

C6611395

MODEL 700TM M24

Model **SWS**TM

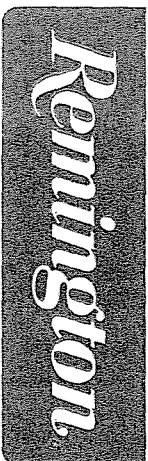
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



CONTRACT # DAAA21-87-C-0086

GEM

GUN SERIAL # C6611395

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 25 91		RW
600	Proof	1 25 91		RW
607	Check Headspace	1 25 91		RW
610	Dis-assemble Gun	1 25		RW
612	Magnaflux Barrel Action			KR
	Magnaflux Bolt			KR
615	Rollmark Caliber	1 25 91		JS
617	Drill and Tap Sight Holes	1 30 91		FB
618	Polish Barrel <i>RBB</i>	1 30 91		WB
620	Apply Coatings (Barrel Action)		2-10-91	JS
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		2/11/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/11/91	RW
	C) Inspect Ejector Hole for Chamfer		2/11/91	RW
	D) Oil Firing Pin Ass'y		2/11/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2/18/91	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2			2/20/91	WB
	G) Safety Off Force	2 3/4	2 3/4	2 3/4			2/20/91	WB
	H) Trigger Pull Test & Retainability						2/18/91	SL
	I) Firing Pin Indent	.0215	.021	.021			2/20/91	WB
	J) Assemble Stock						2/20/91	RW
	K) Assemble Swivel Studs						2-26-91	A
	L) Attach Front and Rear Sight Assemblies						2/20/91	RW
	M) Iron Sight Alignment						2/20/91	RW
	N) Detach Front & Rear Sights & place in numbered container						2/20/91	RW
	O) Attach Scope to Rifle						2/20/91	RW
	P) Detach & Attach Scope 20 Times						2/20/91	RW
640	Gallery Target & Test						2-21-91	VF
	A) Time						"	VF
	B) Malfunctions						"	VF
	C) Pierced Primers						"	VF
	D) Optical Clarity of Scope						"	VF
645	Inspect for Live Ammo						2-21-91	VF
655	Final Inspection							
	A) Headspace						2-26-91	A
	B) Trigger Pull	2.44	2.37	2.33	2.31	2.31	2/22/91	SL
	C) Function						2-26-91	AC
660	Pack						3-14-91	VF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6611395

DATE 2/18/91

TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.32	2.34	2.44	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.40	2.33	2.37	
PULL #3	2.51	2.40	2.42	2.33	
PULL #4	2.38	2.41	2.40	2.31	
PULL #5	2.39	2.34	2.36	2.31	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.25	3.17		
PULL #2	3.29	3.44		
PULL #3	3.44	3.40		
PULL #4	3.38	3.28		
PULL #5	3.17	3.46		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.20	4.31		4.15
PULL #2	4.21	4.17		4.43
PULL #3	4.15	4.15		4.35
PULL #4	4.16	4.18		4.39
PULL #5	4.27	4.20		4.34
TOTAL				
AVG.				




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

MODEL 700TM M24

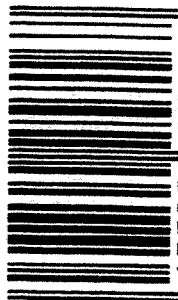
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

SERIAL NO.
C6611395

ORDER NO.
5716

20

UPC



0 47700 25716 7



5716 C6611395

CENTROIDAL DISTANCE CALCULATIONS

FOR RIFLE # C6611395
21 Feb 1991

CENTROIDAL DISTANCES

0 TO 1	.145344
1 TO 2	.409928
1 TO 3	.0870919
1 TO 4	.0470106
1 TO 5	.171003

$\bar{x}_2$ <----FOR

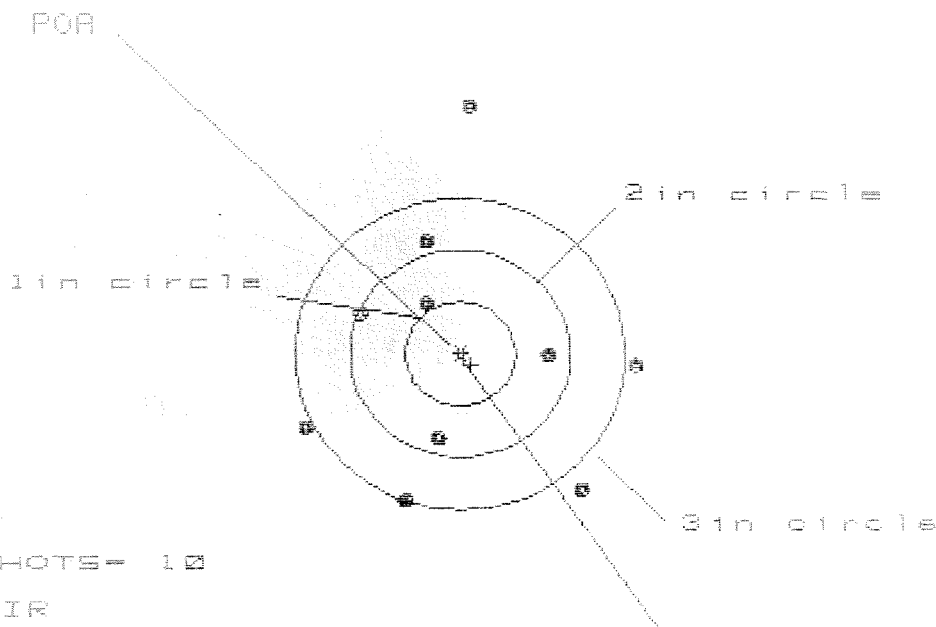
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0158
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0168
THE RESULTING AVERAGE FOI RADIUS FOR THIS RIFLE IS: .0230625
THE AME FOR THIS RIFLE IS: .9434

27 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611395

CENTERFIRE PATTERNS

1



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 4

3 in = 5

HS= 3.058

VS= 3.860

CS= 3.913

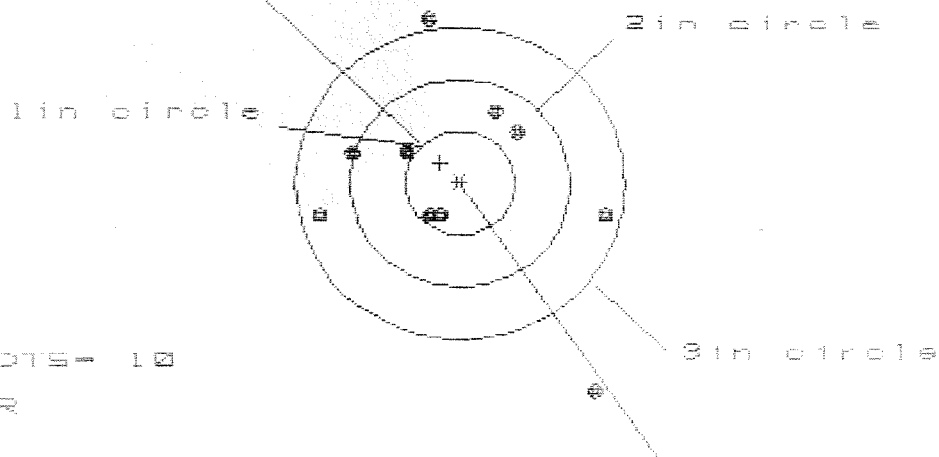
PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.622	1.635	1.772
MINIMUM X	-1.436	-1.423	-1.286
MAXIMUM Y	2.412	1.339	1.286
MINIMUM Y	-1.448	-1.180	-1.313
CENTROID X	-0.095	-0.108	-0.245
CENTROID Y	.110	-0.158	-0.025
POA TO CENTROID in.	.146	.191	.246
MIN RADIUS	.537	.553	.616
MEAN RADIUS	1.310	1.176	1.110
MAX RADIUS	2.415	1.643	1.772
HORIZONTAL SPREAD	3.058	3.058	3.058
VERTICAL SPREAD	3.860	2.519	2.519
EXTREME SPREAD	3.913	3.116	3.116
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	5		

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CENTERFIRE PATTERNS # 2

FOR



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 2.584

VS= 3.594

GS= 3.867

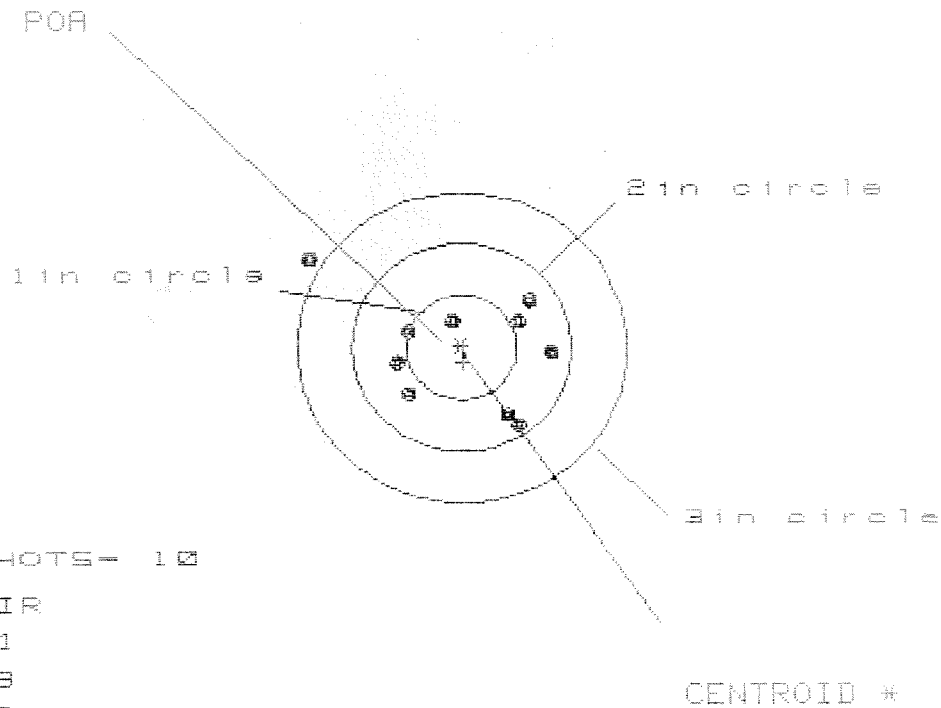
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.328	1.461	1.448
MINIMUM X	:	-1.256	-1.123	-1.136
MAXIMUM Y	:	1.611	1.391	.613
MINIMUM Y	:	-1.983	-.568	-.394
CENTROID X	:	.180	.047	.060
CENTROID Y	:	-.194	.027	-.147
POR TO CENTROID in.	:	.264	.054	.159
MIN RADIUS	:	.405	.324	.394
MEAN RADIUS	:	1.040	.870	.788
MAX RADIUS	:	2.314	1.551	1.489
HORIZONTAL SPREAD	:	2.584	2.584	2.584
VERTICAL SPREAD	:	3.594	1.959	1.007
EXTREME SPREAD	:	3.867	2.584	2.584
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 9

3in = 9

HS= 2.181

VS= 1.604

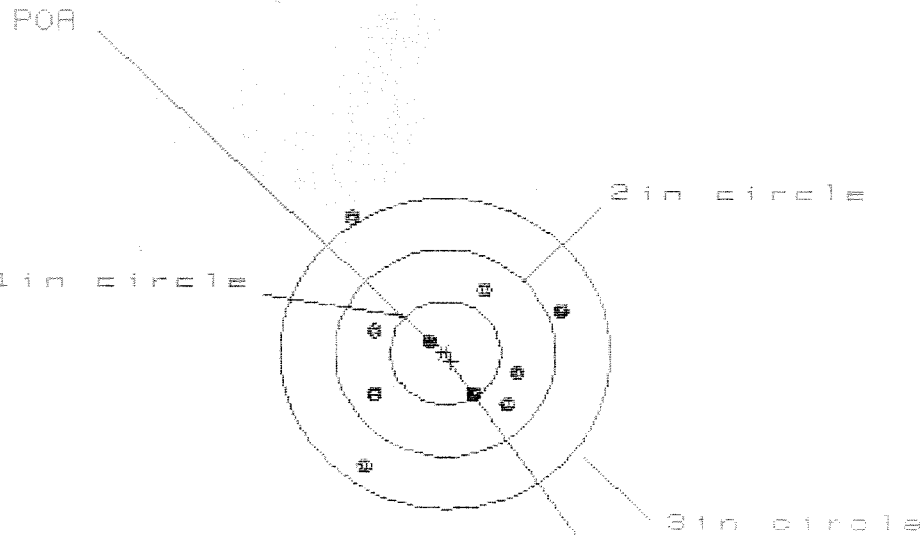
GS= 2.490

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.819	.667	.716
MINIMUM X	-1.363	-.687	-.638
MAXIMUM Y	.858	.561	.480
MINIMUM Y	-.746	-.651	-.635
CENTROID X	-.014	.137	.088
CENTROID Y	.142	.047	.128
POA TO CENTROID in.	.143	.145	.155
MIN RADIUS	.237	.380	.285
MEAN RADIUS	.751	.648	.622
MAX RADIUS	1.610	.759	.755
HORIZONTAL SPREAD	2.181	1.354	1.354
VERTICAL SPREAD	1.604	1.212	1.115
EXTREME SPREAD	2.490	1.470	1.470
NUMBER IN ONE INCH CIRCLE	= 1		
NUMBER IN TWO INCH CIRCLE	= 9		
NUMBER IN THREE INCH CIRCLE	= 9		

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS= 1.948

VS= 2.376

GS= 2.380

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.094

.999

.898

MINIMUM X

-.854

-.809

-.872

MAXIMUM Y

1.277

.754

.634

MINIMUM Y

-1.099

-.957

-.460

CENTROID X

-.054

.041

.142

CENTROID Y

.087

-.055

.065

POA TO CENTROID in.

.102

.069

.156

MIN RADIUS

.127

.275

.312

MEAN RADIUS

.826

.734

.660

MAX RADIUS

1.536

1.253

.993

HORIZONTAL SPREAD

1.948

1.808

1.770

VERTICAL SPREAD

2.376

1.711

1.894

EXTREME SPREAD

2.380

2.349

1.932

NUMBER IN ONE

INCH CIRCLE

=

2

NUMBER IN TWO

INCH CIRCLE

=

7

NUMBER IN THREE

INCH CIRCLE

=

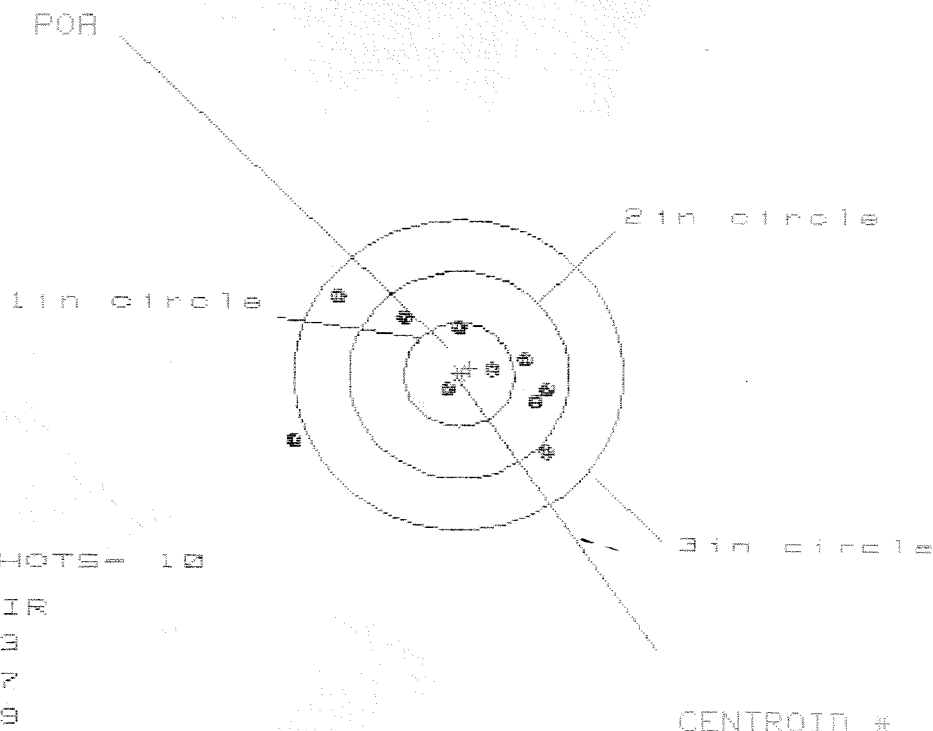
9

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FILE:/PATTERNING/CENTERFIRE_PATT/C6611395

CENTERFIRE PATTERNS

5



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 2.300

VS= 1.438

GS= 2.385

PATTERN #

5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.816	.651	.489
MINIMUM X	-1.485	-1.294	-.882
MAXIMUM Y	.716	.645	.538
MINIMUM Y	-.722	-.793	-.713
CENTROID X	-.096	.069	.231
CENTROID Y	-.061	.010	-.070
POA TO CENTROID in.	.113	.070	.242
MIN RADIUS	.208	.160	.038
MEAN RADIUS	.790	.659	.520
MAX RADIUS	1.618	1.446	.966
HORIZONTAL SPREAD	2.300	1.945	1.291
VERTICAL SPREAD	1.438	1.438	1.251
EXTREME SPREAD	2.385	2.385	1.768

NUMBER IN ONE INCH CIRCLE = 3

NUMBER IN TWO INCH CIRCLE = 7

NUMBER IN THREE INCH CIRCLE = 9