

C6649106

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

* Includes 1 in chamber.






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

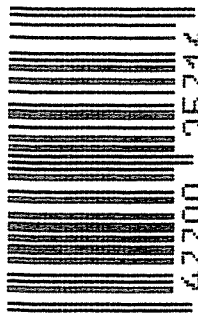
MODEL 700™ H24

SERIAL NO.
C6649106

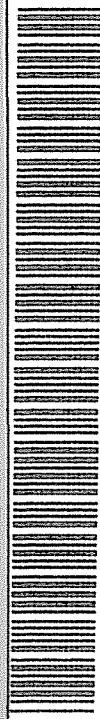
ORDER NO.
5716

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

UPC



0 47700 25716 7



5716 C6649106

CONTRACT # DAAA21-87-C-0086

GFM

GUN SERIAL #

C6649106

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		8/2/91	KA
600	Proof		8/2/91	KA
607	Check Headspace		8/2/91	KA
610	Dis-assemble Gun		8/2/91	KA
612	Magnaflux Barrel Action		AUG 7 1991	KR
	Magnaflux Bolt		AUG 7 1991	KR
615	Rollmark Caliber		AUG 7 1991	LS
617	Drill and Tap Sight Holes		AUG 7 1991	LB
618	Polish Barrel		AUG 13 1991	WB
620	Apply Coatings (Barrel Action)		8-27-91	KA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		9/5/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/5/91	KA
	C) Inspect Ejector Hole for Chamfer		9/5/91	KA
	D) Oil Firing Pin Ass'y		9/5/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		9-6-91	KA

Op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			9/7/91	PH
	G) Safety Off Force	4	4	4			9/7/91	PH
	H) Trigger Pull Test & Retainability						9-6-91	PH
	I) Firing Pin Indent	.021	.022	.022			9-7-91	PH
	J) Assemble Stock						9/9/91	PH
	K) Assemble Swivel Studs						9-13-91	PH
	L) Attach Front and Rear Sight Assemblies						9/9/91	PH
	M) Iron Sight Alignment						9/9/91	PH
	N) Detach Front & Rear Sights & place in numbered container						9/9/91	PH
	O) Attach Scope to Rifle						9/9/91	PH
	P) Detach & Attach Scope 20 Times						9/9/91	PH
640	Gallery Target & Test						9-10-91	AC
	A) Time						9-10-91	AC
	B) Malfunctions						9-10-91	AC
	C) Pierced Primers						9-10-91	AC
	D) Optical Clarity of Scope						9-10-91	AC
645	Inspect for Live Ammo						9-10-91	AC
655	Final Inspection							
	A) Headspace						9-13-91	PH
	B) Trigger Pull	2.51	2.54	2.49	2.53	2.49	9-12-91	PH
	C) Function						9-13-91	PH
660	Pack						9-17-91	PH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50#+ .50#
3.00#+ .75#
4.00#+1.00#

SERIAL NO. C-6649 106

DATE 9-6-91

TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.68	2.23	2.38	2.51	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.56	2.35	2.34	2.54	
PULL #3	2.62	2.36	2.30	2.49	
PULL #4	2.60	2.32	2.39	2.53	
PULL #5	2.65	2.30	2.45	2.49	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.54	3.30		
PULL #2	3.40	3.40		
PULL #3	3.40	3.45		
PULL #4	3.37	3.40		
PULL #5	3.39	3.40		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.23	4.27		4.40
PULL #2	4.43	4.37		4.32
PULL #3	4.29	4.38		4.36
PULL #4	4.26	4.38		4.35
PULL #5	4.29	4.39		4.46
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
 FOR RIFLE # C6649106
 10 Sep 1991

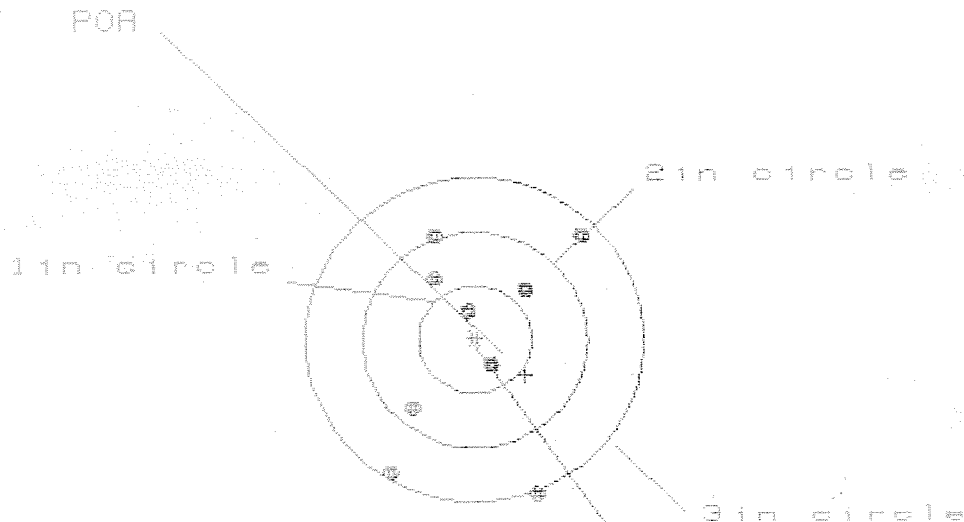
CENTROIDAL DISTANCES

0 TO	1	.554401
1 TO	2	.707008
1 TO	3	.216116
1 TO	4	.58845
1 TO	5	.893377

$\frac{1^2}{2 \cdot 4 \cdot 5}$ <----PDR

DATE FOR THIS RIFLE IS: -.2496
 DATE FOR THIS RIFLE IS: -.0296
 RADIUS FOR THIS RIFLE IS: .251349
 .785

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 3

2in = 6

3in = 9

HS= 1.702

VS= 2.400

GS= 2.736

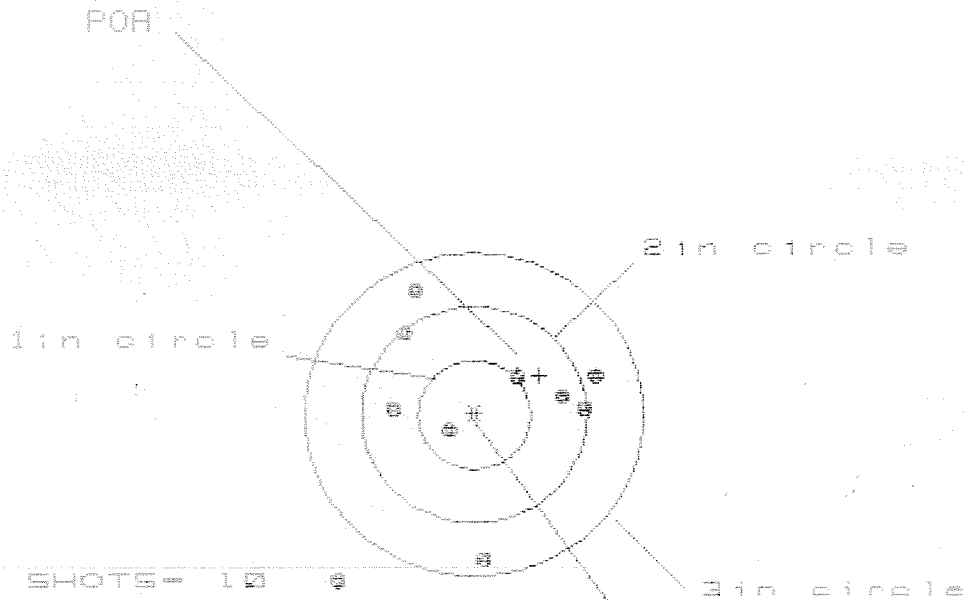
CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.959	1.020	.934
MINIMUM X	-.743	-.682	-.560
MAXIMUM Y	.985	.828	.657
MINIMUM Y	-1.415	-1.364	-.989
CENTROID X	-.444	-.505	-.419
CENTROID Y	.332	.489	.660
FOR TO CENTROID in.	.554	.703	.782
MIN RADIUS	.228	.080	.109
MEAN RADIUS	.825	.706	.587
MAX RADIUS	1.517	1.525	1.136
HORIZONTAL SPREAD	1.702	1.702	1.494
VERTICAL SPREAD	2.400	2.192	1.646
EXTREME SPREAD	2.736	2.736	2.186
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

10 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CBB49106

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 2.300

VS= 2.684

GS= 2.971

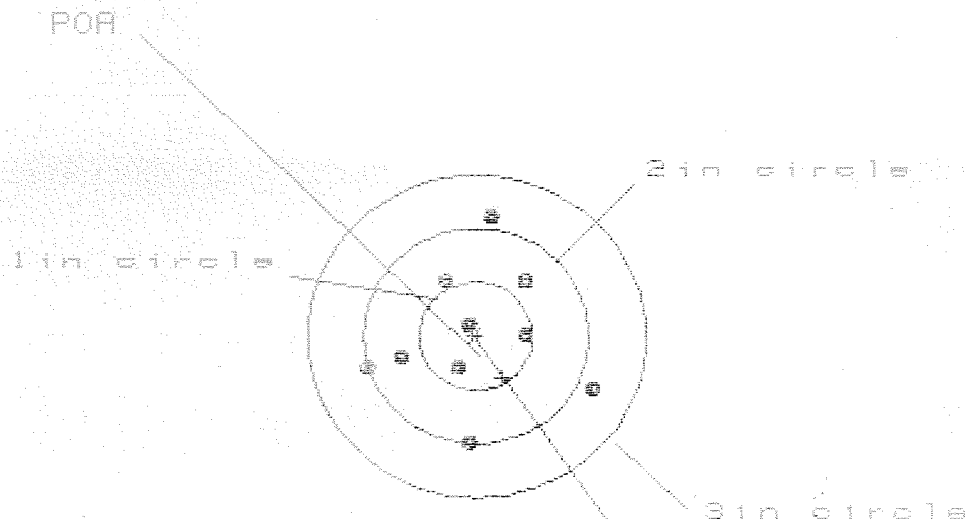
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.120	.989	.980
MINIMUM X	:	-1.180	-.862	-.871
MAXIMUM Y	:	1.181	1.014	.821
MINIMUM Y	:	-1.503	-1.550	-.462
CENTROID X	:	-.579	-.448	-.439
CENTROID Y	:	-.362	-.195	-.002
POA TO CENTROID in.	:	.683	.488	.439
MIN RADIUS	:	.282	.313	.198
MEAN RADIUS	:	1.010	.880	.777
MAX RADIUS	:	1.911	1.551	1.024
HORIZONTAL SPREAD	:	2.300	1.851	1.851
VERTICAL SPREAD	:	2.684	2.564	1.282
EXTREME SPREAD	:	2.971	2.619	1.879
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

18 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649106

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 2.022

VS= 2.115

GS= 2.125

CENTROID #

PATTERN #

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.058	.587	.624
MINIMUM X	-.964	-.847	-.810
MAXIMUM Y	1.134	1.081	.608
MINIMUM Y	-.981	-1.034	-.899
CENTROID X	-.235	-.352	-.389
CENTROID Y	.387	.440	.305
POA TO CENTROID in.	.453	.564	.494
MIN RADIUS	.132	.116	.181
MEAN RADIUS	.713	.653	.590
MAX RADIUS	1.160	1.119	.908
HORIZONTAL SPREAD	2.022	1.434	1.434
VERTICAL SPREAD	2.115	2.115	1.507
EXTREME SPREAD	2.125	2.125	1.596
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

16 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08649186

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 8

3 in = 10

HS= 1.935

VS= 1.787

GS= 2.059

CENTROID #

PATTERN #

SHOTS (BEST OF)

	10	9	8
MAXIMUM X	1.134	1.045	.840
MINIMUM X	-.802	-.795	-.664
MAXIMUM Y	.830	.724	.678
MINIMUM Y	-.957	-.618	-.663
CENTROID X	-.147	-.058	-.189
CENTROID Y	-.176	-.070	-.024
POA TO CENTROID in.	.230	.091	.190
MIN RADIUS	.038	.132	.121
MEAN RADIUS	.703	.648	.568
MAX RADIUS	1.248	1.106	.877
HORIZONTAL SPREAD	1.936	1.840	1.504
VERTICAL SPREAD	1.787	1.342	1.342
EXTREME SPREAD	2.059	1.848	1.504
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	

10 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649186

CENTERFIRE PATTERNS

5

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 8

3 in = 10

HS = 1.393

VS = 1.911

GS = 2.060

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.754

.429

.426

MINIMUM X

-.639

-.555

-.558

MAXIMUM Y

1.044

1.140

1.067

MINIMUM Y

-.867

-.771

-.628

CENTROID X

.157

.073

.076

CENTROID Y

-.329

-.425

-.568

POA TO CENTROID in.

.365

.431

.573

MIN RADIUS

.171

.049

.094

MEAN RADIUS

.674

.598

.511

MAX RADIUS

1.147

1.140

1.082

HORIZONTAL SPREAD

1.393

.984

.984

VERTICAL SPREAD

1.911

1.911

1.695

EXTREME SPREAD

2.060

1.918

1.736

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

8

NUMBER IN THREE INCH CIRCLE =

10