

C6498853

MODEL 700™ M24

Model **SWS**™

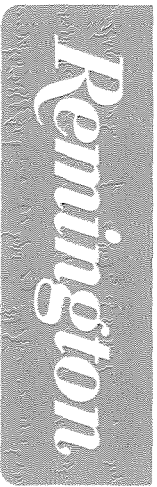
Action

Barrel Length

Capacity

Order No. **5716**

* Includes 1 in chamber.



Smead

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 649 8853

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		8-21-90	DB
600	Proof		8-21-90	DB
607	Check Headspace		8-21-90	DB
610	Dis-assemble Gun		8-21-90	DB
612	Magnaflux Barrel Action		8/22/90	KCR
	Magnaflux Bolt		8/22/90	KCR
615	Rollmark Caliber		8/22/90	GS
617	Drill and Tap Sight Holes		8/23/90	FB
618	Polish Barrel RB		8/23/90	WB
620	Apply Coatings (Barrel Action)		8/30/90	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		9/15/90	WB

op. #	OP. NAME	READINGS			DATE	INIT		
625 nt.	F) Safety On Force	5 1/2	5 1/2	5 1/2	9/15/90	WB		
	G) Safety Off Force	2 1/2	2 1/2	2 1/2	9/15/90	WB		
	H) Trigger Pull Test & Retainability				9/15/90	WB		
	I) Firing Pin Indent	.023	.023	.023	9/15/90	WB		
	J) Assemble Stock				9/15/90	KA		
	K) Assemble Swivel Studs				9/17/90	JS		
	L) Attach Front and Rear Sight Assemblies				9/15/90	KA		
	M) Iron Sight Alignment				9/15/90	KA		
	N) Detach Front & Rear Sights & place in numbered container				9/15/90	KA		
	O) Attach Scope to Rifle				9/15/90	KA		
	P) Detach & Attach Scope 20 Times				9/15/90	KA		
640	Gallery Target & Test				9-16-90	DH		
	A) Time				9-16-90	DH		
	B) Malfunctions				9-16-90	DH		
	C) Pierced Primers				9-16-90	DH		
	D) Optical Clarity of Scope				9-16-90	DH		
645	Inspect for Live Ammo				9-16-90	DH		
655	Final Inspection							
	A) Headspace				9/17/90	JS		
	B) Trigger Pull	2.52	2.39	2.42	2.44	2.42	9-16-90	JS
	C) Function						9/17/90	JS
660	Pack						2/20/90	NF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6498853
DATE 9/15/90
TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.24	2.35	2.52	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.42	2.26	2.27	2.39	
PULL #3	2.47	2.28	2.33	2.42	
PULL #4	2.44	2.34	2.31	2.44	
PULL #5	2.41	2.38	2.35	2.42	
TOTAL	12.18	11.50	11.61	12.19	
AVG.	2.43	2.30	2.32	2.438	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.31	3.27		
PULL #2	3.18	3.18		
PULL #3	3.22	3.27		
PULL #4	3.24	3.29		
PULL #5	3.22	3.32		
TOTAL	16.17	16.33		
AVG.	3.23	3.27		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.12	3.93		4.06
PULL #2	4.03	3.97		4.06
PULL #3	4.00	4.00		3.90
PULL #4	4.01	4.00		4.01
PULL #5	3.98	4.06		4.12
TOTAL	20.14	19.96		20.15
AVG.	4.03	3.99		4.03

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6498853
16 Sep 1990

CENTROIDAL DISTANCES

Ø TO	1	.286094
1 TO	2	.121297
1 TO	3	.125706
1 TO	4	.434497
1 TO	5	.604325

$\frac{4}{5} \phi$ <----POA

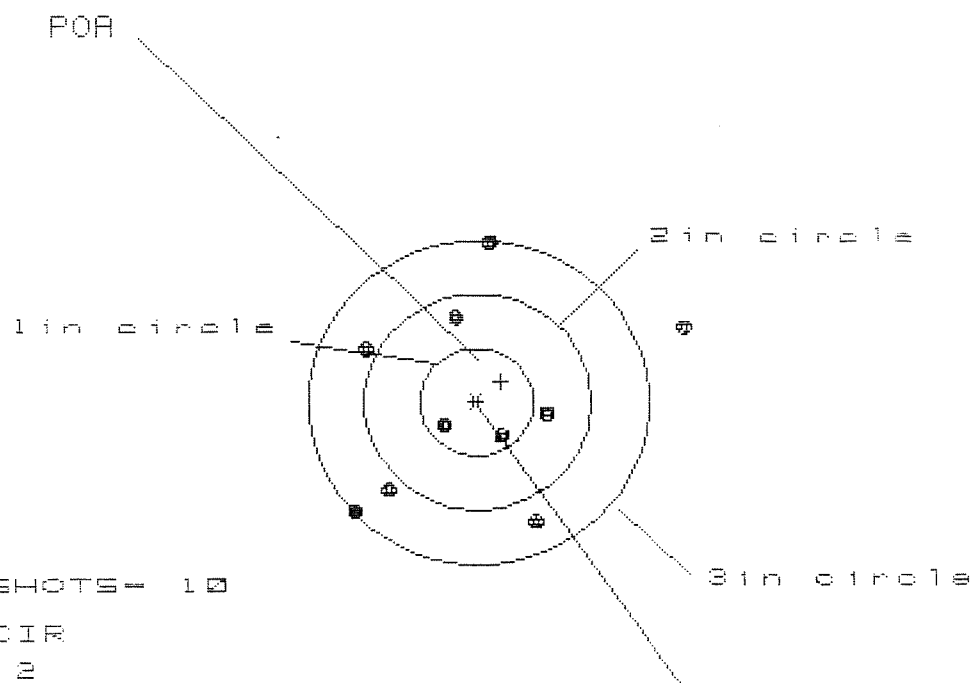
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.3812
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1672
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .416256
THE AMR FOR THIS RIFLE IS: .8584

16 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6498853

CENTERFIRE PATTERNS

1



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

HS= 2.840

VS= 2.565

GS= 3.302

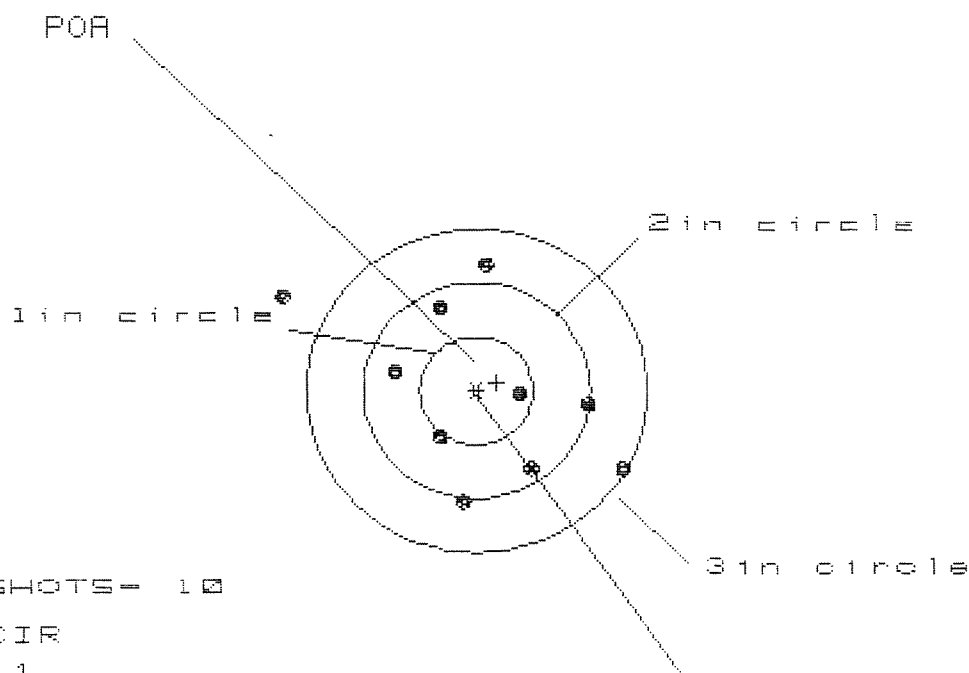
CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.778	.845	.880
MINIMUM X	:	-1.062	-.864	-.829
MAXIMUM Y	:	1.502	1.580	1.099
MINIMUM Y	:	-1.063	-.985	-.788
CENTROID X	:	-.213	-.411	-.446
CENTROID Y	:	-.191	-.270	-.467
POR TO CENTROID in.	:	.287	.491	.646
MIN RADIUS	:	.361	.183	.037
MEAN RADIUS	:	1.042	.919	.796
MAX RADIUS	:	1.913	1.605	1.101
HORIZONTAL SPREAD	:	2.840	1.709	1.709
VERTICAL SPREAD	:	2.565	2.565	1.887
EXTREME SPREAD	:	3.302	2.734	2.102
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	8		

16 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8498853

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 3.014

VS= 2.165

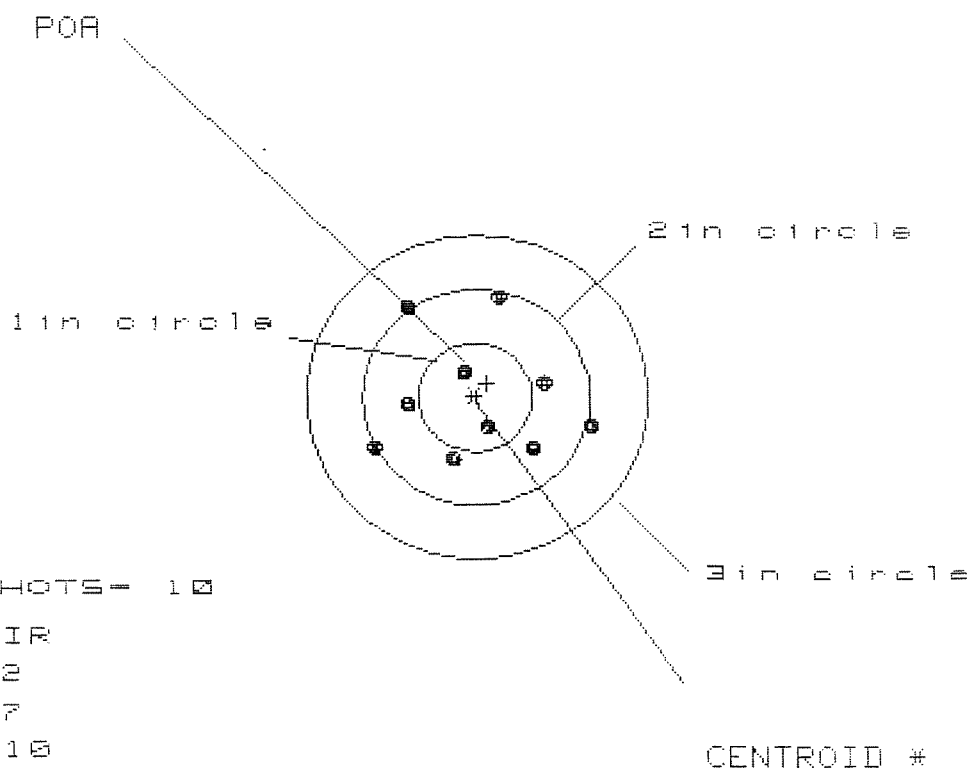
GS= 3.447

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.248	1.052	.929
MINIMUM X	:	-1.766	-.923	-.791
MAXIMUM Y	:	1.179	1.279	1.195
MINIMUM Y	:	-.986	-.886	-.970
CENTROID X	:	-.181	.015	-.117
CENTROID Y	:	-.074	-.174	-.090
POA TO CENTROID in.	:	.196	.175	.147
MIN RADIUS	:	.387	.215	.323
MEAN RADIUS	:	1.008	.868	.823
MAX RADIUS	:	1.981	1.288	1.195
HORIZONTAL SPREAD	:	3.014	1.975	1.720
VERTICAL SPREAD	:	2.165	2.165	2.165
EXTREME SPREAD	:	3.447	2.296	2.170
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

16 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6498853

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 1.915

VS= 1.484

GS= 1.970

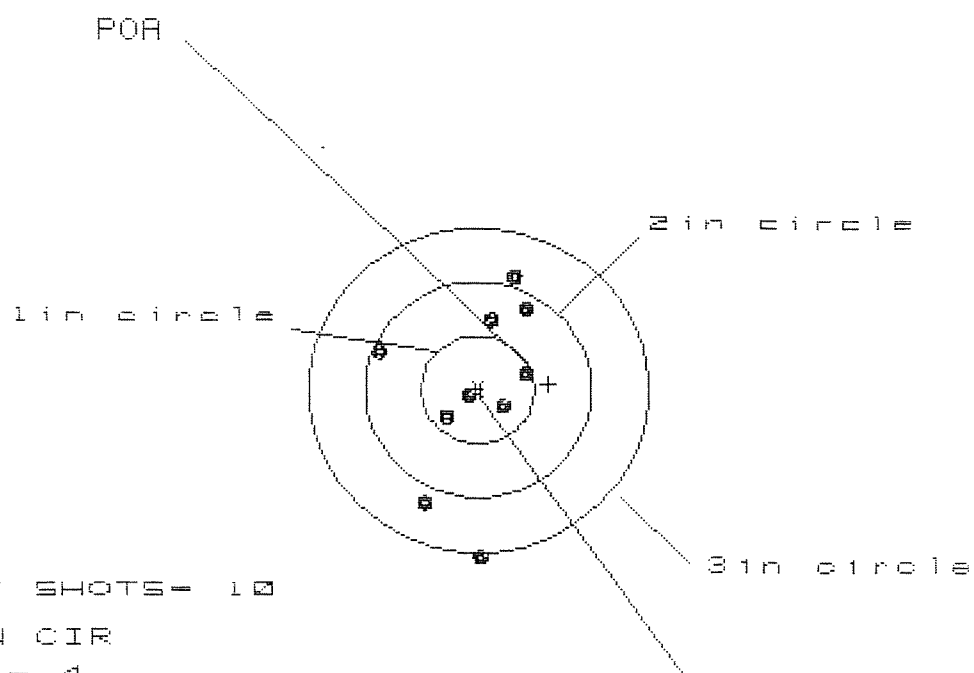
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.028	.707	.648
MINIMUM X	:	-.887	-.773	-.832
MAXIMUM Y	:	.966	.933	1.034
MINIMUM Y	:	-.518	-.551	-.450
CENTROID X	:	-.102	-.216	-.157
CENTROID Y	:	-.132	-.099	-.200
POA TO CENTROID in.	:	.167	.237	.254
MIN RADIUS	:	.222	.194	.250
MEAN RADIUS	:	.712	.670	.622
MAX RADIUS	:	1.069	.980	1.062
HORIZONTAL SPREAD	:	1.915	1.480	1.480
VERTICAL SPREAD	:	1.484	1.484	1.484
EXTREME SPREAD	:	1.970	1.806	1.806
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

16 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6498853

CENTERFIRE PATTERNS

4



OF SHOTS = 10

IN CIR

1 in = 4

2 in = 7

3 in = 10

HS = 1.348

VS = 2.507

GS = 2.522

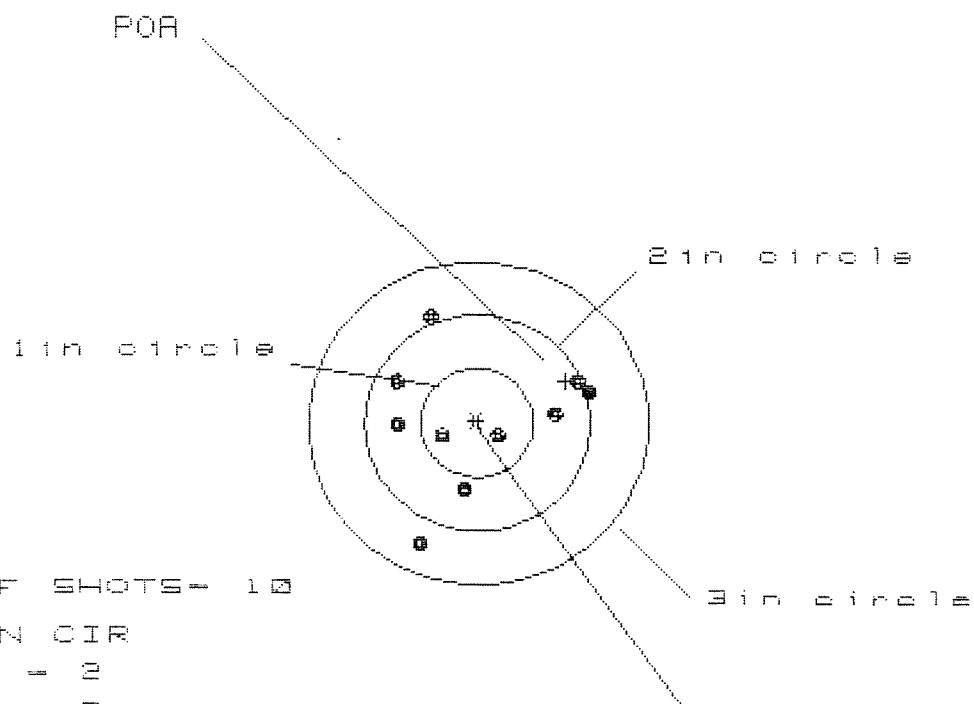
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.470	.476	.413
MINIMUM X	:	-.878	-.872	-.935
MAXIMUM Y	:	1.009	.843	.688
MINIMUM Y	:	-1.498	-1.235	-.597
CENTROID X	:	-.625	-.631	-.568
CENTROID Y	:	-.053	.113	.268
POR TO CENTROID in.	:	.628	.642	.628
MIN RADIUS	:	.035	.186	.318
MEAN RADIUS	:	.751	.667	.574
MAX RADIUS	:	1.499	1.336	.938
HORIZONTAL SPREAD	:	1.348	1.348	1.348
VERTICAL SPREAD	:	2.507	2.078	1.285
EXTREME SPREAD	:	2.522	2.243	1.437
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

16 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C649B853

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 6

3 in = 10

HS= 1.686

VS= 2.085

GS= 2.129

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.965	.908	.851
MINIMUM X	:	-.721	-.778	-.835
MAXIMUM Y	:	.940	.812	.401
MINIMUM Y	:	-1.145	-.789	-.687
CENTROID X	:	-.785	-.728	-.671
CENTROID Y	:	-.386	-.258	-.360
FOR TO CENTROID in.	:	.875	.772	.761
MIN RADIUS	:	.266	.327	.210
MEAN RADIUS	:	.779	.732	.687
MAX RADIUS	:	1.257	.931	.899
HORIZONTAL SPREAD	:	1.686	1.686	1.686
VERTICAL SPREAD	:	2.085	1.601	1.088
EXTREME SPREAD	:	2.129	1.688	1.688
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	




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

MODEL 700™ M24

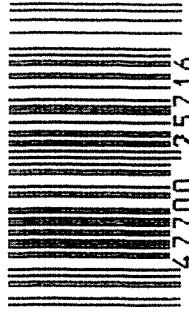
SERIAL NO.
C6498853

ORDER NO.
5716

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

Q1

UPC



0 47700 25716 7



5716 C6498853