C661616

MODEL 700™ M24

Model SWS™

Action

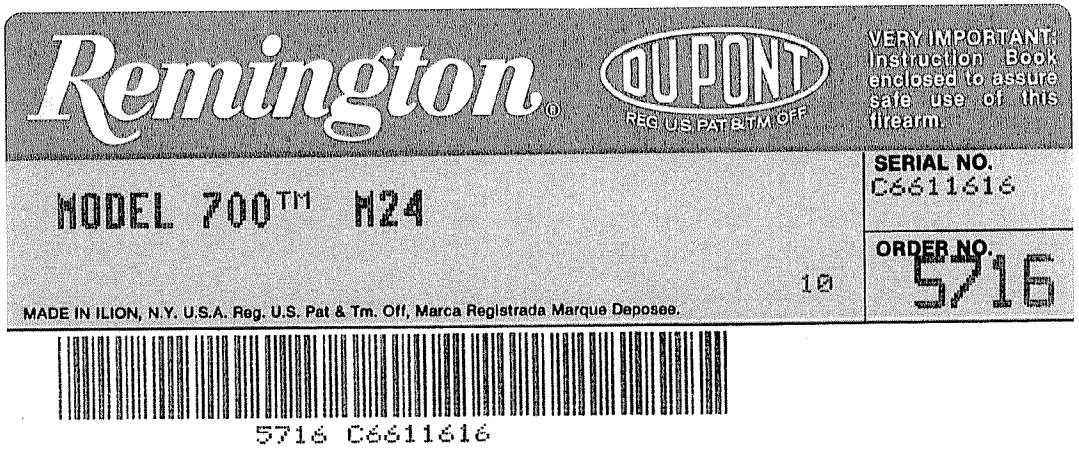
Barrel Length

Capacity

Order No. 576

*Includes 1 in chamber.

Remington®



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611616

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 28	91	RW
600	Proof	3 28	91	RW
607	Check Headspace	3 28	91	RW
610	Dis-assemble Gun	3 28	91	RW
612	Magnaflux Barrel Action	APR	2 1991	KR
	Magnaflux Bolt	APR	2 1991	"
615	Rollmark Caliber	APR	2 1991	DS
617	Drill and Tap Sight Holes	APR	5 1991	KB
618	Polish Barrel	APR	5 1991	WB
620	Apply Coatings (Barrel Action)		4-10-91	
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/10/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/10/91	RW
	C) Inspect Ejector Hole for Chamfer		4/10/91	RW
	D) Oil Firing Pin Ass'y		4/10/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4/16/91	

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			4-16-91	AC
	G) Safety Off Force	3	3	3			4-16-91	AC
	H) Trigger Pull Test & Retainability						4/16/91	JC
	I) Firing Pin Indent	.022	.022	.022			4-16-91	AC
	J) Assemble Stock						4/17/91	Rw
	K) Assemble Swivel Studs						5-13-91	DH
	L) Attach Front and Rear Sight Assemblies						4/17/91	Rw
	M) Iron Sight Alignment						4/17/91	Rw
	N) Detach Front & Rear Sights & place in numbered container						4/17/91	Rw
	O) Attach Scope to Rifle						4/17/91	Rw
	P) Detach & Attach Scope 20 Times						4/17/91	Rw
640	Gallery Target & Test						4/18/91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clearity of Scope						"	NF
645	Inspect for Live Ammo						4/18/91	NF
655	Final Inspection A) Headspace						5-13-91	DH
	B) Trigger Pull	2.59	2.22	2.26	2.30	2.30	5/16/91	JC
	C) Function						5-13-91	DH
660	Pack						6-20-91	NF

TEST	INIT.	ACTION TO CORRECT	ASSEM. #
PROOF		Ream Ejector Hole + New Ejector 100 Rd Test Needed	RW 4/19/91
TEST			
TGT			
PROOF		100 Rd test	
TEST	5-29-91	shot OK DH	
TGT			
PROOF		ENGINEER	
TEST			
TGT			
PROOF		ENGINEER	
TEST			
TGT			

MOD. _____ GA. _____ CAL. _____ GUN # 1616

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st		
NF	4/18	Ejector Sticks	Rw
	2nd		
	3rd		
	4th		
		FUNCTION RD 6654	Rev 1

SWS TRIGGER PULL TEST

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

SERIAL NO C661616
DATE 4/16/91
TESTER JJ

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.51	2.32	2.35	2.59	MIN. SETTING,
PULL #2	2.52	2.30	2.24	2.22	NO AVG. OF 5
PULL #3	2.44	2.22	2.36	2.26	READINGS ACCEPT-
PULL #4	2.36	2.31	2.46	2.30	ABLE LESS THAN 2#
PULL #5	2.27	2.24	2.28	2.30	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.37	3.39		
PULL #2	3.30	3.39		
PULL #3	3.26	3.29		
PULL #4	3.19	3.17		
PULL #5	3.18	3.20		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.27	4.24		4.45
PULL #2	4.26	4.34		4.47
PULL #3	4.20	4.35		4.49
PULL #4	4.25	4.43		4.50
PULL #5	4.22	4.41		4.49
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611616
18 Apr 1991

CENTROIDAL DISTANCES

0	TO	1	.06
1	TO	2	.0890225
1	TO	3	.252958
1	TO	4	.200823
1	TO	5	.082801

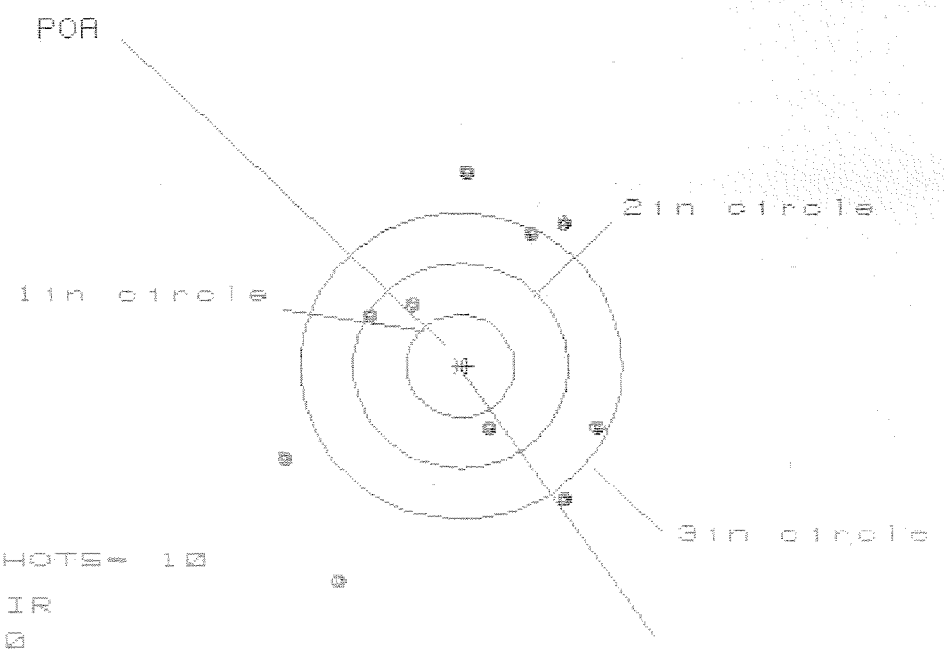
<----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0016
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .031
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0310413

THE AMR FOR THIS RIFLE IS: .9492

18 Apr 1991 FILE:/PATTERNING/CENTERFIRE_PATT/C8611618

CENTERFIRE PATTERNS # 1

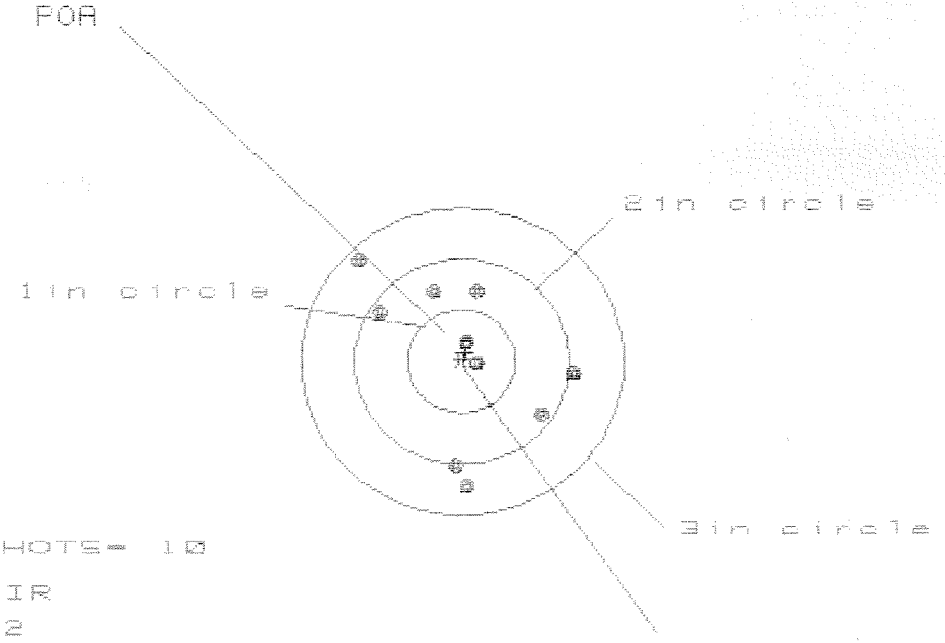


# OF SHOTS= 10
# IN CIR
1in = 0
2in = 3
3in = 5
HS= 2.874
VS= 3.944
GS= 4.114

PATTERN #	:	1	
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.212	1.085	.861
MINIMUM X	:	-1.662	-1.789	-1.179
MAXIMUM Y	:	1.865	1.634	1.489
MINIMUM Y	:	-2.079	-1.515	-1.660
CENTROID X	:	-.060	.067	.291
CENTROID Y	:	.000	.231	.376
POA TO CENTROID in.	:	.060	.241	.475
MIN RADIUS	:	.643	.664	.813
MEAN RADIUS	:	1.454	1.328	1.214
MAX RADIUS	:	2.374	2.131	1.778
HORIZONTAL SPREAD	:	2.874	2.874	2.040
VERTICAL SPREAD	:	3.944	3.149	3.149
EXTREME SPREAD	:	4.114	3.446	2.294
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		5	

18 Apr 1991 FILE:/PATTERNING/CENTERFIRE_PATT/CSG11618

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

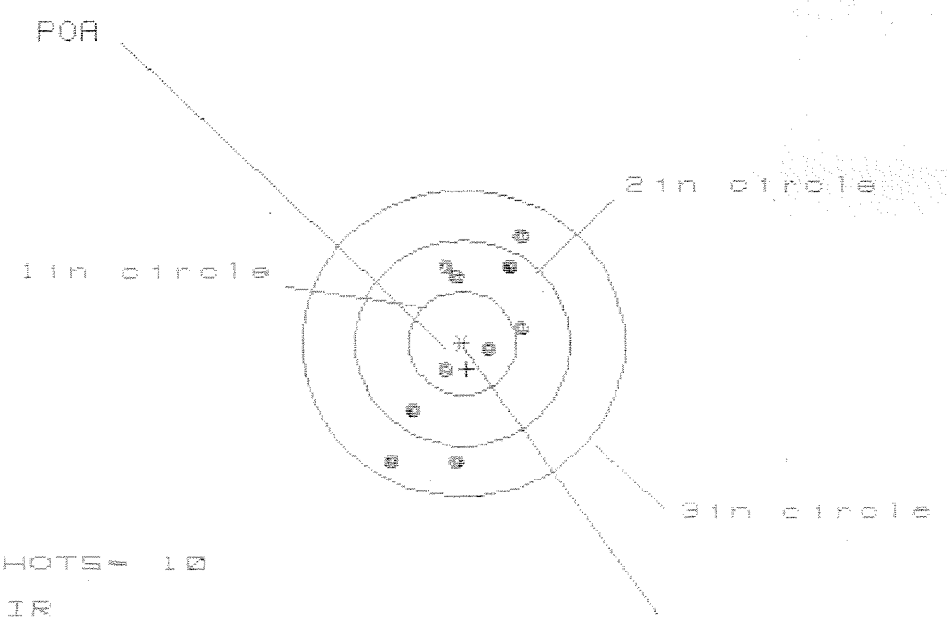
# IN CIR
1in = 2
2in = 6
3in = 10

HS= 1.977
VS= 2.201
GS= 2.406

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.022	.915	.904
MINIMUM X	:	-.956	-.892	-.903
MAXIMUM Y	:	.953	.816	.673
MINIMUM Y	:	-1.248	-1.142	-1.040
CENTROID X	:	-.037	.069	.080
CENTROID Y	:	-.086	-.192	-.049
POA TO CENTROID in.	:	.094	.204	.094
MIN RADIUS	:	.104	.057	.092
MEAN RADIUS	:	.818	.756	.684
MAX RADIUS	:	1.350	1.146	1.055
HORIZONTAL SPREAD	:	1.977	1.807	1.807
VERTICAL SPREAD	:	2.201	1.958	1.713
EXTREME SPREAD	:	2.406	1.975	1.913
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

18 Apr 1991 FILE:/PATTERNING/CENTERFIRE_PATT/CB811616

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 1.216

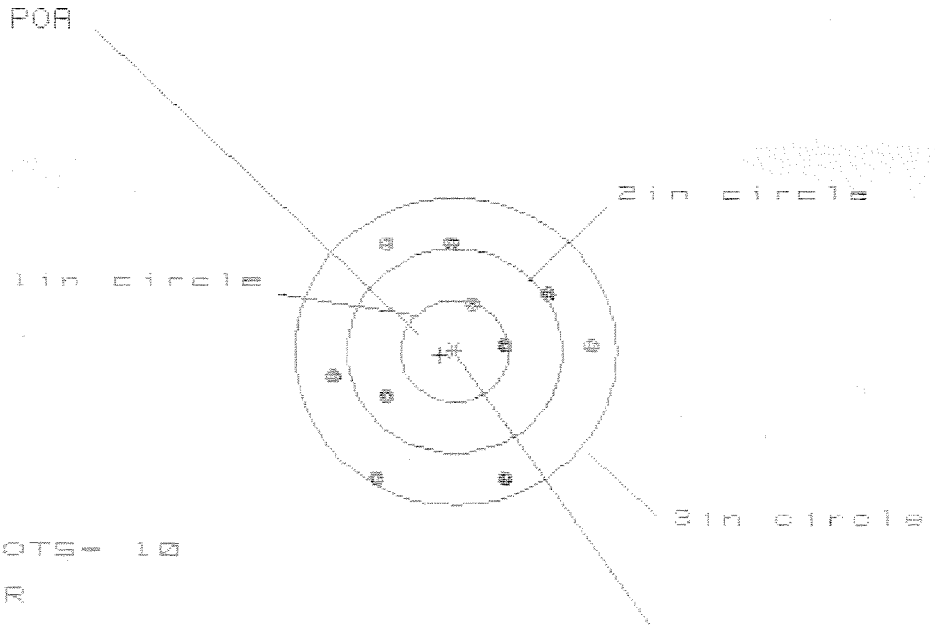
VS= 2.201

GS= 2.489

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.516	.439	.418
MINIMUM X	:	-.700	-.582	-.603
MAXIMUM Y	:	1.009	.879	.714
MINIMUM Y	:	-1.192	-1.322	-.941
CENTROID X	:	-.038	.039	.059
CENTROID Y	:	.252	.382	.547
POA TO CENTROID in.	:	.255	.384	.550
MIN RADIUS	:	.265	.252	.366
MEAN RADIUS	:	.785	.700	.600
MAX RADIUS	:	1.358	1.331	1.117
HORIZONTAL SPREAD	:	1.216	1.021	1.021
VERTICAL SPREAD	:	2.201	2.201	1.655
EXTREME SPREAD	:	2.489	2.281	1.945
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

18 Apr 1991 FILE:/PATTERNING/CENTERFIRE_PATT/C6B11618

CENTERFIRE PATTERNS # 4

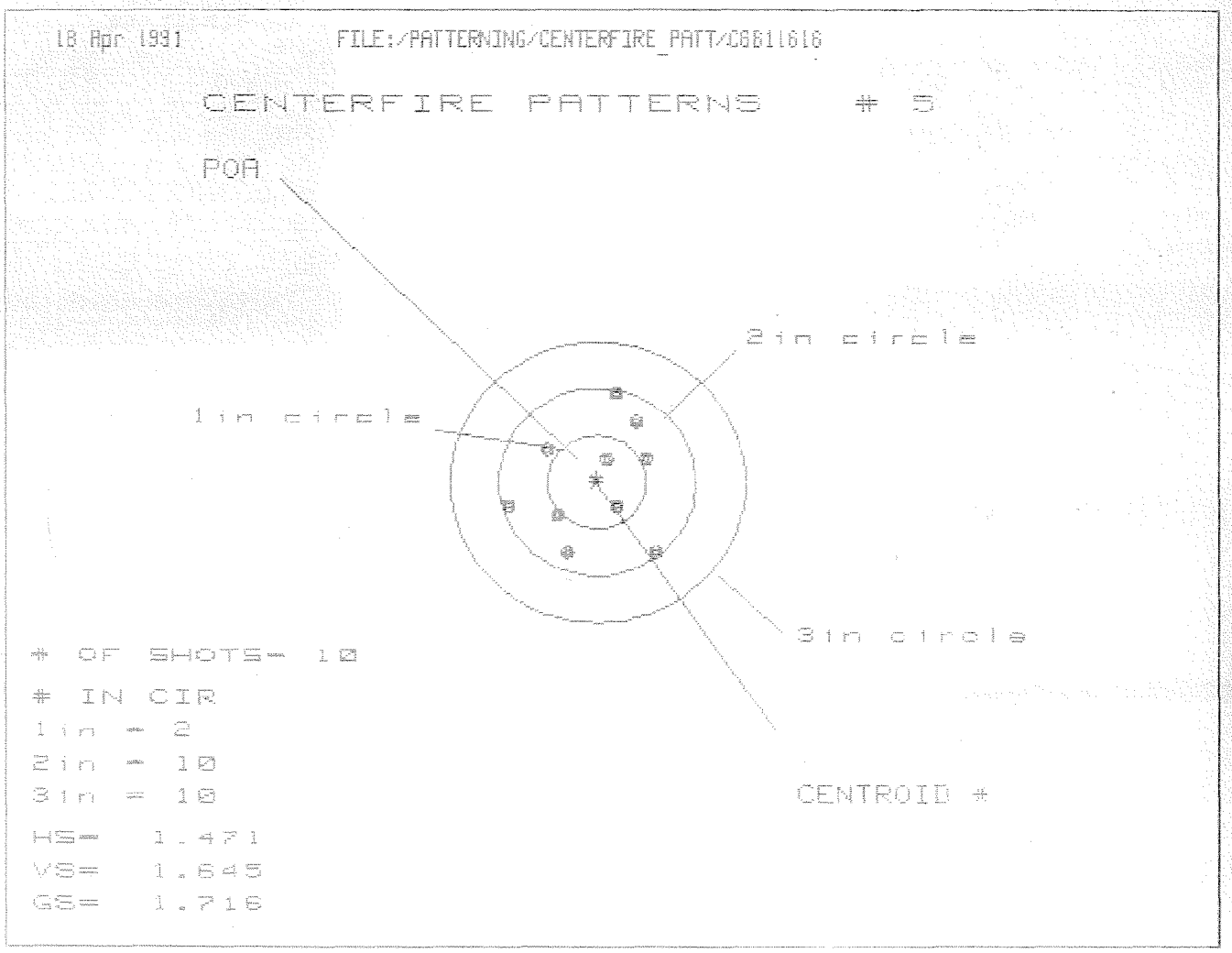


OF SHOTS= 10

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

HS= 2.413
VS= 2.326
GS= 2.511

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.267	1.186	1.229
MINIMUM X	:	-1.146	-1.227	-1.184
MAXIMUM Y	:	1.079	.943	.770
MINIMUM Y	:	-1.247	-1.383	-.798
CENTROID X	:	.137	.218	.175
CENTROID Y	:	.039	.176	.349
POA TO CENTROID in.	:	.142	.281	.390
MIN RADIUS	:	.452	.384	.258
MEAN RADIUS	:	1.029	.954	.871
MAX RADIUS	:	1.434	1.427	1.308
HORIZONTAL SPREAD	:	2.413	2.413	2.413
VERTICAL SPREAD	:	2.326	2.326	1.568
EXTREME SPREAD	:	2.511	2.511	2.430
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	:	.595	.620	.599
MINIMUM X	:	-.876	-.851	-.773
MAXIMUM Y	:	.909	.727	.651
MINIMUM Y	:	-.736	-.635	-.711
CENTROID X	:	.006	-.019	-.097
CENTROID Y	:	-.050	-.151	-.076
POA TO CENTROID in.	:	.050	.152	.123
MIN RADIUS	:	.246	.319	.319
MEAN RADIUS	:	.660	.625	.592
MAX RADIUS	:	.937	.866	.822
HORIZONTAL SPREAD	:	1.471	1.471	1.372
VERTICAL SPREAD	:	1.645	1.362	1.362
EXTREME SPREAD	:	1.716	1.553	1.524
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		10	
NUMBER IN THREE INCH CIRCLE	=		10	