

C6636240

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.





MODEL 700™ H24



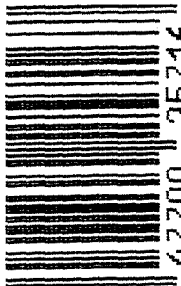
REG. U.S. PAT. & TM. OFF.

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

SERIAL NO.	C6636240
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 C6636240

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636240

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 30	91	RW
600	Proof	4 30	91	RW
607	Check Headspace	4 30	91	RW
610	Dis-assemble Gun	4 30		RW
612	Magnaflux Barrel Action	5 6 9 1		KCD
	Magnaflux Bolt	5 6 9 1		KCD
615	Rollmark Caliber	5 6 9 1		GB
617	Drill and Tap Sight Holes	5 10	91	FB
618	Polish Barrel	5 10	91	WB
620	Apply Coatings (Barrel Action)		5-30-91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/30/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/91	RW
	C) Inspect Ejector Hole for Chamfer		5/30/91	RW
	D) Oil Firing Pin Ass'y		5/30/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		6-12-91	MI

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			6-12-91	DH
	G) Safety Off Force	3	3½	3½			6-12-91	DH
	H) Trigger Pull Test & Retainability						6-12-91	JH
	I) Firing Pin Indent	.020	.020	.020			6-12-91	DH
	J) Assemble Stock						6-13-91	RW
	K) Assemble Swivel Studs						6-14-91	JH
	L) Attach Front and Rear Sight Assemblies						6-13-91	RW
	M) Iron Sight Alignment						6-13-91	RW
	N) Detach Front & Rear Sights & place in numbered container						6-13-91	RW
	O) Attach Scope to Rifle						6-13-91	RW
	P) Detach & Attach Scope 20 Times						6-13-91	RW
640	Gallery Target & Test						6-13-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						6-13-91	NF
655	Final Inspection							
	A) Headspace						6-14-91	JH
	B) Trigger Pull	2.47	2.32	2.30	2.40	2.40	6-14-91	JH
	C) Function						6-14-91	JH
660	Pack						6-20-91	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6636240

DATE 6-12-91

TESTER QU.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.52	2.55	2.50	2.47	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.43	2.55	2.55	2.32	
PULL #3	2.52	2.55	2.44	2.30	
PULL #4	2.54	2.58	2.48	2.40	
PULL #5	2.54	2.57	2.59	2.40	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.62	3.46		
PULL #2	3.49	3.43		
PULL #3	3.42	3.51		
PULL #4	3.50	3.40		
PULL #5	3.43	3.44		
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	4.41		4.42
PULL #2	4.29	4.45		4.53
PULL #3	4.37	4.47		4.55
PULL #4	4.44	4.39		4.56
PULL #5	4.40	4.50		4.49
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636240
14 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.143136
1 TO	2	.248455
1 TO	3	.411433
1 TO	4	.403408
1 TO	5	.143388

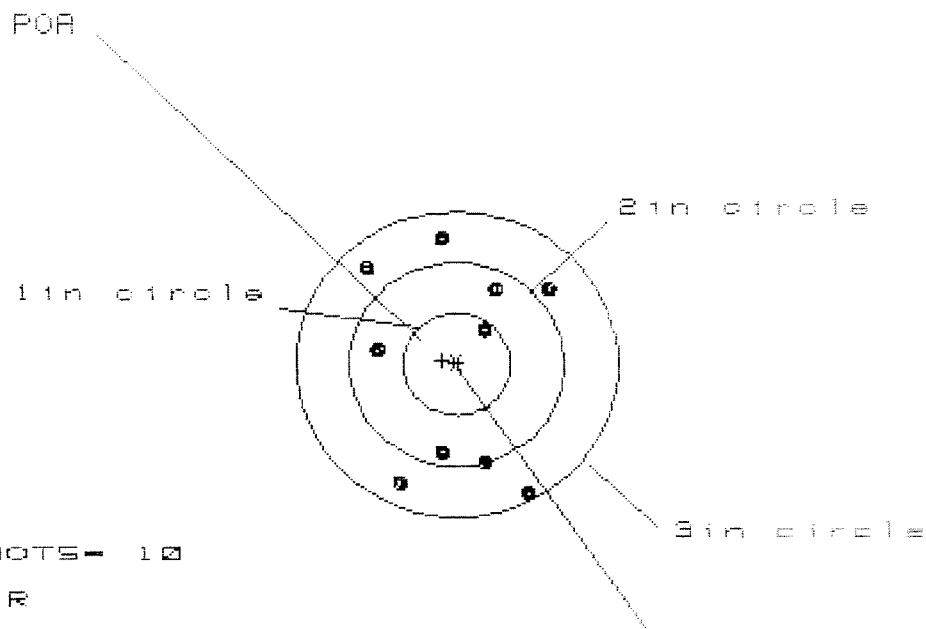
$\bar{x}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .143
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0256
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .145273
THE AMR FOR THIS RIFLE IS: .8928

14 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636240

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 1.713

VS= 2.527

GS= 2.669

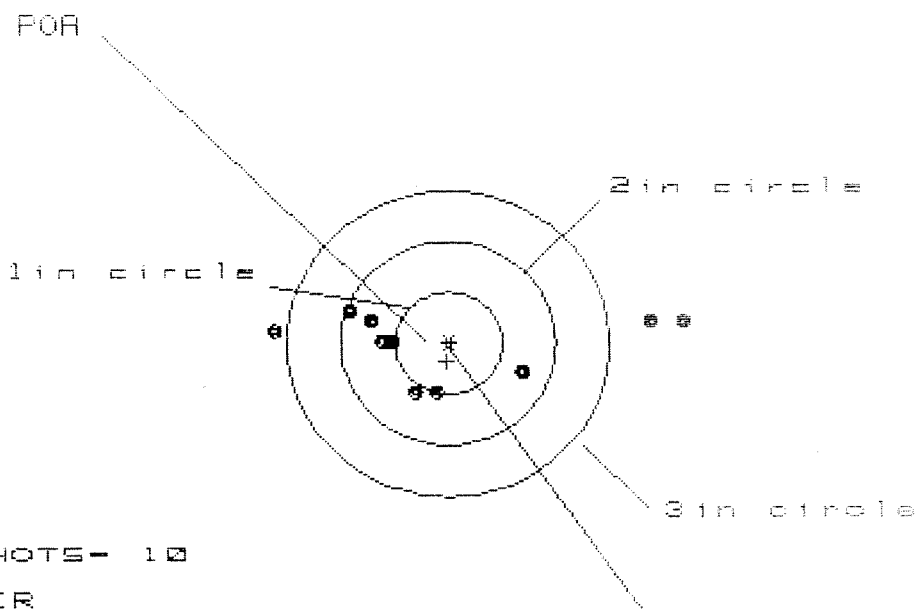
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.873	.951	.941
MINIMUM X	:	-.840	-.762	-.772
MAXIMUM Y	:	1.284	1.146	.913
MINIMUM Y	:	-1.243	-1.259	-1.116
CENTROID X	:	.138	.060	.070
CENTROID Y	:	-.038	.100	-.043
POA TO CENTROID in.	:	.143	.117	.082
MIN RADIUS	:	.424	.370	.466
MEAN RADIUS	:	1.015	.951	.928
MAX RADIUS	:	1.428	1.342	1.213
HORIZONTAL SPREAD	:	1.713	1.713	1.713
VERTICAL SPREAD	:	2.527	2.405	2.029
EXTREME SPREAD	:	2.669	2.435	2.338
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

14 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8638240

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in - 1

2 in - 7

3 in = 7

HS- 3.873

VS= .787

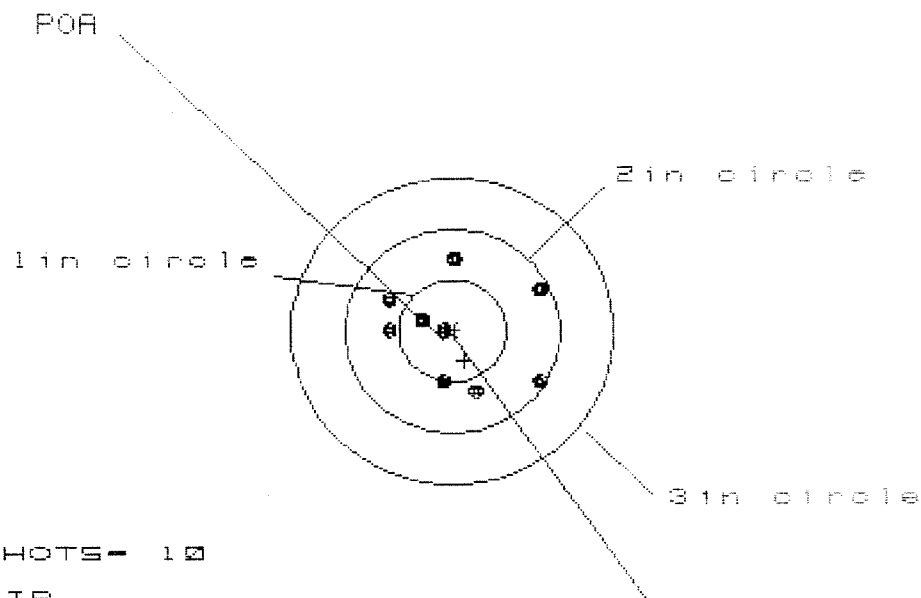
GS= 3.874

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.227	2.111	1.208
MINIMUM X	:	-1.646	-1.399	-1.135
MAXIMUM Y	:	.339	.363	.399
MINIMUM Y	:	-.448	-.424	-.389
CENTROID X	:	.017	-.230	-.494
CENTROID Y	:	.179	.155	.120
POA TO CENTROID in.:	:	.180	.277	.500
MIN RADIUS	:	.454	.299	.061
MEAN RADIUS	:	1.037	.811	.555
MAX RADIUS	:	2.238	2.130	1.232
HORIZONTAL SPREAD	:	3.873	3.510	2.343
VERTICAL SPREAD	:	.787	.787	.787
EXTREME SPREAD	:	3.874	3.512	2.382
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		7	

14 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8B3B240

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 4

2in = 10

3in = 10

HS= 1.468

VS= 1.342

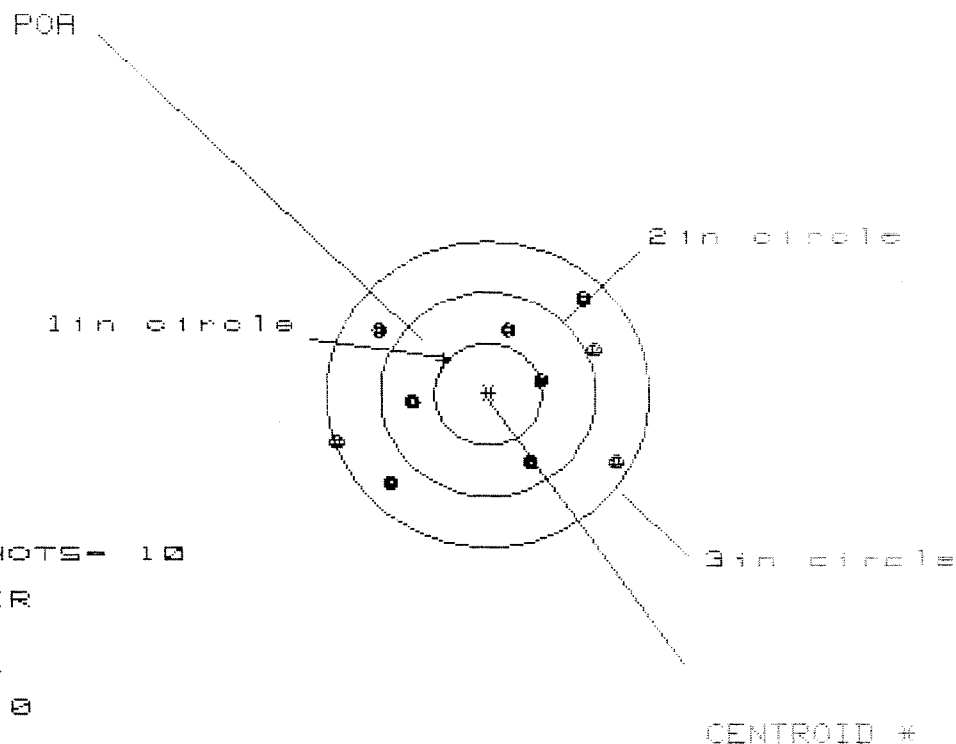
GS= 1.587

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.837	.924	.382
MINIMUM X	-.631	-.544	-.428
MAXIMUM Y	.753	.695	.735
MINIMUM Y	-.589	-.647	-.607
CENTROID X	-.113	-.200	-.316
CENTROID Y	.288	.346	.305
POA TO CENTROID in.	.309	.400	.440
MIN RADIUS	.076	.083	.111
MEAN RADIUS	.549	.486	.405
MAX RADIUS	.945	.979	.764
HORIZONTAL SPREAD	1.468	1.468	.810
VERTICAL SPREAD	1.342	1.342	1.342
EXTREME SPREAD	1.587	1.502	1.353
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	10		
NUMBER IN THREE INCH CIRCLE =	10		

14 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6696240

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in - 1

2in - 4

3in = 10

HS= 2.544

VS= 1.779

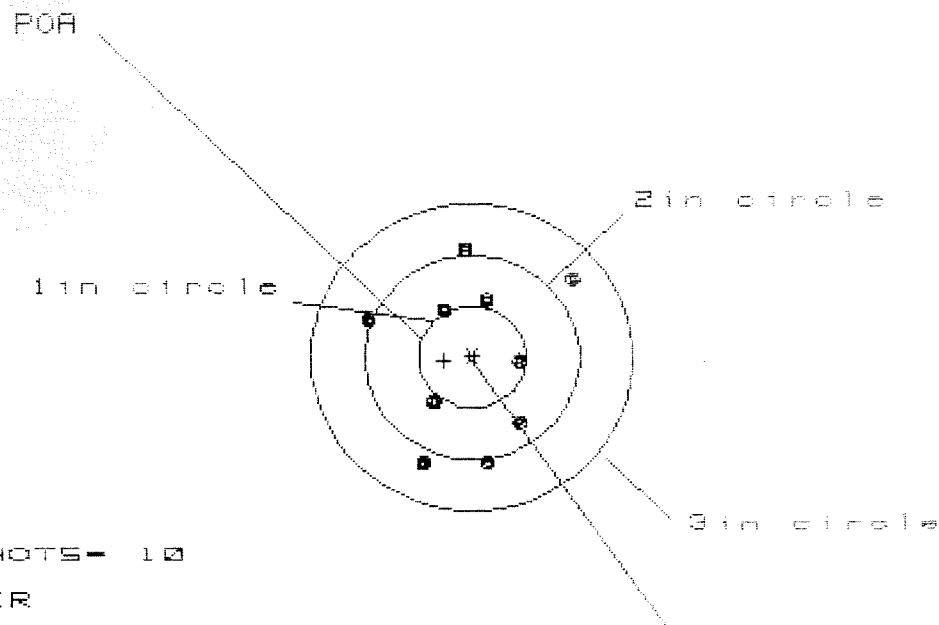
GS= 2.639

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.165	1.011	.977
MINIMUM X	:	-1.379	-1.166	-1.039
MAXIMUM Y	:	.891	.840	.750
MINIMUM Y	:	-.888	-.939	-1.029
CENTROID X	:	.411	.565	.438
CENTROID Y	:	-.335	-.284	-.194
POA TO CENTROID in.	:	.531	.632	.479
MIN RADIUS	:	.495	.333	.444
MEAN RADIUS	:	1.034	.960	.925
MAX RADIUS	:	1.455	1.445	1.415
HORIZONTAL SPREAD	:	2.544	2.177	2.016
VERTICAL SPREAD	:	1.779	1.779	1.779
EXTREME SPREAD	:	2.639	2.557	2.552
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

14 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CS696240

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 1.905

VS= 2.065

GS= 2.245

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.925	.506	.462
MINIMUM X	:	-.980	-.877	-.921
MAXIMUM Y	:	1.031	1.114	.997
MINIMUM Y	:	-1.034	-.951	-1.068
CENTROID X	:	.262	.159	.203
CENTROID Y	:	.034	-.049	.068
POA TO CENTROID in.	:	.264	.166	.214
MIN RADIUS	:	.410	.444	.453
MEAN RADIUS	:	.829	.786	.747
MAX RADIUS	:	1.191	1.117	1.090
HORIZONTAL SPREAD	:	1.905	1.383	1.383
VERTICAL SPREAD	:	2.065	2.065	2.065
EXTREME SPREAD	:	2.245	2.094	2.074
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	