

C6636245

MODEL 700TM M24

Model **SWS** TM

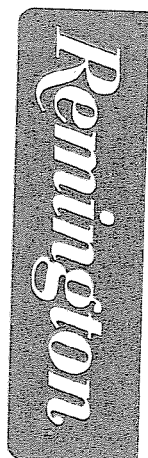
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.






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

MODEL 700TM H24

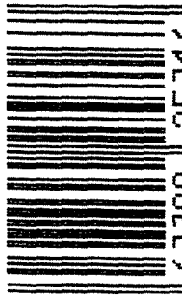
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SERIAL NO.
C6636245

ORDER NO.
5716

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

UPC



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5716 C6636245

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636245

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 30	91	RW
600	Proof	4 30	91	RW
607	Check Headspace	4 30	91	RW
610	Dis-assemble Gun	4 30	91	RW
612	Magnaflux Barrel Action	5 6	91	KCR
	Magnaflux Bolt	5 6	91	KCR
615	Rollmark Caliber	5 6	91	CS
617	Drill and Tap Sight Holes	5 10	91	LB
618	Polish Barrel	5 10	91	WB
620	Apply Coatings (Barrel Action)		5/30/91	JA
	Apply Coating (Bolt)		5/30/91	JA
625	Final Assembly A) Clean inside of Bolt Assembly		5/30/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/91	RW
	C) Inspect Ejector Hole for Chamfer		5/30/91	RW
	D) Oil Firing Pin Ass'y		5/30/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		6/8/91	WB

op. #	OP. NAME	READINGS			DATE	INIT
625 cont.	F) Safety On Force	5	5	5	6-10-91	DH
	G) Safety Off Force	3	2 $\frac{3}{4}$	2 $\frac{1}{2}$	6-10-91	DH
	H) Trigger Pull Test & Retainability				6/8/91	WB
	I) Firing Pin Indent	.020	.020	.020	6-10-91	DH
	J) Assemble Stock				6/10/91	RW
	K) Assemble Swivel Studs				6-12-91	A
	L) Attach Front and Rear Sight Assemblies				6/10/91	RW
	M) Iron Sight Alignment				6/10/91	RW
	N) Detach Front & Rear Sights & place in numbered container				6/10/91	RW
	O) Attach Scope to Rifle				6/10/91	RW
	P) Detach & Attach Scope 20 Times				6/10/91	RW
640	Gallery Target & Test				6-11-91	AC
	A) Time				6-11-91	AC
	B) Malfunctions				6-11-91	AC
	C) Pierced Primers				6-11-91	AC
	D) Optical Clarity of Scope				6-11-91	AC
645	Inspect for Live Ammo				6-11-91	AC
655	Final Inspection					
	A) Headspace				6-12-91	A
	B) Trigger Pull	2.27	2.30	2.26	2.17, 2.37	6-12-91
	C) Function				6-12-91	AC
660	Pack				6-20-91	NF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6636245
DATE 6/8/91
TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.47	2.43	2.40	2.24	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.35	2.60	2.30	
PULL #3	2.43	2.26	2.60	2.26	
PULL #4	2.21	2.35	2.41	2.17	
PULL #5	2.43	2.15	2.65	2.37	
TOTAL	11.95	11.54	12.66		
AVG.	2.39	2.31	2.53		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.37	3.42		
PULL #2	3.31	3.39		
PULL #3	3.31	3.49		
PULL #4	3.27	3.40		
PULL #5	3.17	3.22		
TOTAL	16.43	16.92		
AVG.	3.29	3.38		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.00	4.03		4.11
PULL #2	4.06	4.20		4.30
PULL #3	4.15	4.12		4.12
PULL #4	3.95	4.20		4.17
PULL #5	4.18	4.20		4.18
TOTAL	20.34	20.75		20.88
AVG.	4.07	4.15		4.17

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636245
11 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.147899
1 TO	2	.451717
1 TO	3	.19642
1 TO	4	.380522
1 TO	5	.50232

$\frac{4}{42}^5$ <----FOR

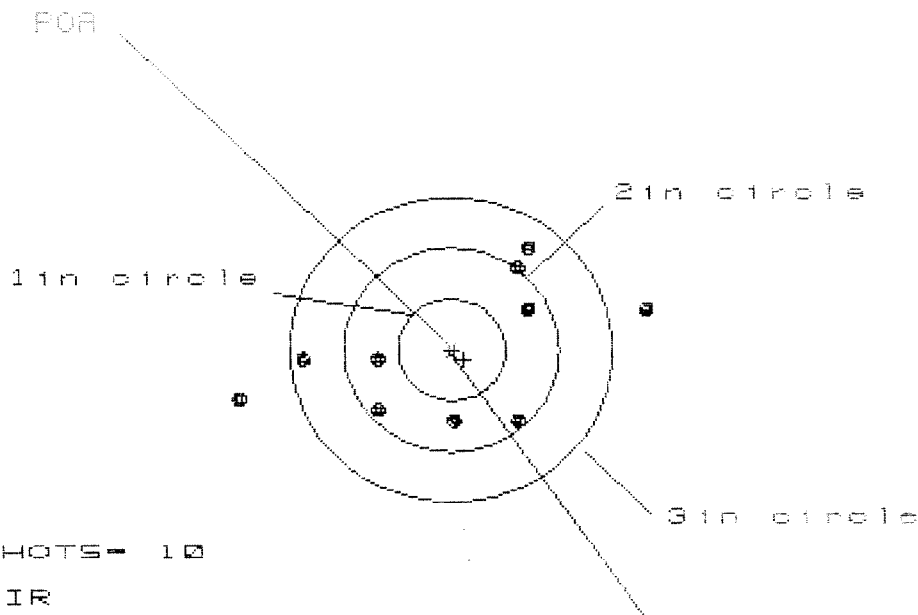
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0876
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0234
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0906715

THE AMR FOR THIS RIFLE IS: .946

11 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636245

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 0

2in = 5

3in = 8

HS= 3.801

VS= 1.713

GS= 3.904

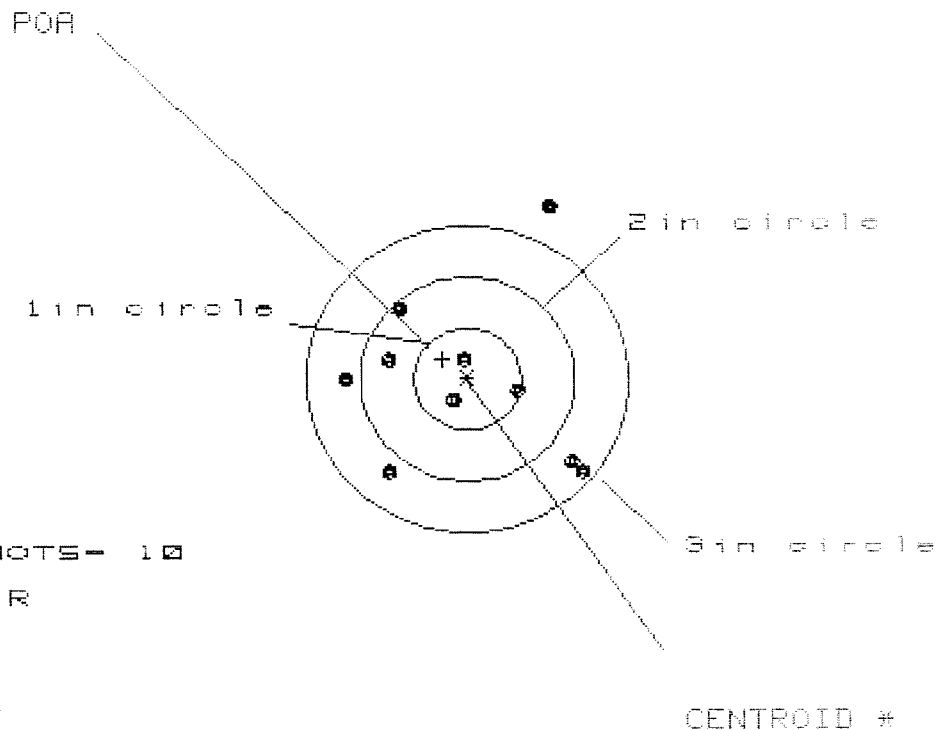
CENTROID *

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.844	1.626	.736
MINIMUM X	:	-1.957	-1.561	-1.358
MAXIMUM Y	:	.973	.919	.961
MINIMUM Y	:	-.740	-.794	-.752
CENTROID X	:	-.115	.103	-.100
CENTROID Y	:	.093	.148	.106
POA TO CENTROID in.	:	.148	.181	.146
MIN RADIUS	:	.665	.664	.681
MEAN RADIUS	:	1.156	1.046	.958
MAX RADIUS	:	2.019	1.661	1.360
HORIZONTAL SPREAD	:	3.801	3.187	2.094
VERTICAL SPREAD	:	1.713	1.713	1.713
EXTREME SPREAD	:	3.904	3.220	2.323
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.153

VS= 2.568

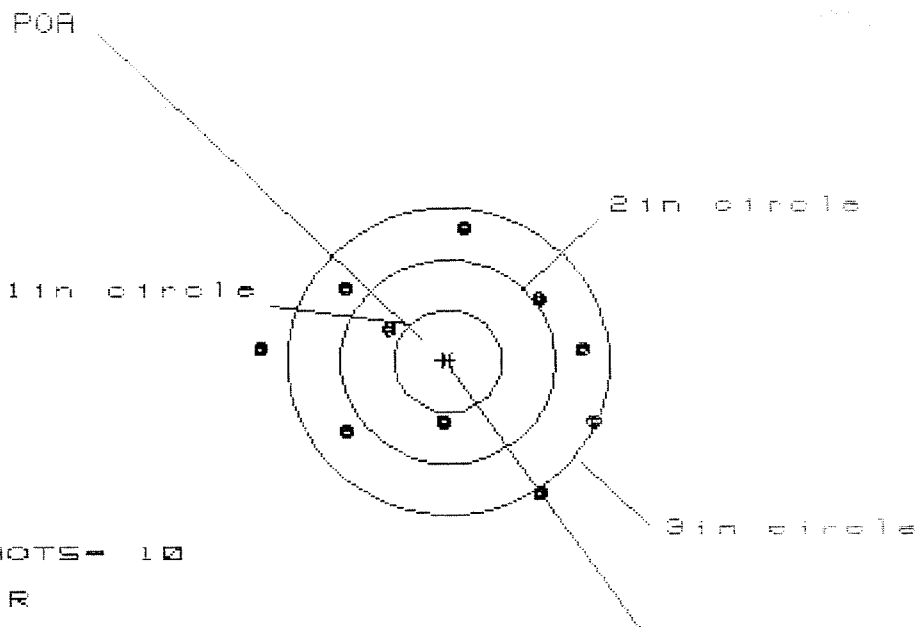
GS= 2.957

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.040	1.124	1.164
MINIMUM X	:	-1.113	-1.029	-0.889
MAXIMUM Y	:	1.683	.921	.836
MINIMUM Y	:	-.886	-.699	-.784
CENTROID X	:	.233	.150	.010
CENTROID Y	:	-.195	-.381	-.296
POA TO CENTROID in.	:	.304	.410	.296
MIN RADIUS	:	.202	.031	.175
MEAN RADIUS	:	.928	.808	.738
MAX RADIUS	:	1.842	1.316	1.335
HORIZONTAL SPREAD	:	2.153	2.153	2.053
VERTICAL SPREAD	:	2.568	1.620	1.620
EXTREME SPREAD	:	2.957	2.336	2.200
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 0

2in = 2

3in = 8

HS= 3.103

VS= 2.629

GS= 3.173

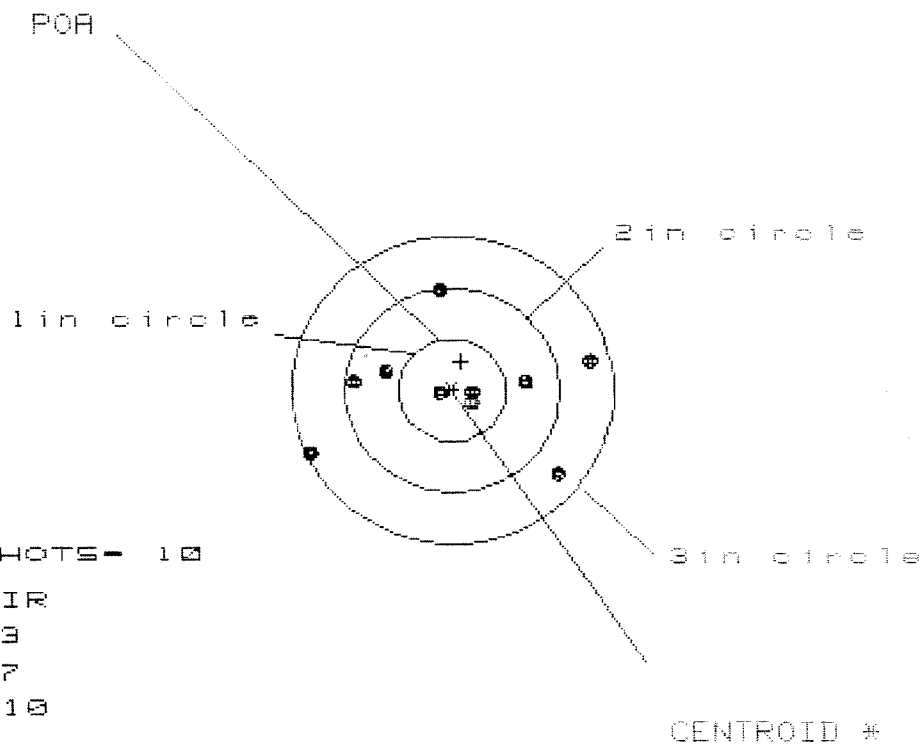
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.311	1.112	1.190
MINIMUM X	:	-1.792	-1.193	-1.115
MAXIMUM Y	:	1.309	1.320	1.156
MINIMUM Y	:	-1.320	-1.309	-0.832
CENTROID X	:	.051	.250	.172
CENTROID Y	:	-.012	-.023	.141
POA TO CENTROID in.	:	.052	.251	.222
MIN RADIUS	:	.589	.625	.705
MEAN RADIUS	:	1.203	1.130	1.077
MAX RADIUS	:	1.794	1.451	1.406
HORIZONTAL SPREAD	:	3.103	2.305	2.305
VERTICAL SPREAD	:	2.629	2.629	1.988
EXTREME SPREAD	:	3.179	2.724	2.602
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

HS= 2.654

VS= 1.811

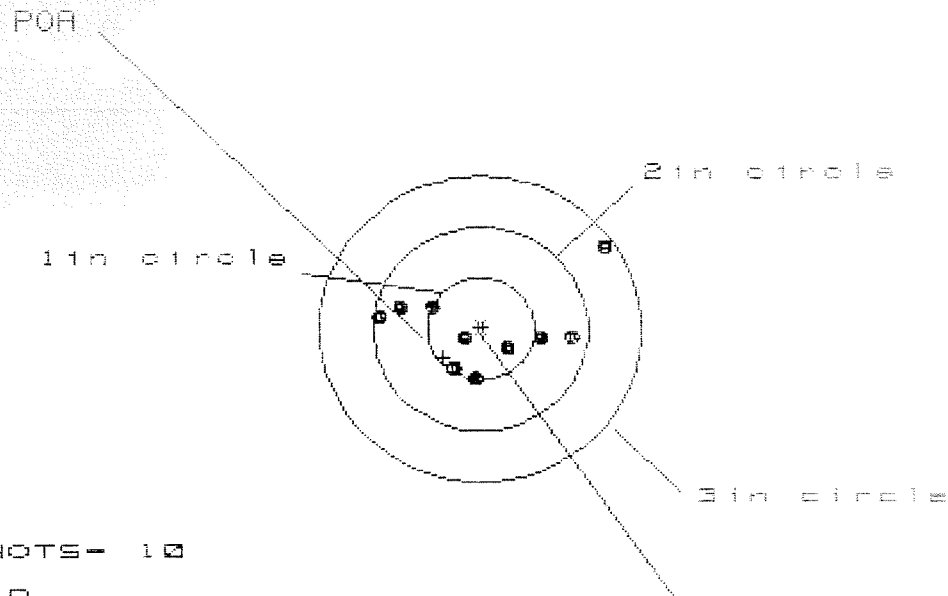
GS= 2.818

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.296	1.145	.945
MINIMUM X	:	-1.358	-1.101	-.958
MAXIMUM Y	:	.956	.885	.916
MINIMUM Y	:	-.855	-.926	-.895
CENTROID X	:	-.081	.070	-.073
CENTROID Y	:	-.286	-.215	-.246
POA TO CENTROID in.	:	.297	.226	.257
MIN RADIUS	:	.152	.101	.158
MEAN RADIUS	:	.789	.703	.634
MAX RADIUS	:	1.498	1.225	1.302
HORIZONTAL SPREAD	:	2.654	2.246	1.903
VERTICAL SPREAD	:	1.811	1.811	1.811
EXTREME SPREAD	:	2.818	2.253	2.145
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 2.093

VS= 1.322

GS= 2.188

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.104
MINIMUM X	-.989
MAXIMUM Y	.794
MINIMUM Y	-.528
CENTROID X	.350
CENTROID Y	.283
POA TO CENTROID in.	.450
MIN RADIUS	.194
MEAN RADIUS	.654
MAX RADIUS	1.360
HORIZONTAL SPREAD	2.093
VERTICAL SPREAD	1.322
EXTREME SPREAD	2.188
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	8
NUMBER IN THREE INCH CIRCLE =	10