

C6522314

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.





MODEL 700TH H24



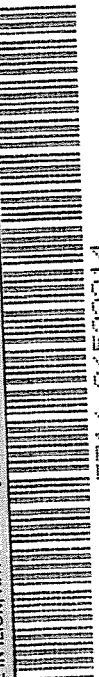
REG. U.S. PAT. & TM. OFF.

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

SERIAL NO.
C6522314

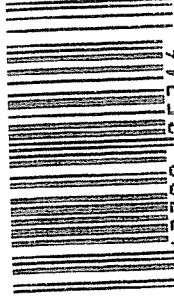
ORDER NO.
5716

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



5716 C6522314

UPC



0 47700 25716 7

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522314
12 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.414673
1 TO	2	.541223
1 TO	3	.369962
1 TO	4	.308691
1 TO	5	.293743



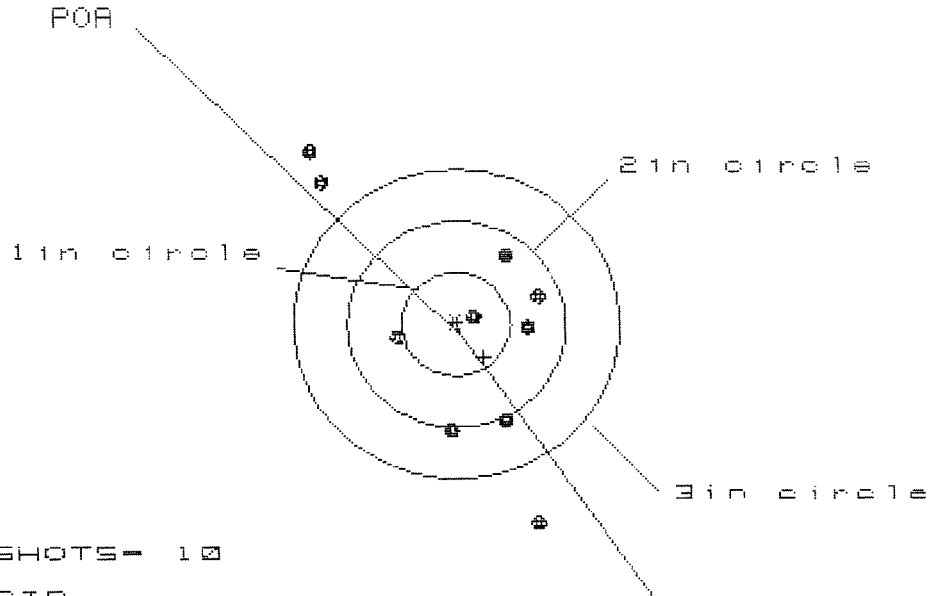
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2226
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0316
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .224832
THE AMR FOR THIS RIFLE IS: 1.257

12 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8522314

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 7

HS= 2.0330

VS= 3.587

GS= 4.113

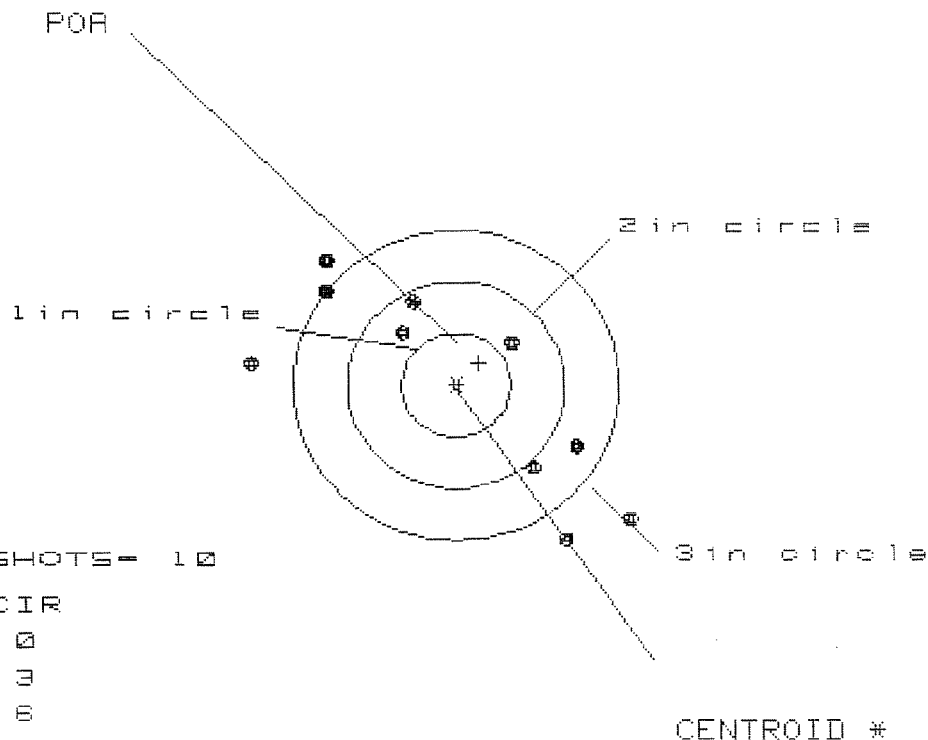
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.734	.589	.661
MINIMUM X	:	-1.296	-1.437	-1.365
MAXIMUM Y	:	1.687	1.598	1.384
MINIMUM Y	:	-1.900	-1.712	-1.051
CENTROID X	:	-.255	-.110	-.182
CENTROID Y	:	.327	.139	.353
POA TO CENTROID in.	:	.414	.178	.397
MIN RADIUS	:	.165	.230	.088
MEAN RADIUS	:	1.116	.975	.856
MAX RADIUS	:	2.128	2.149	1.944
HORIZONTAL SPREAD	:	2.030	2.026	2.026
VERTICAL SPREAD	:	3.587	3.310	2.435
EXTREME SPREAD	:	4.113	3.872	2.942
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 3

3 in = 6

HS= 3.483

VS= 2.696

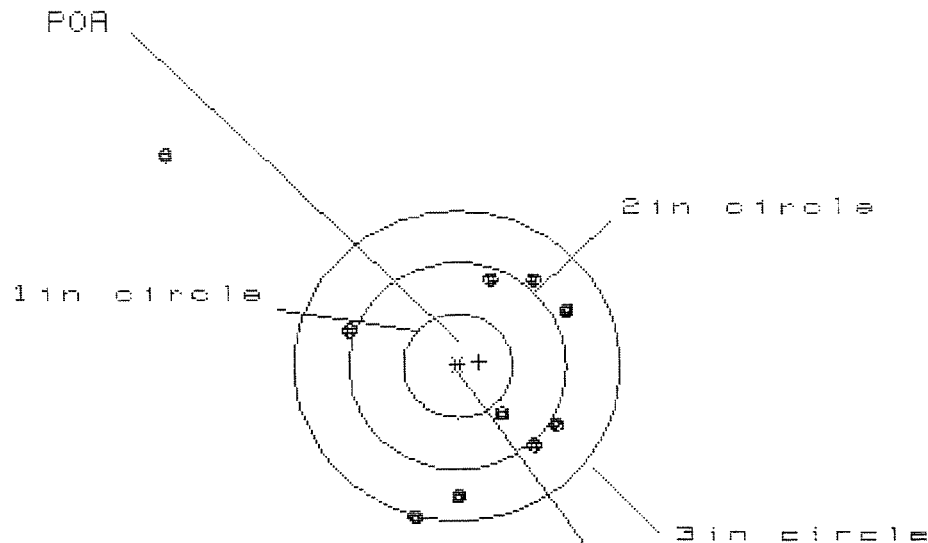
GS= 3.783

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.610	1.329	1.117
MINIMUM X	-1.873	-1.694	-1.249
MAXIMUM Y	1.230	1.092	1.103
MINIMUM Y	-1.466	-1.604	-1.593
CENTROID X	-.206	-.385	-.173
CENTROID Y	-.212	-.074	-.085
POA TO CENTROID in.	.296	.392	.193
MIN RADIUS	.682	.501	.587
MEAN RADIUS	1.358	1.250	1.186
MAX RADIUS	2.036	1.988	1.861
HORIZONTAL SPREAD	3.483	3.023	2.366
VERTICAL SPREAD	2.696	2.696	2.696
EXTREME SPREAD	3.783	3.487	3.487
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	6		

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 0

2in = 2

3in = 8

HS = 3.735

VS = 3.457

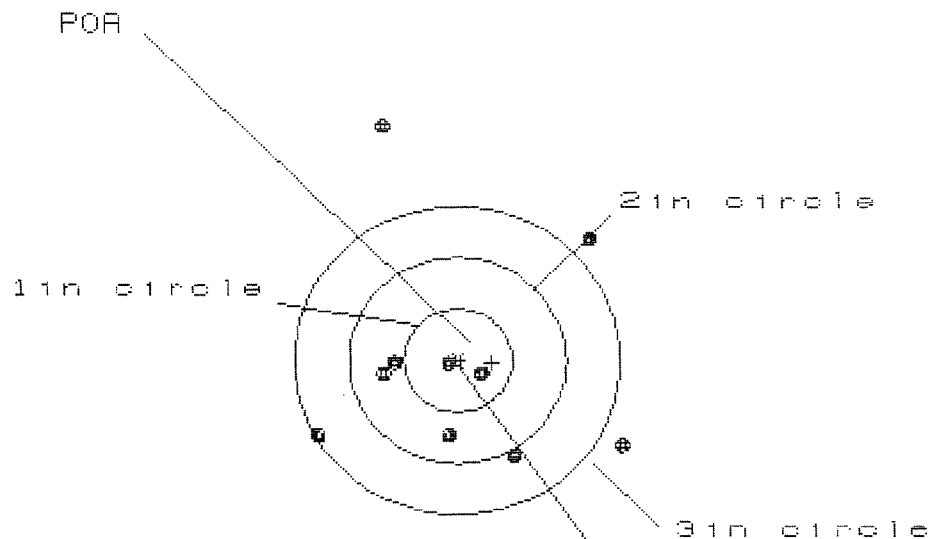
GS = 4.481

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.009	.706	.622
MINIMUM X	:	-2.726	-1.305	-1.389
MAXIMUM Y	:	2.043	1.097	.948
MINIMUM Y	:	-1.414	-1.187	-1.229
CENTROID X	:	-.201	.102	.186
CENTROID Y	:	-.039	-.266	-.117
POA TO CENTROID in.	:	.205	.285	.220
MIN RADIUS	:	.639	.289	.422
MEAN RADIUS	:	1.315	.981	.926
MAX RADIUS	:	3.406	1.421	1.449
HORIZONTAL SPREAD	:	3.735	2.011	2.011
VERTICAL SPREAD	:	3.457	2.284	2.177
EXTREME SPREAD	:	4.481	2.482	2.240
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 7

HS= 2.753

VS= 3.240

GS= 3.779

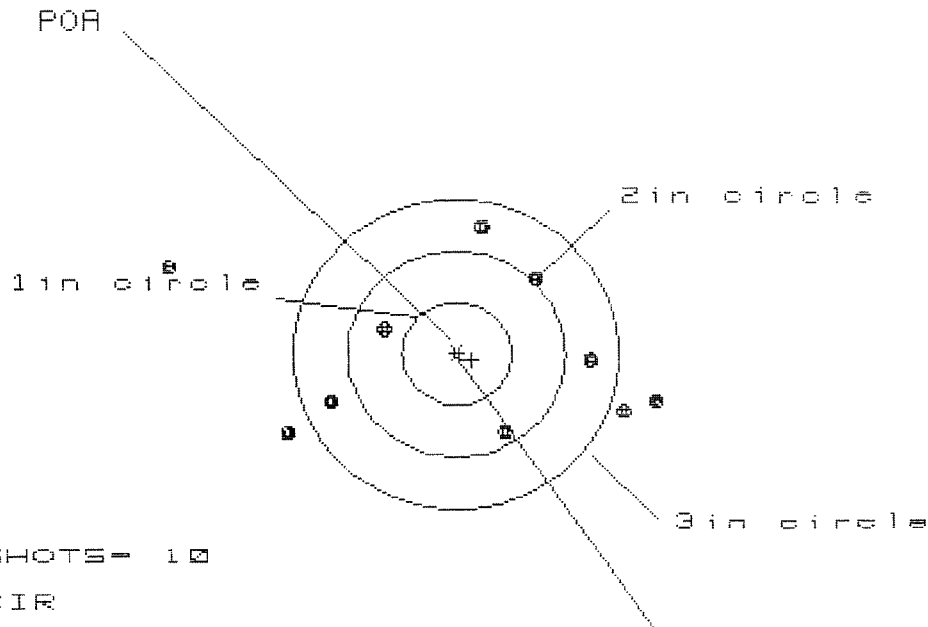
CENTROID *

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.494	1.417	1.264
MINIMUM X	-1.259	-1.336	-1.159
MAXIMUM Y	2.271	1.400	1.331
MINIMUM Y	-.969	-.717	-.786
CENTROID X	-.314	-.236	-.413
CENTROID Y	.024	-.228	-.159
POA TO CENTROID in.	.314	.328	.443
MIN RADIUS	.089	.192	.193
MEAN RADIUS	1.053	.886	.776
MAX RADIUS	2.376	1.773	1.836
HORIZONTAL SPREAD	2.753	2.753	2.423
VERTICAL SPREAD	3.240	2.117	2.117
EXTREME SPREAD	3.779	3.075	3.075
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		7	

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 2

3 in = 8

HS= 4.506

VS= 2.023

GS= 4.694

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.863
MINIMUM X	-2.643
MAXIMUM Y	1.259
MINIMUM Y	-1.764
CENTROID X	-1.137
CENTROID Y	.058
POA TO CENTROID in.	.148
MIN RADIUS	.735
MEAN RADIUS	1.444
MAX RADIUS	2.766
HORIZONTAL SPREAD	4.506
VERTICAL SPREAD	2.023
EXTREME SPREAD	4.694
NUMBER IN ONE INCH CIRCLE	= 0
NUMBER IN TWO INCH CIRCLE	= 2
NUMBER IN THREE INCH CIRCLE	= 8

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C 6522314

DATE 9/10/90

TESTER W.B.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.37	2.19	2.12	2.13	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.40	2.34	2.17	2.02	
PULL #3	2.31	2.43	2.15	2.11	
PULL #4	2.26	2.52	2.13	2.08	
PULL #5	2.45	2.46	2.20	2.15	
TOTAL	11.79	11.94	10.77	10.49	
AVG.	2.26	2.39	2.15	2.098	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.09	3.12		
PULL #2	3.12	2.95		
PULL #3	3.11	2.95		
PULL #4	3.00	2.95		
PULL #5	3.01	3.08		
TOTAL	15.33	15.05		
AVG.	3.07	3.01		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.14	4.00		4.02
PULL #2	4.08	3.95		4.02
PULL #3	4.00	3.95		4.10
PULL #4	4.00	3.90		4.13
PULL #5	4.10	3.98		4.11
TOTAL	20.32	19.78		20.38
AVG.	4.06	3.96		4.07

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6522314

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	SL
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)		8/31/90	TH
	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		9/10/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			9/10/90	WB
	G) Safety Off Force	3	3	3			9/10/90	WB
	H) Trigger Pull Test & Retainability						9/10/90	WB
	I) Firing Pin Indent	1.0235	1.0235	1.0235			9/10/90	WB
	J) Assemble Stock						9/10/90	KS
	K) Assemble Swivel Studs						9/15/90	428
	L) Attach Front and Rear Sight Assemblies						9/10/90	KS
	M) Iron Sight Alignment						9/10/90	KS
	N) Detach Front & Rear Sights & place in numbered container						9/10/90	KS
	O) Attach Scope to Rifle						9/10/90	KS
	P) Detach & Attach Scope 20 Times						9/10/90	KS
640	Gallery Target & Test						9/12/90	KT
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	KT
645	Inspect for Live Ammo						9/12/90	KT
655	Final Inspection							
	A) Headspace						9/15/90	WB
	B) Trigger Pull	2.13	2.02	2.11	2.08	2.15	9-14-90	90
	C) Function						9/15/90	428
660	Pack						9/19/90	NE