

C6636283

MODEL 700™ M24

Model **SWS**™

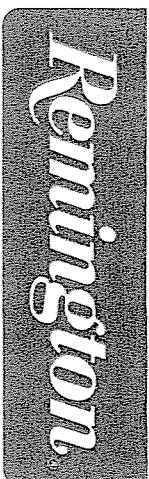
Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.





MODEL 700™ H24

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



REG. U.S. PAT. & T.M. OFF.

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

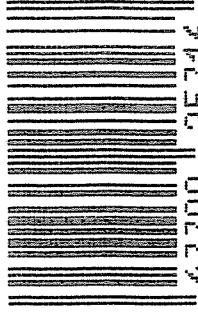
SERIAL NO.
C6636283

ORDER NO.
5716



5716 C6636283

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636283

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		5/3/91	KS
600	Proof		5/3/91	KS
607	Check Headspace		5/3/91	KS
610	Dis-assemble Gun		5/3/91	KS
612	Magnaflux Barrel Action		JUL 2 1991	KR
	Magnaflux Bolt		JUL 2 1991	KR
615	Rollmark Caliber		JUL 2 1991	KR
617	Drill and Tap Sight Holes		JUL 2 1991	LB
618	Polish Barrel		JUL 7 1991	WB
620	Apply Coatings (Barrel Action)		8-6-91	JA
	Apply Coating (Bolt)		8-6-91	JA
625	Final Assembly			
	A) Clean inside of Bolt Assembly		8/19/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/19/91	KL
	C) Inspect Ejector Hole for Chamfer		8/19/91	KL
	D) Oil Firing Pin Ass'y		8/19/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		8/20/91	KL

Op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			8/20/91	JK
	G) Safety Off Force	2	2	2			8/20/91	JK
	H) Trigger Pull Test & Retainability						8/20/91	JK
	I) Firing Pin Indent	1021	1021	1021			8/20/91	JK
	J) Assemble Stock						8/20/91	JK
	K) Assemble Swivel Studs						8/22/91	JK
	L) Attach Front and Rear Sight Assemblies						8/20/91	JK
	M) Iron Sight Alignment						8/20/91	JK
	N) Detach Front & Rear Sights & place in numbered container						8/20/91	JK
	O) Attach Scope to Rifle						8/20/91	JK
	P) Detach & Attach Scope 20 Times						8/20/91	JK
640	Gallery Target & Test						8/21/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						8/21/91	KT
655	Final Inspection							
	A) Headspace						8/21/91	JK
	B) Trigger Pull	2.49	2.50	2.60	2.46	2.55	8/22/91	JK
	C) Function						8/22/91	JK
660	Pack						9-18-91	JK

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636283
23 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.20801
1 TO	2	.0950789
1 TO	3	.247073
1 TO	4	.02
1 TO	5	.127613

\$ <----POA

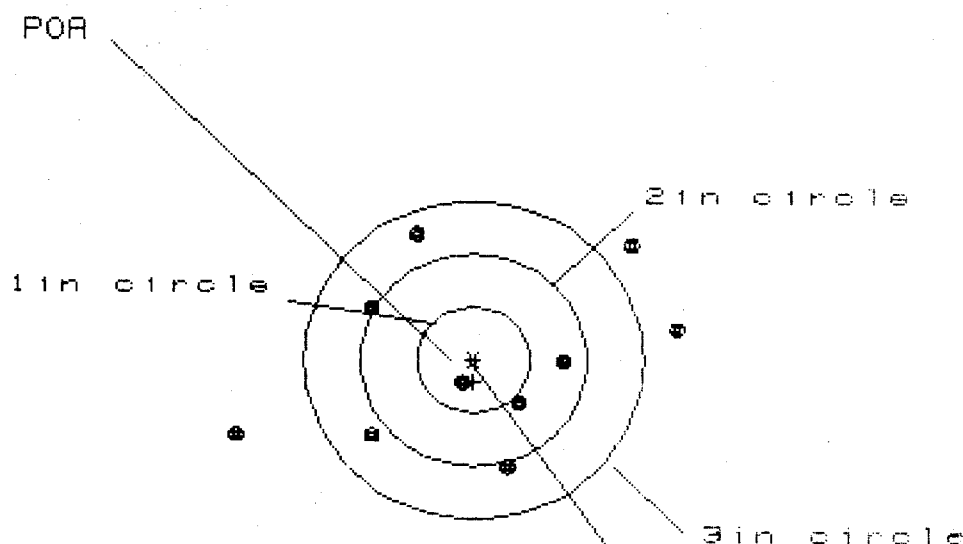
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0052
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1206
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .120759
THE AMR FOR THIS RIFLE IS: 1.019

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C86362B3

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 7

HS= 3.937

VS= 2.161

GS= 4.072

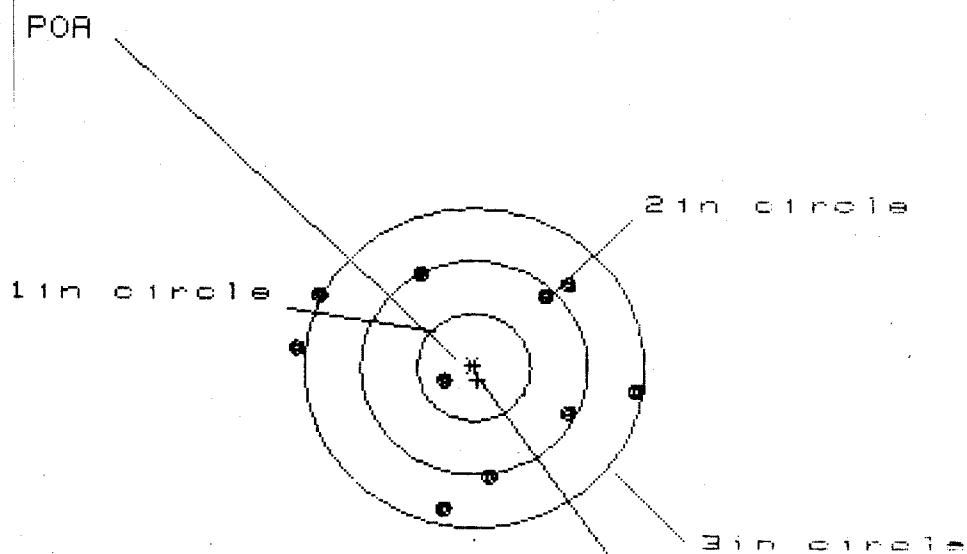
CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.805	1.568	1.338
MINIMUM X	:	-2.132	-1.184	-.988
MAXIMUM Y	:	1.186	1.108	1.140
MINIMUM Y	:	-.975	-1.053	-1.021
CENTROID X	:	.002	.239	.043
CENTROID Y	:	.208	.286	.254
POA TO CENTROID in.	:	.208	.373	.257
MIN RADIUS	:	.224	.438	.283
MEAN RADIUS	:	1.193	1.074	.989
MAX RADIUS	:	2.245	1.590	1.680
HORIZONTAL SPREAD	:	3.937	2.752	2.326
VERTICAL SPREAD	:	2.161	2.161	2.161
EXTREME SPREAD	:	4.072	2.942	2.926
NUMBER IN ONE INCH CIRCLE =	:	1	1	1
NUMBER IN TWO INCH CIRCLE =	:	3	3	3
NUMBER IN THREE INCH CIRCLE =	:	7	7	7

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C86362B3

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in - 1

2 in - 5

3 in - 4

HS- 2.944

VS= 2.228

GS= 2.968

CENTROID *

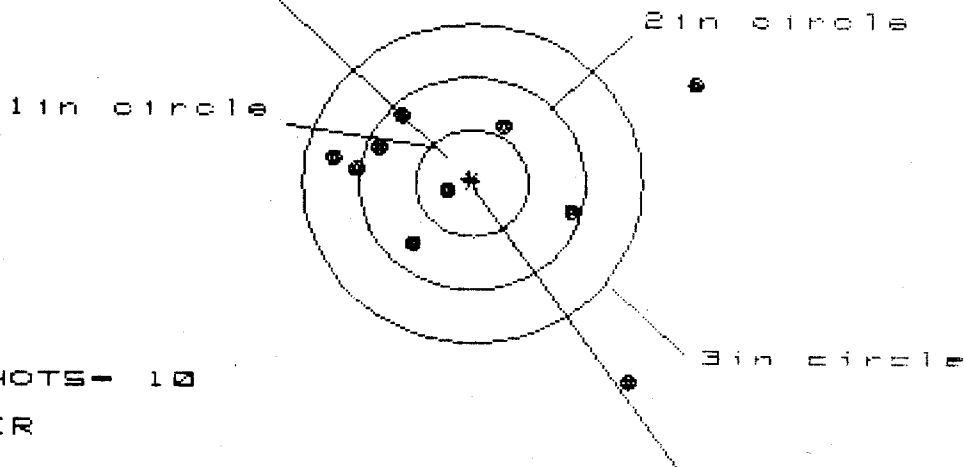
PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.416	1.246	1.058
MINIMUM X	:	-1.528	-1.499	-.795
MAXIMUM Y	:	.876	.895	.980
MINIMUM Y	:	-1.352	-1.333	-1.248
CENTROID X	:	-.034	.136	.324
CENTROID Y	:	.120	.101	.016
POA TO CENTROID in.	:	.124	.170	.324
MIN RADIUS	:	.303	.452	.546
MEAN RADIUS	:	1.107	1.047	.951
MAX RADIUS	:	1.537	1.646	1.409
HORIZONTAL SPREAD	:	2.944	2.745	1.853
VERTICAL SPREAD	:	2.228	2.228	2.228
EXTREME SPREAD	:	2.968	2.880	2.402
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			9	

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66362B3

CENTERFIRE PATTERNS # 3

POA



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 8

HS= 3.171

VS= 2.745

GS= 3.255

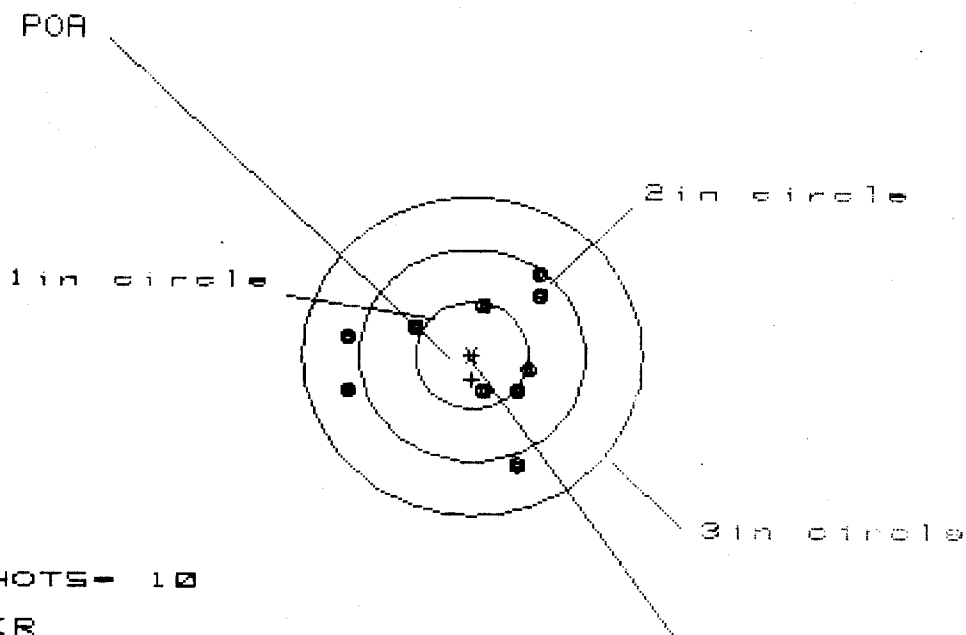
CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.964	2.112	1.272
MINIMUM X	:	-1.207	-1.059	-.795
MAXIMUM Y	:	.921	.719	.521
MINIMUM Y	:	-1.824	-.751	-.661
CENTROID X	:	.025	-.123	-.387
CENTROID Y	:	-.038	.164	.074
POA TO CENTROID in.	:	.046	.205	.394
MIN RADIUS	:	.273	.317	.260
MEAN RADIUS	:	1.094	.915	.678
MAX RADIUS	:	2.255	2.231	1.336
HORIZONTAL SPREAD	:	3.171	3.171	2.067
VERTICAL SPREAD	:	2.745	1.470	1.182
EXTREME SPREAD	:	3.255	3.247	2.131
NUMBER IN ONE INCH CIRCLE =	:	1		
NUMBER IN TWO INCH CIRCLE =	:	7		
NUMBER IN THREE INCH CIRCLE =	:	8		

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66362B3

CENTERFIRE PATTERNS # 4



* OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS= 1.744

VS= 1.777

GS= 2.045

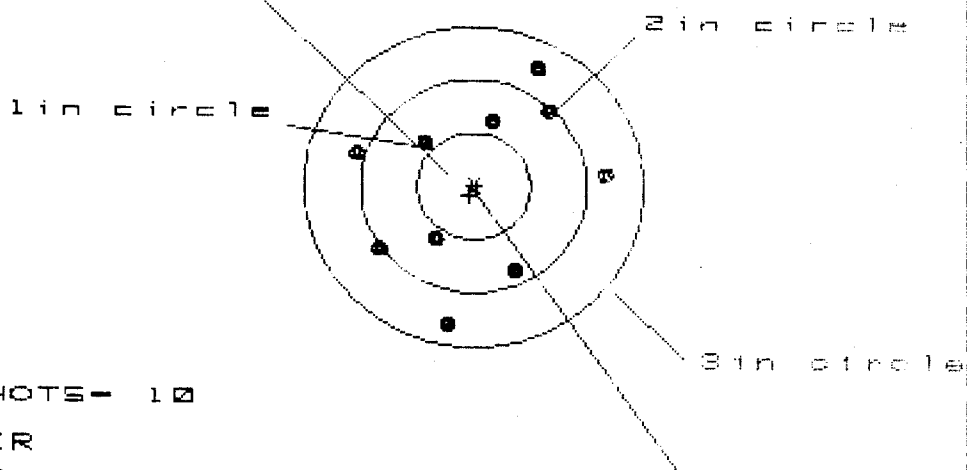
PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.627	.503	.535
MINIMUM X	:	-1.117	-1.196	-1.164
MAXIMUM Y	:	.751	.709	.576
MINIMUM Y	:	-1.026	-1.068	-.538
CENTROID X	:	.002	.126	.094
CENTROID Y	:	.228	.270	.403
POA TO CENTROID in.	:	.228	.298	.414
MIN RADIUS	:	.306	.326	.297
MEAN RADIUS	:	.757	.688	.635
MAX RADIUS	:	1.179	1.199	1.166
HORIZONTAL SPREAD	:	1.744	1.699	1.699
VERTICAL SPREAD	:	1.777	1.777	1.114
EXTREME SPREAD	:	2.045	1.850	1.776
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			10	

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66362B3

CENTERFIRE PATTERNS # 5

POA



* OF SHOTS- 10

IN CIR

1in = 0

2in = 6

3in = 10

HS= 2.174

VS= 2.423

GS= 2.553

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.139	1.118	1.101
MINIMUM X	:	-1.034	-1.056	-.983
MAXIMUM Y	:	1.118	.972	.651
MINIMUM Y	:	-1.310	-.910	-.794
CENTROID X	:	.036	.058	-.015
CENTROID Y	:	.085	.231	.109
POA TO CENTROID in.	:	.093	.238	.110
MIN RADIUS	:	.600	.484	.545
MEAN RADIUS	:	.942	.887	.845
MAX RADIUS	:	1.325	1.136	1.193
HORIZONTAL SPREAD	:	2.174	2.174	2.174
VERTICAL SPREAD	:	2.420	1.888	1.445
EXTREME SPREAD	:	2.553	2.196	2.182
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6636283

DATE 8-20-91

TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.34	2.36	2.35	2.44	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.50	2.46	2.38	2.50	
PULL #3	2.51	2.35	2.48	2.60	
PULL #4	2.45	2.35	2.44	2.46	
PULL #5	2.35	2.45	2.35	2.55	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.39	3.38		
PULL #2	3.29	3.30		
PULL #3	3.35	3.20		
PULL #4	3.34	3.29		
PULL #5	3.25	3.23		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.49	4.44		4.18
PULL #2	4.48	4.40		4.41
PULL #3	4.50	4.45		4.39
PULL #4	4.25	4.23		4.34
PULL #5	4.28	4.51		4.42
TOTAL				
AVG.				