C6349159

MODEL 700™ M24

Model SWS ™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

INTERCHANGEABILITY M-24

Scott 0569

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349159

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		89	RW
612	Magnaflux Barrel Action	REJECTED	11/3/89	KCR
	Magnaflux Bolt		11/3/89	KCR
615	Rollmark Caliber			
7	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	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			

QUALITY AUDIT

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

Scott 0569

CONTRACT # DAAA21-87-C-0086

INTERCHANGEABILITY

GUN SERIAL # C6349159

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	11-8	89	RW
600	Proof	11-8	89	RW
607	Check Headspace	11-8	89	RW
610	Dis-assemble Gun	11-8	89	RW
612	Magnaflux Barrel Action	11-9-89		KCR
	Magnaflux Bolt	11-9-89		KCR
615	Rollmark Caliber			
617	Drill and Tap Sight Holes	11 9	89	LB
618	Polish Barrel RG	11 9	89	BT
620	Apply Coatings (Barrel Action)		11-17-89	
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/28/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/28/89	RW
	C) Inspect Ejector Hole for Chamfer		11/28/89	RW
	D) Oil Firing Pin Ass'y		11/28/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11/28/89	RW

QUALITY AUDIT

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			4 Dec 89	GS
	G) Safety Off Force	3	3	3			4 Dec 89	GS
	H) Trigger Pull Test & Retainability						4 Dec 89	GS
	I) Firing Pin Indent	.021	.021	.0215			4 Dec 89	GS
	J) Assemble Stock						12/8/89	RW
	K) Assemble Swivel Studs						8 Dec 89	GS
	L) Attach Front and Rear Sight Assemblies						12/8/89	RW
	M) Iron Sight Alignment						12/8/89	RW
	N) Detach Front & Rear Sights & place in numbered container						12/8/89	RW
	O) Attach Scope to Rifle						8 Dec 89	GS
	P) Detach & Attach Scope 20 Times						8 Dec 89	GS
640	Gallery Target & Test						12-8-89	AC
	A) Time						12-8-89	AC
	B) Malfunctions						12-8-89	AC
	C) Pierced Primers						12-8-89	AC
	D) Optical Clearity of Scope						12-8-89	AC
645	Inspect for Live Ammo						12-8-89	AC
655	Final Inspection A) Headspace						8 Dec 89	GS
	B) Trigger Pull	248	256	267	264	262	8 Dec 89	GS
	C) Function						8 Dec 89	GS
660	Pack						14 Dec 89 GS	

SWS TRIGGER PULL TEST

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

SERIAL NO. C6349159
DATE 3/27/90
TESTER RW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.46	2.51	2.44	MIN. SETTING,
PULL #2	2.34	2.50	2.44	NO AVG. OF 5
PULL #3	2.36	2.52	2.43	READINGS ACCEPT-
PULL #4	2.37	2.49	2.43	ABLE LESS THAN 2#
PULL #5	2.31	2.50	2.41	
TOTAL	11.84	12.52	12.15	
AVG.	2.37	2.50	2.43	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.05	3.07		—
PULL #2	3.04	3.05		
PULL #3	3.08	3.02		
PULL #4	3.05	3.03		
PULL #5	3.07	3.04		
TOTAL	15.29	15.21		
AVG.	3.06	3.04		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.13	4.12		
PULL #2	4.15	4.08		
PULL #3	4.10	4.10		
PULL #4	4.19	4.00		
PULL #5	4.13	4.11		
TOTAL	20.70	20.41		
AVG.	4.14	4.08		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349159
6 Dec 1989

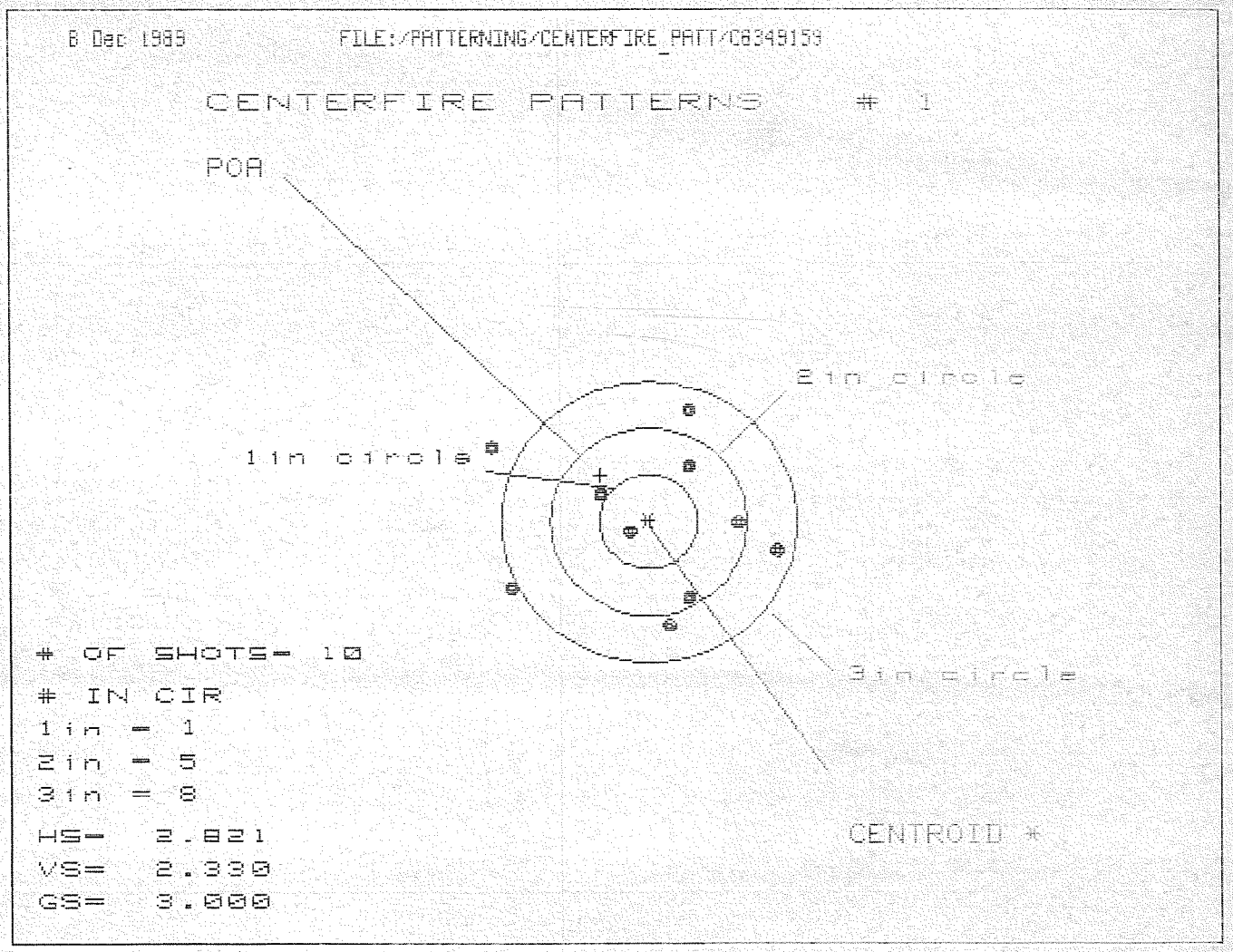
CENTROIDAL DISTANCES

0	TO	1	.698623
1	TO	2	.52897
1	TO	3	.66503
1	TO	4	1.08639
1	TO	5	.275801

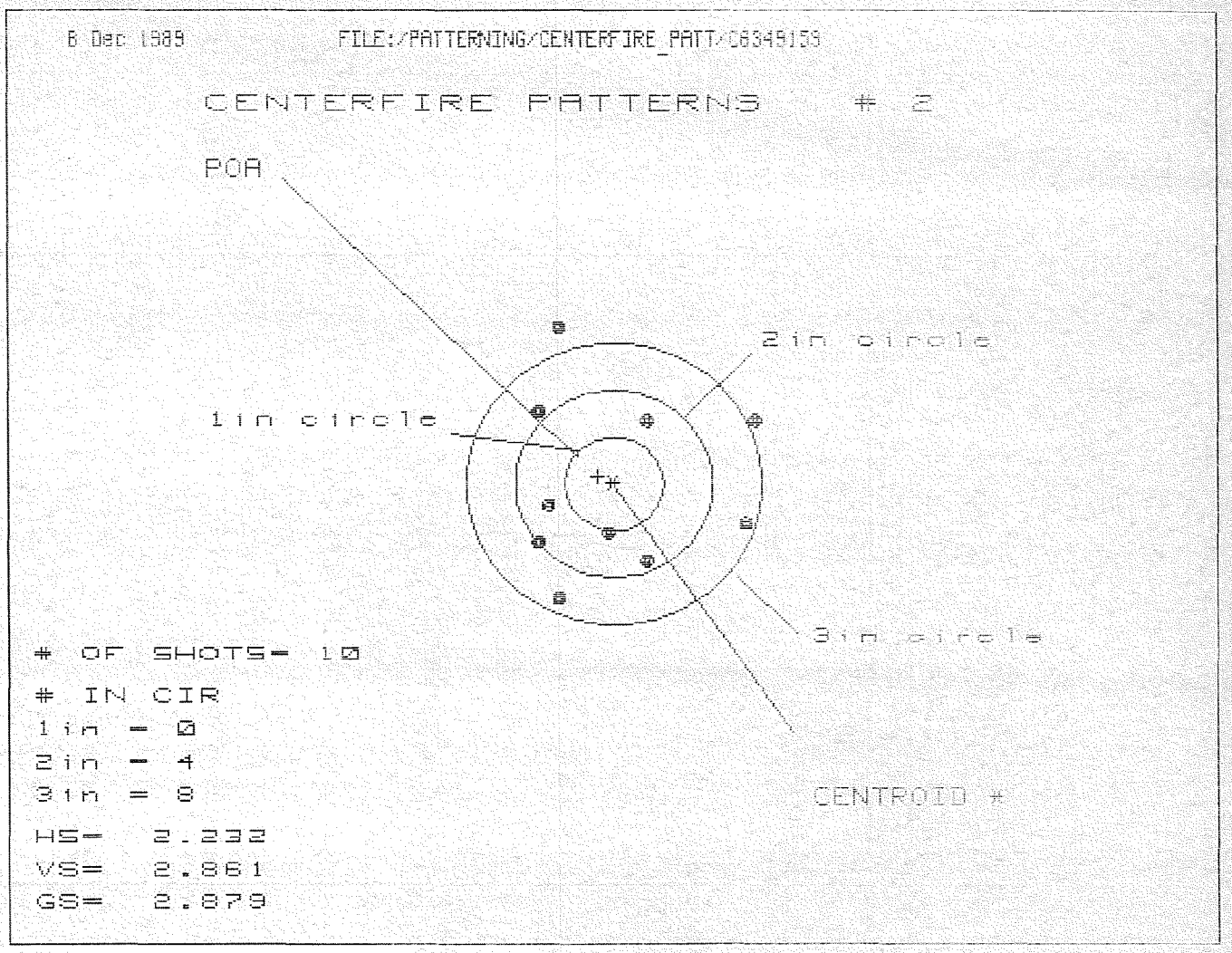
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .218
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0738
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .230153

THE AMR FOR THIS RIFLE IS: 1.039



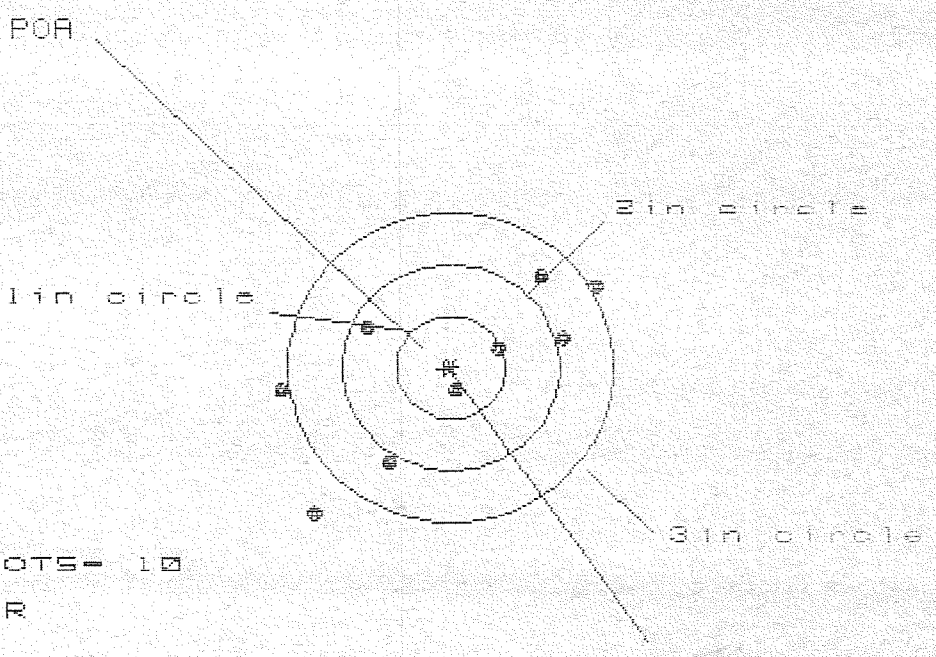
PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.275	1.103	.905
MINIMUM X	:	-1.546	-1.586	-.861
MAXIMUM Y	:	1.202	1.287	1.215
MINIMUM Y	:	-1.128	-1.043	-1.115
CENTROID X	:	.493	.665	.863
CENTROID Y	:	-.495	-.580	-.508
POA TO CENTROID in.	:	.699	.882	1.001
MIN RADIUS	:	.204	.365	.497
MEAN RADIUS	:	1.026	.939	.830
MAX RADIUS	:	1.723	1.685	1.216
HORIZONTAL SPREAD	:	2.821	2.689	1.766
VERTICAL SPREAD	:	2.330	2.330	2.330
EXTREME SPREAD	:	3.000	2.718	2.336
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	



PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.437	1.370	1.465
MINIMUM X	:	-.795	-.862	-.691
MAXIMUM Y	:	1.671	.934	1.036
MINIMUM Y	:	-1.190	-1.004	-.902
CENTROID X	:	.165	.232	.061
CENTROID Y	:	-.080	-.266	-.368
POA TO CENTROID in.	:	.184	.353	.373
MIN RADIUS	:	.521	.349	.243
MEAN RADIUS	:	1.106	1.003	.886
MAX RADIUS	:	1.775	1.596	1.473
HORIZONTAL SPREAD	:	2.232	2.232	2.156
VERTICAL SPREAD	:	2.861	1.938	1.938
EXTREME SPREAD	:	2.879	2.715	2.461
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

8 Dec 1989 FILE:/PATTERNING/CENTERFIRE_PATT/C8349159

CENTERFIRE PATTERNS # 3



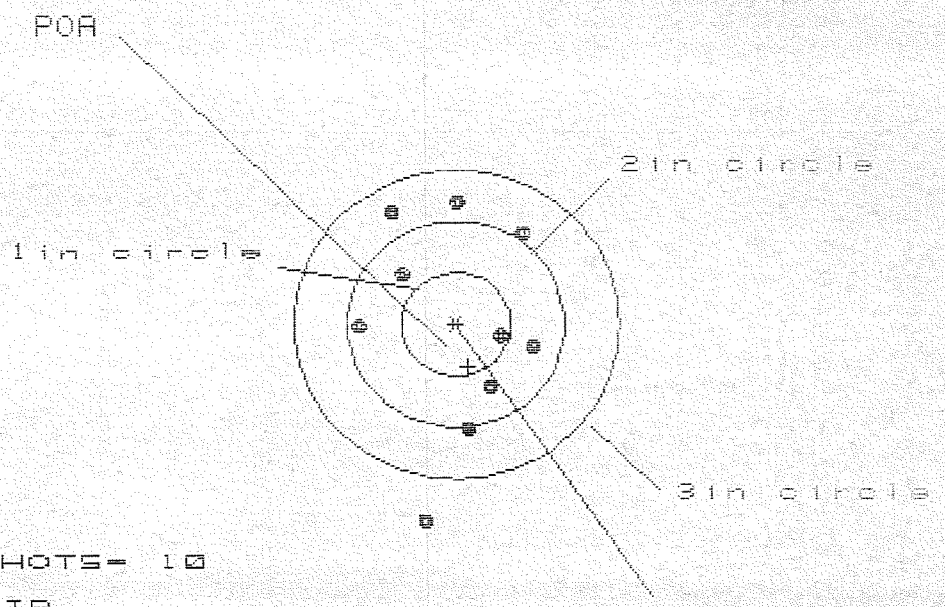
OF SHOTS= 10

# IN CIR	
1in =	3
2in =	4
3in =	7
HS=	2.946
VS=	2.210
GS=	3.390

PATTERN # :	3		
SHOTS (BEST OF) :	10	9	8
MAXIMUM X :	1.347	1.205	.987
MINIMUM X :	-1.599	-1.741	-1.140
MAXIMUM Y :	.840	.688	.640
MINIMUM Y :	-1.370	-1.079	-1.127
CENTROID X :	.065	.206	.424
CENTROID Y :	.014	.166	.214
POA TO CENTROID in.:	.066	.265	.475
MIN RADIUS :	.185	.283	.062
MEAN RADIUS :	1.040	.909	.731
MAX RADIUS :	1.872	1.783	1.440
HORIZONTAL SPREAD :	2.946	2.946	2.127
VERTICAL SPREAD :	2.210	1.767	1.767
EXTREME SPREAD :	3.390	3.114	2.540
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		7	

8 Dec 1999 FILE:/PATTERNING/CENTERFIRE_PATT/C8349159

CENTERFIRE PATTERNS # 4

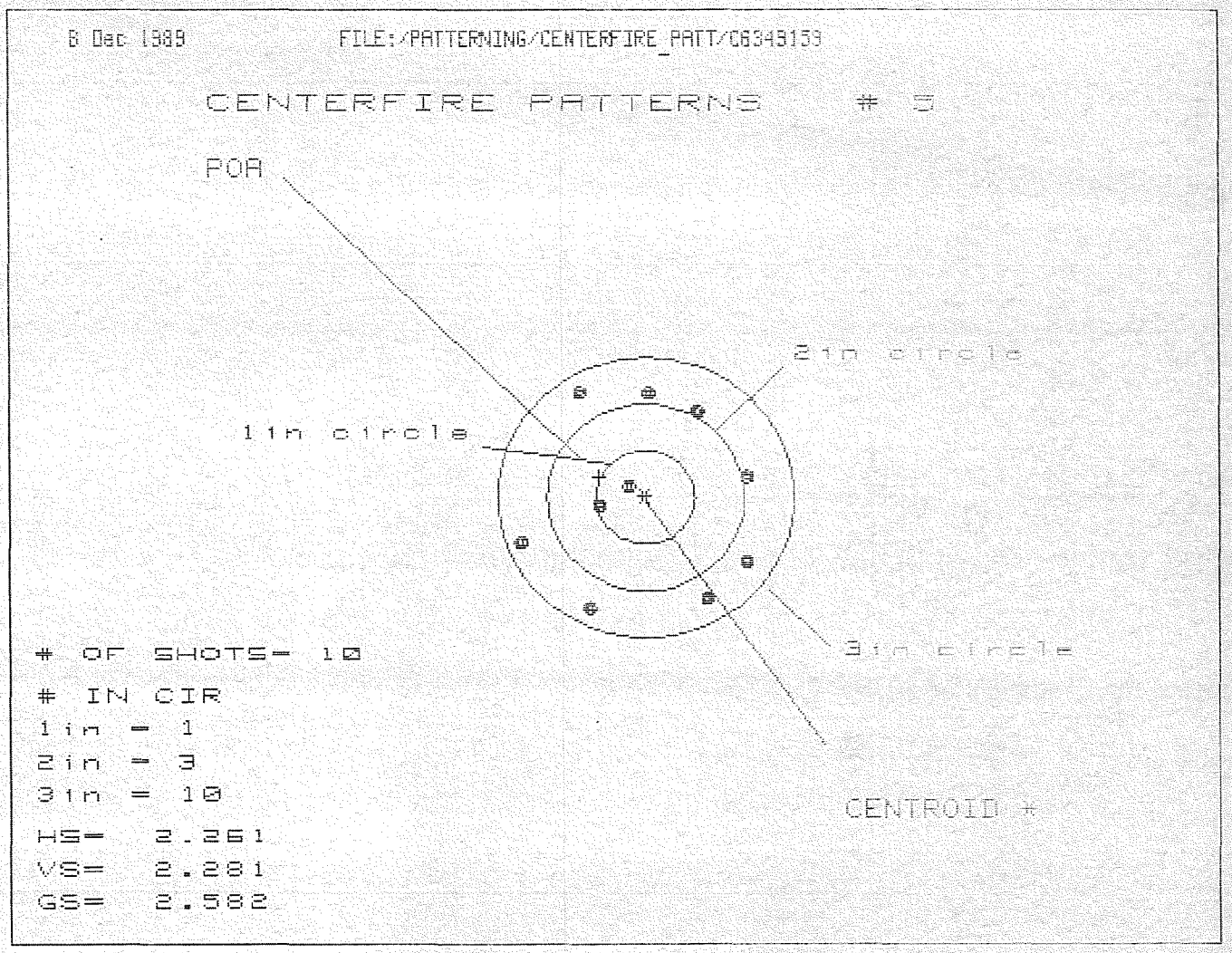


OF SHOTS= 10

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

HS= 1.564
VS= 3.124
GS= 3.141

PATTERN #	:	[redacted]		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.716	.685	.602
MINIMUM X	:	-.848	-.879	-.962
MAXIMUM Y	:	1.231	1.021	1.135
MINIMUM Y	:	-1.893	-1.193	-1.079
CENTROID X	:	-.105	-.074	.009
CENTROID Y	:	.412	.622	.508
POA TO CENTROID in.	:	.425	.627	.508
MIN RADIUS	:	.413	.469	.336
MEAN RADIUS	:	.994	.879	.828
MAX RADIUS	:	1.913	1.197	1.137
HORIZONTAL SPREAD	:	1.564	1.564	1.564
VERTICAL SPREAD	:	3.124	2.214	2.214
EXTREME SPREAD	:	3.141	2.243	2.215
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	



PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.023	.947	.782
MINIMUM X	:	-1.238	-1.314	-.767
MAXIMUM Y	:	1.138	1.263	1.222
MINIMUM Y	:	-1.143	-1.017	-1.058
CENTROID X	:	.472	.548	.713
CENTROID Y	:	-.220	-.346	-.305
POA TO CENTROID in.	:	.521	.649	.775
MIN RADIUS	:	.193	.327	.447
MEAN RADIUS	:	1.029	1.001	.954
MAX RADIUS	:	1.331	1.356	1.307
HORIZONTAL SPREAD	:	2.261	2.261	1.549
VERTICAL SPREAD	:	2.281	2.280	2.280
EXTREME SPREAD	:	2.582	2.343	2.343
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		10	

INTERCHANGEABILITY

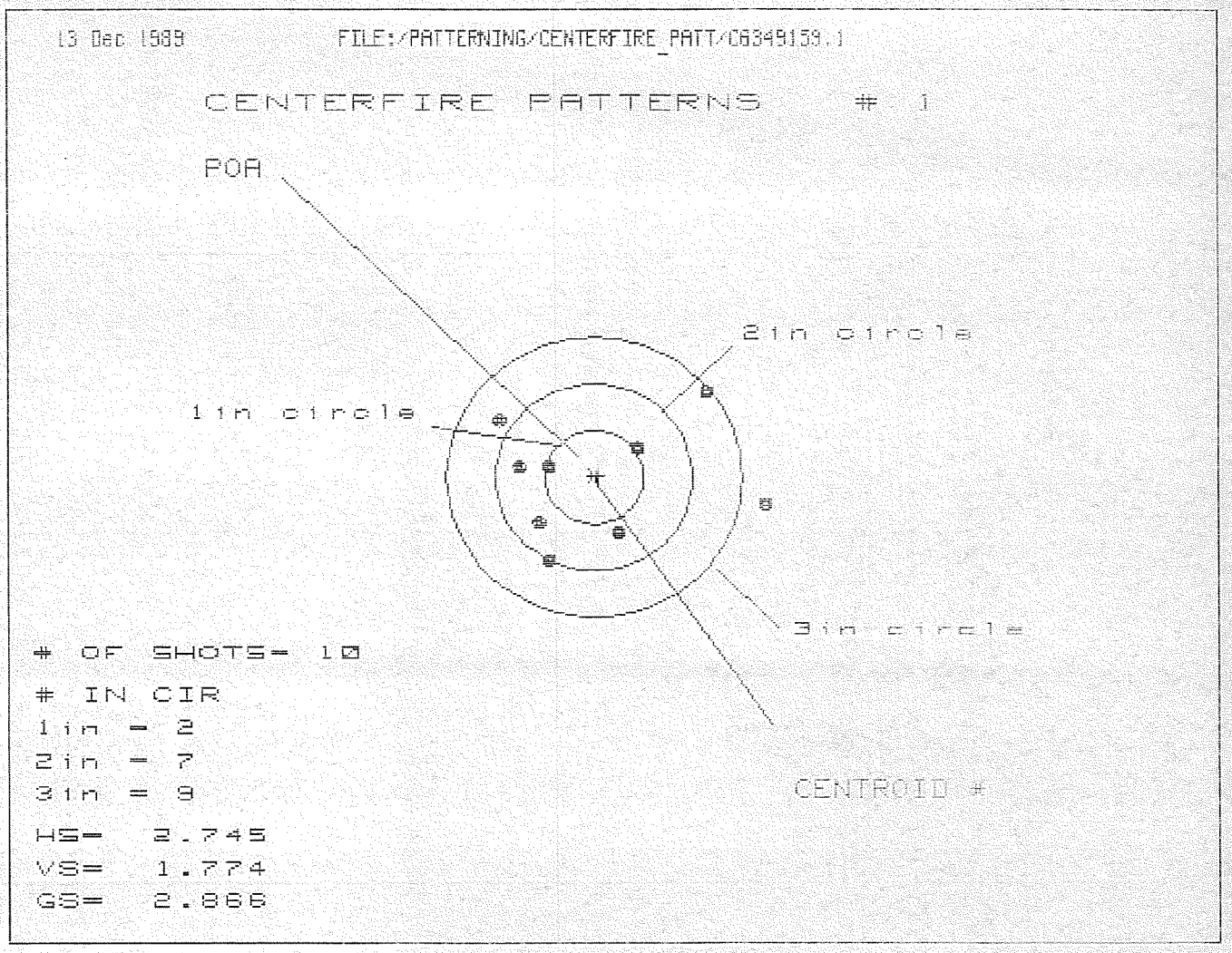
CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349159
13 Dec 1989

CENTROIDAL DISTANCES

Ø	TO	1	.Ø43Ø813
1	TO	2	.5472
1	TO	3	.185173
1	TO	4	.968Ø33
1	TO	5	.725827

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2122
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0018
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .212208

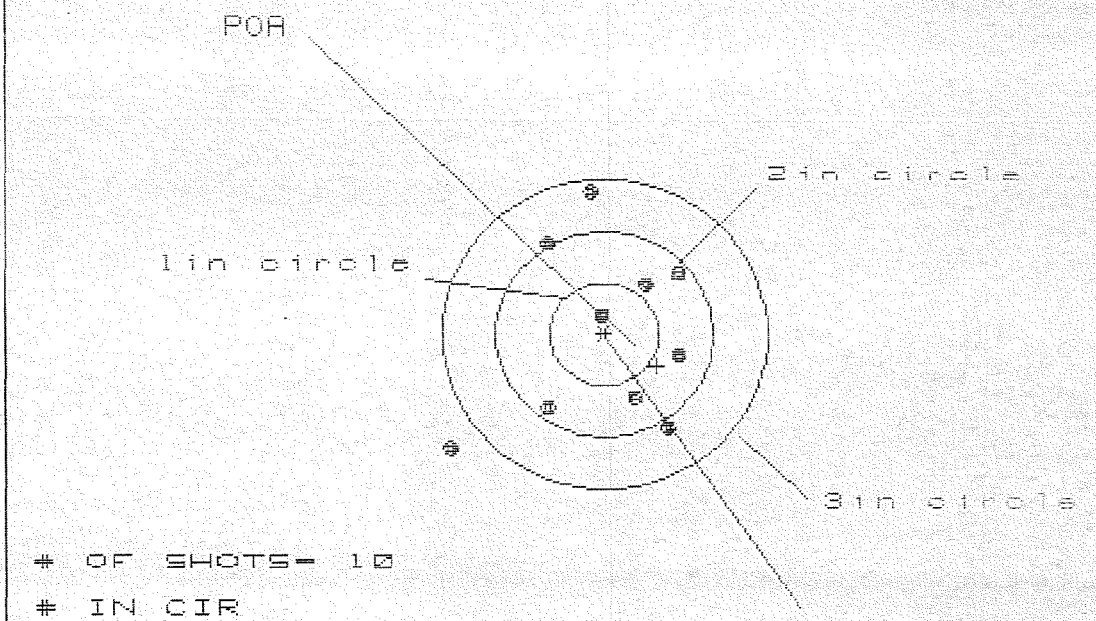
THE AMR FOR THIS RIFLE IS: .9932



PATTERN #	:	[redacted]		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.772	1.314	.823
MINIMUM X	:	-.973	-.776	-.612
MAXIMUM Y	:	.917	.889	.649
MINIMUM Y	:	-.857	-.885	-.774
CENTROID X	:	-.040	-.237	-.401
CENTROID Y	:	-.016	.012	-.099
POA TO CENTROID in.	:	.043	.237	.413
MIN RADIUS	:	.441	.248	.201
MEAN RADIUS	:	.889	.734	.585
MAX RADIUS	:	1.791	1.586	.914
HORIZONTAL SPREAD	:	2.745	2.090	1.441
VERTICAL SPREAD	:	1.774	1.774	1.423
EXTREME SPREAD	:	2.866	2.376	1.652
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

13 Dec 1999 FILE:/PATTERNING/CENTERFIRE_PATT/06349159.1

CENTERFIRE PATTERNS # 2

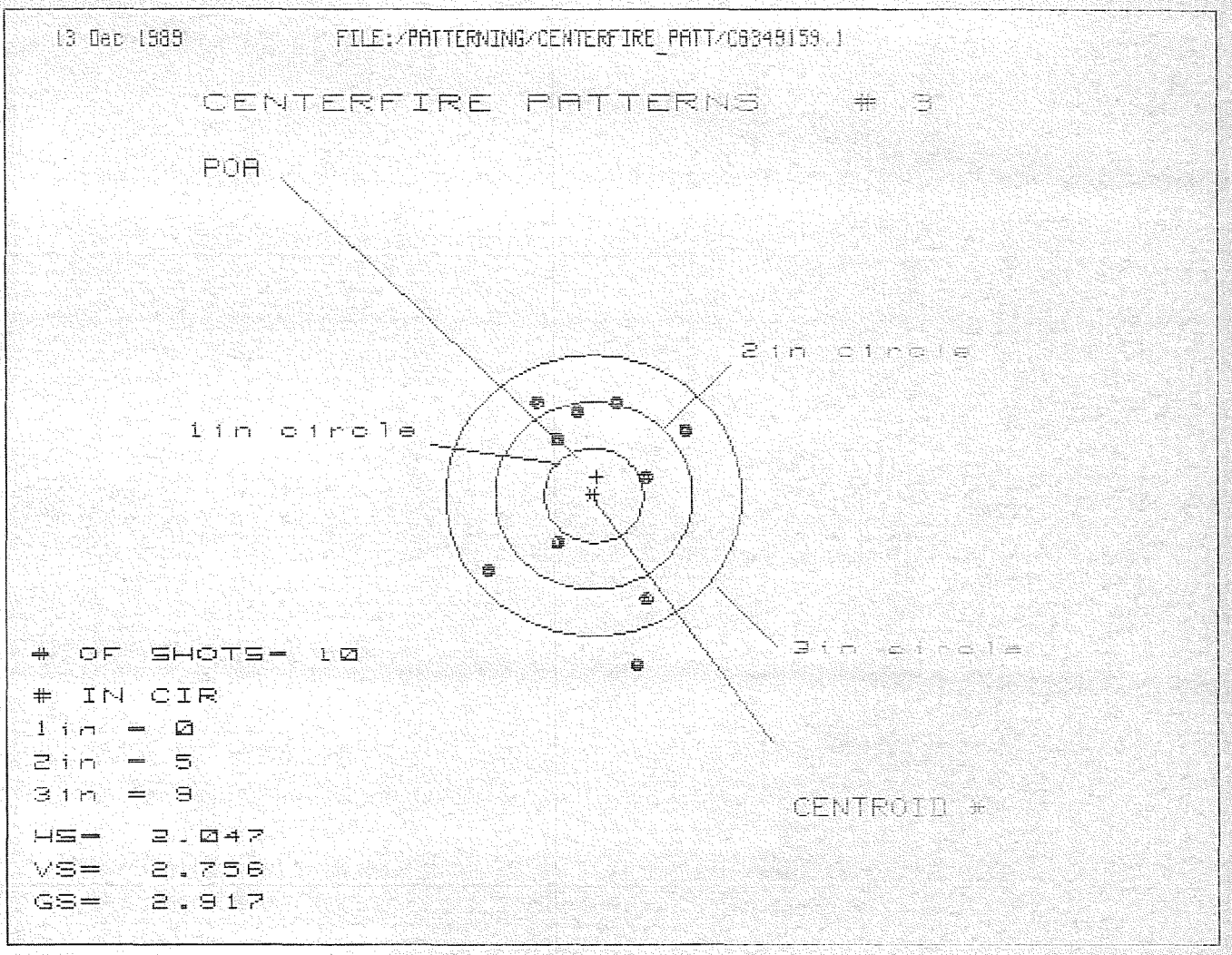


OF SHOTS= 10

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

HS= 2.162
VS= 2.471
GS= 2.778

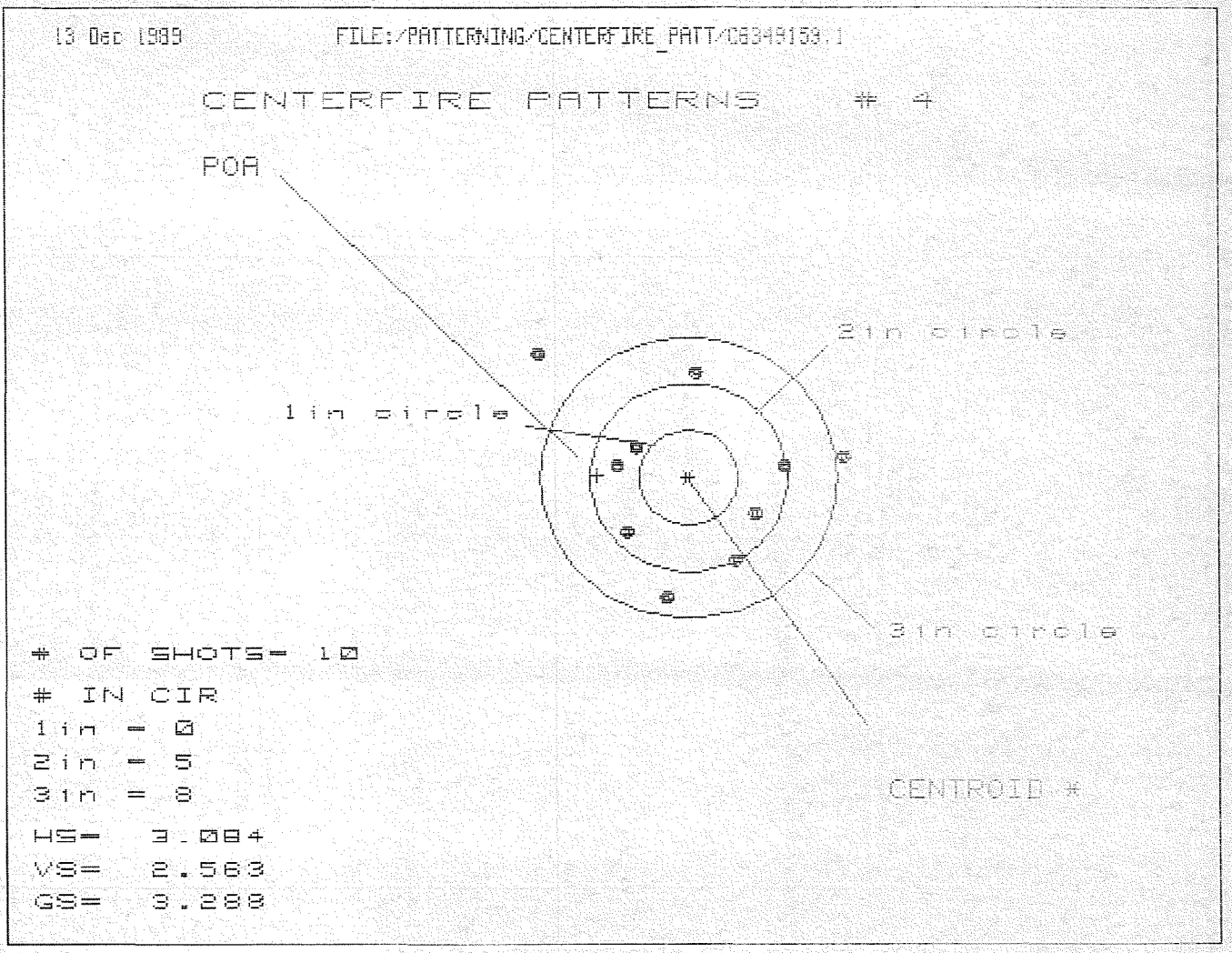
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.721	.561	.519
MINIMUM X	:	-1.441	-.698	-.740
MAXIMUM Y	:	1.400	1.281	.940
MINIMUM Y	:	-1.071	-.983	-.823
CENTROID X	:	-.478	-.318	-.276
CENTROID Y	:	.312	.431	.271
POA TO CENTROID in.	:	.571	.536	.387
MIN RADIUS	:	.169	.155	.282
MEAN RADIUS	:	.936	.806	.738
MAX RADIUS	:	1.796	1.323	1.196
HORIZONTAL SPREAD	:	2.162	1.259	1.259
VERTICAL SPREAD	:	2.471	2.264	1.763
EXTREME SPREAD	:	2.778	2.391	2.097
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	



PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.942	.986	.854
MINIMUM X	:	-1.105	-1.061	-.649
MAXIMUM Y	:	.982	.785	.656
MINIMUM Y	:	-1.774	-1.314	-1.443
CENTROID X	:	-.032	-.076	.056
CENTROID Y	:	-.201	-.004	.125
POA TO CENTROID in.	:	.204	.077	.137
MIN RADIUS	:	.542	.565	.464
MEAN RADIUS	:	1.056	.933	.830
MAX RADIUS	:	1.817	1.483	1.511
HORIZONTAL SPREAD	:	2.047	2.047	1.503
VERTICAL SPREAD	:	2.756	2.099	2.099
EXTREME SPREAD	:	2.917	2.533	2.368
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

13 Dec 1989 FILE:/PATTERNING/CENTERFIRE_PATT/C83485153.1

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

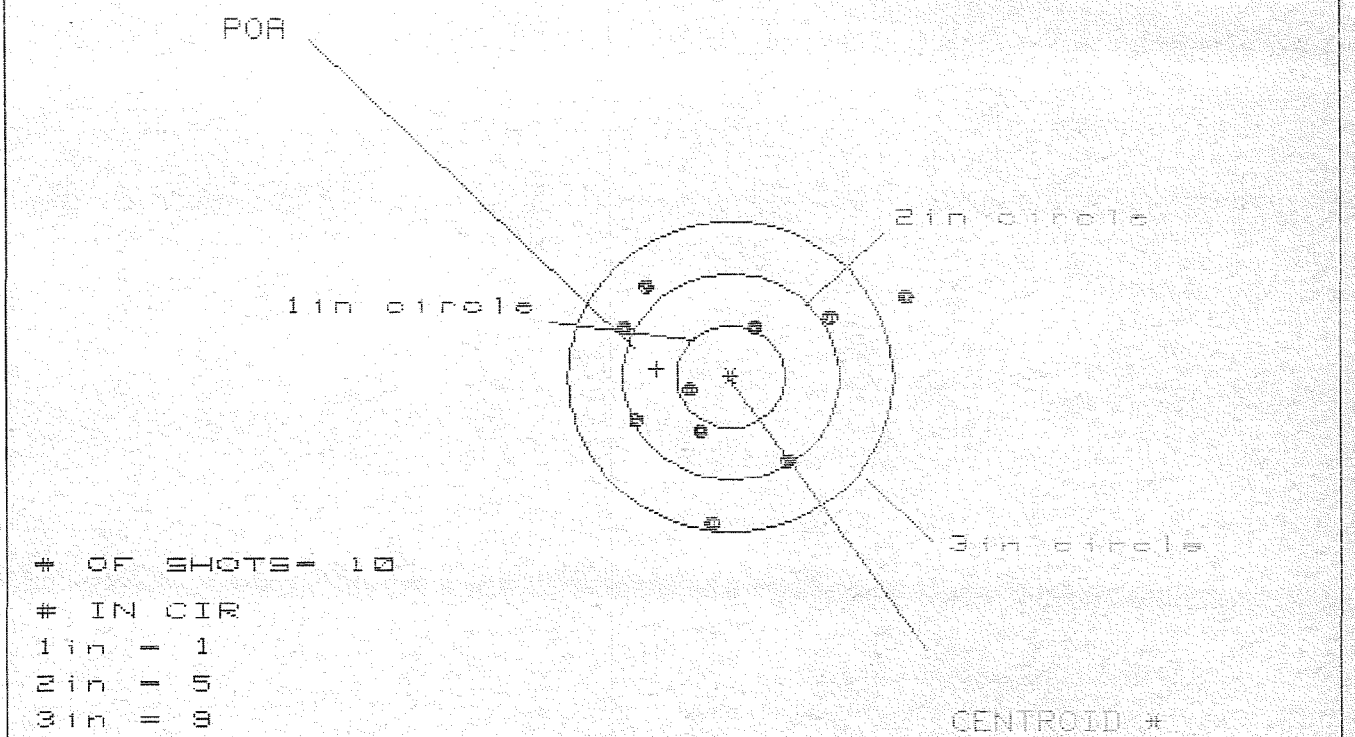
# IN CIR
1in = 0
2in = 5
3in = 8

HS= 3.084
VS= 2.563
GS= 3.288

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.565	1.396	1.000
MINIMUM X	:	-1.519	-.931	-.757
MAXIMUM Y	:	1.325	1.230	1.271
MINIMUM Y	:	-1.238	-1.091	-1.050
CENTROID X	:	.928	1.097	.923
CENTROID Y	:	-.024	-.171	-.212
POA TO CENTROID in.	:	.929	1.110	.947
MIN RADIUS	:	.648	.519	.663
MEAN RADIUS	:	1.092	.969	.895
MAX RADIUS	:	2.016	1.435	1.272
HORIZONTAL SPREAD	:	3.084	2.327	1.763
VERTICAL SPREAD	:	2.563	2.321	2.321
EXTREME SPREAD	:	3.288	2.335	2.335
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

13 Dec 1988 FILE:/PATTERNING/CENTERFIRE_PATT/CS345159.1

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

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

HS= 2.566
VS= 2.246
GS= 2.808

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.610	1.131	1.130
MINIMUM X	:	-.948	-.768	-.769
MAXIMUM Y	:	.874	.961	.800
MINIMUM Y	:	-1.372	-1.285	-.871
CENTROID X	:	.683	.503	.504
CENTROID Y	:	-.080	-.167	-.006
POA TO CENTROID in.	:	.688	.530	.504
MIN RADIUS	:	.404	.205	.296
MEAN RADIUS	:	.993	.863	.814
MAX RADIUS	:	1.797	1.307	1.233
HORIZONTAL SPREAD	:	2.566	1.899	1.899
VERTICAL SPREAD	:	2.246	2.246	1.671
EXTREME SPREAD	:	2.808	2.312	2.087
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9