

C6594664

MODEL 700™ M24

Model **SWS**™

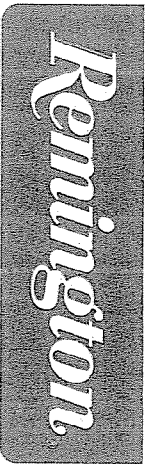
Action

Barrel Length

Capacity

Order No. **5716**

* Includes 1 in chamber.






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

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

MODEL 700™ H24

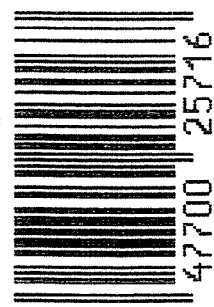
SERIAL NO. C6594664

ORDER NO. 5716

46

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

UPC



0 47700 25716 7



5716 C6594664

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6594664

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	1 16 91	RW
600	Proof		1 16 91	RW
607	Check Headspace		1 16 91	RW
610	Dis-assemble Gun		1 16 91	RW
612	Magnaflux Barrel Action		1 18 91	KR
	Magnaflux Bolt		1 18 91	KR
615	Rollmark Caliber		1 18 91	LS
617	Drill and Tap Sight Holes		1 24 91	FB
618	Polish Barrel		1 24 91	WB
620	Apply Coatings (Barrel Action)		2-15-91	TH
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		3/6/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		3/6/91	RW
	C) Inspect Ejector Hole for Chamfer		3/6/91	RW
	D) Oil Firing Pin Ass'y		3/6/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		3/8/91	TH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 $\frac{1}{4}$	4	4			3-11-91	DH
	G) Safety Off Force	3	3	3			3-11-91	DH
	H) Trigger Pull Test & Retainability						3/8/91	JH
	I) Firing Pin Indent	.020	.020	.021			3-11-91	DH
	J) Assemble Stock						4/3/91	RW
	K) Assemble Swivel Studs						4-10-91	DH
	L) Attach Front and Rear Sight Assemblies						4/3/91	RW
	M) Iron Sight Alignment						4/3/91	RW
	N) Detach Front & Rear Sights & place in numbered container						4/3/91	RW
	O) Attach Scope to Rifle						4/3/91	RW
	P) Detach & Attach Scope 20 Times						4/3/91	RW
640	Gallery Target & Test						4-8-91	AC
	A) Time						4-8-91	AC
	B) Malfunctions						4-8-91	AC
	C) Pierced Primers						4-8-91	AC
	D) Optical Clarity of Scope						4-8-91	AC
645	Inspect for Live Ammo						4-8-91	AC
655	Final Inspection A) Headspace						4-10-91	DH
	B) Trigger Pull	2.41	2.51	2.42	2.52	2.46	4/10/91	JH
	C) Function						4-10-91	DH
660	Pack						6-19-91	W

SWS TRIGGER PULL TEST

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

SERIAL NO. 06594664
DATE 3-8-91
TESTER J.P.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.45	2.36	2.38	2.41	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.40	2.32	2.36	2.51	
PULL #3	2.37	2.33	2.34	2.42	
PULL #4	2.38	2.35	2.34	2.52	
PULL #5	2.34	2.34	2.35	2.46	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.46	3.37		
PULL #2	3.47	3.38		
PULL #3	3.43	3.40		
PULL #4	3.41	3.39		
PULL #5	3.37	3.36		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.27		4.26
PULL #2	4.27	4.25		4.27
PULL #3	4.26	4.25		4.28
PULL #4	4.24	4.25		4.28
PULL #5	4.25	4.25		4.22
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06594664
8 Apr 1991

CENTROIDAL DISTANCES

0 TO 1	.419634
1 TO 2	.343281
1 TO 3	.274563
1 TO 4	.511682
1 TO 5	.288295

$\frac{3}{2}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2038
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0682
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .214909
THE AMR FOR THIS RIFLE IS: .8844

8 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8594664

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in - 1

2 in - 6

3 in - 8

HS - 3.166

VS - 2.786

GS - 3.883

CENTROID *

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.772	1.617	.937
MINIMUM X	-1.394	-1.076	-.874
MAXIMUM Y	1.049	.856	.896
MINIMUM Y	-1.737	-.930	-.890
CENTROID X	.418	.573	.371
CENTROID Y	.037	.230	.190
POA TO CENTROID in.	.420	.618	.417
MIN RADIUS	.187	.263	.058
MEAN RADIUS	1.037	.881	.751
MAX RADIUS	2.228	1.648	1.292
HORIZONTAL SPREAD	3.166	2.693	1.811
VERTICAL SPREAD	2.786	1.786	1.786
EXTREME SPREAD	3.883	2.734	2.033
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

9 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594664

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS - 10

IN CIR

1in - 1

2in - 7

3in - 10

HS - 2.050

VS - 2.052

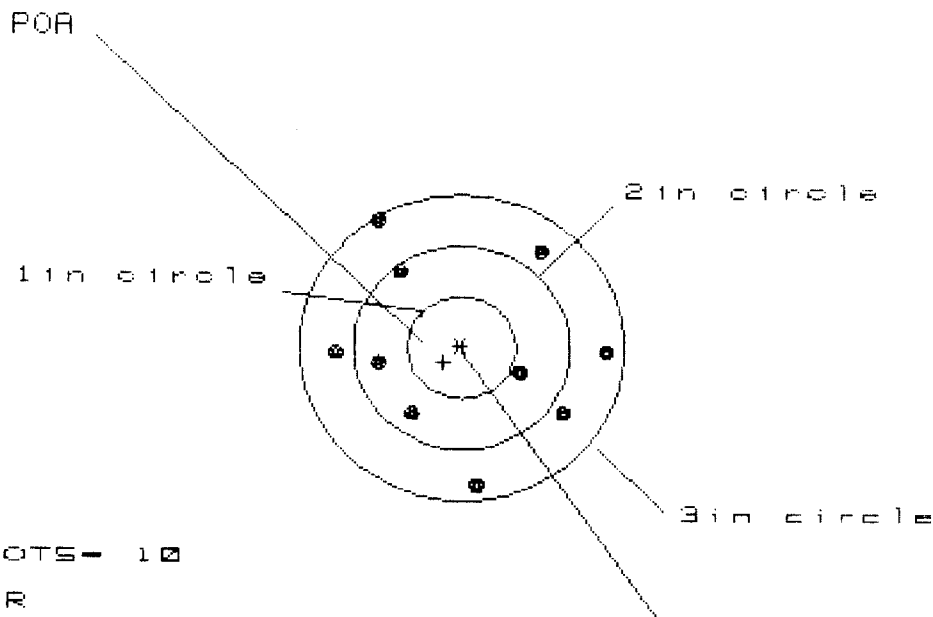
GS - 2.531

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.613	.453	.504
MINIMUM X	:	-1.437	-1.061	-1.004
MAXIMUM Y	:	.870	.903	.759
MINIMUM Y	:	-1.182	-1.149	-.561
CENTROID X	:	.327	.487	.430
CENTROID Y	:	-.294	-.327	-.183
POA TO CENTROID in.	:	.440	.586	.468
MIN RADIUS	:	.269	.237	.368
MEAN RADIUS	:	.816	.698	.656
MAX RADIUS	:	1.468	1.378	1.245
HORIZONTAL SPREAD	:	2.050	1.514	1.508
VERTICAL SPREAD	:	2.052	2.052	1.320
EXTREME SPREAD	:	2.531	2.531	1.880
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

8 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594664

CENTERFIRE PATTERNS # 3



* OF SHOTS - 10

IN CIR

1in - 3

2in - 4

3in - 10

HS - 2.491

VS - 2.572

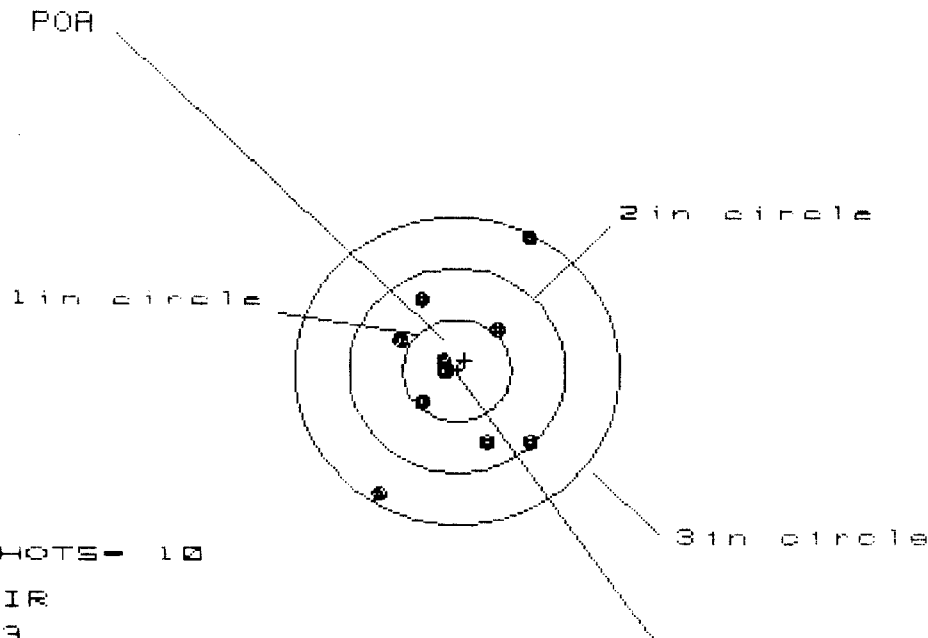
GS - 2.731

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.323	1.241	1.253
MINIMUM X	:	-1.168	-1.250	-1.238
MAXIMUM Y	:	1.228	1.132	.981
MINIMUM Y	:	-1.344	-1.208	-.642
CENTROID X	:	.166	.247	.235
CENTROID Y	:	.146	.010	.161
POR TO CENTROID in.	:	.221	.247	.284
MIN RADIUS	:	.588	.468	.533
MEAN RADIUS	:	1.074	1.019	.994
MAX RADIUS	:	1.431	1.292	1.254
HORIZONTAL SPREAD	:	2.491	2.491	2.491
VERTICAL SPREAD	:	2.572	2.340	1.623
EXTREME SPREAD	:	2.731	2.491	2.491
NUMBER IN ONE INCH CIRCLE	=	3	0	
NUMBER IN TWO INCH CIRCLE	=	4	4	
NUMBER IN THREE INCH CIRCLE	=	10	10	

8 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594664

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.437

VS= 2.505

GS= 2.888

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.709	.725	.644
MINIMUM X	:	-.728	-.649	-.497
MAXIMUM Y	:	1.322	.804	.674
MINIMUM Y	:	-1.183	-1.036	-.697
CENTROID X	:	-.075	-.154	-.073
CENTROID Y	:	-.100	-.247	-.117
POA TO CENTROID IN.	:	.125	.291	.138
MIN RADIUS	:	.098	.186	.108
MEAN RADIUS	:	.724	.642	.547
MAX RADIUS	:	1.500	1.223	.949
HORIZONTAL SPREAD	:	1.437	1.374	1.141
VERTICAL SPREAD	:	2.505	1.840	1.371
EXTREME SPREAD	:	2.888	1.969	1.662
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

8 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8534664

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS - 10

IN CIR

1in - 2

2in - 8

3in - 10

HS- 1.609

VS= 1.971

GS= 2.204

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.984	.887	.901
MINIMUM X	-.705	-.605	-.591
MAXIMUM Y	1.119	1.226	.698
MINIMUM Y	-.852	-.745	-.592
CENTROID X	.183	.083	.069
CENTROID Y	-.130	-.237	-.390
POA TO CENTROID in.	.224	.251	.396
MIN RADIUS	.275	.348	.321
MEAN RADIUS	.771	.698	.617
MAX RADIUS	1.322	1.231	.950
HORIZONTAL SPREAD	1.609	1.492	1.492
VERTICAL SPREAD	1.971	1.971	1.290
EXTREME SPREAD	2.204	2.002	1.540
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	