

65522132

MODEL 700TM M24

Model **SWS** TM

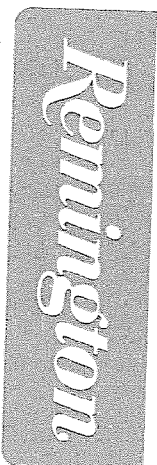
Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

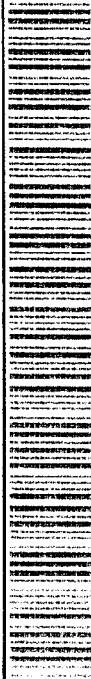





VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

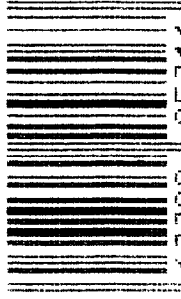
MODEL 700™ H24	SERIAL NO. C6522132
20	ORDER NO. 5716

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



5716 C6522132

UPC



0 4200 25716

5c

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522132

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	10 9 90	RW
600	Proof		10 9 90	RW
607	Check Headspace		10 9 90	RW
610	Dis-assemble Gun		10 9 90	RW
612	Magnaflux Barrel Action		10/17/90	KR
	Magnaflux Bolt		10/17/90	KR
615	Rollmark Caliber		10/17/90	GL
617	Drill and Tap Sight Holes		10/18/90	FB
618	Polish Barrel <i>RB</i>		10/19/90	WB
620	Apply Coatings (Barrel Action)		11/5/90	TH
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		12/12/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/12/90	RW
	C) Inspect Ejector Hole for Chamfer		12/12/90	RW
	D) Oil Firing Pin Ass'y		12/12/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		1-10-91	GL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4.0	4.0	4.25			1/8/91	1-2
	G) Safety Off Force	3.50	3.50	3.25			1/8/91	1-2
	H) Trigger Pull Test & Retainability						1-10-91	JH
	I) Firing Pin Indent	.020	.020	.020			1/8/91	1-2
	J) Assemble Stock						1/11/91	RW
	K) Assemble Swivel Studs						1/14/91	JH
	L) Attach Front and Rear Sight Assemblies						1/11/91	RW
	M) Iron Sight Alignment						1/11/91	RW
	N) Detach Front & Rear Sights & place in numbered container						1/11/91	RW
	O) Attach Scope to Rifle						1/11/91	RW
	P) Detach & Attach Scope 20 Times						1/11/91	RW
640	Gallery Target & Test						1-13-91	AC
	A) Time						1-13-91	AC
	B) Malfunctions						1-13-91	AC
	C) Pierced Primers						1-13-91	AC
	D) Optical Clarity of Scope						1-13-91	AC
645	Inspect for Live Ammo						1-13-91	AC
655	Final Inspection						1-14-91	JH
	A) Headspace						1-14-91	JH
	B) Trigger Pull	2.28	2.41	2.30	2.41	2.44	1-14-91	JH
	C) Function						1-14-91	JH
660	Pack						3-18-91	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. C6522152

DATE 1-10-91

TESTER JRL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.35	2.40	2.28	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.39	2.43	2.40	2.41	
PULL #3	2.44	2.40	2.41	2.38	
PULL #4	2.38	2.41	2.38	2.41	
PULL #5	2.37	2.20	2.44	2.44	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.25	3.17		
PULL #2	3.24	3.21		
PULL #3	3.21	3.17		
PULL #4	3.23	3.34		
PULL #5	3.25	3.42		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.43	4.34		4.38
PULL #2	4.41	4.32		4.38
PULL #3	4.39	4.34		4.30
PULL #4	4.41	4.30		4.41
PULL #5	4.32	4.42		4.44
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06522132
14 Jan 1991

CENTROIDAL DISTANCES

0 TO	1	.333143
1 TO	2	.417404
1 TO	3	.512445
1 TO	4	.29045
1 TO	5	.652511

$\frac{1}{5}$

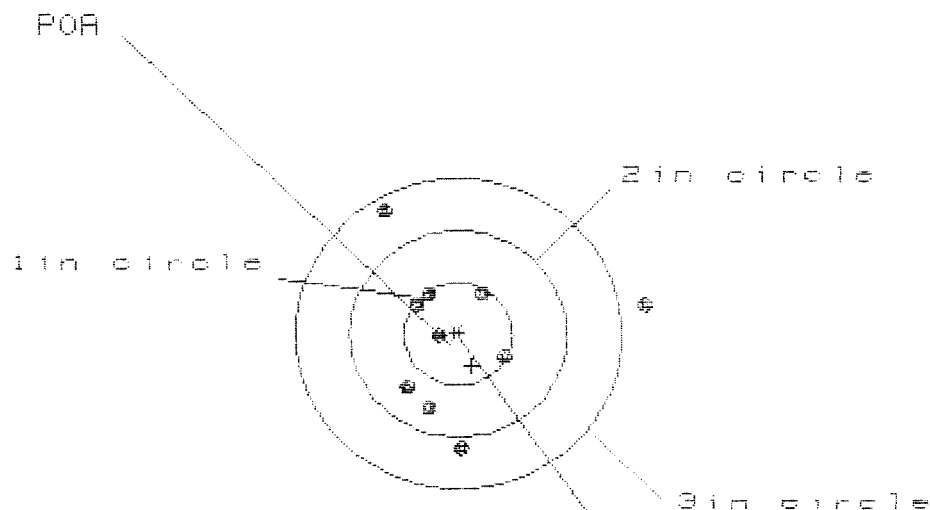
-----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1046
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0026
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .1119
THE AMP FOR THIS RIFLE IS: .0954

14 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8522132

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 4

2in = 7

3in = 9

HG = 2.461

VG = 2.323

GS = 2.641

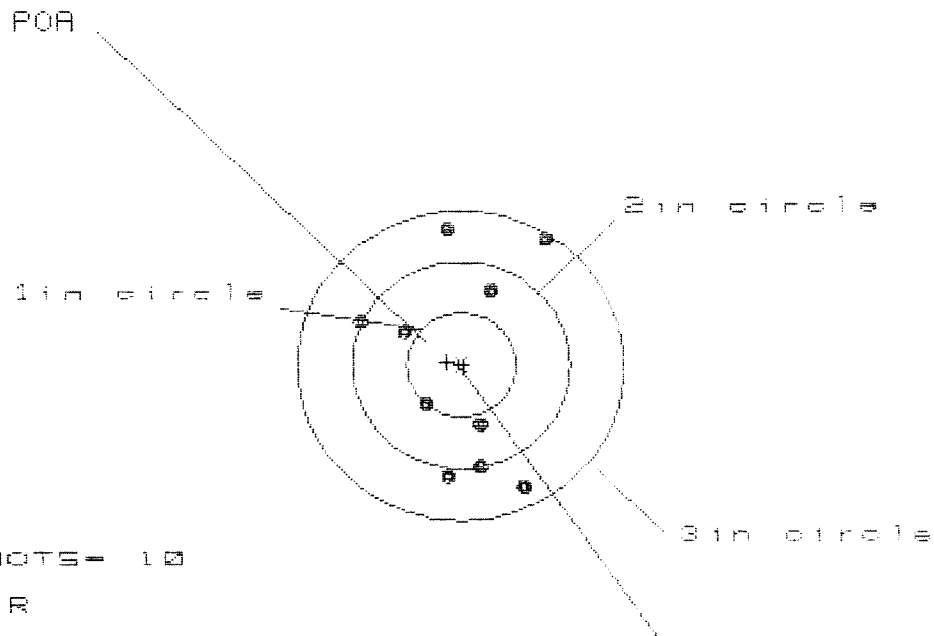
CENTROID +

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.739	.614	.548
MINIMUM X	-.722	-.528	-.340
MAXIMUM Y	1.206	1.233	.568
MINIMUM Y	-1.117	-1.090	-.935
CENTROID X	-.122	-.316	-.250
CENTROID Y	.310	.283	.128
POA TO CENTROID in.	.333	.424	.281
MIN RADIUS	.208	.067	.234
MEAN RADIUS	.788	.650	.577
MAX RADIUS	1.757	1.342	.949
HORIZONTAL SPREAD	2.461	1.142	.898
VERTICAL SPREAD	2.323	2.323	1.503
EXTREME SPREAD	2.641	2.443	1.529
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

14 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8522132

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

HS= 1.793

VS= 2.463

GS= 2.580

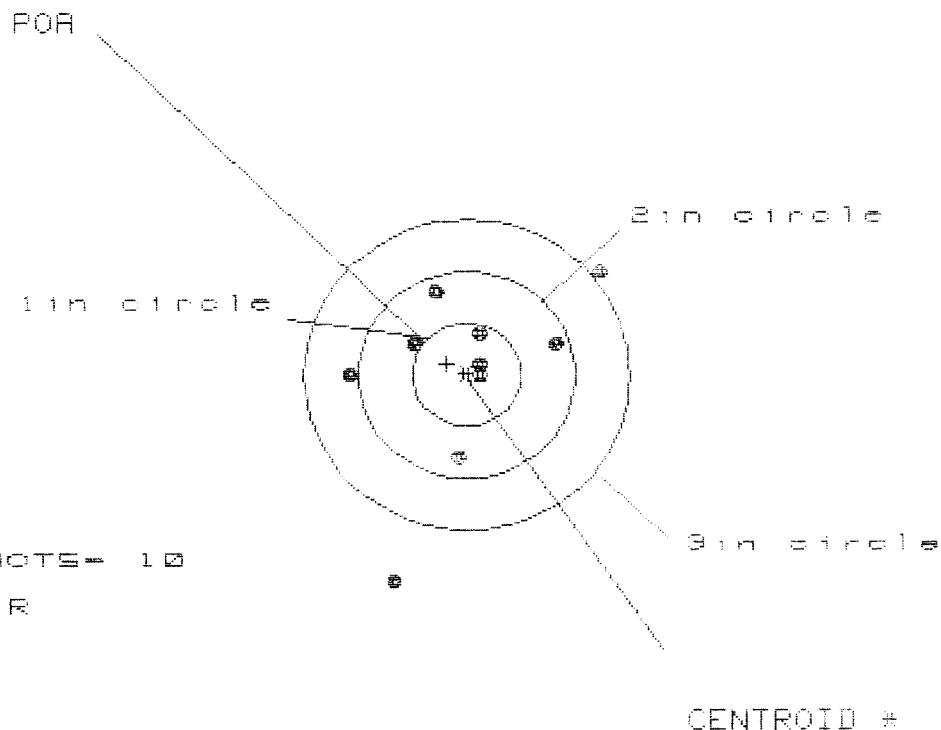
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.820	.700	.691
MINIMUM X	:	-.973	-.882	-.891
MAXIMUM Y	:	1.336	1.469	1.056
MINIMUM Y	:	-1.127	-.994	-.810
CENTROID X	:	.127	.036	.045
CENTROID Y	:	-.025	-.158	-.342
POA TO CENTROID in.	:	.130	.162	.345
MIN RADIUS	:	.448	.287	.205
MEAN RADIUS	:	.971	.888	.779
MAX RADIUS	:	1.451	1.471	1.183
HORIZONTAL SPREAD	:	1.793	1.582	1.582
VERTICAL SPREAD	:	2.463	2.463	1.876
EXTREME SPREAD	:	2.580	2.580	2.242
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

14 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08522132

CENTERFIRE PATTERNS # 3



OF SHOTS = 10
 # IN CIR
 1 in = 3
 2 in = 7
 3 in = 8
 HS = 3.324
 VS = 3.022
 GS = 3.575

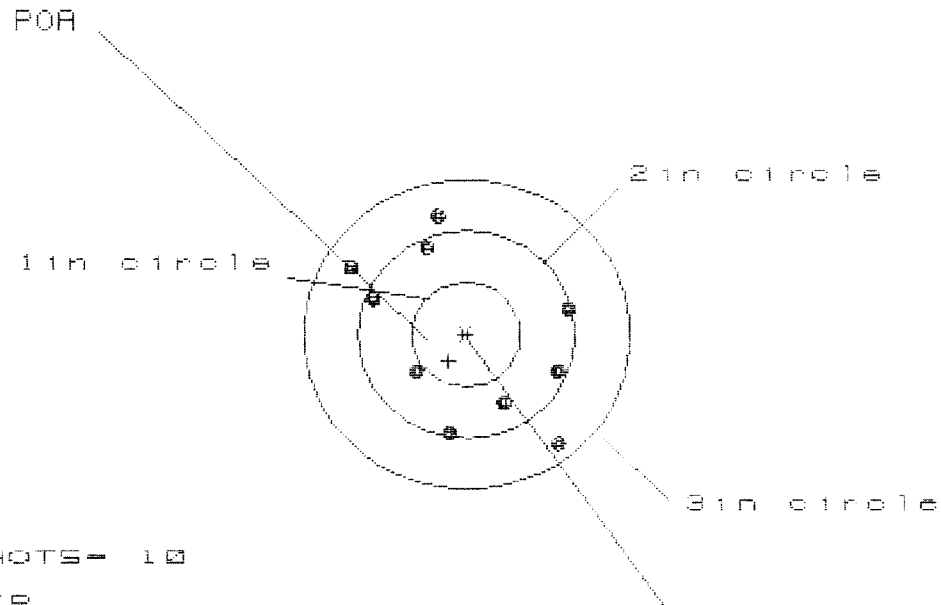
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.240	1.165	.878
MINIMUM X	:	-1.084	-1.159	-1.013
MAXIMUM Y	:	.999	.775	.627
MINIMUM Y	:	-2.023	-1.032	-1.935
CENTROID X	:	.180	.255	.109
CENTROID Y	:	-.104	.120	.023
POA TO CENTROID in.	:	.208	.282	.111
MIN RADIUS	:	.149	.174	.243
MEAN RADIUS	:	.860	.682	.599
MAX RADIUS	:	2.131	1.399	1.027
HORIZONTAL SPREAD	:	2.324	2.324	1.891
VERTICAL SPREAD	:	3.022	1.807	1.562
EXTREME SPREAD	:	3.575	2.546	1.927
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

14 Jan 1991

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CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 7

3 in = 10

HS= 1.905

VS= 2.251

GS= 2.568

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.888	.986	.871
MINIMUM X	:	-1.017	-.919	-.866
MAXIMUM Y	:	1.171	1.051	1.118
MINIMUM Y	:	-1.080	-1.035	-.968
CENTROID X	:	.163	.065	.180
CENTROID Y	:	.254	.374	.307
POA TO CENTROID in.	:	.301	.379	.356
MIN RADIUS	:	.551	.573	.599
MEAN RADIUS	:	.962	.908	.880
MAX RADIUS	:	1.394	1.061	1.143
HORIZONTAL SPREAD	:	1.905	1.905	1.737
VERTICAL SPREAD	:	2.251	2.086	2.086
EXTREME SPREAD	:	2.568	2.088	2.088
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

14 Jan 1991

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CENTERFIRE PATTERNS

5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 5

3 in = 10

HS = 2.5988

VS = 2.447

CS = 2.634

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.324	1.072	1.085
MINIMUM X	:	-1.374	-1.241	-1.228
MAXIMUM Y	:	1.150	1.131	.967
MINIMUM Y	:	-1.297	-1.316	-1.490
CENTROID X	:	.175	.327	.314
CENTROID Y	:	-.271	-.252	-.088
POA TO CENTROID in.	:	.322	.413	.327
MIN RADIUS	:	.072	.107	.234
MEAN RADIUS	:	.896	.825	.766
MAX RADIUS	:	1.384	1.320	1.229
HORIZONTAL SPREAD	:	2.598	2.313	2.313
VERTICAL SPREAD	:	2.447	2.447	1.457
EXTREME SPREAD	:	2.634	2.463	2.314
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	