

C6649079

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



Still
Smart.




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

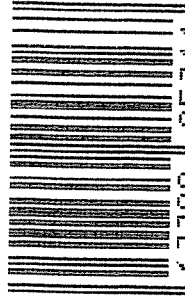
MODEL 700TM H24

SERIAL NO.
C6649079

ORDER NO.
5716

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

LPC



0 47700 25716 2



5716 C6649079

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6649079

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		4/25/91	KA
600	Proof		4/25/91	KA
607	Check Headspace		4/25/91	KA
610	Dis-assemble Gun		4/25/91	KA
612	Magnaflux Barrel Action		JUL 18 1991	GS
	Magnaflux Bolt		JUL 18 1991	GS
615	Rollmark Caliber		JUL 18 1991	GS
617	Drill and Tap Sight Holes		JUL 18 1991	FB
618	Polish Barrel		JUL 20 1991	WB
620	Apply Coatings (Barrel Action)		8-7-91	KA
	Apply Coating (Bolt)			KA
625	Final Assembly A) Clean inside of Bolt Assembly		8/8/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/8/91	KA
	C) Inspect Ejector Hole for Chamfer		8/8/91	KA
	D) Oil Firing Pin Ass'y		8/8/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		8-9-91	KA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8-9-91	JH
	G) Safety Off Force	3	3	3			8-9-91	JH
	H) Trigger Pull Test & Retainability						8-9-91	JH
	I) Firing Pin Indent	.0205	.022	.022			8-9-91	JH
	J) Assemble Stock						8-9-91	JH
	K) Assemble Swivel Studs						8-14-91	D/H
	L) Attach Front and Rear Sight Assemblies						8-9-91	JH
	M) Iron Sight Alignment						8-9-91	JH
	N) Detach Front & Rear Sights & place in numbered container						8-9-91	JH
	O) Attach Scope to Rifle						8-9-91	JH
	P) Detach & Attach Scope 20 Times						8-9-91	JH
640	Gallery Target & Test						8-13-91	AC
	A) Time						8-13-91	AC
	B) Malfunctions						8-13-91	AC
	C) Pierced Primers						8-13-91	AC
	D) Optical Clarity of Scope						8-13-91	AC
645	Inspect for Live Ammo						8-13-91	AC
655	Final Inspection						8-14-91	D/H
	A) Headspace						8-14-91	D/H
	B) Trigger Pull	2.57	2.49	2.46	2.22	2.41	8-14-91	JH
	C) Function						8-14-91	D/H
660	Pack						9-17-91	D/H

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO 0-6649029

DATE 8-9-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.47	2.37	2.40	2.57	MIN. SETTING,
PULL #2	2.31	2.31	2.40	2.49	NO AVG. OF 5
PULL #3	2.43	2.35	2.46	2.46	READINGS ACCEPT-
PULL #4	2.35	2.47	2.48	2.22	ABLE LESS THAN 2#
PULL #5	2.29	2.37	2.44	2.41	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.30	3.37		
PULL #2	3.27	3.38		
PULL #3	3.25	3.52		
PULL #4	3.22	3.42		
PULL #5	3.57	3.57		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.47	4.54		4.47
PULL #2	4.30	4.60		4.49
PULL #3	4.28	4.56		4.41
PULL #4	4.20	4.45		4.60
PULL #5	4.47	4.48		4.64
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649079
22 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.176819
1 TO	2	.0672086
1 TO	3	.344026
1 TO	4	.109417
1 TO	5	.0530094

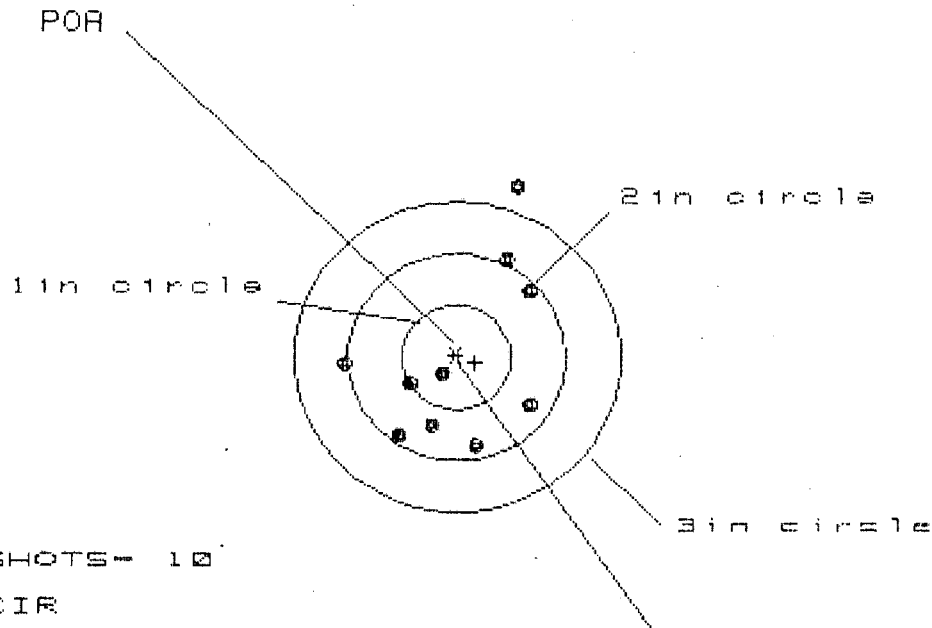
←----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0974
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0322
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .102585
THE AMR FOR THIS RIFLE IS: .787

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649079

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 9

HS= 1.692

VS= 2.552

GS= 2.648

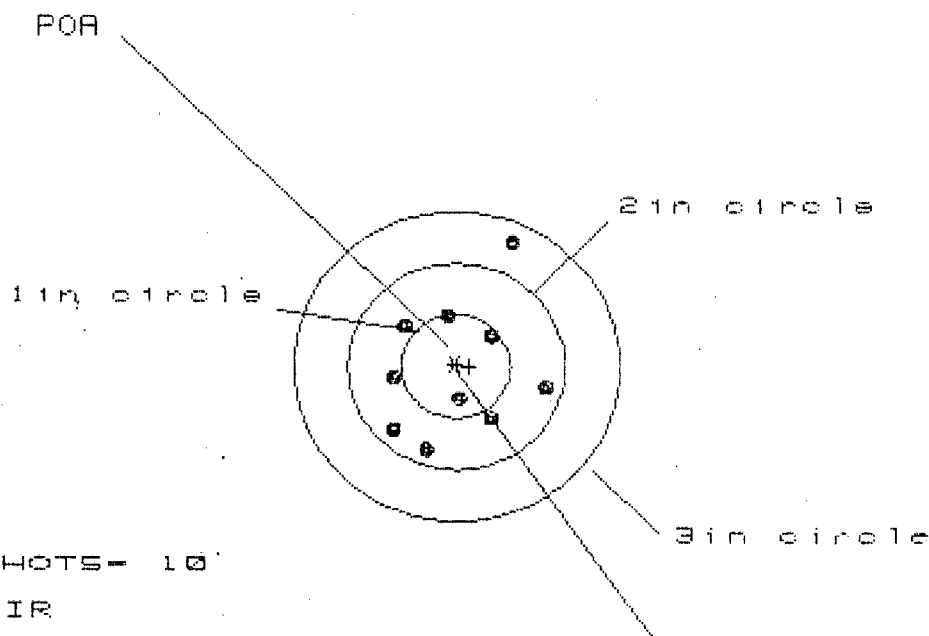
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.631	.691	.566
MINIMUM X	-1.061	-1.001	-.573
MAXIMUM Y	1.664	1.111	1.122
MINIMUM Y	-.888	-.703	-.692
CENTROID X	-.169	-.229	-.104
CENTROID Y	.052	-.133	-.144
POA TO CENTROID in.	.177	.265	.177
MIN RADIUS	.209	.047	.173
MEAN RADIUS	.879	.721	.700
MAX RADIUS	1.749	1.217	1.182
HORIZONTAL SPREAD	1.692	1.692	1.139
VERTICAL SPREAD	2.552	1.814	1.814
EXTREME SPREAD	2.648	1.941	1.941
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

22 Aug 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 9

3 in = 10

HS= 1.462

VS= 2.068

GS= 2.192

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.868	.921	.520
MINIMUM X	-.594	-.541	-.425
MAXIMUM Y	1.224	.633	.627
MINIMUM Y	-.844	-.708	-.714
CENTROID X	-.123	-.176	-.292
CENTROID Y	.003	-.133	-.127
POA TO CENTROID in.	.123	.221	.318
MIN RADIUS	.271	.152	.234
MEAN RADIUS	.704	.618	.576
MAX RADIUS	1.313	.923	.719
HORIZONTAL SPREAD	1.462	1.462	.945
VERTICAL SPREAD	2.068	1.341	1.341
EXTREME SPREAD	2.192	1.518	1.347
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	9		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 10

HS= 2.171

VS= 1.963

GS= 2.487

CENTROID *

PATTERN #

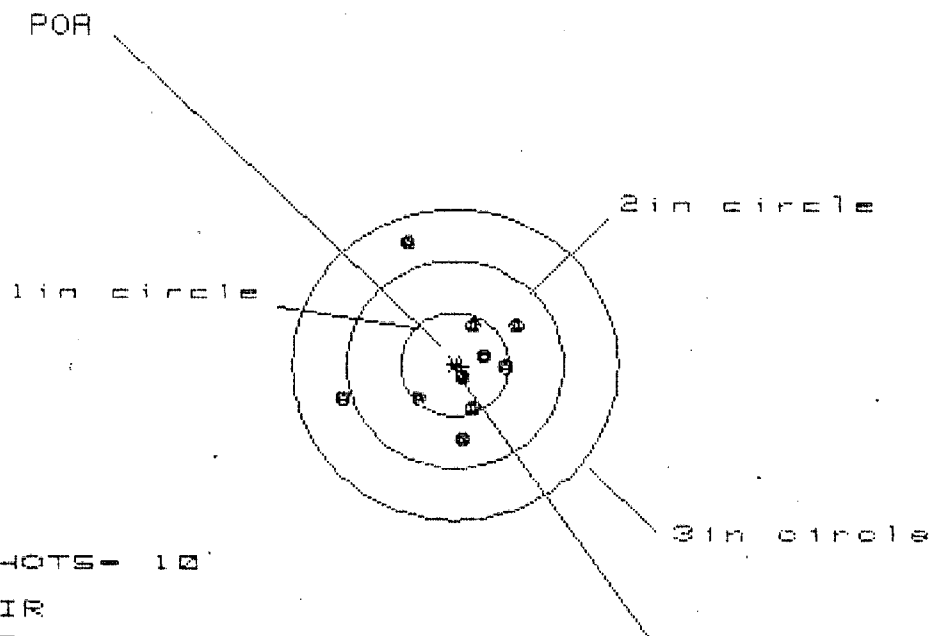
3

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.167	1.082	1.054
MINIMUM X	:	-1.004	-.874	-.739
MAXIMUM Y	:	1.075	1.148	1.046
MINIMUM Y	:	-.888	-.815	-.890
CENTROID X	:	.008	-.122	-.257
CENTROID Y	:	-.243	-.316	-.214
POA TO CENTROID in.	:	.243	.339	.334
MIN RADIUS	:	.112	.246	.275
MEAN RADIUS	:	.877	.819	.715
MAX RADIUS	:	1.338	1.354	1.130
HORIZONTAL SPREAD	:	2.171	1.956	1.793
VERTICAL SPREAD	:	1.963	1.963	1.944
EXTREME SPREAD	:	2.487	2.460	2.093
NUMBER IN ONE INCH CIRCLE =		1		
NUMBER IN TWO INCH CIRCLE =		6		
NUMBER IN THREE INCH CIRCLE =		10		

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 5

2in = 8

3in = 10

HS= 1.578

VS= 1.927

GS= 2.003

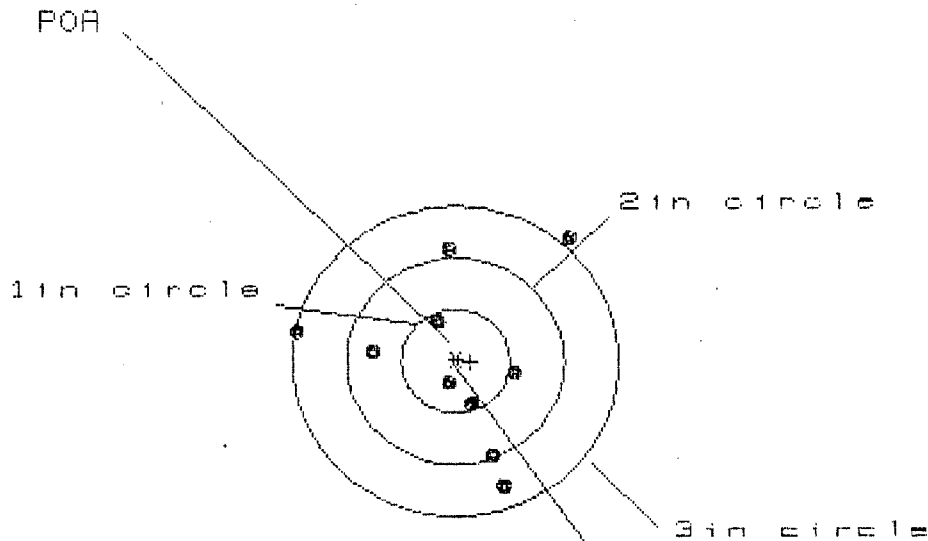
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.537	.488	.352
MINIMUM X	-1.041	-1.090	-.552
MAXIMUM Y	1.168	.511	.493
MINIMUM Y	-.759	-.629	-.647
CENTROID X	-.065	-.016	.120
CENTROID Y	.018	-.112	-.094
POA TO CENTROID in.	.068	.113	.152
MIN RADIUS	.168	.050	.091
MEAN RADIUS	.599	.495	.397
MAX RADIUS	1.249	1.100	.652
HORIZONTAL SPREAD	1.578	1.578	.904
VERTICAL SPREAD	1.927	1.140	1.140
EXTREME SPREAD	2.003	1.695	1.184
NUMBER IN ONE INCH CIRCLE =	5		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 9

HS= 2.469

VS= 2.362

GS= 2.617

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.009	.681	.512
MINIMUM X	:	-1.460	-1.348	-.825
MAXIMUM Y	:	1.154	1.190	1.242
MINIMUM Y	:	-1.208	-1.080	-1.028
CENTROID X	:	-.138	-.250	-.081
CENTROID Y	:	.009	-.119	-.171
POA TO CENTROID in.	:	.138	.277	.189
MIN RADIUS	:	.205	.095	.107
MEAN RADIUS	:	.876	.786	.683
MAX RADIUS	:	1.533	1.410	1.249
HORIZONTAL SPREAD	:	2.469	2.029	1.337
VERTICAL SPREAD	:	2.362	2.270	2.270
EXTREME SPREAD	:	2.617	2.401	2.324
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	