1689	BT
620	Apply Coatings (Barrel Action)		10-27-89	TJ
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/30/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/30/89	RW
	C) Inspect Ejector Hole for Chamfer		10/30/89	RW
	D) Oil Firing Pin Ass'y		10/30/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11/1/89	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			11/1/89	
	G) Safety Off Force	3	3	3			11/1/89	
	H) Trigger Pull Test & Retainability						11/1/89	
	I) Firing Pin Indent	.022	.021	.0215			11/1/89	
	J) Assemble Stock						11/2/89	
	K) Assemble Swivel Studs						11/2/89	
	L) Attach Front and Rear Sight Assemblies						11/2/89	
	M) Iron Sight Alignment						11/2/89	
	N) Detach Front & Rear Sights & place in numbered container						11/2/89	
	O) Attach Scope to Rifle						11/2/89	
	P) Detach & Attach Scope 20 Times						11/2/89	
640	Gallery Target & Test						11-3-89	DH
	A) Time						11-3-89	DH
	B) Malfunctions						11-3-89	DH
	C) Pierced Primers						11-3-89	DH
	D) Optical Clearity of Scope						11-3-89	DH
645	Inspect for Live Ammo						11-3-89	DH
655	Final Inspection A) Headspace						11/20/89	
	B) Trigger Pull	237	254	244	245	240	11/20/89	
	C) Function						11/20/89	
660	Pack						11/20/89	

SWS TRIGGER PULL TEST

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

SERIAL NO. C6348768

DATE 4-6-90

TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.47	2.37		2.36	MIN. SETTING,
PULL #2	2.40	2.31		2.31	NO AVG. OF 5
PULL #3	2.49	2.31		2.30	READINGS ACCEPT-
PULL #4	2.53	2.36		2.34	ABLE LESS THAN 2#
PULL #5	2.54	2.33		2.40	
TOTAL	12.43	11.68		11.71	
AVG.	2.486	2.336		2.342	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.51	3.50		
PULL #2	3.47	3.51		
PULL #3	3.55	3.49		
PULL #4	3.45	3.56		
PULL #5	3.55	3.53		
TOTAL	17.53	17.59		
AVG.	3.506	3.518		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.32	4.27		
PULL #2	4.20	4.24		
PULL #3	4.24	4.24		
PULL #4	4.28	4.17		
PULL #5	4.24	4.32		
TOTAL	21.28	21.24		
AVG.	4.256	4.248		

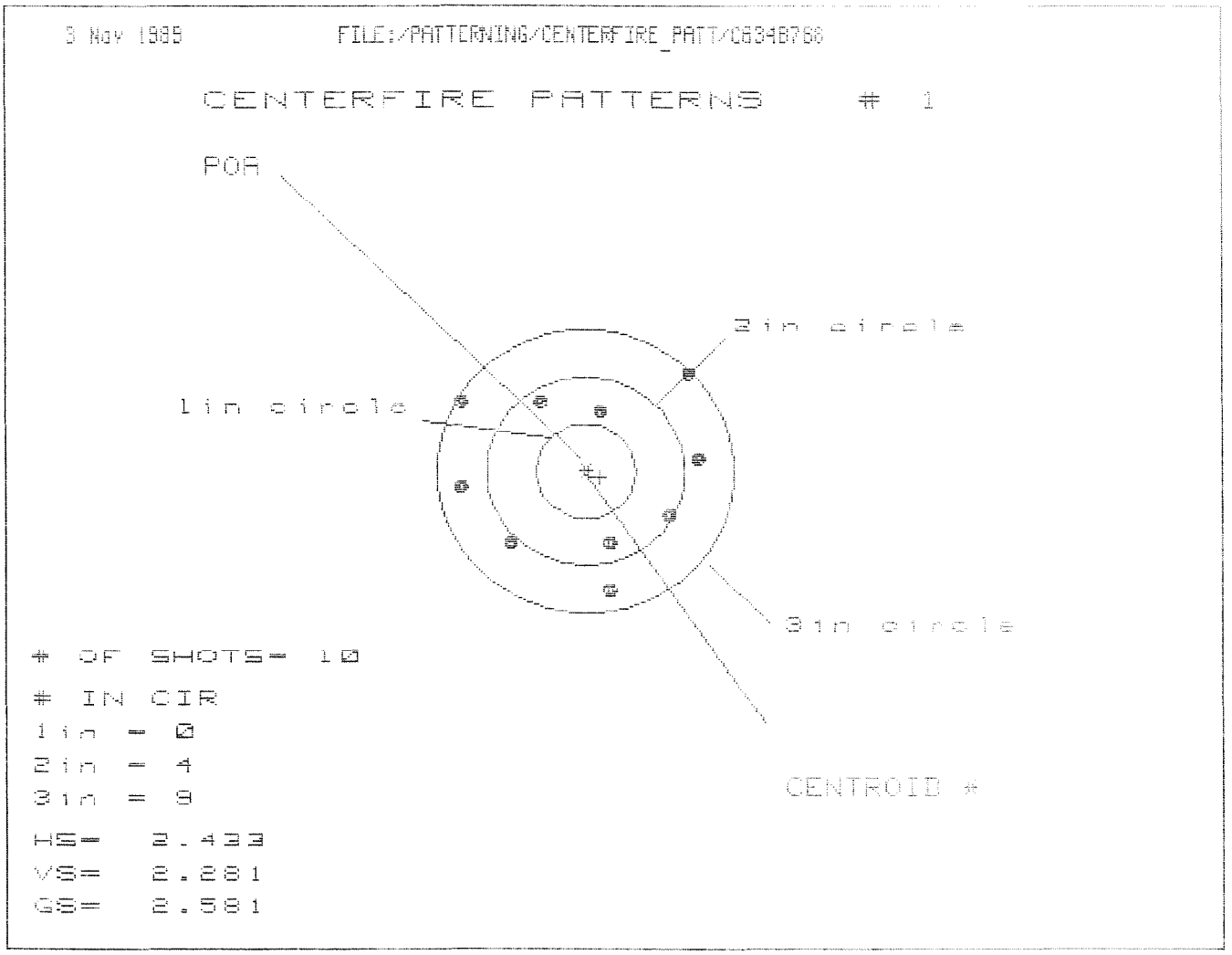
CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348768
3 Nov 1989

CENTROIDAL DISTANCES

0	TO	1	.151924
1	TO	2	.283544
1	TO	3	.132925
1	TO	4	.221461
1	TO	5	.262406

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.169
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0936
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .140678

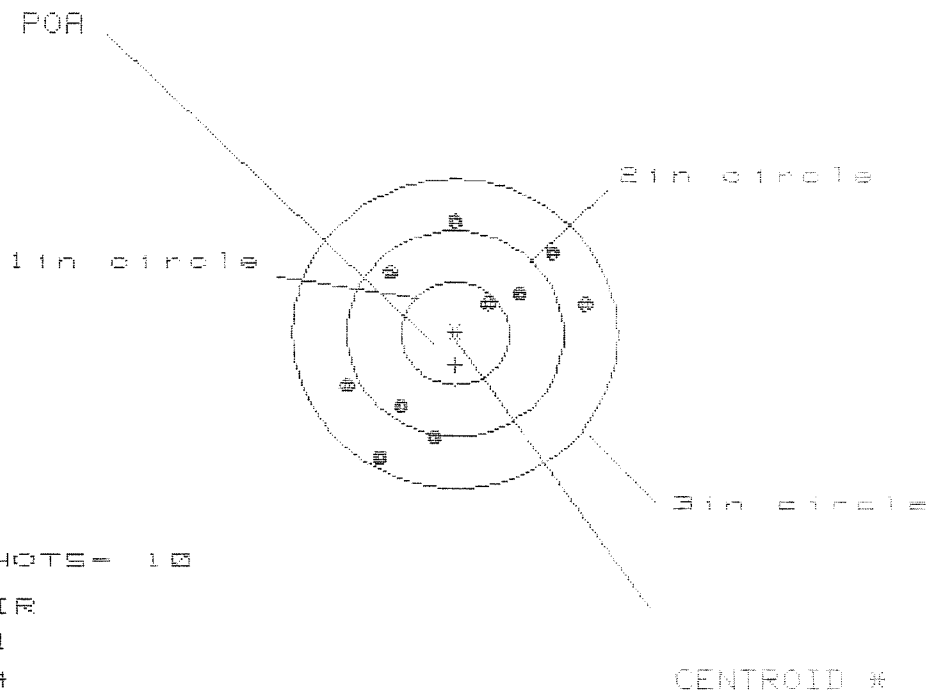
THE AMR FOR THIS RIFLE IS: .996



PATTERN #	:	[redacted]		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.134	.990	1.106
MINIMUM X	:	-1.299	-1.362	-1.246
MAXIMUM Y	:	1.034	1.121	.992
MINIMUM Y	:	-1.247	-1.160	-1.020
CENTROID X	:	-.140	.004	-.112
CENTROID Y	:	.059	-.028	-.168
POA TO CENTROID in.	:	.152	.028	.202
MIN RADIUS	:	.623	.639	.548
MEAN RADIUS	:	1.089	1.025	.959
MAX RADIUS	:	1.517	1.458	1.248
HORIZONTAL SPREAD	:	2.433	2.352	2.352
VERTICAL SPREAD	:	2.281	2.281	2.012
EXTREME SPREAD	:	2.581	2.581	2.365
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

3 Nov 1999 FILE:/PATTERNING/CENTERFIRE_PATT/CG84B?B0

CENTERFIRE PATTERNS # 2

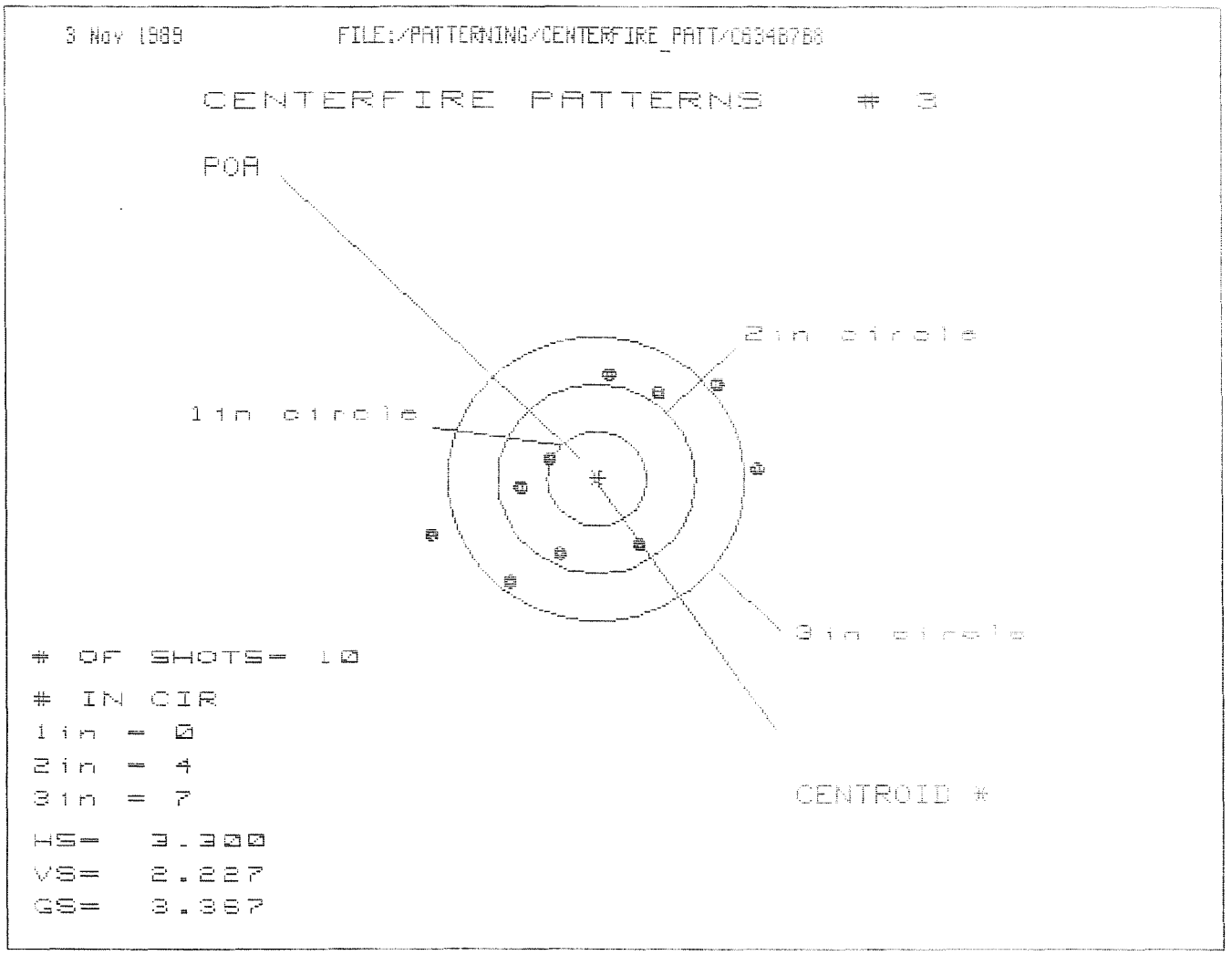


OF SHOTS= 10

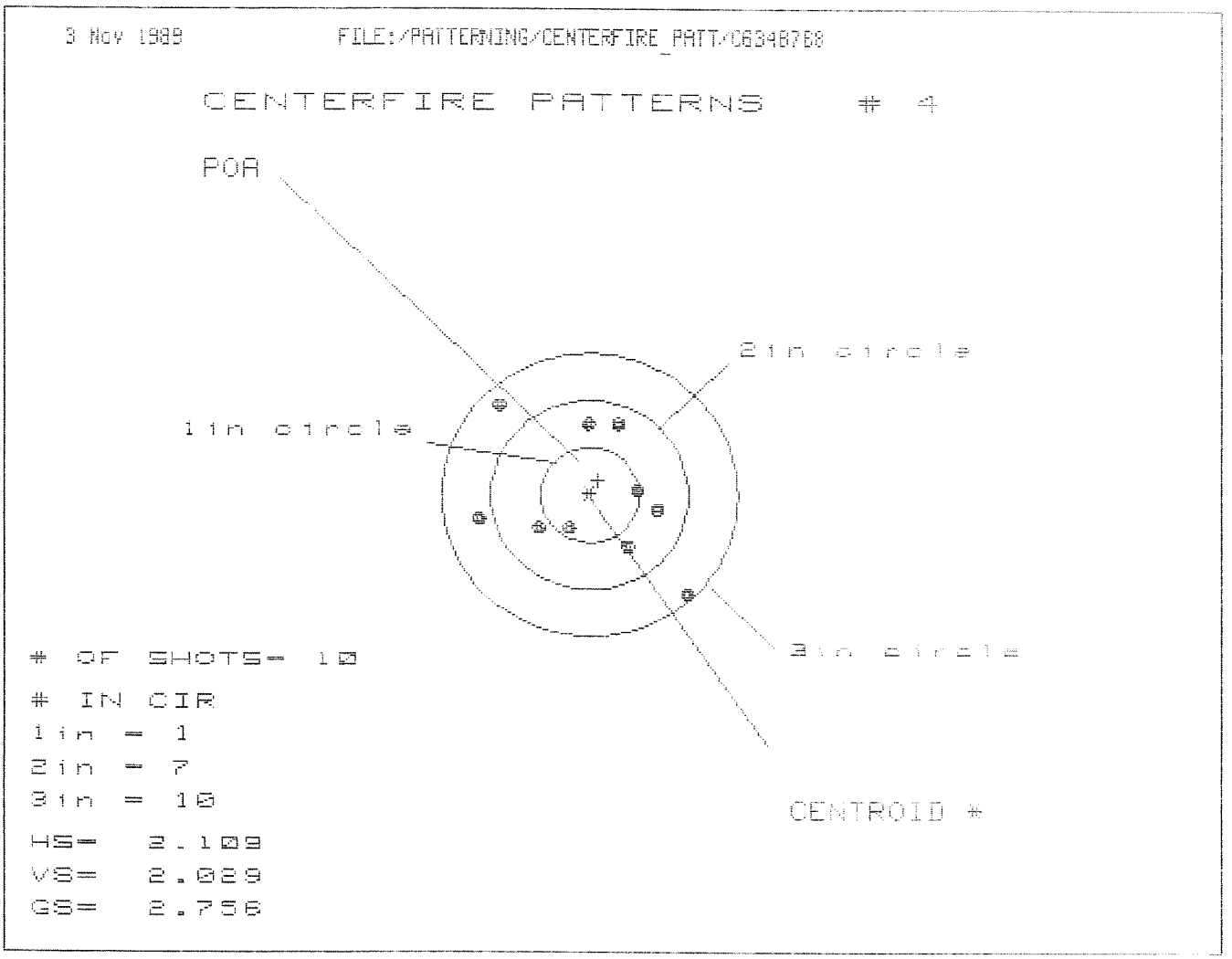
# IN CIR
1in = 1
2in = 4
3in = 10

HS= 2.111
VS= 2.267
GS= 2.570

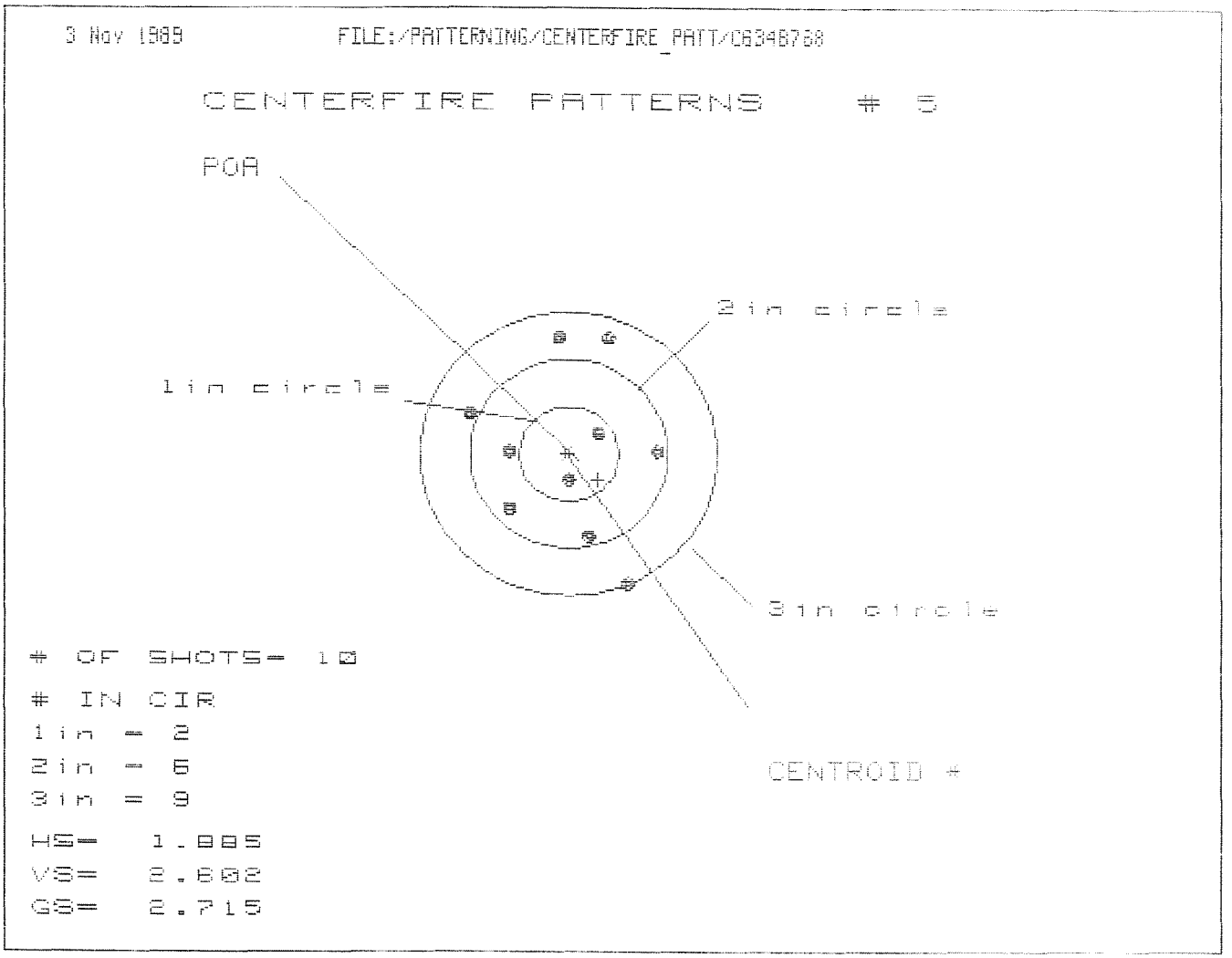
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.157	1.076	1.176
MINIMUM X	:	-.954	-1.035	-.935
MAXIMUM Y	:	1.085	.953	1.039
MINIMUM Y	:	-1.182	-1.117	-1.031
CENTROID X	:	.001	.082	-.018
CENTROID Y	:	.305	.437	.351
POA TO CENTROID in.	:	.305	.444	.352
MIN RADIUS	:	.440	.299	.429
MEAN RADIUS	:	.992	.921	.913
MAX RADIUS	:	1.392	1.228	1.197
HORIZONTAL SPREAD	:	2.111	2.111	2.111
VERTICAL SPREAD	:	2.267	2.070	2.070
EXTREME SPREAD	:	2.570	2.275	2.257
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	



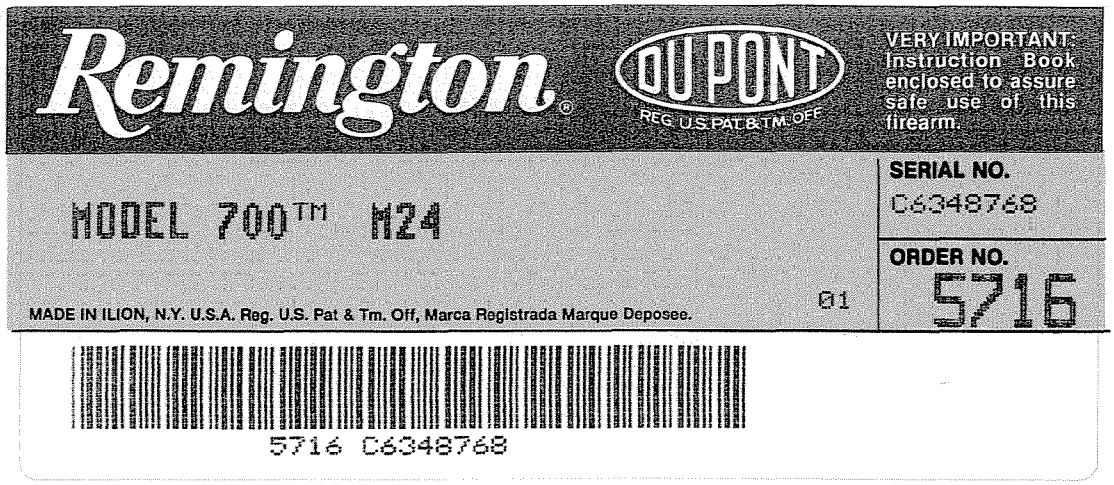
PATTERN #	:	[redacted]		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.600	1.411	1.544
MINIMUM X	:	-1.700	-1.030	-.897
MAXIMUM Y	:	1.113	1.046	1.165
MINIMUM Y	:	-1.114	-1.181	-1.062
CENTROID X	:	-.027	.162	.029
CENTROID Y	:	-.011	.056	-.063
POA TO CENTROID in.	:	.029	.171	.069
MIN RADIUS	:	.518	.684	.589
MEAN RADIUS	:	1.164	1.099	1.031
MAX RADIUS	:	1.804	1.567	1.548
HORIZONTAL SPREAD	:	3.300	2.441	2.441
VERTICAL SPREAD	:	2.227	2.227	2.227
EXTREME SPREAD	:	3.367	2.986	2.710
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	



PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.953	.771	.670
MINIMUM X	:	-1.156	-1.050	-1.151
MAXIMUM Y	:	.968	.850	.786
MINIMUM Y	:	-1.062	-.682	-.576
CENTROID X	:	-.083	-.189	-.088
CENTROID Y	:	-.155	-.038	-.144
POA TO CENTROID in.	:	.176	.193	.169
MIN RADIUS	:	.348	.424	.355
MEAN RADIUS	:	.842	.783	.709
MAX RADIUS	:	1.427	1.171	1.170
HORIZONTAL SPREAD	:	2.109	1.821	1.821
VERTICAL SPREAD	:	2.029	1.532	1.362
EXTREME SPREAD	:	2.756	2.012	1.822
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	



PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.911	.981	1.035
MINIMUM X	:	-.974	-.904	-.850
MAXIMUM Y	:	1.202	1.046	1.176
MINIMUM Y	:	-1.400	-1.022	-.892
CENTROID X	:	-.296	-.366	-.420
CENTROID Y	:	.270	.426	.296
POA TO CENTROID in.	:	.401	.561	.514
MIN RADIUS	:	.285	.335	.348
MEAN RADIUS	:	.893	.823	.766
MAX RADIUS	:	1.535	1.125	1.176
HORIZONTAL SPREAD	:	1.885	1.885	1.885
VERTICAL SPREAD	:	2.602	2.068	2.068
EXTREME SPREAD	:	2.715	2.090	2.090
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	


Remington
DU PONT
REG. U.S. PAT. & TM. OFF.
VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700™ M24
SERIAL NO.
C6348768
ORDER NO.
5716
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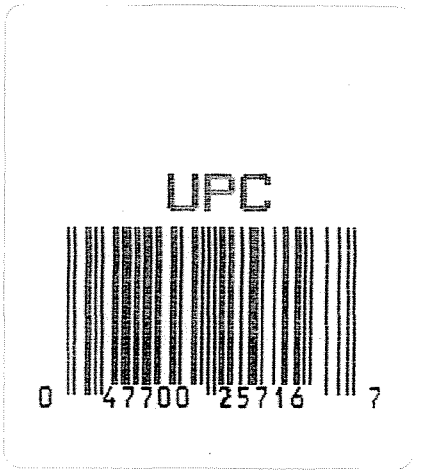
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