

06522229

MODEL 700™ N24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Smead®

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522229

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		8/13/90	KS
600	Proof		8/13/90	KS
607	Check Headspace		8/13/90	KS
610	Dis-assemble Gun		8/13/90	KS
612	Magnaflux Barrel Action		8/16	KCR
	Magnaflux Bolt		8/16	KCR
615	Rollmark Caliber		8/16	GL
617	Drill and Tap Sight Holes		8/16/90	WB
618	Polish Barrel		8/16/90	WB
620	Apply Coatings (Barrel Action)		8-31-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/16/90	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/16/90	WB
	C) Inspect Ejector Hole for Chamfer		8/16/90	WB
	D) Oil Firing Pin Ass'y		8/16/90	WB
	E) Adjust Trigger Pull to Min Setting and Stake		9/10/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2			9/10/90	WB
	G) Safety Off Force	2	2	2			9/10/90	WB
	H) Trigger Pull Test & Retainability						9/10/90	WB
	I) Firing Pin Indent	.023	.023	.023			9/10/90	WB
	J) Assemble Stock						9/10/90	KL
	K) Assemble Swivel Studs						9/18/90	JB
	L) Attach Front and Rear Sight Assemblies						9/10/90	KL
	M) Iron Sight Alignment						9/10/90	KL
	N) Detach Front & Rear Sights & place in numbered container						9/10/90	KL
	O) Attach Scope to Rifle						9/11/90	KL
	P) Detach & Attach Scope 20 Times						9/10/90	KL
640	Gallery Target & Test						9/12/90	KT
	A) Time						9/12/90	KT
	B) Malfunctions						9/12/90	KT
	C) Pierced Primers						9/12/90	KT
	D) Optical Clarity of Scope						9/12/90	KT
645	Inspect for Live Ammo						9/12/90	KT
655	Final Inspection							
	A) Headspace						9/18/90	JB
	B) Trigger Pull	2.47	2.43	2.44	2.53	2.47	9-18-90	KL
	C) Function						9/18/90	JB
660	Pack						9/20/90	VF

MOD. 200 SWS GA. 208 GUN # 66522229
 CAL. 208

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st		
	9/12	Bolt Release Sticker	KS
	2nd		
		Rep'd	KS 9/16/90
	3rd		
	4th		
		FUNCTION	RD 6654 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

SWS TRIGGER PULL TEST

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

SERIAL NO. C6522229
DATE 9/10/90
TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.37	2.15	2.19	2.47	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.44	2.25	2.15	2.43	
PULL #3	2.38	2.22	2.14	2.44	
PULL #4	2.30	2.17	2.30	2.53	
PULL #5	2.30	2.26	2.18	2.47	
TOTAL	11.79	11.05	10.96	12.34	
AVG.	2.36	2.21	2.19	2.468	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.13	3.06		
PULL #2	3.09	3.07		
PULL #3	3.14	3.07		
PULL #4	3.08	3.10		
PULL #5	3.07	3.10		
TOTAL	15.51	15.40		
AVG.	3.10	3.08		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.11	3.95		4.13
PULL #2	4.02	3.95		4.17
PULL #3	4.00	3.97		4.09
PULL #4	3.95	4.03		4.10
PULL #5	4.00	3.97		4.11
TOTAL	20.08	19.87		20.60
AVG.	4.02	3.97		4.12

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522229
13 Sep 1990

CENTROIDAL DISTANCES

0 TO 1	.156042
1 TO 2	.225754
1 TO 3	.379075
1 TO 4	.248244
1 TO 5	.401693

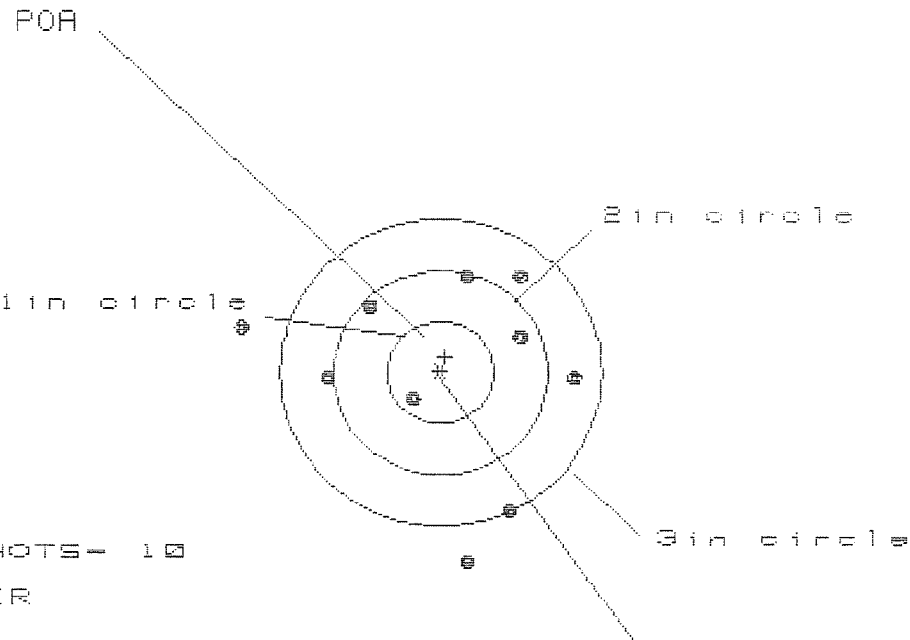
$\bar{x}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0208
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0504
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0545234
THE AMR FOR THIS RIFLE IS: 1.067

12 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06522229

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 6

HS= 3.109

VS= 2.832

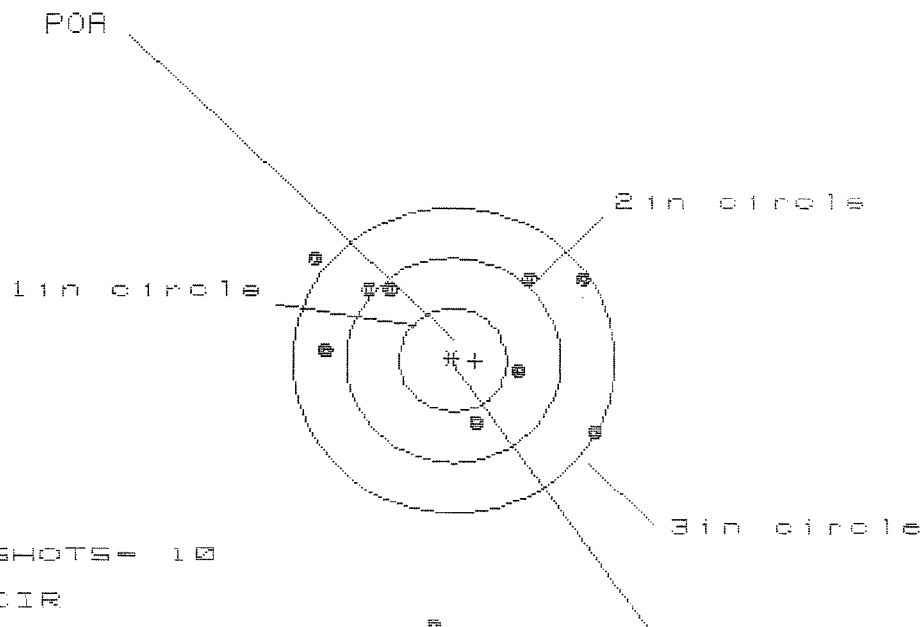
GS= 3.143

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.277	1.073	1.076
MINIMUM X	-1.832	-1.272	-1.269
MAXIMUM Y	.981	1.031	.806
MINIMUM Y	-1.851	-1.801	-1.508
CENTROID X	-.043	.161	.158
CENTROID Y	-.150	-.200	.025
POA TO CENTROID in.	.156	.257	.160
MIN RADIUS	.338	.497	.542
MEAN RADIUS	1.187	1.105	.981
MAX RADIUS	1.888	1.801	1.573
HORIZONTAL SPREAD	3.109	2.345	2.345
VERTICAL SPREAD	2.832	2.832	2.314
EXTREME SPREAD	3.143	2.865	2.377
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	8		

12 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8522229

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 3

3 in = 8

HS= 2.559

VS= 3.571

GS= 3.718

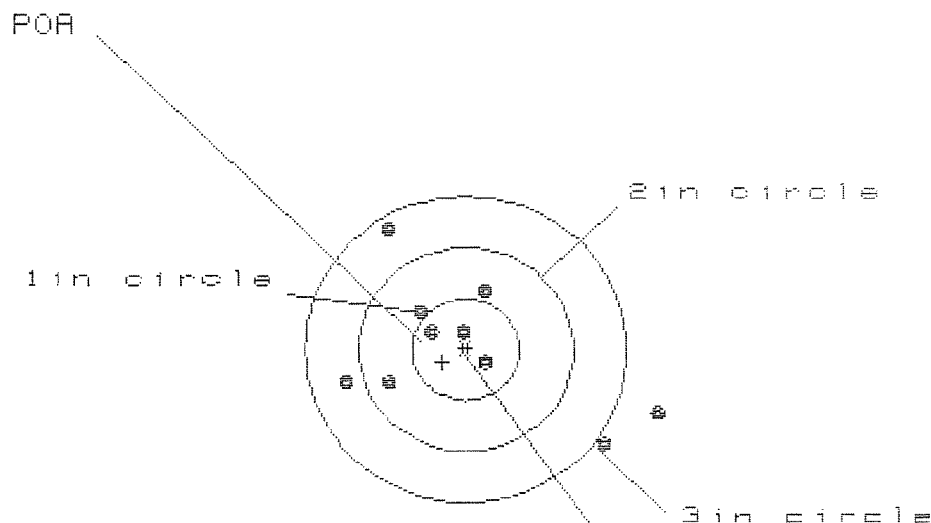
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.310	1.286	1.127
MINIMUM X	:	-1.249	-1.273	-1.350
MAXIMUM Y	:	.974	.686	.641
MINIMUM Y	:	-2.597	-1.011	-.926
CENTROID X	:	-.209	-.185	-.026
CENTROID Y	:	.003	.291	.206
POR TO CENTROID in.	:	.209	.345	.207
MIN RADIUS	:	.582	.685	.556
MEAN RADIUS	:	1.251	1.070	1.010
MAX RADIUS	:	2.606	1.636	1.459
HORIZONTAL SPREAD	:	2.559	2.559	2.477
VERTICAL SPREAD	:	3.571	1.697	1.567
EXTREME SPREAD	:	3.718	3.071	2.613
NUMBER IN ONE INCH CIRCLE =		0		
NUMBER IN TWO INCH CIRCLE =		3		
NUMBER IN THREE INCH CIRCLE =		8		

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 3

2in = 6

3in = 8

HS= 2.869

VS= 2.053

GS= 3.069

CENTROID #

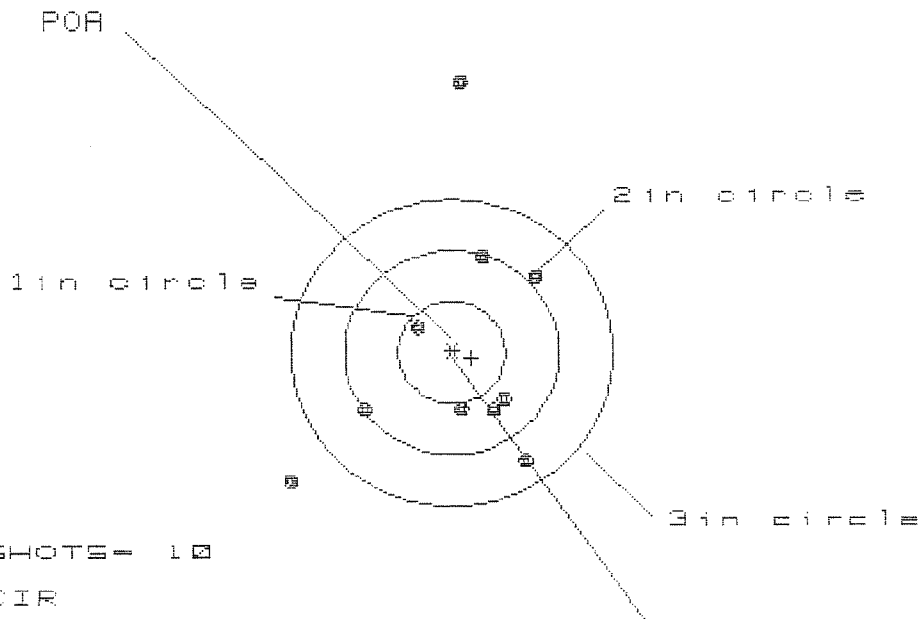
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.757	1.440	.579
MINIMUM X	:	-1.112	-.916	-.737
MAXIMUM Y	:	1.137	1.069	.946
MINIMUM Y	:	-.916	-.984	-.532
CENTROID X	:	.220	.024	-.155
CENTROID Y	:	.123	.191	.314
POR TO CENTROID in.	:	.252	.193	.351
MIN RADIUS	:	.150	.128	.103
MEAN RADIUS	:	.863	.710	.565
MAX RADIUS	:	1.861	1.744	1.023
HORIZONTAL SPREAD	:	2.869	2.356	1.316
VERTICAL SPREAD	:	2.053	2.053	1.478
EXTREME SPREAD	:	3.069	2.872	1.621
NUMBER IN ONE INCH CIRCLE	=		3	
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 = 1

2in = 5

3in = 8

HS = 2.250

VS = 3.890

GS = 4.186

CENTROID #

PATTERN #	4	4	4
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.756	.762	.576
MINIMUM X	-1.494	-1.488	-1.017
MAXIMUM Y	2.626	1.230	1.108
MINIMUM Y	-1.264	-.972	-.900
CENTROID X	-.183	-.189	-.003
CENTROID Y	.055	-.237	-.115
POA TO CENTROID in.	.191	.303	.115
MIN RADIUS	.407	.279	.403
MEAN RADIUS	1.123	.902	.781
MAX RADIUS	2.626	1.778	1.111
HORIZONTAL SPREAD	2.250	2.250	1.593
VERTICAL SPREAD	3.890	2.202	2.008
EXTREME SPREAD	4.186	3.003	2.067
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 2.024

VS= 3.294

ES= 3.441

CENTROID *

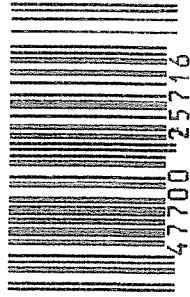
PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.811	.691	.550
MINIMUM X	-1.213	-1.123	-1.050
MAXIMUM Y	2.368	.529	.542
MINIMUM Y	-.926	-.663	-.650
CENTROID X	.111	.021	.161
CENTROID Y	.221	-.042	-.055
POA TO CENTROID in.	.247	.047	.171
MIN RADIUS	.154	.380	.323
MEAN RADIUS	.913	.726	.658
MAX RADIUS	2.503	1.128	1.087
HORIZONTAL SPREAD	2.024	1.814	1.600
VERTICAL SPREAD	3.294	1.192	1.192
EXTREME SPREAD	3.441	1.864	1.800
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

 		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700™ H24		SERIAL NO. C6522229
MADE IN ILION, N.Y., U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.		ORDER NO. 5716



5716 C6522229

UPC



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