

06587632

MODEL 700TM M24

Model SWSTM

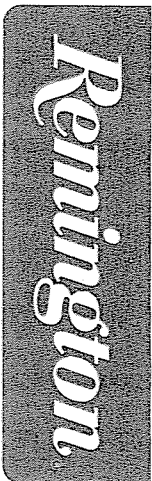
Action /

Barrel Length

Capacity

Order No. 5715

*Includes 1 in chamber.






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

MODEL 700™

124

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

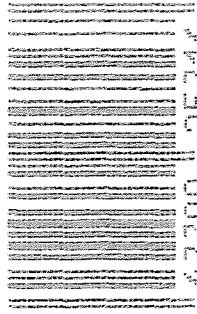
SERIAL NO.

C6587632

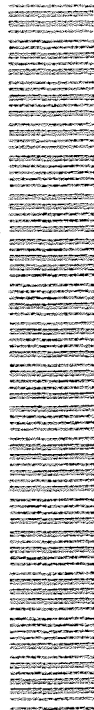
ORDER NO.

5716

LPC



0 4700 2576



5716 C6587632

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6587632

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1024	90	RW
600	Proof	1024	90	RW
607	Check Headspace	1024	90	RW
610	Dis-assemble Gun	1024	90	RW
612	Magnaflux Barrel Action		10/30/90	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	LS
617	Drill and Tap Sight Holes		11/5/90	LB
618	Polish Barrel RWB		11/6/90	WB
620	Apply Coatings (Barrel Action)		11-26-90	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		1/3/91	DH

Op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	3 1/2	3 1/2	3 1/2	3 1/2	3 1/2	1/3/91	WB
	G) Safety Off Force	2 1/4	2 1/4	2 1/4	2 1/4	2 1/4	1/3/91	WB
	H) Trigger Pull Test & Retainability						1/3/91	DIT
	I) Firing Pin Indent	.020	.0205	.0205	.0205	.0205	1/3/91	WB
	J) Assemble Stock						1/16/91	RW
	K) Assemble Swivel Studs						1-12-91	RL
	L) Attach Front and Rear Sight Assemblies						1/16/91	RW
	M) Iron Sight Alignment						1/16/91	RW
	N) Detach Front & Rear Sights & place in numbered container						1/16/91	RW
	O) Attach Scope to Rifle						1/16/91	RW
	P) Detach & Attach Scope 20 Times						1/16/91	RW
640	Gallery Target & Test						1-16-90	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						1-16-91	NF
655	Final Inspection							
	A) Headspace						1-17-91	RL
	B) Trigger Pull	2.43	2.31	2.32	2.34	2.33	1-17-91	RL
	C) Function						1-17-91	RL
660	Pack						3-19-91	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6587632

DATE 1-3-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.64	2.51	2.64	2.43	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.66	2.53	2.44	2.31	
PULL #3	2.63	2.53	2.59	2.32	
PULL #4	2.62	2.56	2.59	2.34	
PULL #5	2.51	2.57	2.42	2.33	
TOTAL	13.06	12.70	12.68		
AVG.	2.61	2.54	2.53		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.21	3.15		
PULL #2	3.25	3.15		
PULL #3	3.18	3.06		
PULL #4	3.11	3.02		
PULL #5	3.14	3.16		
TOTAL	15.89	15.54		
AVG.	3.17	3.10		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.16	4.28		4.34
PULL #2	4.25	4.19		4.38
PULL #3	4.36	4.07		4.27
PULL #4	4.01	4.19		4.28
PULL #5	4.25	4.13		4.13
TOTAL	21.03	20.86		21.40
AVG.	4.20	4.17		4.28

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587632
17 Jan 1991

CENTROIDAL DISTANCES

0 TO	1	.0447214
1 TO	2	.249128
1 TO	3	.102416
1 TO	4	.101045
1 TO	5	.0596825

32 <----POR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0796
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0492
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0935778
THE AMR FOR THIS RIFLE IS: 1.077

17 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8587632

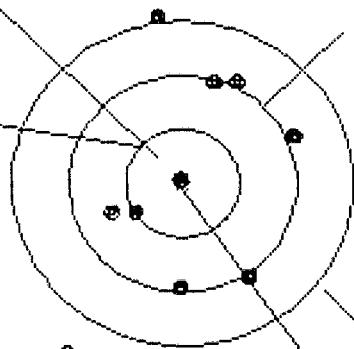
CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle



OF SHOTS - 10

IN CIR

1in = 1

2in = 4

3in = 5

HS = 1.941

VS = 3.038

GS = 3.139

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.952	.842	.803
MINIMUM X	-.989	-.720	-.759
MAXIMUM Y	1.495	1.324	.983
MINIMUM Y	-1.543	-1.136	-.971
CENTROID X	.020	.130	.169
CENTROID Y	-.040	.131	-.034
POA TO CENTROID in.	.045	.185	.172
MIN RADIUS	.045	.184	.171
MEAN RADIUS	.976	.889	.816
MAX RADIUS	1.833	1.359	1.041
HORIZONTAL SPREAD	1.941	1.562	1.562
VERTICAL SPREAD	3.038	2.460	1.954
EXTREME SPREAD	3.139	2.466	2.023
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	5		

17 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6587632

CENTERFIRE PATTERNS

2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in - 0

2 in - 4

3 in - 7

HS- 2.905

VS- 2.769

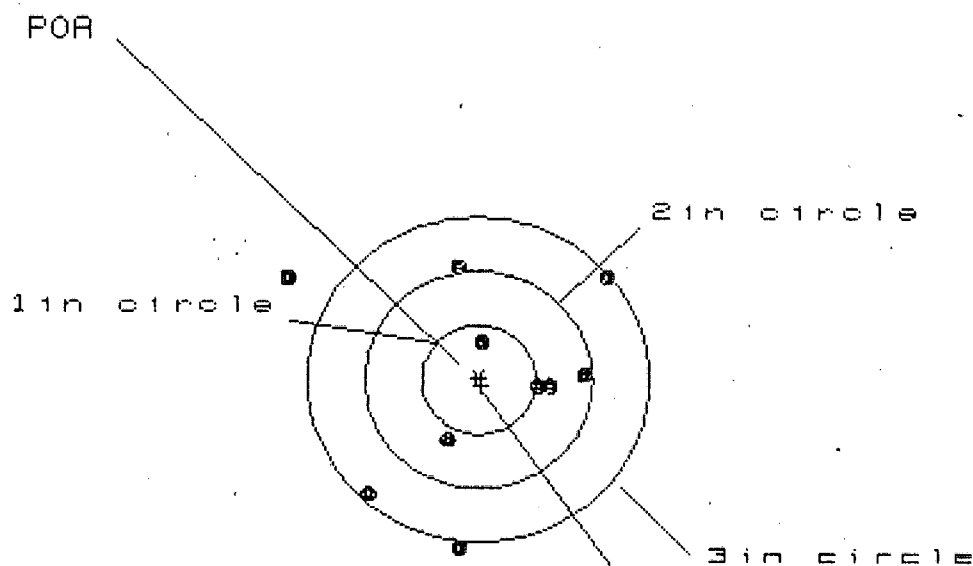
GS- 3.034

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.476	1.317	1.273
MINIMUM X	:	-1.429	-1.239	-1.283
MAXIMUM Y	:	1.038	.822	.621
MINIMUM Y	:	-1.731	-1.616	-.855
CENTROID X	:	.269	.428	.472
CENTROID Y	:	-.048	-.163	.039
POA TO CENTROID in.	:	.274	.458	.473
MIN RADIUS	:	.625	.649	.624
MEAN RADIUS	:	1.174	1.105	1.010
MAX RADIUS	:	1.767	1.652	1.381
HORIZONTAL SPREAD	:	2.905	2.556	2.556
VERTICAL SPREAD	:	2.769	2.438	1.476
EXTREME SPREAD	:	3.034	2.804	2.690
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

17 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6587632

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in - 1

2 in - 5

3 in - 8

HS - 2.751

VS - 2.623

GS - 2.956

CENTROID *

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.126
MINIMUM X	-1.625
MAXIMUM Y	1.037
MINIMUM Y	-1.586
CENTROID X	-.025
CENTROID Y	.052
POA TO CENTROID in.	.058
MIN RADIUS	.329
MEAN RADIUS	1.040
MAX RADIUS	1.898
HORIZONTAL SPREAD	2.751
VERTICAL SPREAD	2.623
EXTREME SPREAD	2.956
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	8

17 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6587632

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 8

HS= 2.851

VS= 2.791

GS= 3.150

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.298

1.196

.989

MINIMUM X

-1.553

-1.655

-.934

MAXIMUM Y

1.570

1.391

1.453

MINIMUM Y

-1.221

-1.046

-.984

CENTROID X

.083

.185

.392

CENTROID Y

-.119

-.294

-.356

POA TO CENTROID in.

.145

.347

.530

MIN RADIUS

.358

.330

.518

MEAN RADIUS

1.204

1.114

1.022

MAX RADIUS

1.821

1.728

1.576

HORIZONTAL SPREAD

2.851

2.851

1.923

VERTICAL SPREAD

2.791

2.437

2.437

EXTREME SPREAD

3.150

3.016

2.470

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

3

NUMBER IN THREE INCH CIRCLE =

8

17 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6587632

CENTERFIRE PATTERNS # 5

POR

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 0

2in = 7

3in = 9

HS= 1.997

VS= 3.352

GS= 3.352

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.895
MINIMUM X	-1.102
MAXIMUM Y	1.383
MINIMUM Y	-1.969
CENTROID X	.051
CENTROID Y	-.091
POR TO CENTROID in.	.104
MIN RADIUS	.635
MEAN RADIUS	.990
MAX RADIUS	1.975
HORIZONTAL SPREAD	1.997
VERTICAL SPREAD	3.352
EXTREME SPREAD	3.352
NUMBER IN ONE INCH CIRCLE =	0
NUMBER IN TWO INCH CIRCLE =	7
NUMBER IN THREE INCH CIRCLE =	9