

C6636286

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.

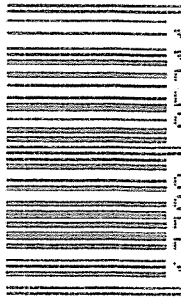
MODEL 700™ N24

SERIAL NO.
C6636286

ORDER NO.
5716

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

UPC



0 47700 25716 7



5716 C6636286

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6636286

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/24/91	KA
600	Proof		6/24/91	KA
607	Check Headspace		6/24/91	KA
610	Dis-assemble Gun		6/24/91	KA
612	Magnaflux Barrel Action		1 1991	KR
	Magnaflux Bolt		JUL 1 1991	KR
615	Rollmark Caliber		JUL 1 1991	YG
617	Drill and Tap Sight Holes		JUL 1 1991	WB
618	Polish Barrel		2 1991	WB
620	Apply Coatings (Barrel Action)		7-23-91	KA
	Apply Coating (Bolt)			KA
625	Final Assembly A) Clean inside of Bolt Assembly		8/5/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/5/91	KA
	C) Inspect Ejector Hole for Chamfer		8/5/91	KA
	D) Oil Firing Pin Ass'y		8/5/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		8-6-91	D/H

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8-6-91	DH
	G) Safety Off Force	3	3	3			8-6-91	DH
	H) Trigger Pull Test & Retainability						8-6-91	DH
	I) Firing Pin Indent	.021	.020	.020			8-6-91	DH
	J) Assemble Stock						8/7/91	KL
	K) Assemble Swivel Studs						8-12-91	DH
	L) Attach Front and Rear Sight Assemblies						8/7/91	KL
	M) Iron Sight Alignment						8/7/91	KL
	N) Detach Front & Rear Sights & place in numbered container						8/7/91	KL
	O) Attach Scope to Rifle						8/7/91	KL
	P) Detach & Attach Scope 20 Times						8/7/91	KL
640	Gallery Target & Test						8/8/91	KL
	A) Time							KL
	B) Malfunctions							KL
	C) Pierced Primers							KL
	D) Optical Clarity of Scope							KL
645	Inspect for Live Ammo						8/8/91	KL
655	Final Inspection							
	A) Headspace						8-12-91	DH
	B) Trigger Pull	2.45	2.51	2.58	2.59	2.66	8-9-91	KL
	C) Function						8-12-91	DH
660	Pack						9-19-91	KL

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C6636786

DATE 8-6-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.60	2.40	2.59	2.45	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.59	2.44	2.24	2.51	
PULL #3	2.62	2.47	2.64	2.58	
PULL #4	2.48	2.36	2.54	2.59	
PULL #5	2.45	2.38	2.55	2.66	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.18	3.34		
PULL #2	3.29	3.31		
PULL #3	3.39	3.07		
PULL #4	3.30	3.28		
PULL #5	3.03	3.31		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.33	4.08		4.03
PULL #2	4.24	4.06		4.18
PULL #3	4.16	4.39		4.17
PULL #4	4.21	4.18		4.02
PULL #5	4.13	4.17		4.08
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636286
8 Aug 1991

CENTROIDAL DISTANCES

0 TO 1	.45
1 TO 2	.452678
1 TO 3	.552521
1 TO 4	.500353
1 TO 5	.681751

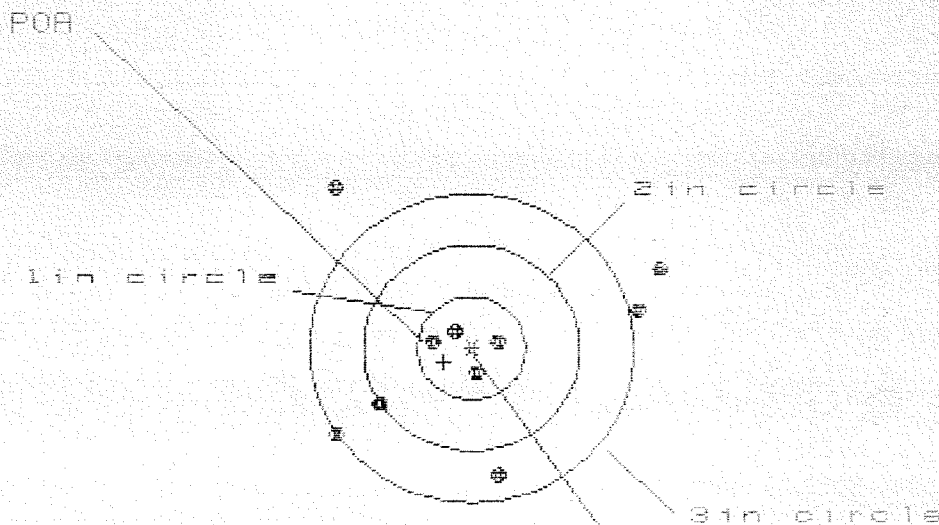
#5 <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .116
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0814
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .141711
THE AMR FOR THIS RIFLE IS: 1.017

6 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8836286

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 4

2in = 0

3in = 7

HS= 3.006

VS= 2.812

GS= 3.385

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.772	1.634	1.640
MINIMUM X	:	-1.234	-1.348	-1.143
MAXIMUM Y	:	1.556	.896	.611
MINIMUM Y	:	-1.256	-1.084	-.972
CENTROID X	:	.257	.394	.139
CENTROID Y	:	.132	-.041	-.153
POA TO CENTROID in.	:	.288	.396	.244
MIN RADIUS	:	.254	.160	.081
MEAN RADIUS	:	1.046	.948	.800
MAX RADIUS	:	1.986	1.864	1.750
HORIZONTAL SPREAD	:	3.006	2.982	2.783
VERTICAL SPREAD	:	2.812	1.980	1.583
EXTREME SPREAD	:	3.385	3.385	3.033
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

8 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636286

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 5

3 in = 7

HS = 2.113

VS = 4.427

GS = 4.585

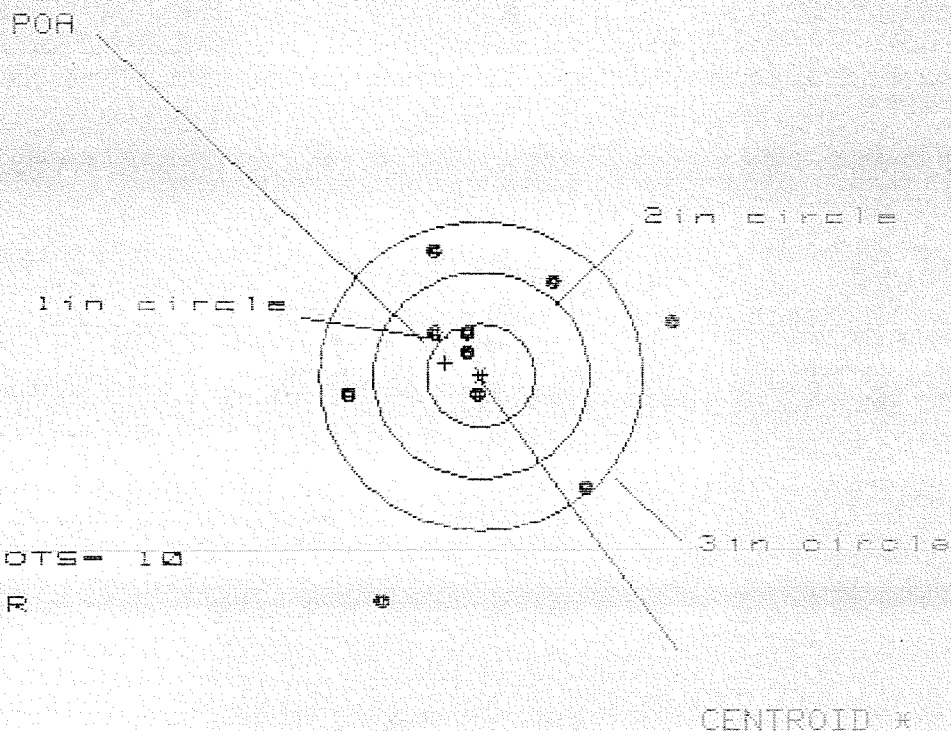
CENTROID *

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.944	.902	.998
MINIMUM X	-1.169	-1.211	-1.115
MAXIMUM Y	2.046	1.781	.993
MINIMUM Y	-2.381	-1.562	-1.339
CENTROID X	.051	.093	-.003
CENTROID Y	.036	.301	.078
POA TO CENTROID in.	.062	.315	.078
MIN RADIUS	.294	.257	.226
MEAN RADIUS	1.107	.956	.802
MAX RADIUS	2.411	1.976	1.743
HORIZONTAL SPREAD	2.113	2.113	2.113
VERTICAL SPREAD	4.427	3.343	2.332
EXTREME SPREAD	4.585	3.896	2.932
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

8 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/G85352B6

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 3

2in = 4

3in = 8

HS= 2.939

VS= 3.431

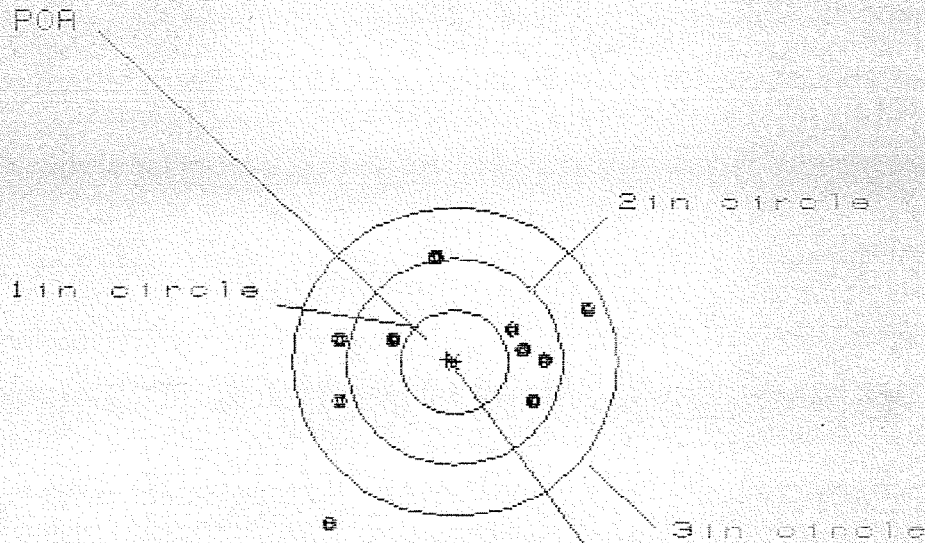
GS= 3.811

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.744
MINIMUM X	-1.195
MAXIMUM Y	1.224
MINIMUM Y	-2.207
CENTROID X	.300
CENTROID Y	-.120
POA TO CENTROID in.	.351
MIN RADIUS	.230
MEAN RADIUS	1.082
MAX RADIUS	2.382
HORIZONTAL SPREAD	2.939
VERTICAL SPREAD	3.431
EXTREME SPREAD	3.811
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	8

6 Aug 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 0

2in = 5

3in = 9

HS = 2.340

VS = 2.605

GS = 3.142

PATTERN #	2
SHOTS (BEST OF)	10
MAXIMUM X	1.202
MINIMUM X	-1.138
MAXIMUM Y	1.007
MINIMUM Y	-1.598
CENTROID X	.068
CENTROID Y	-.023
POA TO CENTROID in.	.071
MIN RADIUS	.621
MEAN RADIUS	1.017
MAX RADIUS	1.962
HORIZONTAL SPREAD	2.340
VERTICAL SPREAD	2.605
EXTREME SPREAD	3.142
NUMBER IN ONE INCH CIRCLE	0
NUMBER IN TWO INCH CIRCLE	5
NUMBER IN THREE INCH CIRCLE	9

8 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/G8B3B2B6

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 8

3 in = 9

HS = 2.954

VS = 1.381

GS = 2.979

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.722	.625	.495
MINIMUM X	-1.233	-1.041	-.801
MAXIMUM Y	.669	.655	.589
MINIMUM Y	-.712	-.726	-.792
CENTROID X	-.126	-.317	-.187
CENTROID Y	-.423	-.409	-.343
POA TO CENTROID in.	.441	.517	.390
MIN RADIUS	.400	.449	.334
MEAN RADIUS	.833	.734	.650
MAX RADIUS	1.726	1.167	.897
HORIZONTAL SPREAD	2.954	1.666	1.296
VERTICAL SPREAD	1.381	1.381	1.381
EXTREME SPREAD	2.979	1.867	1.717
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	9		