

C6611630

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Smith
Sword




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

MODEL 700TM M24

MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off. Marca Registrada Marqué Déposée.

SERIAL NO.
C6611630

ORDER NO.
5716



5716 C6611630



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611630

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 16	91	RW
600	Proof	1 16	91	RW
607	Check Headspace	1 16	91	RW
610	Dis-assemble Gun	1 16	91	RW
612	Magnaflux Barrel Action	1 18	91	KR
	Magnaflux Bolt	1 18	91	KR
615	Rollmark Caliber	1 18	91	SS
617	Drill and Tap Sight Holes	1 24	91	FB
618	Polish Barrel	1 24	91	WB
620	Apply Coatings (Barrel Action)		2-15-91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/18/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/18/91	RW
	C) Inspect Ejector Hole for Chamfer		2/18/91	RW
	D) Oil Firing Pin Ass'y		2/18/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2-18-91	104

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 ³ / ₄	5	5 ¹ / ₄			2-22-91	DH
	G) Safety Off Force	3	3	3			2-22-91	DH
	H) Trigger Pull Test & Retainability						2-22-91	DH
	I) Firing Pin Indent	.020	.021	.0215			2-22-91	DH
	J) Assemble Stock						3/1/91	RW
	K) Assemble Swivel Studs						3/2/91	WB
	L) Attach Front and Rear Sight Assemblies						3/1/91	RW
	M) Iron Sight Alignment						3/1/91	RW
	N) Detach Front & Rear Sights & place in numbered container						3/1/91	RW
	O) Attach Scope to Rifle						3/1/91	RW
	P) Detach & Attach Scope 20 Times						3/1/91	RW
640	Gallery Target & Test						3/1/91	KJ
	A) Time							KJ
	B) Malfunctions							KJ
	C) Pierced Primers							KJ
	D) Optical Clarity of Scope							KJ
645	Inspect for Live Ammo						3/1/91	KJ
655	Final Inspection							
	A) Headspace						3/2/91	WB
	B) Trigger Pull	2.36	2.40	2.67	2.62	2.60	3/2/91	WB
	C) Function						3/2/91	WB
660	Pack						5-15-91	DH

SWS TRIGGER PULL TEST

BARBER - M24 0079847

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6611630DATE 2-21-91TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.48	2.46	2.48	2.36	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.56	2.45	2.52	2.40	
PULL #3	2.59	2.40	2.54	2.67	
PULL #4	2.64	2.44	2.55	2.62	
PULL #5	2.49	2.45	2.43	2.60	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.22	3.41		
PULL #2	3.29	3.38		
PULL #3	3.32	3.41		
PULL #4	3.42	3.28		
PULL #5	3.40	3.27		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.38	4.47		4.24
PULL #2	4.40	4.48		4.27
PULL #3	4.36	4.46		4.21
PULL #4	4.49	4.48		4.00
PULL #5	4.14	4.38		4.26
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611630
1 Mar 1991

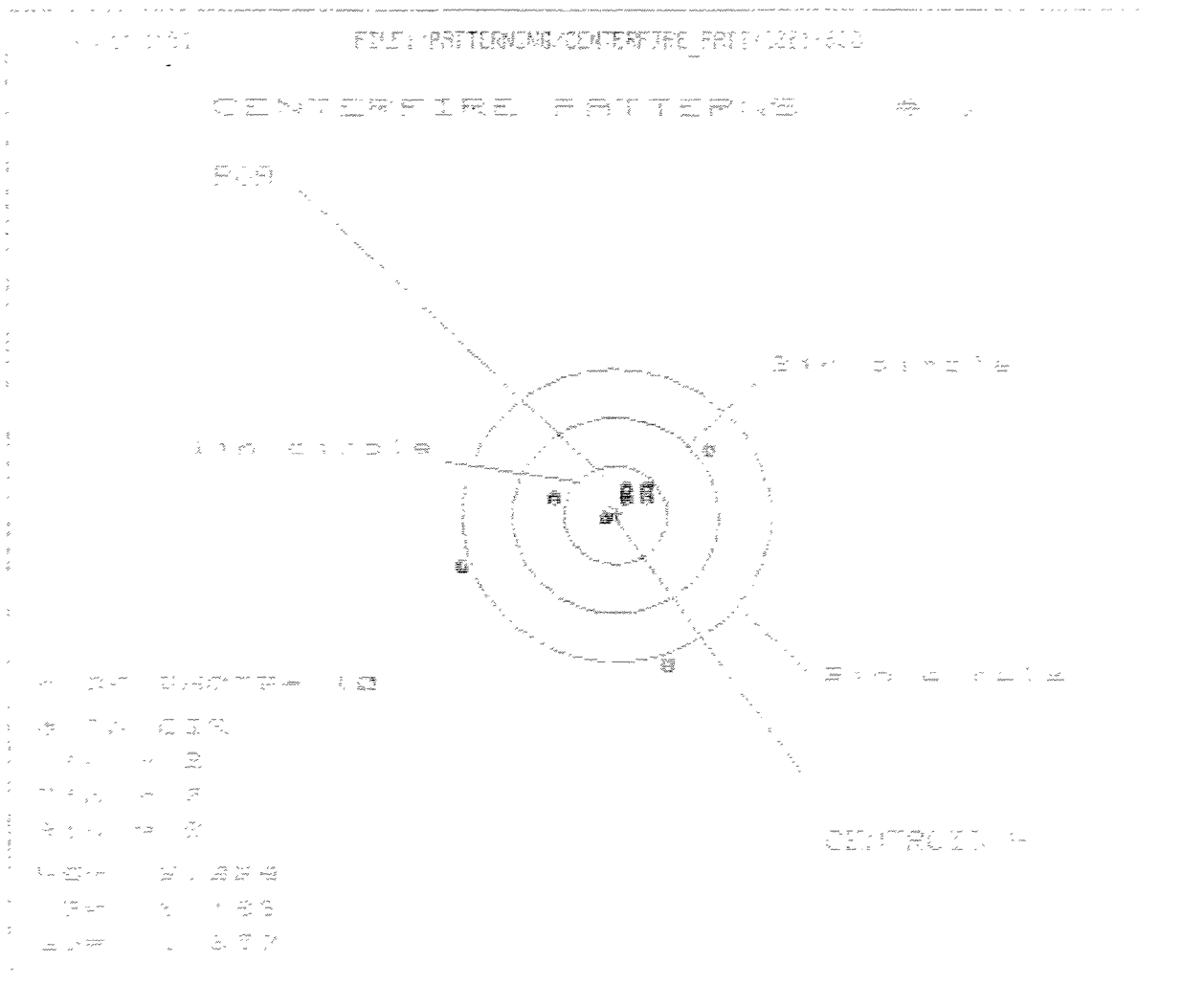
CENTROIDAL DISTANCES

0 TO	1	.207019
1 TO	2	.952476
1 TO	3	.0460109
1 TO	4	.29194
1 TO	5	.511645

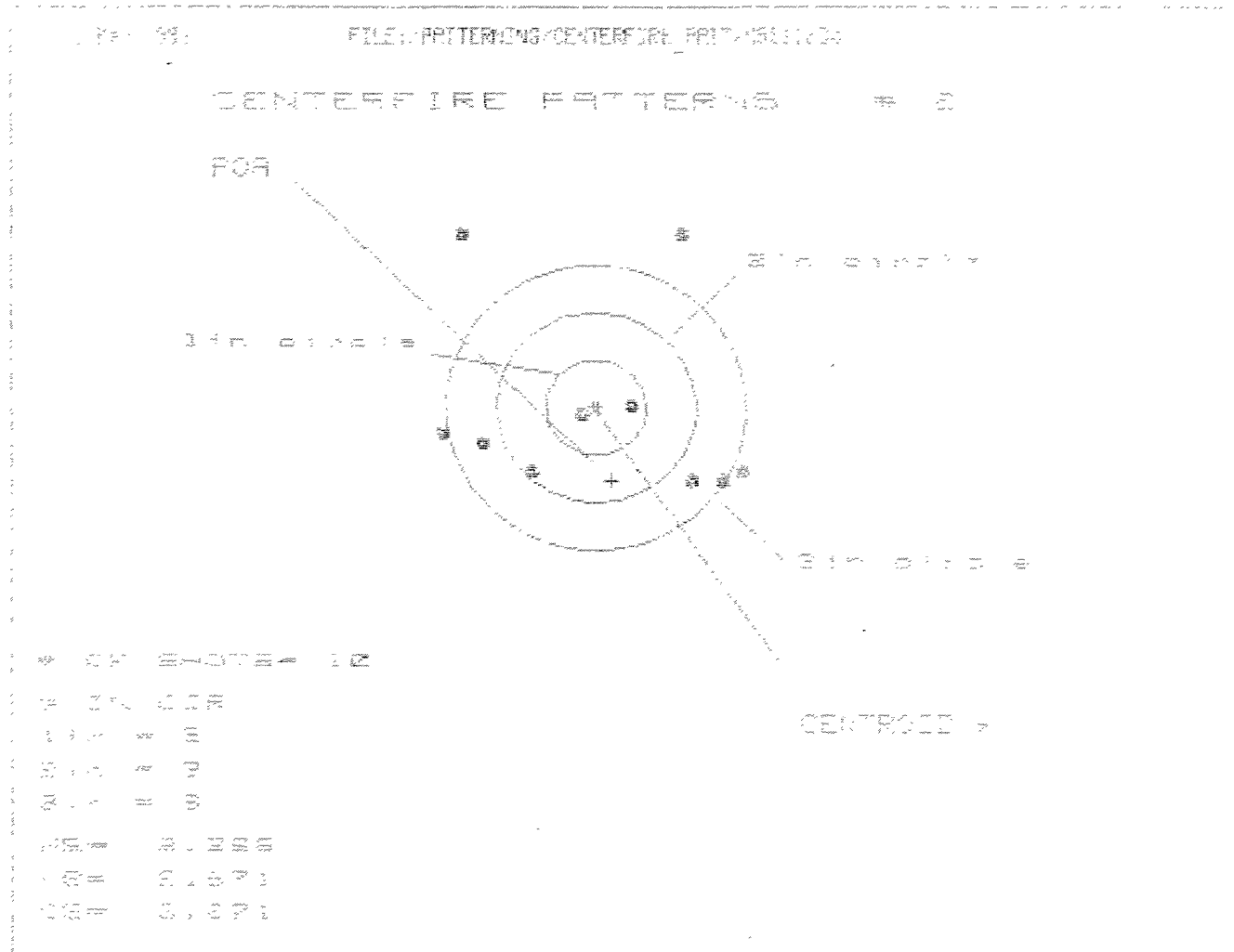
2
5
31

<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1352
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .168
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .215646
THE AMR FOR THIS RIFLE IS: 1.032



COORDINATE	10	9	8
1000 000 000	.874	.933	.982
1000 000 000	-1.489	-1.489	-1.747
1000 000 000	.698	.523	.437
1000 000 000	-1.588	-1.588	-1.851
1000 000 000	-1.104	-1.108	-1.350
1000 000 000	-1.179	-1.012	-1.214
1000 000 000	.287	.156	.077
1000 000 000	.068	.127	.038
1000 000 000	.646	.512	.380
1000 000 000	1.588	1.590	1.871
1000 000 000	2.368	2.368	2.810
1000 000 000	2.193	1.208	.868
1000 000 000	2.650	2.650	3.100
NUMBER OF ROUNDS IN EACH CIRCLE	=	8	
NUMBER OF ROUNDS IN EACH CIRCLE	=	7	
NUMBER OF ROUNDS IN EACH CIRCLE	=	6	



PATTERN #		2		
BOOTS LEFT OF		10	9	8
MAXIMUM		1.420	1.274	1.362
MINIMUM		-1.566	-1.712	-1.604
MAXIMUM		1.870	2.070	1.451
MINIMUM		-1.801	-1.601	-1.343
CENTERED		-1.157	-1.011	-1.099
CENTERED		.772	.572	.314
FOR TO CENTERED		.787	.573	.223
FOR PATTERN		.146	.279	.430
FOR PATTERN		1.201	1.145	1.012
FOR PATTERN		2.224	2.186	1.684
FOR PATTERN		2.986	2.986	2.996
FOR PATTERN		2.671	2.671	1.791
FOR PATTERN		3.671	3.232	3.010
FOR PATTERN		2	2	2
FOR PATTERN		3	3	3
FOR PATTERN		6	6	6

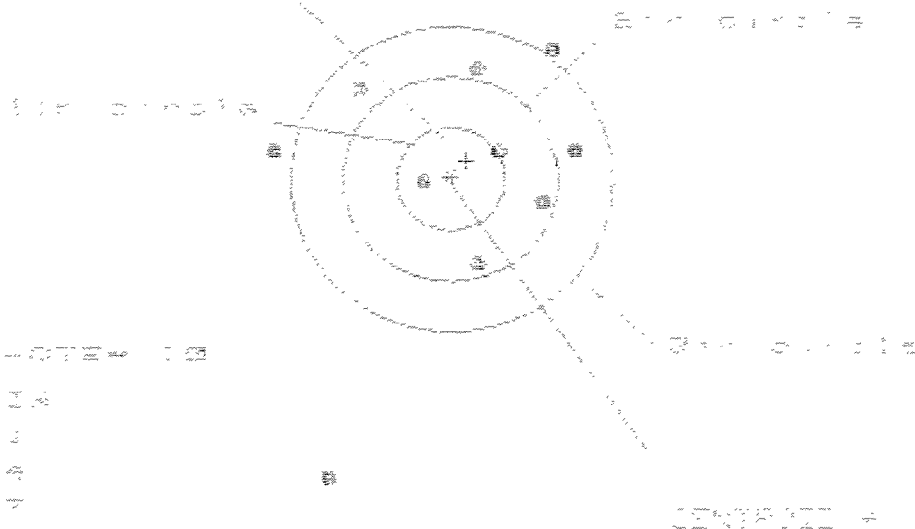
177 132

FILE: PATTERNING/CENTERFIRE_PATL_001133

CENTERFIRE PATTERNS

W 3

FOR



1 OF 4-078-100

4 INCH

4 INCH

4 INCH

4 INCH

100% 4 INCH

100% 4 INCH

100% 4 INCH

PATTERN 4

13

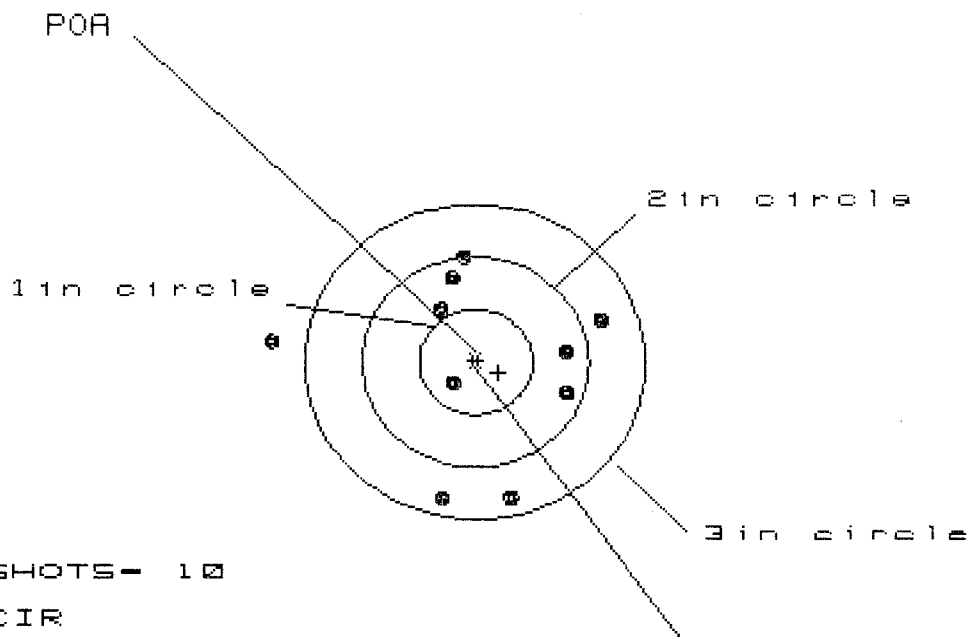
WADTS (BEST OF)	10	9	8
MAXIMUM	1.178	1.046	.881
MINIMUM	-1.685	-1.725	-1.188
MAXIMUM	1.268	.941	.931
MINIMUM	-2.947	-1.132	-1.148
CENTROID	-1.158	-1.028	.197
CENTROID	-1.188	.147	.187
CLX TO CENTROID	.234	.148	.157
CLX RADIUS	.228	.335	.126
CLX ANGLE	1.237	.974	.827
MAX RADIUS	3.171	1.737	1.815
HORIZONTAL SPREAD	2.783	2.763	2.811
VERTICAL SPREAD	4.213	2.873	2.873
EXTREME SPREAD	4.698	2.783	2.753
COUNT IN ONE 1/4 INCH CIRCLE	=	1	
COUNT IN TWO 1/4 INCH CIRCLE	=	4	
COUNT IN THREE 1/4 INCH CIRCLE	=	7	

1 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611630

CENTERFIRE PATTERNS

4



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 6

3 in = 9

HS = 2.947

VS = 2.299

GS = 2.954

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.106	.902	.914
MINIMUM X	:	-1.841	-.542	-.530
MAXIMUM Y	:	.980	1.004	.842
MINIMUM Y	:	-1.319	-1.295	-1.391
CENTROID X	:	-.202	.002	-.010
CENTROID Y	:	.096	.072	.234
POA TO CENTROID in.	:	.224	.072	.234
MIN RADIUS	:	.316	.475	.552
MEAN RADIUS	:	1.010	.902	.833
MAX RADIUS	:	1.853	1.339	1.484
HORIZONTAL SPREAD	:	2.947	1.444	1.444
VERTICAL SPREAD	:	2.299	2.299	2.233
EXTREME SPREAD	:	2.954	2.332	2.246
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

1 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611630

CENTERFIRE PATTERNS

5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS= 1.971

VS= 3.416

GS= 3.436

CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.814	.863	.549
MINIMUM X	-1.157	-1.108	-1.000
MAXIMUM Y	2.168	1.354	1.228
MINIMUM Y	-1.248	-1.007	-.864
CENTROID X	-.063	-.112	-.220
CENTROID Y	.331	.090	.216
POA TO CENTROID in.	.337	.144	.309
MIN RADIUS	.399	.202	.246
MEAN RADIUS	.984	.791	.741
MAX RADIUS	2.213	1.368	1.231
HORIZONTAL SPREAD	1.971	1.971	1.549
VERTICAL SPREAD	3.416	2.361	2.092
EXTREME SPREAD	3.436	2.588	2.097
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

RECEIVING REPORT

COMMENTS

ORDER

R 94-18361

INITIAL FDC CUSTOMER ORDER NO. DAAA09-92-C-0834

W/10X SCOPE, M-24 SNIPER, W/DEPLOYMENT KIT
ATTN: FRED MARTIN

90-
Scope 0445

DATE RECEIVED 06/11/94 DATE OPENED 06/11/94 DATE CODE SERIAL NUMBER C6811630 NEW SERIAL NUMBER MODEL AND GRADE 700 7.62 NATO
ACCESSORIES SLING STRAP HARD CASE SCOPE MNTS SCOPE BASE

FROM:

SHIP TO:

COMMANDER (W52H094138H226)
DEFENSE DIST DEPOT ANNISTON
ATTN DDAA-UR BLDG 112
ANNISTON AL 36201-5025

COMMANDER (W52H094138H226)
DEFENSE DIST DEPOT ANNISTON
ATTN DDAA-UR BLDG 112
ANNISTON AL 36201-5025

CUST NO: 098397 C.I.D.L

ACCOUNT NUMBER

ACCOUNT NUMBER N/C

WRITE ☐

PROM. DATE

ESTIMATED

VIA

FRT

GUN CONDITION

- ☐ NEW
☐ LIGHTLY WORN
☐ WORN
☐ VERY WORN
☐ UNREPAIRABLE
☐ MARRED

REPAIR CHARGE

EXCISE

TAX

INSURANCE

UPS

PARCEL POST

TOTAL

CUSTOMER CONCERN AMMO FUNCTION FINISH ACCURACY FIT INSPECT

CYCLE	B1					
TRIGGER GROUP	B3				E1	F1
BOLT ASSY.	B3				E2	F2
BARREL ASSY.	B4		D1		E3	F3
REC. ASSY.	B5		D2		E4	F4
WOOD		C1	D3		E5	F5
METAL		C2				
MAIN FAULT						

PARTS

COMMENTS

Trigger Assy \$173.31
CTI 50.00
\$223.31

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

GALLERY TESTER

DATE

DATE

DATE

DATE

DATE

OFFICE COPY

RD6925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 007989479893

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

SERIAL NO. 1661630DATE 11-17-94TESTER Bm

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.51	2.50	2.61		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.52	2.48	2.56		
PULL #3	2.49	2.60	2.59		
PULL #4	2.53	2.55	2.69		
PULL #5	2.62	2.52	2.66		
TOTAL	12.67	12.74	13.11		
AVG.	2.53	2.54	2.62		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.25	3.10		
PULL #2	3.16	3.21		
PULL #3	3.14	3.04		
PULL #4	3.12	3.08		
PULL #5	3.14	3.12		
TOTAL	15.81	15.55		
AVG.	3.16	3.11		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.00	4.29		4.27
PULL #2	4.18	4.16		4.15
PULL #3	4.00	4.16		4.17
PULL #4	4.30	4.22		4.08
PULL #5	4.05	4.10		4.11
TOTAL	20.53	20.93		20.78
AVG.	4.10	4.18		4.15

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611630

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock			
600	Proof			
607.	Check Headspace			
610	Dis-assemble Gun			
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	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			

op. #	BARBER - M24 0079857 OP. NAME	READINGS					DATE	INIT
525 cont.	F) Safety On Force	5 1/2	6	6			12/14	WB
	G) Safety Off Force	3	3	3			12/14	WB
	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							
540	Gallery Target & Test							
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection A) Headspace							
	B) Trigger Pull	2.74	2.75	2.74	2.69	2.62	12/14	WB
	C) Function							
660	Pack							