

C6636066

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



M2400037336

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

Smith

Remington®

MODEL 700™ H24

DUPONT
REG. U.S. PAT. & TM. OFF.

VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

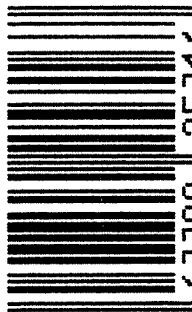
SERIAL NO. C6636066	20
ORDER NO. 5716	

MADE IN ALBANY, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



5716 C6636066

UPC



0 47700 25716 7

GUN SERIAL #

C 6636066

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		4/9/91	K.S.
600	Proof		4/9/91	K.S.
607	Check Headspace		4/9/91	K.S.
610	Dis-assemble Gun		4/9/91	K.S.
612	Magnaflux Barrel Action		4/10/91	KR
	Magnaflux Bolt		4/10/91	U
615	Rollmark Caliber		4/10/91	Y.S.
617	Drill and Tap Sight Holes		APR 19 1991	LB
618	Polish Barrel		APR 19 1991	WB
620	Apply Coatings (Barrel Action)		5/10/91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/22/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/22/91	KS
	C) Inspect Ejector Hole for Chamfer		5/22/91	KS
	D) Oil Firing Pin Ass'y		5/22/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		5/24/91	JP

Op. #	Op. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5/24/91	JH
	G) Safety Off Force	3	3	3			5/24/91	JH
	H) Trigger Pull Test & Retainability						5/24/91	JH
	I) Firing Pin Indent	1021	1021	1021			5/24/91	JH
	J) Assemble Stock						5/25/91	KS
	K) Assemble Swivel Studs						6-3-91	D/H
	L) Attach Front and Rear Sight Assemblies						5/25/91	KS
	M) Iron Sight Alignment						5/25/91	KS
	N) Detach Front & Rear Sights & place in numbered container						5/25/91	KS
	O) Attach Scope to Rifle						5/25/91	KS
	P) Detach & Attach Scope 20 Times						5/25/91	KS
640	Gallery Target & Test						4/1/91	KJ
	A) Time							KJ
	B) Malfunctions							KJ
	C) Pierced Primers							KJ
	D) Optical Clarity of Scope							KJ
645	Inspect for Live Ammo						4/1/91	KJ
655	Final Inspection							
	A) Headspace						6-3-91	D/H
	B) Trigger Pull	240	247	256	258	267	6/3/91	JH
	C) Function						6-3-91	D/H
660	Pack						6-20-91	N

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6636066

DATE 5/24/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.60	2.48	2.50	2.60	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.55	2.44	2.48	2.47	
PULL #3	2.56	2.51	2.33	2.56	
PULL #4	2.60	2.45	2.44	2.58	
PULL #5	2.60	2.47	2.44	2.67	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.43	3.38		
PULL #2	3.33	3.37		
PULL #3	3.30	3.36		
PULL #4	3.31	3.45		
PULL #5	3.41	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	4.21	4.27		4.28
PULL #2	4.16	4.40		4.36
PULL #3	4.17	4.19		4.37
PULL #4	4.25	4.40		4.28
PULL #5	4.18	4.16		4.40
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636066
1 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.109882
1 TO	2	.3191
1 TO	3	.739157
1 TO	4	.39899
1 TO	5	.456396

$\frac{4}{2} \frac{3}{5}$ <----POA

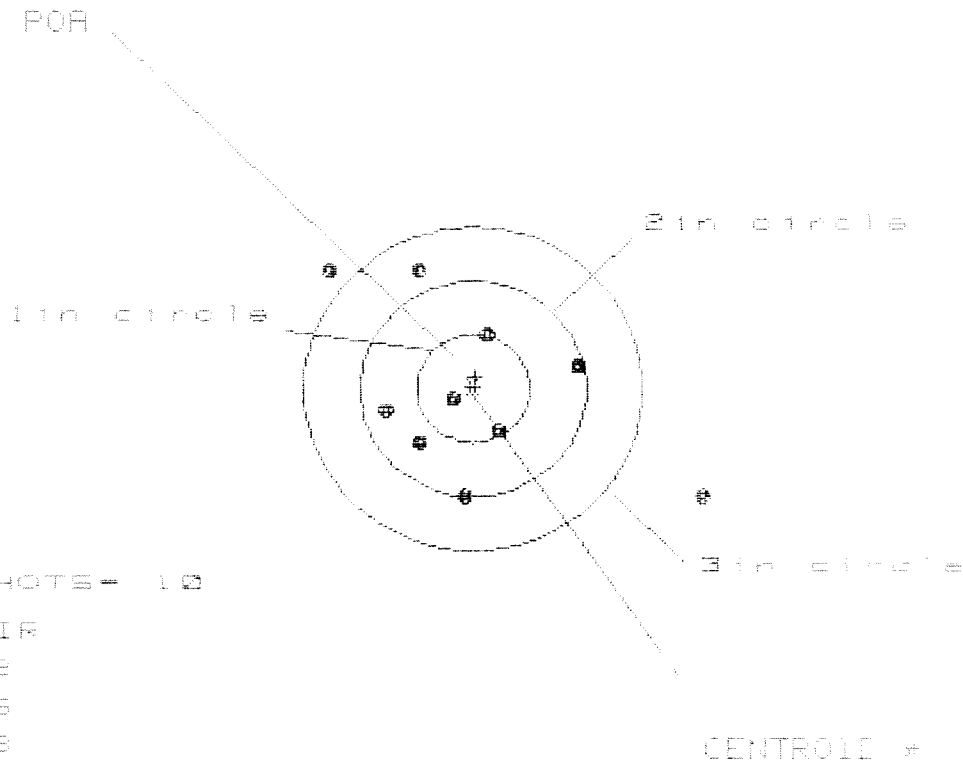
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1004
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0834
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .133771

THE AMR FOR THIS RIFLE IS: 1.101

1 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636066

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 2

2in = 6

3in = 8

HS = 3.268

VS = 2.177

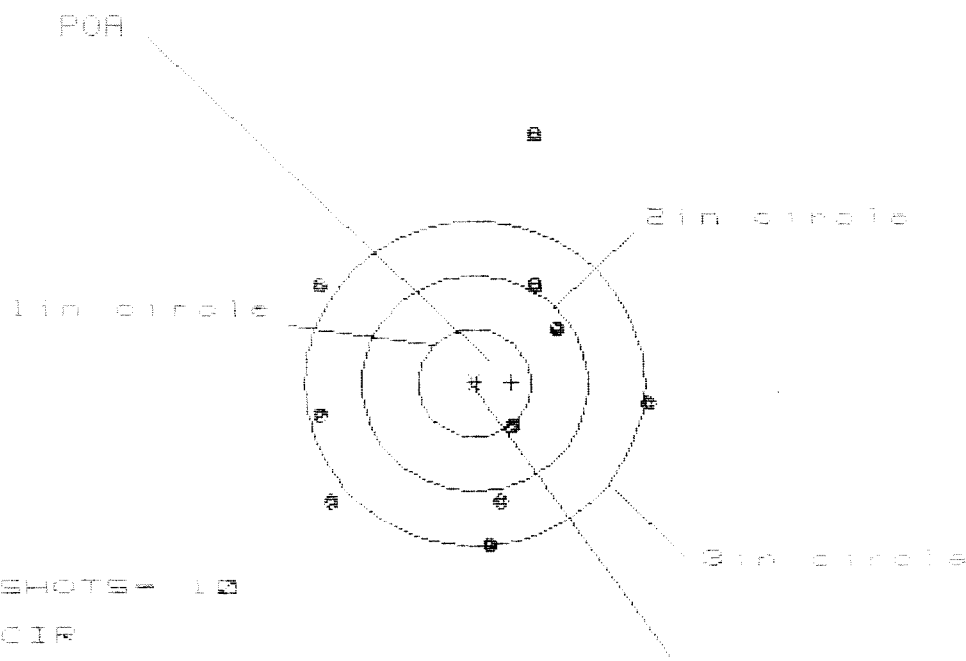
ES = 3.898

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.990	1.112	.980
MINIMUM X	:	-1.278	-1.056	-.659
MAXIMUM Y	:	1.148	1.041	1.154
MINIMUM Y	:	-1.029	-1.136	-1.086
CENTROID X	:	-.025	-.246	-.114
CENTROID Y	:	-.107	.000	-.130
POA TO CENTROID in.	:	.109	.246	.173
MIN RADIUS	:	.156	.177	.065
MEAN RADIUS	:	.972	.827	.709
MAX RADIUS	:	2.211	1.483	1.225
HORIZONTAL SPREAD	:	3.268	2.168	1.633
VERTICAL SPREAD	:	2.177	2.177	2.160
EXTREME SPREAD	:	3.898	2.483	2.200
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

1 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08638086

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 1

2in = 2

3in = 6

101 = 0.834

VS = 0.731

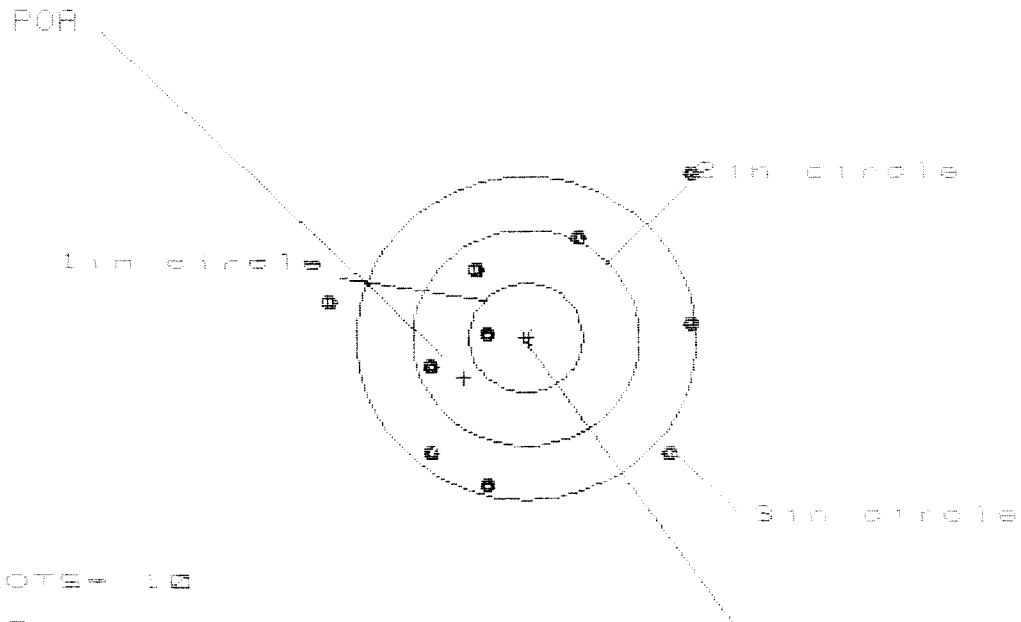
GS = 0.849

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.560	1.615	1.458
MINIMUM X	-1.374	-1.319	-1.476
MAXIMUM Y	2.266	1.159	1.049
MINIMUM Y	-1.465	-1.213	-1.323
CENTROID X	-0.329	-0.384	-0.227
CENTROID Y	-0.010	-0.262	-0.152
POA TO CENTROID in.	0.330	0.465	0.273
MIN RADIUS	0.482	0.365	0.307
MEAN RADIUS	1.365	1.230	1.169
MAX RADIUS	2.319	1.732	1.789
HORIZONTAL SPREAD	2.934	2.934	2.934
VERTICAL SPREAD	3.731	2.372	2.372
EXTREME SPREAD	3.849	3.114	3.114
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	6		

1 Jun 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 3

3 in = 7

HS = 3.146

VS = 2.855

GS = 3.468

CENTROID #

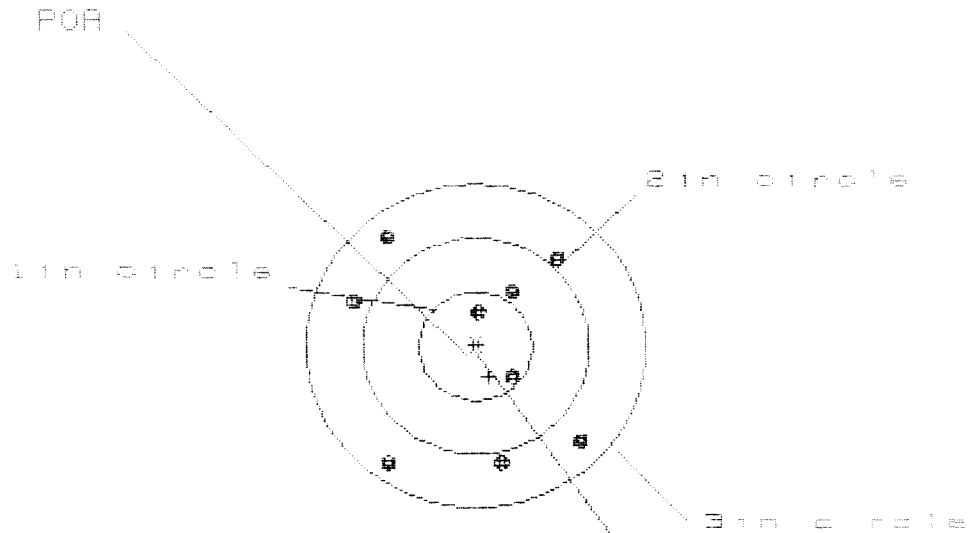
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.440	1.597	1.403
MINIMUM X	:	-1.706	-1.549	-1.929
MAXIMUM Y	:	1.524	1.145	1.214
MINIMUM Y	:	-1.331	-1.161	-1.092
CENTROID X	:	.543	.386	.586
CENTROID Y	:	.386	.196	.127
POR TO CENTROID in.	:	.655	.433	.594
MIN RADIUS	:	.320	.281	.463
MEAN RADIUS	:	1.274	1.157	1.119
MAX RADIUS	:	2.079	1.665	1.466
HORIZONTAL SPREAD	:	3.146	3.146	2.332
VERTICAL SPREAD	:	2.855	2.306	2.306
EXTREME SPREAD	:	3.468	3.289	2.605
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	3		
NUMBER IN THREE INCH CIRCLE	=	7		

1 Jun 1991

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CENTERFIRE PATTERNS

4



OF SHOTS- 18

IN CIR

1in = 3

2in = 4

3in = 10

HS= 1.806

VS= 2.126

GS= 2.484

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.874	.789	.682
MINIMUM X	:	-1.032	-1.117	-1.224
MAXIMUM Y	:	1.009	.885	.799
MINIMUM Y	:	-1.117	-1.175	-1.065
CENTROID X	:	-.118	-.033	.074
CENTROID Y	:	.281	.405	.295
POA TO CENTROID in.	:	.305	.407	.304
MIN RADIUS	:	.285	.161	.303
MEAN RADIUS	:	.875	.781	.736
MAX RADIUS	:	1.354	1.258	1.287
HORIZONTAL SPREAD	:	1.906	1.906	1.906
VERTICAL SPREAD	:	2.126	2.060	1.864
EXTREME SPREAD	:	2.484	2.484	2.289
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

1 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08636056

CENTERFIRE PATTERNS

5

POB

1 in circle

2 in circle

3 in circle

CENTROID +

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 6

3 in = 8

ME = 2.071

MS = 3.676

SE = 4.193

PATTERN #

5

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.303	1.288	1.269
MINIMUM X	:	-1.768	-1.623	-1.642
MAXIMUM Y	:	1.766	1.176	.936
MINIMUM Y	:	-2.110	-1.913	-1.967
CENTROID X	:	.431	.286	.305
CENTROID Y	:	-1.088	-1.285	-1.045
POB TO CENTROID in.	:	.440	.404	.308
MIN RADIUS	:	.127	.035	.055
MEAN RADIUS	:	1.018	.869	.707
MAX RADIUS	:	2.195	1.919	1.286
HORIZONTAL SPREAD	:	2.071	1.911	1.911
VERTICAL SPREAD	:	3.876	3.089	1.904
EXTREME SPREAD	:	4.193	3.100	2.051
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			8	