

C6611642

MODEL 700™ M24

Model SWS™

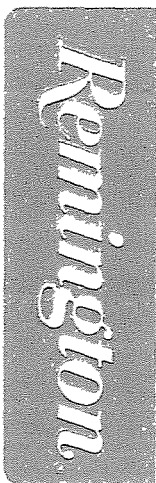
Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.



Smith
Snead

Remington



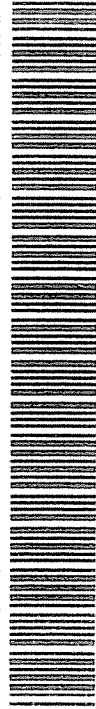
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700™ H24

SERIAL NO.
C6611640

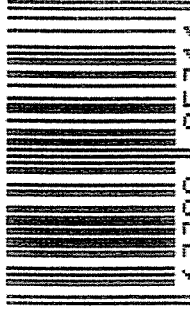
ORDER NO.
5716

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



5716 C6611640

UPC



0 47700 25716 7

GUN SERIAL #

C6611640

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/19/91	K.S.
600	Proof		3/19/91	K.S.
607	Check Headspace		3/19/91	K.S.
610	Dis-assemble Gun		3/19/91	K.S.
612	Magnaflux Barrel Action		3/28/91	KR
	Magnaflux Bolt		11	KR
615	Rollmark Caliber		u	GL
617	Drill and Tap Sight Holes	APR	3 1991	FRB
618	Polish Barrel	APR	3 1991	WLB
620	Apply Coatings (Barrel Action)		4-19-91	JA
	Apply Coating (Bolt)			
625	Final Assembly		5/1/91	KS
	A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/1/91	KS
	C) Inspect Ejector Hole for Chamfer		5/1/91	KS
	D) Oil Firing Pin Ass'y		5/1/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		5-16-91	RM

Op. #	Op. NAME	READINGS						
625 cont.	F) Safety On Force	5	5	5	5-16-91	JL		
	G) Safety Off Force	3	3	3	5-16-91	JL		
	H) Trigger Pull Test & Retainability				5-16-91	JL		
	I) Firing Pin Indent	.0225	.0225	.0225	5-16-91	JL		
	J) Assemble Stock				5/16/91	KS		
	K) Assemble Swivel Studs				5-20-91	A		
	L) Attach Front and Rear Sight Assemblies				5/14/91	KS		
	M) Iron Sight Alignment				5/14/91	KS		
	N) Detach Front & Rear Sights & place in numbered container				5/14/91	KS		
	O) Attach Scope to Rifle				5/14/91	KS		
	P) Detach & Attach Scope 20 Times				5/14/91	KS		
640	Gallery Target & Test				5-17-91	AF		
	A) Time				"	AF		
	B) Malfunctions				"	AF		
	C) Pierced Primers				"	AF		
	D) Optical Clarity of Scope				"	AF		
645	Inspect for Live Ammo				5-17-91	AF		
655	Final Inspection							
	A) Headspace				5-20-91	A		
	B) Trigger Pull	2.46	2.50	2.56	2.63	2.69	5/20/91	JL
	C) Function				5-20-91	A		
660	Pack				6-17-91	AF		

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6611640

DATE 5-16-91

TESTER JLI

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.34	2.28	2.30	2.46	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.32	2.28	2.36	2.50	
PULL #3	2.31	2.29	2.48	2.56	
PULL #4	2.23	2.29	2.28	2.43	
PULL #5	2.20	2.28	2.32	2.69	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.33	3.42		
PULL #2	3.34	3.40		
PULL #3	3.35	3.38		
PULL #4	3.32	3.36		
PULL #5	3.36	3.38		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.48	4.46		4.41
PULL #2	4.48	4.39		4.42
PULL #3	4.40	4.39		4.45
PULL #4	4.49	4.20		4.49
PULL #5	4.46	4.44		4.43
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611640
17 May 1991

CENTROIDAL DISTANCES

0 TO	1	.395214
1 TO	2	.611543
1 TO	3	.602224
1 TO	4	.509086
1 TO	5	.19638

Fig <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0486
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .070
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS:

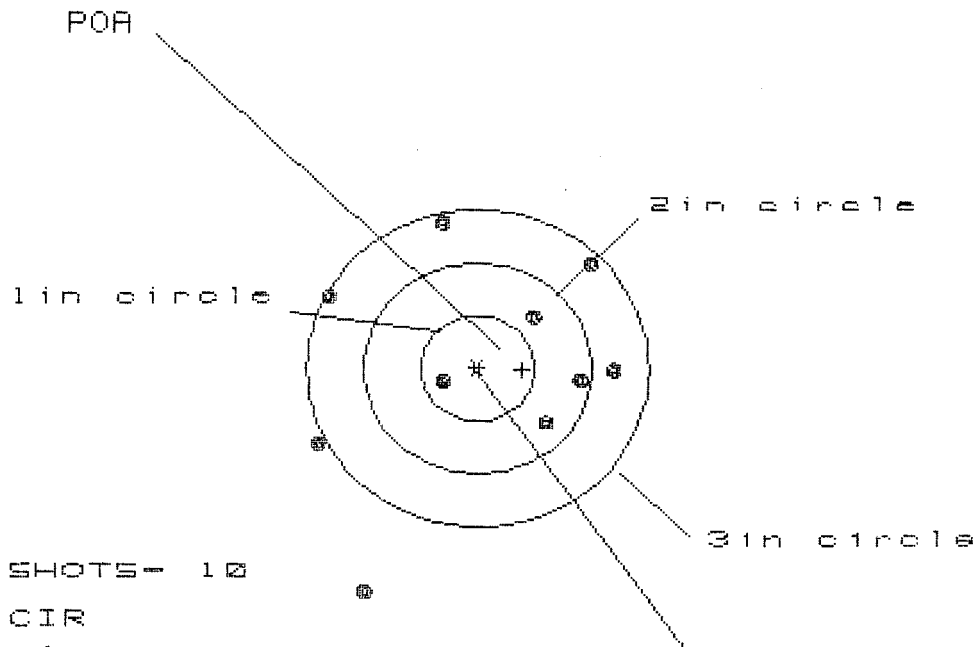
THE AMR FOR THIS RIFLE IS: 1.157

17 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B11640

CENTERFIRE PATTERNS

1



OF SHOTS - 10

IN CIR

1in = 1

2in = 4

3in = 8

HS = 2.593

VS = 3.516

GS = 3.726

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.238	1.131	.948
MINIMUM X	-1.355	-1.462	-1.583
MAXIMUM Y	1.392	1.156	1.037
MINIMUM Y	-2.124	-.947	-.841
CENTROID X	-.395	-.288	-.105
CENTROID Y	.013	.249	.368
POA TO CENTROID in.	.395	.381	.382
MIN RADIUS	.353	.427	.209
MEAN RADIUS	1.219	1.066	.942
MAX RADIUS	2.332	1.742	1.617
HORIZONTAL SPREAD	2.593	2.593	2.531
VERTICAL SPREAD	3.516	2.103	1.978
EXTREME SPREAD	3.726	2.948	2.637
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

17 May 1991

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CENTERFIRE PATTERNS

2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 4

3 in = 6

HS= 4.154

VS= 2.097

GS= 4.428

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.968	1.514	1.268
MINIMUM X	:	-2.186	-1.967	-1.525
MAXIMUM Y	:	1.397	1.532	1.509
MINIMUM Y	:	-.700	-.565	-.588
CENTROID X	:	.201	-.018	.228
CENTROID Y	:	.150	.015	.038
POA TO CENTROID in.	:	.251	.023	.231
MIN RADIUS	:	.453	.372	.345
MEAN RADIUS	:	1.226	1.077	.933
MAX RADIUS	:	2.313	1.976	1.782
HORIZONTAL SPREAD	:	4.154	3.481	2.793
VERTICAL SPREAD	:	2.097	2.097	2.097
EXTREME SPREAD	:	4.428	3.598	3.089
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	

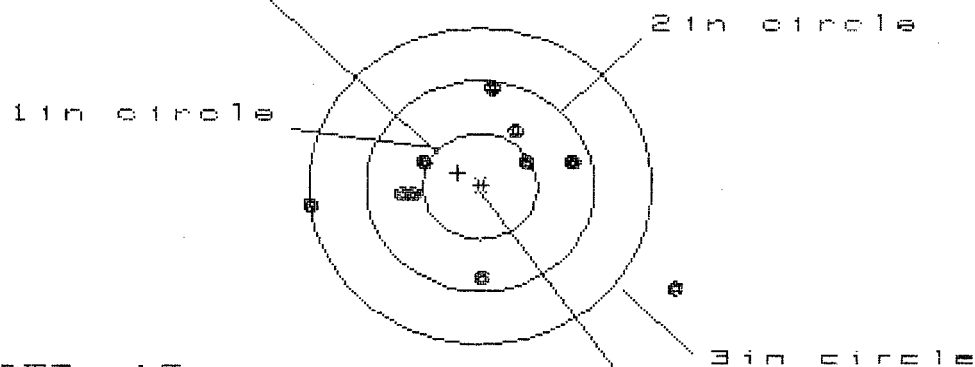
17 May 1991

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CENTERFIRE PATTERNS

3

POA



OF SHOTS- 10

IN CIR

1in = 1

2in = 8

3in = 8

HS= 3.202

VS= 1.934

GS= 3.301

CENTROID #

PATTERN #	:	31		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.682	.987	.820
MINIMUM X	:	-1.520	-1.333	-.625
MAXIMUM Y	:	.966	.859	.825
MINIMUM Y	:	-.968	-1.010	-1.044
CENTROID X	:	.190	.003	.170
CENTROID Y	:	-.130	-.022	.012
POA TO CENTROID in.	:	.230	.022	.170
MIN RADIUS	:	.455	.363	.415
MEAN RADIUS	:	.896	.747	.663
MAX RADIUS	:	1.940	1.360	1.044
HORIZONTAL SPREAD	:	3.202	2.320	1.445
VERTICAL SPREAD	:	1.934	1.869	1.869
EXTREME SPREAD	:	3.301	2.350	1.874
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		8	

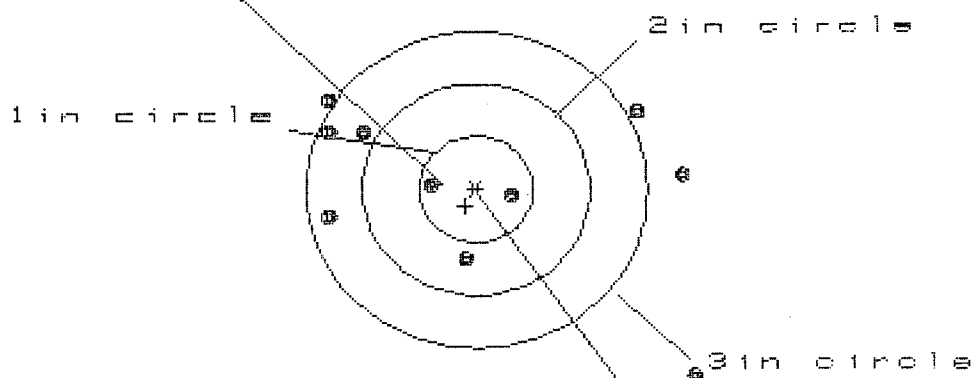
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CENTERFIRE PATTERNS

4

POA



OF SHOTS- 10

IN CIR

1 in - 2

2 in - 3

3 in - 6

HS- 3.267

VS- 2.539

GS- 4.138

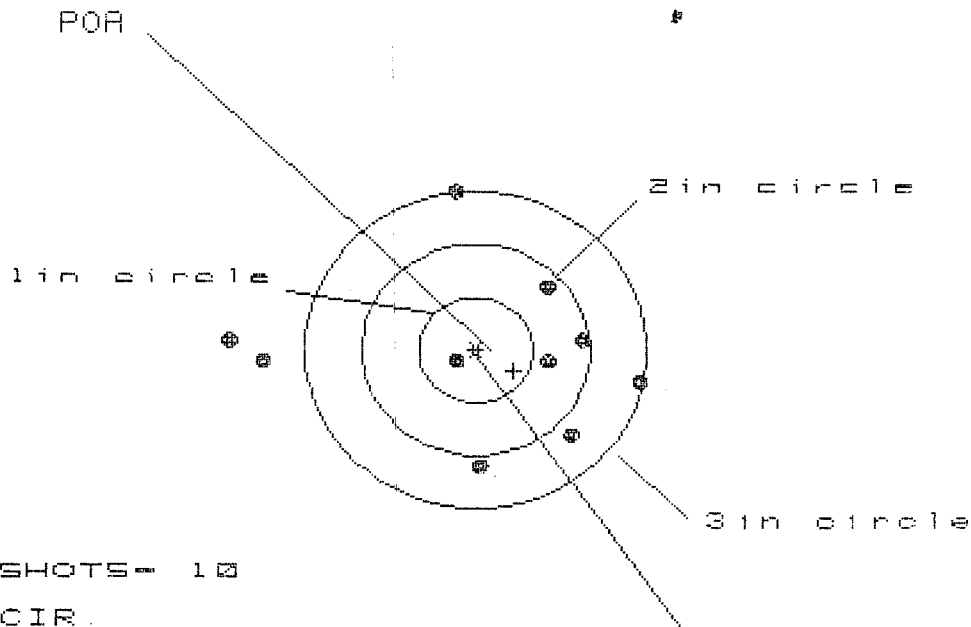
CENTROID *

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.936	2.041	1.832
MINIMUM X	:	-1.331	-1.116	-.861
MAXIMUM Y	:	.824	.634	.629
MINIMUM Y	:	-1.715	-.895	-.900
CENTROID X	:	.093	-.122	-.377
CENTROID Y	:	.158	.348	.353
POA TO CENTROID in.	:	.183	.369	.516
MIN RADIUS	:	.283	.250	.196
MEAN RADIUS	:	1.275	1.094	.923
MAX RADIUS	:	2.586	2.041	1.906
HORIZONTAL SPREAD	:	3.267	3.157	2.693
VERTICAL SPREAD	:	2.539	1.529	1.529
EXTREME SPREAD	:	4.138	3.228	2.813
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	3		
NUMBER IN THREE INCH CIRCLE	=	6		

17 May 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR.

1 in = 1

2 in = 4

3 in = 7

HS = 3.508

VS = 2.572

GS = 3.527

CENTROID #

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.386	1.150	.885
MINIMUM X	-2.122	-2.128	-.655
MAXIMUM Y	1.515	1.527	1.520
MINIMUM Y	-1.057	-1.045	-1.051
CENTROID X	-.332	-.096	.169
CENTROID Y	.199	.187	.193
POA TO CENTROID in.	.387	.210	.257
MIN RADIUS	.163	.392	.156
MEAN RADIUS	1.167	1.009	.801
MAX RADIUS	2.125	2.128	1.654
HORIZONTAL SPREAD	3.508	3.278	1.540
VERTICAL SPREAD	2.572	2.572	2.572
EXTREME SPREAD	3.527	3.283	2.576
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		