C6649224

MODEL 700™ M24

Model SWS ™

Action

Barrel Length

Capacity

Order No. 516

*Includes 1 in chamber.

Remington

M2400066683

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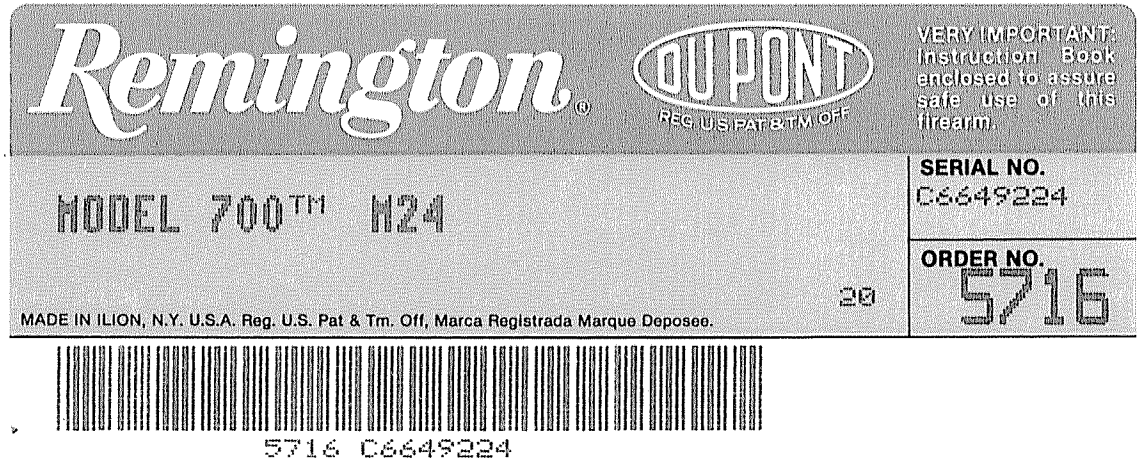

M2400066684

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649224

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 25	9 1	
600	Proof	6 25	9 1	
607	Check Headspace	6 25	9 1	
610	Dis-assemble Gun	6 25	9 1	
612	Magnaflux Barrel Action	JUL	1 1991	KR
	Magnaflux Bolt	JUL	1 1991	KR
615	Rollmark Caliber	JUL	1 1991	
617	Drill and Tap Sight Holes	JUL	1 1991	
618	Polish Barrel	JUL	2 1991	
620	Apply Coatings (Barrel Action)		8-27-91	
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/27/91	
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/27/91	
	C) Inspect Ejector Hole for Chamfer		8/27/91	
	D) Oil Firing Pin Ass'y		8/27/91	
	E) Adjust Trigger Pull to Min Setting and Stake		8/28/91	

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op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8-28-91	DH
	G) Safety Off Force	4	4	4			8-28-91	DH
	H) Trigger Pull Test & Retainability						8/28/91	DH
	I) Firing Pin Indent	.022	.021	.022			8-28-91	DH
	J) Assemble Stock						8/29/91	RW
	K) Assemble Swivel Studs						8-3-91	DH
	L) Attach Front and Rear Sight Assemblies						8/29/91	RW
	M) Iron Sight Alignment						8/29/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/29/91	RW
	O) Attach Scope to Rifle						8/29/91	RW
	P) Detach & Attach Scope 20 Times						8/29/91	RW
640	Gallery Target & Test						8/29/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clearity of Scope							KT
645	Inspect for Live Ammo						8/29/91	KT
655	Final Inspection A) Headspace						8-3-91	DH
	B) Trigger Pull	2.56	2.69	2.75	2.75	2.59	8-3-91	DH
	C) Function						8-3-91	DH
660	Pack						9-18-91	[illegible]

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TIMI N.A

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6649224

DATE 8/28/91

TESTER JC

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.54	2.52	2.50	2.56	MIN. SETTING,
PULL #2	2.56	2.53	2.55	2.69	NO AVG. OF 5
PULL #3	2.53	2.39	2.49	2.75	READINGS ACCEPT-
PULL #4	2.58	2.62	2.44	2.75	ABLE LESS THAN 2#
PULL #5	2.49	2.54	2.52	2.59	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.47	3.36		
PULL #2	3.32	3.33		
PULL #3	3.41	3.30		
PULL #4	3.34	3.29		
PULL #5	3.25	3.27		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.25	4.35		4.47
PULL #2	4.46	4.52		4.44
PULL #3	4.40	4.48		4.33
PULL #4	4.41	4.38		4.32
PULL #5	4.49	4.40		4.41
TOTAL				
AVG.				

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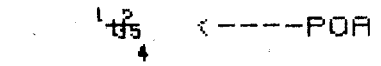
CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649224
29 Aug 1991

CENTROIDAL DISTANCES

Ø	TO	1	.320975
1	TO	2	.50946
1	TO	3	.482121
1	TO	4	1.02034
1	TO	5	.712475



THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2254
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0418
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .229243

THE AMR FOR THIS RIFLE IS: 1.128

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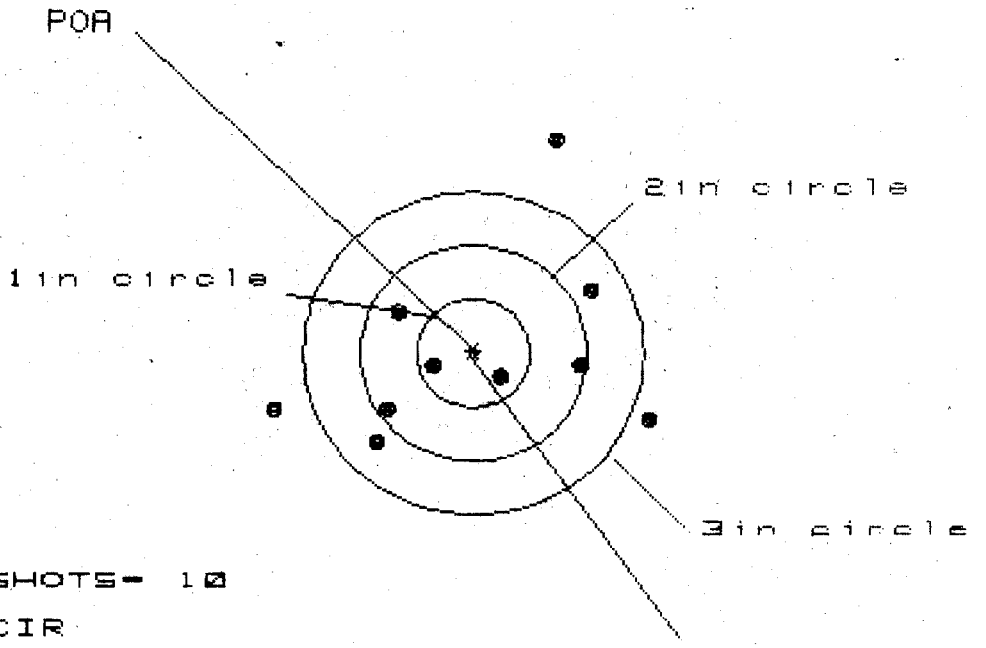
29 Aug 1991 FILE:/PATTERNING/CENTERFIRE_PATT/C6849224

CENTERFIRE PATTERNS # 1



# OF SHOTS= 10
# IN CIR
1in = 2
2in = 5
3in = 7
HS= 3.347
VS= 2.785
GS= 3.554

PATTERN # : [redacted]

SHOTS (BEST OF) :	10	9	8
MAXIMUM X :	1.539	1.616	1.400
MINIMUM X :	-1.808	-1.731	-.973
MAXIMUM Y :	1.973	.786	.745
MINIMUM Y :	-.812	-.593	-.634
CENTROID X :	-.241	-.318	-.102
CENTROID Y :	.212	-.007	.034
POA TO CENTROID in.:	.321	.318	.107
MIN RADIUS :	.352	.312	.143
MEAN RADIUS :	1.128	.995	.890
MAX RADIUS :	2.093	1.761	1.454
HORIZONTAL SPREAD :	3.347	3.347	2.373
VERTICAL SPREAD :	2.785	1.379	1.379
EXTREME SPREAD :	3.554	3.347	2.385

NUMBER IN ONE INCH CIRCLE = 2
NUMBER IN TWO INCH CIRCLE = 5
NUMBER IN THREE INCH CIRCLE = 7

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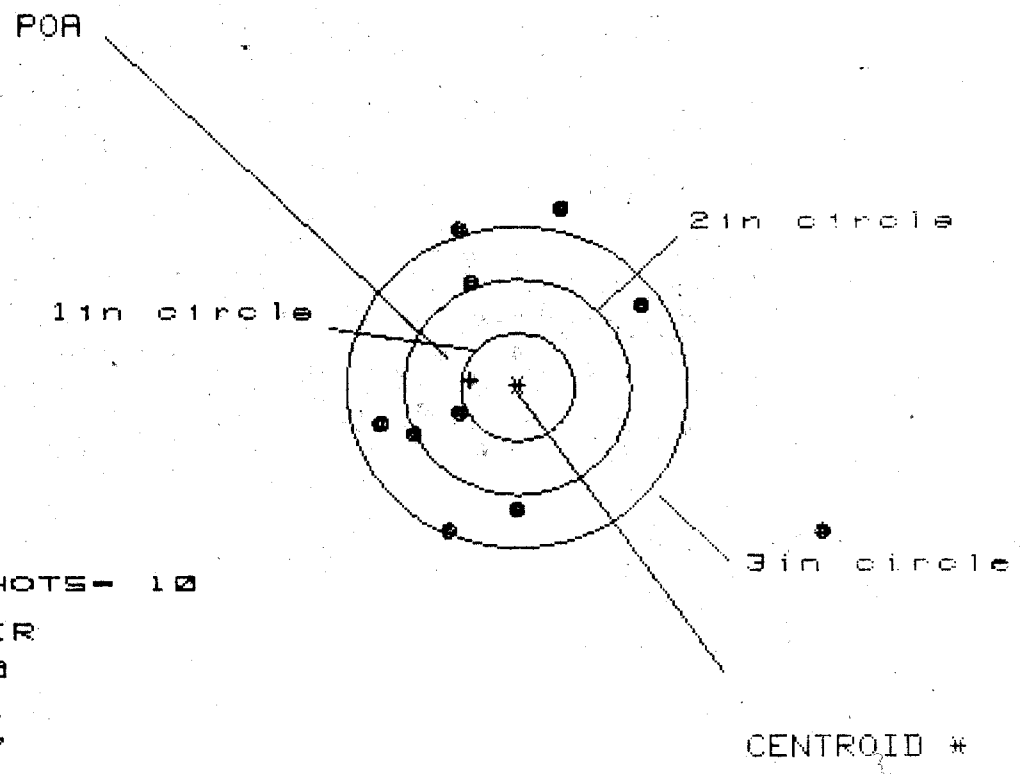
29 Aug 1991 FILE:/PATTERNING/CENTERFIRE_PATT/C6649224

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

# IN CIR
1in = 0
2in = 1
3in = 7

HS= 3.898
VS= 3.048
GS= 4.289

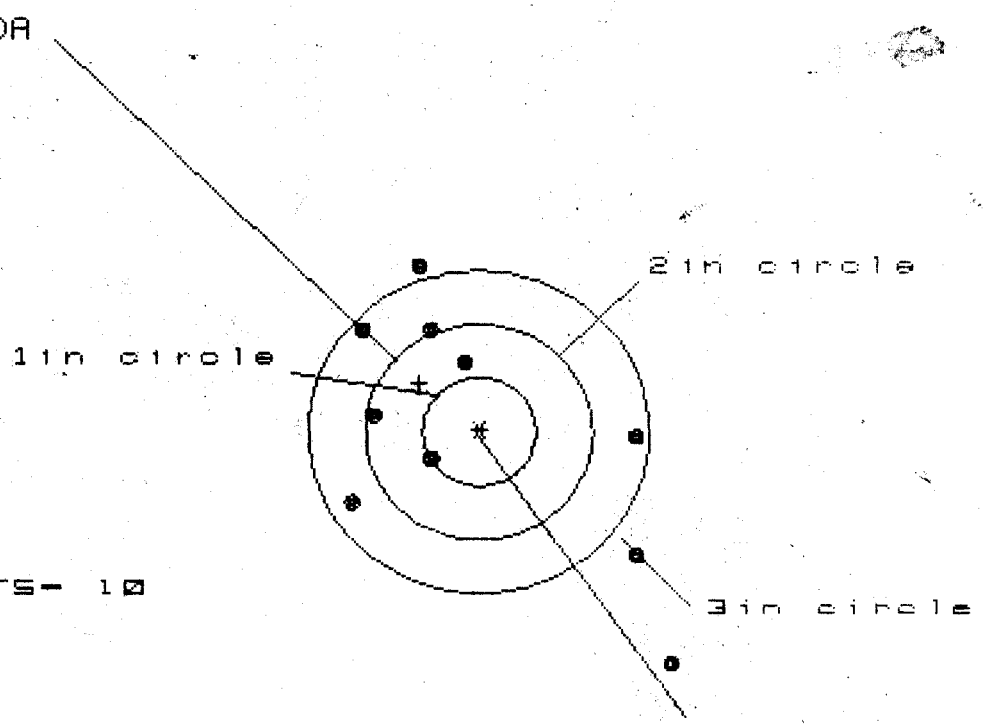
PATTERN # : [redacted]

SHOTS (BEST OF) :	10	9	8
MAXIMUM X :	2.721	1.424	1.507
MINIMUM X :	-1.177	-.874	-.791
MAXIMUM Y :	1.669	1.516	1.472
MINIMUM Y :	-1.379	-1.477	-1.287
CENTROID X :	.415	.112	.029
CENTROID Y :	-.066	.087	-.103
POA TO CENTROID in.:	.420	.142	.107
MIN RADIUS :	.565	.438	.233
MEAN RADIUS :	1.407	1.159	1.046
MAX RADIUS :	3.050	1.655	1.701
HORIZONTAL SPREAD :	3.898	2.298	2.298
VERTICAL SPREAD :	3.048	2.993	2.759
EXTREME SPREAD :	4.289	3.148	2.761

NUMBER IN ONE INCH CIRCLE = 0
NUMBER IN TWO INCH CIRCLE = 1
NUMBER IN THREE INCH CIRCLE = 7

29 Aug 1991 FILE:/PATTERNING/CENTERFIRE_PATT/C6849224

CENTERFIRE PATTERNS # 4



\# OF SHOTS= 10
\# IN CIR
1in = 1
2in = 3
3in = 7
HS= 2.717
VS= 3.678
GS= 4.250

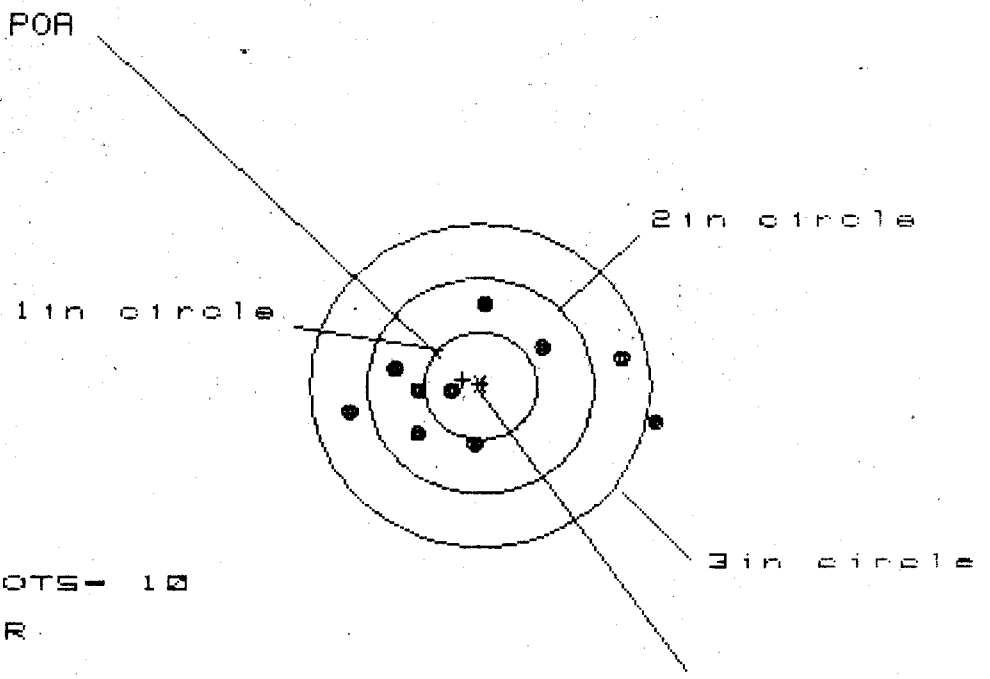
PATTERN # : [redacted]

SHOTS (BEST OF) :	10	9	8
MAXIMUM X :	1.635	1.563	1.756
MINIMUM X :	-1.082	-.900	-.707
MAXIMUM Y :	1.535	1.297	1.129
MINIMUM Y :	-2.143	-1.336	-1.089
CENTROID X :	.523	.341	.148
CENTROID Y :	-.454	-.216	-.049
POA TO CENTROID in.:	.692	.404	.156
MIN RADIUS :	.487	.422	.369
MEAN RADIUS :	1.314	1.080	.898
MAX RADIUS :	2.696	2.041	1.804
HORIZONTAL SPREAD :	2.717	2.463	2.463
VERTICAL SPREAD :	3.678	2.633	2.219
EXTREME SPREAD :	4.250	3.221	2.554

NUMBER IN ONE INCH CIRCLE = 1
NUMBER IN TWO INCH CIRCLE = 3
NUMBER IN THREE INCH CIRCLE = 7

29 Aug 1991 FILE:/PATTERNING/CENTERFIRE_PATT/C6B49224

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

# IN CIR
1in = 1
2in = 7
3in = 9

HS= 2.745
VS= 1.299
GS= 2.747

PATTERN # : [redacted]

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.587	1.419	.908
MINIMUM X	:	-1.158	-.981	-.804
MAXIMUM Y	:	.716	.681	.715
MINIMUM Y	:	-.583	-.618	-.584
CENTROID X	:	.155	-.022	-.199
CENTROID Y	:	-.063	-.028	-.062
POA TO CENTROID in.	:	.167	.036	.208
MIN RADIUS	:	.269	.118	.098
MEAN RADIUS	:	.840	.704	.565
MAX RADIUS	:	1.618	1.443	.987
HORIZONTAL SPREAD	:	2.745	2.400	1.712
VERTICAL SPREAD	:	1.299	1.299	1.299
EXTREME SPREAD	:	2.747	2.452	1.810

NUMBER IN ONE INCH CIRCLE = 1
NUMBER IN TWO INCH CIRCLE = 7
NUMBER IN THREE INCH CIRCLE = 9

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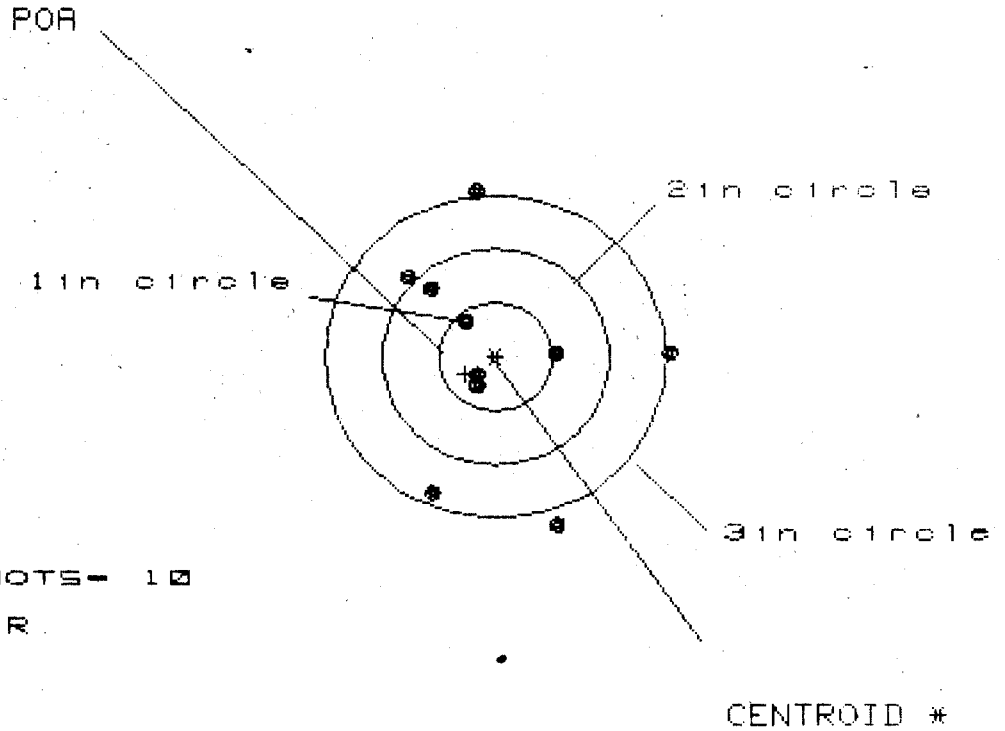
CENTERFIRE PATTERNS # 2



# OF SHOTS= 10
# IN CIR
1in = 3
2in = 5
3in = 7
HS= 2.320
VS= 3.075
GS= 3.151

PATTERN #	:	[redacted]		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.572	1.635	.774
MINIMUM X	:	-.748	-.685	-.481
MAXIMUM Y	:	1.502	1.328	1.315
MINIMUM Y	:	-1.573	-1.455	-1.468
CENTROID X	:	.266	.203	-.001
CENTROID Y	:	.162	.336	.349
POA TO CENTROID in.	:	.311	.393	.350
MIN RADIUS	:	.225	.248	.136
MEAN RADIUS	:	.950	.855	.726
MAX RADIUS	:	1.671	1.638	1.502
HORIZONTAL SPREAD	:	2.320	2.320	1.255
VERTICAL SPREAD	:	3.075	2.783	2.703
EXTREME SPREAD	:	3.151	2.820	2.620
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	