

C6649261

MODEL 706™ N24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Smith
Ward




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

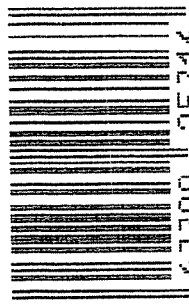
MODEL 700TM H24

SERIAL NO.
C6649261

ORDER NO.
5716

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

UPC



0 47700 25716 7



5716 C6649261

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649261

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 2	9 1	RW
600	Proof	7 2	9 1	RW
607	Check Headspace	7 2	9 1	RW
610	Dis-assemble Gun	7 2	9 1	RW
612	Magnaflux Barrel Action		JUL 22 1991	JS
	Magnaflux Bolt		JUL 22 1991	JS
615	Rollmark Caliber		JUL 22 1991	JS
617	Drill and Tap Sight Holes		JUL 22 1991	JS
618	Polish Barrel		7/28/91	WB
620	Apply Coatings (Barrel Action)		8-2-91	JS
	Apply Coating (Bolt)		8-2-91	JS
625	Final Assembly			
	A) Clean inside of Bolt Assembly		8/9/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/9/91	RW
	C) Inspect Ejector Hole for Chamfer		8/9/91	RW
	D) Oil Firing Pin Ass'y		8/9/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8-12-91	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8-12-91	GH
	G) Safety Off Force	3	3	3			8-12-91	GH
	H) Trigger Pull Test & Retainability						8-12-91	GH
	I) Firing Pin Indent	.0205	.020	.020			8-12-91	GH
	J) Assemble Stock						8-14-91	RW
	K) Assemble Swivel Studs						8-17-91	DH
	L) Attach Front and Rear Sight Assemblies						8-14-91	RW
	M) Iron Sight Alignment						8-14-91	RW
	N) Detach Front & Rear Sights & place in numbered container						8-14-91	RW
	O) Attach Scope to Rifle						8-14-91	RW
	P) Detach & Attach Scope 20 Times						8-14-91	RW
640	Gallery Target & Test						8-15-91	AC
	A) Time						8-15-91	AC
	B) Malfunctions						8-15-91	AC
	C) Pierced Primers						8-15-91	AC
	D) Optical Clarity of Scope						8-15-91	AC
645	Inspect for Live Ammo						8-15-91	AC
655	Final Inspection						8-17-91	DH
	A) Headspace						8-17-91	DH
	B) Trigger Pull	2.73	2.32	2.28	2.32	2.29	8-17-91	DH
	C) Function						8-17-91	DH
660	Pack						9-16-91	AF

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6649261

DATE 8-12-91

TESTER JM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.35	2.32	2.48	2.33	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.25	2.49	2.48	2.32	
PULL #3	2.58	2.44	2.44	2.28	
PULL #4	2.48	2.50	2.47	2.32	
PULL #5	2.46	2.50	2.45	2.29	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.60	3.53		
PULL #2	3.52	3.46		
PULL #3	3.36	3.51		
PULL #4	3.31	3.52		
PULL #5	3.44	3.48		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.44	4.45		4.38
PULL #2	4.45	4.46		4.38
PULL #3	4.33	4.60		4.25
PULL #4	4.26	4.36		4.24
PULL #5	4.39	4.32		4.28
TOTAL				
AVG.				

no. 90

0 TO	1	.107424
1 TO	2	.17623
1 TO	3	.0994786
1 TO	4	.200661
1 TO	5	.475925

6-1-100

M2400067101

29 AUG 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C664B261

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 10

CE= 1.815

VE= 2.613

GE= 2.783

PATTERN #

1

SHOTS (BEST OF)

MAXIMUM X

MINIMUM X

MAXIMUM Y

MINIMUM Y

CENTROID X

CENTROID Y

POA TO CENTROID in.

MIN RADIUS

MEAN RADIUS

MAX RADIUS

HORIZONTAL SPREAD

VERTICAL SPREAD

EXTREME SPREAD

NUMBER IN ONE INCH CIRCLE =

NUMBER IN TWO INCH CIRCLE =

NUMBER IN THREE INCH CIRCLE =

10

9

8

.947

.933

1.046

-.868

-.882

-.766

1.135

.971

1.087

-1.478

-.643

-.527

-.052

-.038

-.155

-.094

.070

-.046

.108

.079

.161

.305

.469

.356

.923

.876

.782

1.483

1.313

1.104

1.815

1.815

1.812

2.613

1.614

1.614

2.783

2.258

1.806

1

7

10

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649261

CENTERFIRE PATTERNS

2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS= 2.683

VS= 3.125

GS= 3.499

CENTROID *

PATTERN #

2

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.485

1.307

1.380

MINIMUM X

-1.278

-1.376

-1.302

MAXIMUM Y

1.511

1.332

.579

MINIMUM Y

-1.614

-1.138

-.972

CENTROID X

.124

.222

.149

CENTROID Y

-.103

.076

-.090

POA TO CENTROID in.

.161

.235

.174

MIN RADIUS

.152

.154

.125

MEAN RADIUS

1.011

.885

.820

MAX RADIUS

1.842

1.456

1.383

HORIZONTAL SPREAD

2.683

2.683

2.683

VERTICAL SPREAD

3.125

2.470

1.551

EXTREME SPREAD

3.499

2.783

2.684

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

5

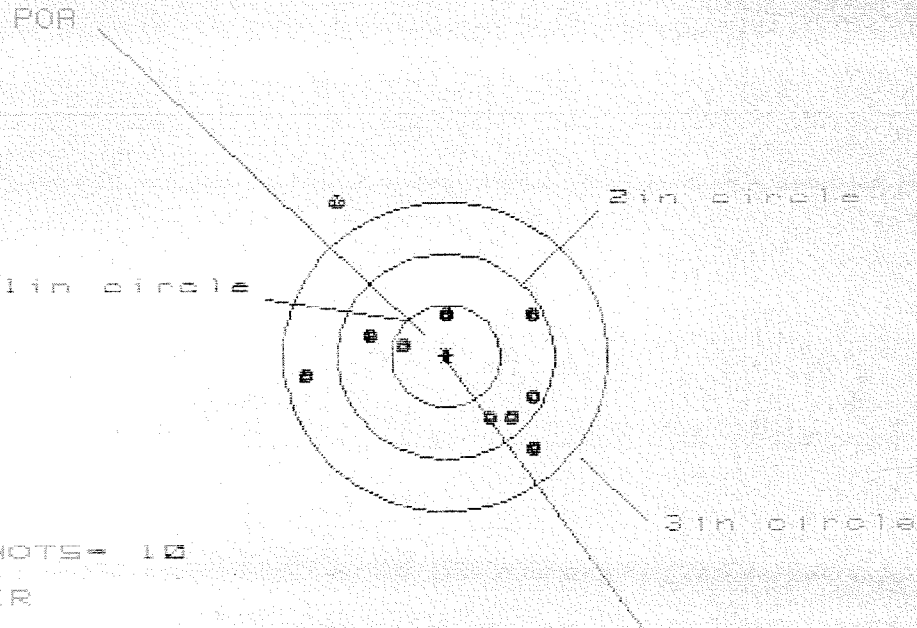
NUMBER IN THREE INCH CIRCLE =

8

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6849261

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 2.139

VS= 2.414

GS= 2.970

PATTERN #

13

SHOTS (BEST OF)

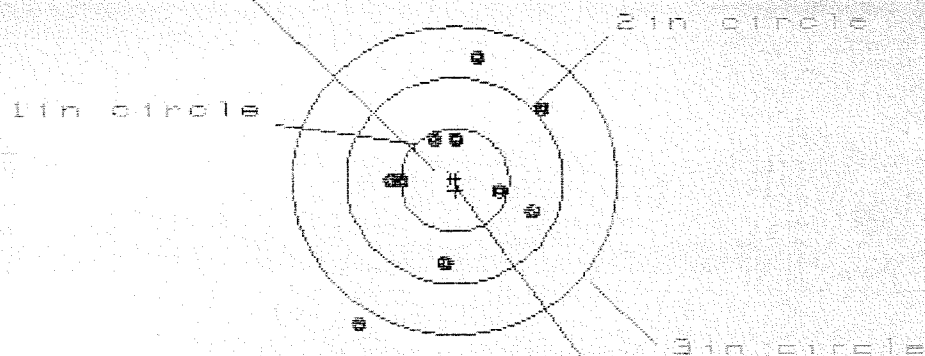
		10	9	8
MAXIMUM X		.824	.717	.539
MINIMUM X		-1.315	-1.422	-.980
MAXIMUM Y		1.514	.617	.610
MINIMUM Y		-.900	-.732	-.739
CENTROID X		-.002	.105	.283
CENTROID Y		-.008	-.176	-.169
POB TO CENTROID in.		.008	.205	.329
MIN RADIUS		.396	.477	.406
MEAN RADIUS		.916	.802	.699
MAX RADIUS		1.794	1.423	1.033
HORIZONTAL SPREAD		2.139	2.139	1.499
VERTICAL SPREAD		2.414	1.349	1.349
EXTREME SPREAD		2.970	2.243	1.826
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=			9

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8645261

CENTERFIRE PATTERNS # 4

POA



OF SHOTS= 10

IN CIR

1in = 4

2in = 7

3in = 9

HS= 1.770

VS= 2.644

GS= 2.871

CENTROID #

PATTERN #

SHOTS (BEST OF)

	10	9	8
MAXIMUM X	.856	.754	.767
MINIMUM X	-.914	-.713	-.700
MAXIMUM Y	1.235	1.078	.693
MINIMUM Y	-1.409	-.990	-.855
CENTROID X	-.009	.093	.080
CENTROID Y	.102	.258	.123
POA TO CENTROID in.	.102	.274	.147
MIN RADIUS	.407	.268	.332
MEAN RADIUS	.800	.686	.633
MAX RADIUS	1.689	1.083	1.034
HORIZONTAL SPREAD	1.770	1.467	1.467
VERTICAL SPREAD	2.644	2.068	1.548
EXTREME SPREAD	2.871	2.083	1.790
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

28 Aug 1991

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CENTERFIRE PATTERNS

5

POB

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 8

HS= 2.217

VS= 2.333

GS= 3.151

CENTROID #

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.081

.996

.882

MINIMUM X

-1.136

-1.016

-1.138

MAXIMUM Y

1.172

.908

.779

MINIMUM Y

-1.161

-1.031

-1.561

CENTROID X

.289

.169

.283

CENTROID Y

.238

.108

.237

POB TO CENTROID in.

.375

.200

.369

MIN RADIUS

.170

.148

.175

MEAN RADIUS

.887

.799

.715

MAX RADIUS

1.594

1.390

1.157

HORIZONTAL SPREAD

2.217

2.012

2.012

VERTICAL SPREAD

2.333

1.939

1.340

EXTREME SPREAD

3.151

2.516

2.137

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

7

NUMBER IN THREE INCH CIRCLE =

8