C6349104

MODEL 700™ M24

Model SWS™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

Scope 0507

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349104

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10-9	89	RW
600	Proof	10-9	89	[illegible]
607	Check Headspace	10-9	89	RW
610	Dis-assemble Gun	[illegible]	89	RW
612	Magnaflux Barrel Action	10/31/89		KCR
	Magnaflux Bolt	10/31/89		KCR
615	Rollmark Caliber			
.7	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)		11-3-89	TJH
	Apply Coating (Bolt)			TJH
625	Final Assembly A) Clean inside of Bolt Assembly		11/6/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/6/89	RW
	C) Inspect Ejector Hole for Chamfer		11/6/89	RW
	D) Oil Firing Pin Ass'y		11/6/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11/6/89	RW

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			11-14-89	[illegible]
	G) Safety Off Force	3	3	3			11-14-89	[illegible]
	H) Trigger Pull Test & Retainability						14 Nov 89	[illegible]
	I) Firing Pin Indent	.0215	.021	.1021			11-14-89	[illegible]
	J) Assemble Stock						11/15/89	[illegible]
	K) Assemble Swivel Studs						11 Dec 89	[illegible]
	L) Attach Front and Rear Sight Assemblies						11/15/89	[illegible]
	M) Iron Sight Alignment						11/15/89	[illegible]
	N) Detach Front & Rear Sights & place in numbered container						11/15/89	[illegible]
	O) Attach Scope to Rifle						15 Nov 89	[illegible]
	P) Detach & Attach Scope 20 Times						15 Nov 89	[illegible]
640	Gallery Target & Test						11-17-89	DH
	A) Time						11-17-89	DH
	B) Malfunctions						11-17-89	DH
	C) Pierced Primers						11-17-89	DH
	D) Optical Clearity of Scope						11-17-89	DH
645	Inspect for Live Ammo						11-17-89	DH
655	Final Inspection A) Headspace						11 Dec 89	[illegible]
	B) Trigger Pull	248	223	240	267	236	11 Dec 89	[illegible]
	C) Function						11 Dec 89	[illegible]
660	Pack						15 Dec 89	[illegible]

SWS TRIGGER PULL TEST

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

SERIAL NO. C6349104
DATE 14 Mar 90
TESTER GDS

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.09	2.58		2.68	MIN. SETTING,
PULL #2	2.47	2.56		2.55	NO AVG. OF 5
PULL #3	2.50	2.58		2.71	READINGS ACCEPT-
PULL #4	2.49	2.58		2.60	ABLE LESS THAN 2#
PULL #5	2.56	2.48		2.56	
TOTAL	12.09	12.78			
AVG.	2.418	2.556			

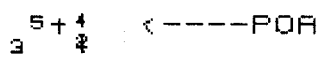
	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.53	3.42		—
PULL #2	3.49	3.45		
PULL #3	3.35	3.41		
PULL #4	3.48	3.48		
PULL #5	3.39	3.50		
TOTAL	17.24	17.26		
AVG.	3.448	3.452		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	3.97	3.95		
PULL #2	3.97	3.92		
PULL #3	3.93	3.98		
PULL #4	3.91	3.97		
PULL #5	3.94	4.01		
TOTAL	19.67	19.73		
AVG.	3.934	3.946		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349104
17 Nov 1989

CENTROIDAL DISTANCES

0	TO	1	.561528
1	TO	2	.0610082
1	TO	3	1.14753
1	TO	4	.454634
1	TO	5	.899177

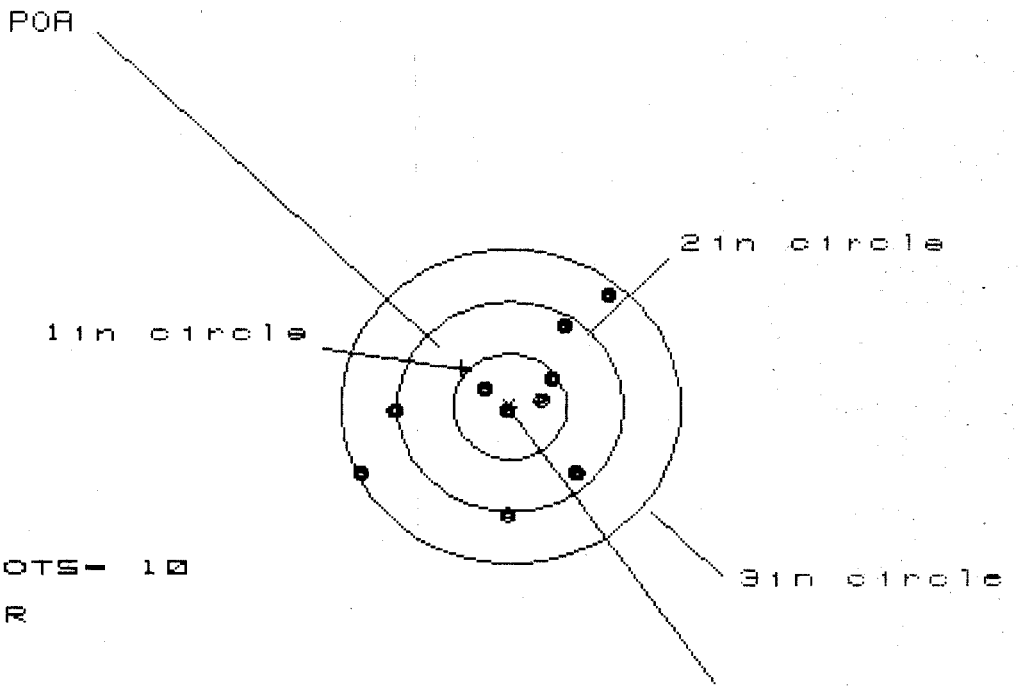


THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0318
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1866
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .18929

THE AMR FOR THIS RIFLE IS: .8924

17 Nov 1989 FILE:/PATTERNING/CENTERFIRE_PATT/C6349104

CENTERFIRE PATTERNS # 1



# OF SHOTS= 10
# IN CIR
1in = 4
2in = 7
3in = 10
HS= 2.179
VS= 2.091
GS= 2.790

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.897	.754	.545
MINIMUM X	:	-1.282	-1.148	-1.053
MAXIMUM Y	:	1.097	1.025	.816
MINIMUM Y	:	-.994	-1.066	-.938
CENTROID X	:	.425	.568	.473
CENTROID Y	:	-.367	-.295	-.423
POA TO CENTROID in.	:	.561	.640	.635
MIN RADIUS	:	.047	.146	.040
MEAN RADIUS	:	.769	.680	.603
MAX RADIUS	:	1.436	1.272	1.054
HORIZONTAL SPREAD	:	2.179	1.902	1.598
VERTICAL SPREAD	:	2.091	2.091	1.754
EXTREME SPREAD	:	2.790	2.296	1.833
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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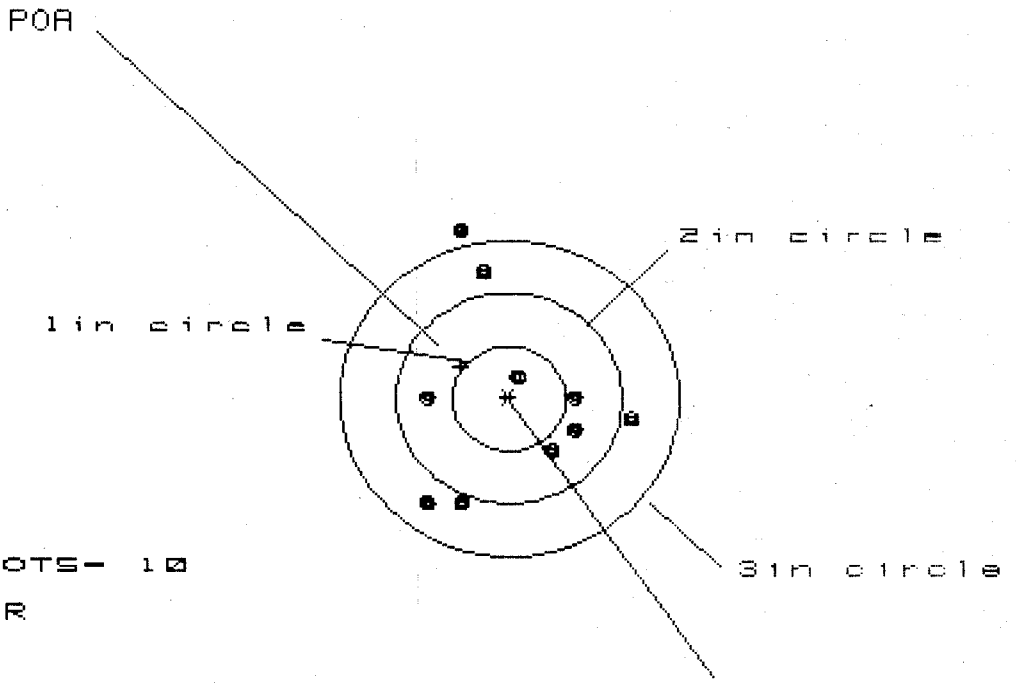
CENTERFIRE PATTERNS # 2



OF SHOTS= 10

# IN CIR	
1in	= 1
2in	= 5
3in	= 9

HS= 1.804
VS= 2.649
GS= 2.670

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.033	.984	.882
MINIMUM X	:	-.771	-.820	-.894
MAXIMUM Y	:	1.614	1.399	1.292
MINIMUM Y	:	-1.035	-.856	-.900
CENTROID X	:	.424	.473	.575
CENTROID Y	:	-.306	-.485	-.378
POA TO CENTROID in.	:	.523	.677	.688
MIN RADIUS	:	.193	.359	.263
MEAN RADIUS	:	.911	.806	.734
MAX RADIUS	:	1.672	1.431	1.353
HORIZONTAL SPREAD	:	1.804	1.804	1.776
VERTICAL SPREAD	:	2.649	2.255	2.192
EXTREME SPREAD	:	2.670	2.314	2.198
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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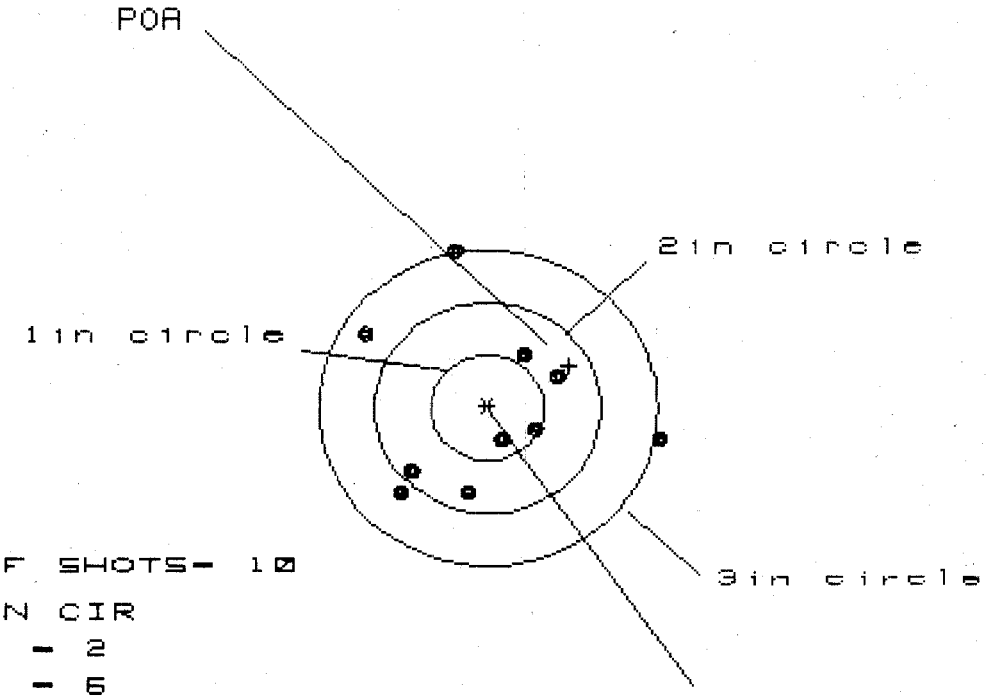
CENTERFIRE PATTERNS # 3



\# OF SHOTS= 10

# IN CIR	
1in	= 2
2in	= 6
3in	= 8

HS= 2.517
VS= 2.380
GS= 2.680

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.488	1.459	.754
MINIMUM X	:	-1.029	-1.058	-.876
MAXIMUM Y	:	1.546	.831	.819
MINIMUM Y	:	-.834	-.662	-.674
CENTROID X	:	-.722	-.693	-.875
CENTROID Y	:	-.402	-.574	-.562
POA TO CENTROID in.	:	.826	.899	1.040
MIN RADIUS	:	.321	.150	.290
MEAN RADIUS	:	.916	.810	.743
MAX RADIUS	:	1.568	1.461	1.199
HORIZONTAL SPREAD	:	2.517	2.517	1.630
VERTICAL SPREAD	:	2.380	1.493	1.493
EXTREME SPREAD	:	2.680	2.680	1.735
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

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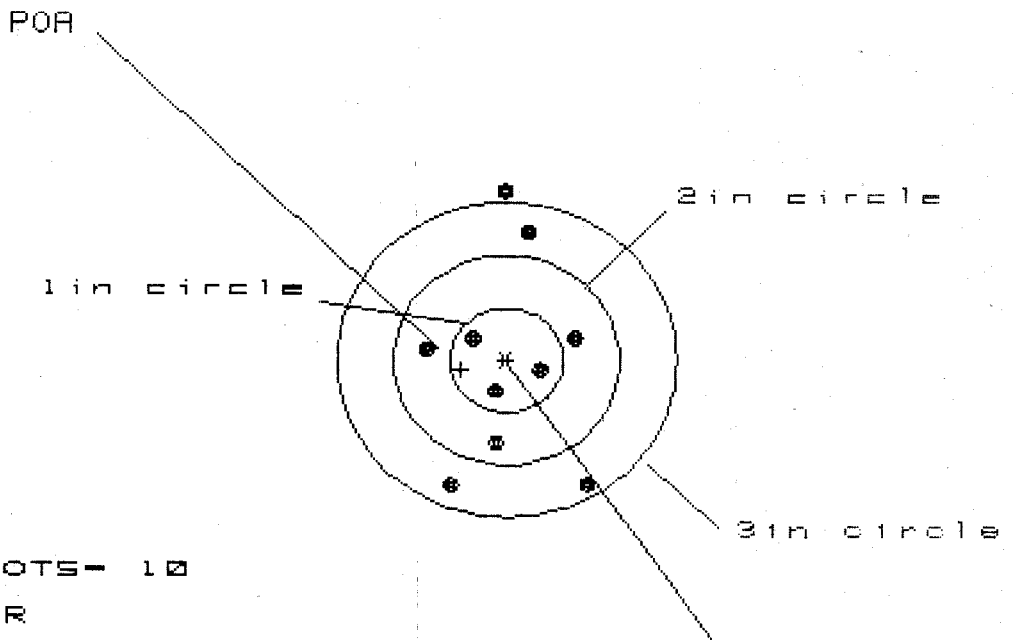
CENTERFIRE PATTERNS # 4



OF SHOTS= 10

# IN CIR
1in = 3
2in = 6
3in = 9

HS= 1.423
VS= 2.792
GS= 2.866

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.719	.720	.733
MINIMUM X	:	-.704	-.703	-.613
MAXIMUM Y	:	1.637	1.356	1.236
MINIMUM Y	:	-1.155	-.973	-1.093
CENTROID X	:	.401	.400	.309
CENTROID Y	:	.087	-.095	.025
POA TO CENTROID in.	:	.411	.411	.311
MIN RADIUS	:	.257	.160	.199
MEAN RADIUS	:	.853	.748	.683
MAX RADIUS	:	1.637	1.372	1.272
HORIZONTAL SPREAD	:	1.423	1.423	1.346
VERTICAL SPREAD	:	2.792	2.329	2.329
EXTREME SPREAD	:	2.866	2.444	2.444
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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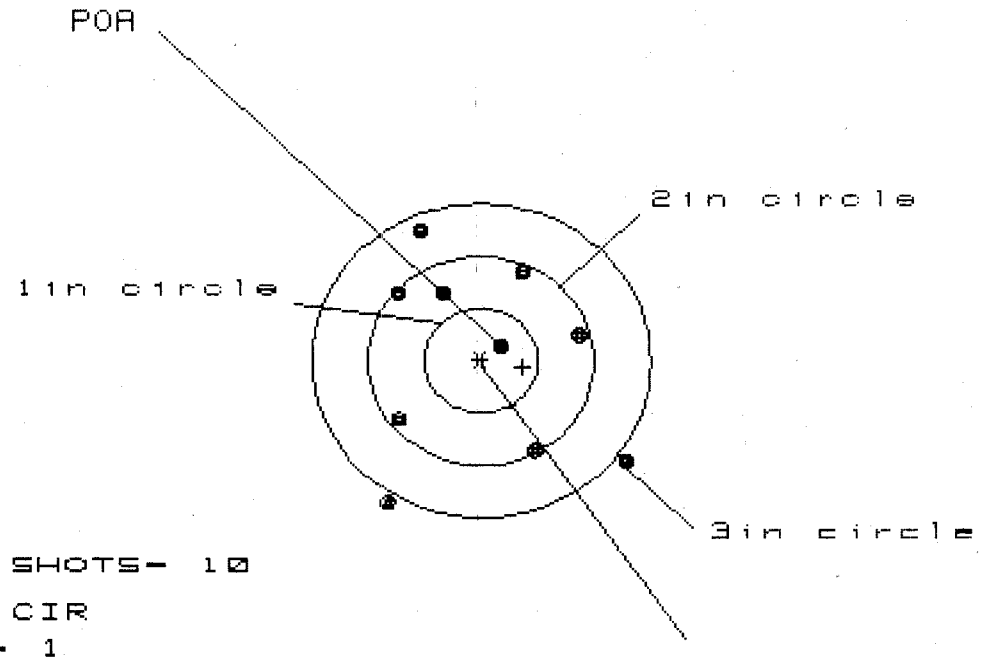
CENTERFIRE PATTERNS # 5

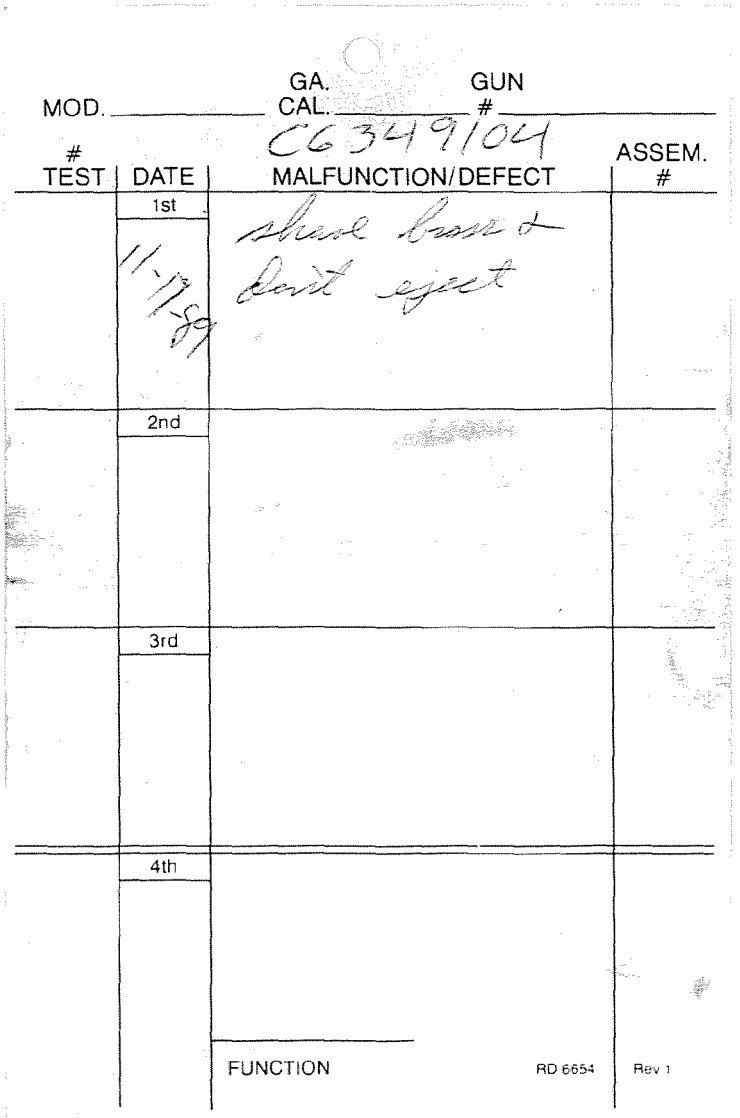


OF SHOTS= 10

# IN CIR
1in = 1
2in = 7
3in = 8

HS= 2.053
VS= 2.649
GS= 2.784

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.220	1.127	.955
MINIMUM X	:	-.834	-.813	-.672
MAXIMUM Y	:	1.248	1.093	.957
MINIMUM Y	:	-1.401	-1.084	-1.136
CENTROID X	:	-.369	-.277	-.418
CENTROID Y	:	.055	.210	.346
POA TO CENTROID in.	:	.374	.348	.542
MIN RADIUS	:	.214	.102	.294
MEAN RADIUS	:	1.013	.911	.816
MAX RADIUS	:	1.630	1.564	1.266
HORIZONTAL SPREAD	:	2.053	1.940	1.627
VERTICAL SPREAD	:	2.649	2.177	2.093
EXTREME SPREAD	:	2.784	2.784	2.331
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	



MOD. _____ GA. CAL. C6349104 GUN # _____

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st	shot bore & dont eject	
		11-17-89	
	2nd		
	3rd		
	4th		

FUNCTION RD 6654 Rev 1

TEST	INIT.	ACTION TO CORRECT	ASSEM. #
PROOF		Ream Ejector hole Polish Ejector 12/5/89	
TEST			RW
TGT			
PROOF		Shot OK	
TEST			
TGT			RW
		ENGINEER	
PROOF			
TEST			
TGT			
		ENGINEER	
PROOF			
TEST			
TGT