

C6636301

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.

REG. U.S. PAT. & TM. OFF.

MODEL 700™ H24

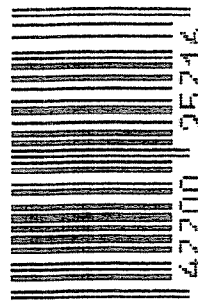
SERIAL NO. C6636301

ORDER NO. 5716

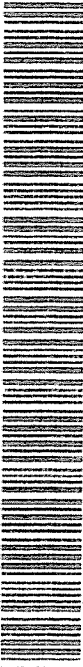
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

06

UPC



0 47700 25716 2



5716 C6636301

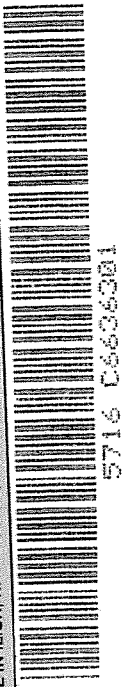
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MODEL 700™ H24

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

SERIAL NO. C6636301	ORDER NO. 5716
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5716 C6636301

UPC

0 47700 25716 2

REPAIRED
chip 9/12/91
15
in
stock

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6636301**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/25/91	K4
600	Proof		6/25/91	K4
607	Check Headspace		6/25/91	K4
610	Dis-assemble Gun		6/25/91	K4
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	LB
618	Polish Barrel		JUL 20 1991	WB
620	Apply Coatings (Barrel Action)		7-21-91	AS
	Apply Coating (Bolt)		7-21-91	AS
625	Final Assembly A) Clean inside of Bolt Assembly		8/20/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/20/91	KS
	C) Inspect Ejector Hole for Chamfer		8/20/91	KS
	D) Oil Firing Pin Ass'y		8/20/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		8/21/91	GS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/2	5 1/2	5			8-21-91	DH
	G) Safety Off Force	2 1/2	3	3			8-21-91	DH
	H) Trigger Pull Test & Retainability						8/21/91	JH
	I) Firing Pin Indent	.020	.021	.021			8-21-91	DH
	J) Assemble Stock						8/21/91	KL
	K) Assemble Swivel Studs						8-23-91	DH
	L) Attach Front and Rear Sight Assemblies						8/21/91	KL
	M) Iron Sight Alignment						8/21/91	KL
	N) Detach Front & Rear Sights & place in numbered container						8/21/91	KL
	O) Attach Scope to Rifle						8/21/91	KL
	P) Detach & Attach Scope 20 Times						8/21/91	KL
640	Gallery Target & Test						8-22-91	NF
	A) Time							NF
	B) Malfunctions							NF
	C) Pierced Primers							NF
	D) Optical Clarity of Scope							NF
645	Inspect for Live Ammo						8-22-91	NF
655	Final Inspection							
	A) Headspace						8-23-91	DH
	B) Trigger Pull	2.54	2.56	2.59	2.59	2.57	8/23/91	JH
	C) Function						8-23-91	DH
660	Pack						9-18-91	NF

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6636301
DATE 8/21/91
TESTER JEL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.20	2.36	2.58	2.54	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.36	2.24	2.45	2.56	
PULL #3	2.31	2.38	2.38	2.59	
PULL #4	2.30	2.34	2.43	2.54	
PULL #5	2.32	2.40	2.40	2.57	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.18	3.51		
PULL #2	3.38	3.50		
PULL #3	3.33	3.39		
PULL #4	3.22	3.57		
PULL #5	3.20	3.56		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.34	4.27		4.23
PULL #2	4.33	4.30		4.34
PULL #3	4.33	4.34		4.28
PULL #4	4.28	4.30		4.31
PULL #5	4.33	4.24		4.34
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636301
22 Aug 1991

CENTROIDAL DISTANCES

0 TO 1	.278342
1 TO 2	.182483
1 TO 3	.255973
1 TO 4	.288141
1 TO 5	.341541

81 (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1314
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1036
THE RESULTING AVERAGE POC RADIUS FOR THIS RIFLE IS: .167329
THE AMR FOR THIS RIFLE IS: .809

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CAB36301

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

CENTROID *

* OF SHOTS = 10

IN CIR

1 in = 4

2 in = 7

3 in = 8

HS = 1.059

VS = 3.687

GS = 3.088

PATTERN #

SHOTS (BEST OF)

MAXIMUM X

MINIMUM X

MAXIMUM Y

MINIMUM Y

CENTROID X

CENTROID Y

POA TO CENTROID in.

MIN RADIUS

MEAN RADIUS

MAX RADIUS

HORIZONTAL SPREAD

VERTICAL SPREAD

EXTREME SPREAD

NUMBER IN ONE INCH CIRCLE =

NUMBER IN TWO INCH CIRCLE =

NUMBER IN THREE INCH CIRCLE =

10

9

8

2.231

2.197

.937

-.828

-.862

-.587

1.232

.960

.987

-2.455

-.509

-.482

.275

.309

.034

-.043

.229

.202

.279

.385

.204

.269

.150

.142

.989

.790

.538

2.473

2.209

1.361

3.059

3.059

1.524

3.687

1.469

1.469

3.088

3.095

2.080

4

7

8

22 Aug 1991

FILE: /PATTERNING/CENTERFIRE_PATT/C8536301

CENTERFIRE PATTERNS

3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 2

2 in = 8

3 in = 10

HS= 1.291

VS= 2.210

GS= 2.520

CENTROID #

PATTERN #

SHOTS (BEST OF)

MAXIMUM X

MINIMUM X

MAXIMUM Y

MINIMUM Y

CENTROID X

CENTROID Y

POA TO CENTROID in.

MIN RADIUS

MEAN RADIUS

MAX RADIUS

HORIZONTAL SPREAD

VERTICAL SPREAD

EXTREME SPREAD

NUMBER IN ONE INCH CIRCLE =

NUMBER IN TWO INCH CIRCLE =

NUMBER IN THREE INCH CIRCLE =

10

9

8

.712

.785

.724

-.579

-.506

-.567

1.060

.932

.869

-1.150

-1.018

-.901

.114

.041

.102

.156

.284

.167

.193

.287

.196

.185

.229

.190

.742

.674

.613

1.323

1.051

.949

1.291

1.291

1.291

2.210

1.950

1.770

2.520

2.038

1.821

2

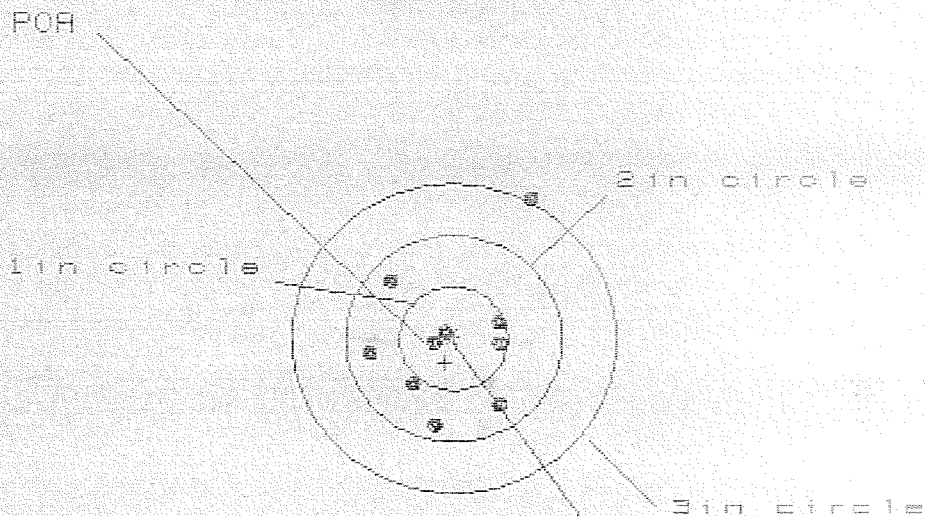
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10

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8696301

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 4

2in = 9

3in = 9

HS= 1.471

VS= 2.156

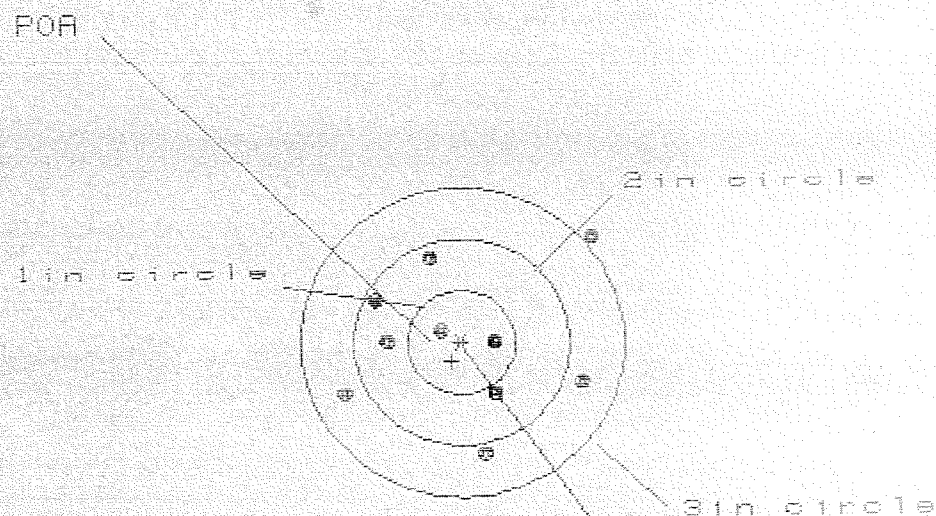
GS= 2.322

PATTERN #				
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.720	.551	.543
MINIMUM X	:	-.751	-.671	-.679
MAXIMUM Y	:	1.343	.897	.614
MINIMUM Y	:	-.813	-.663	-.547
CENTROID X	:	.078	-.002	.006
CENTROID Y	:	.236	.086	.169
POA TO CENTROID in.	:	.248	.086	.169
MIN RADIUS	:	.142	.108	.060
MEAN RADIUS	:	.651	.539	.509
MAX RADIUS	:	1.524	.860	.799
HORIZONTAL SPREAD	:	1.471	1.222	1.222
VERTICAL SPREAD	:	2.156	1.360	1.161
EXTREME SPREAD	:	2.322	1.563	1.563
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		9	

22 Aug 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.389

VS= 2.109

GS= 2.832

PATTERN #

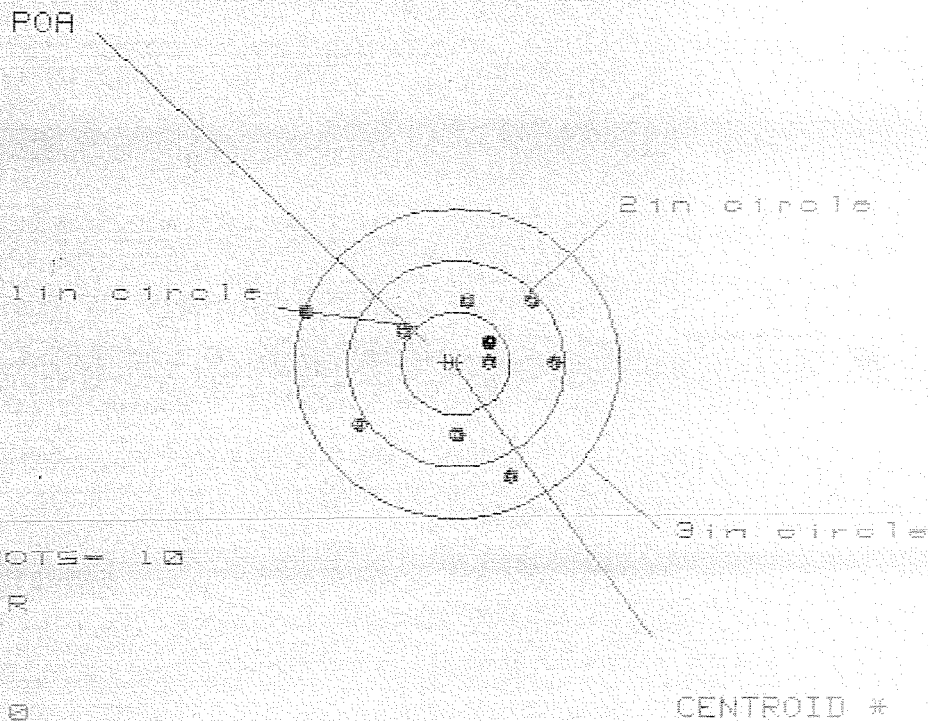
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SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.248	1.210	1.084
MINIMUM X	-1.141	-1.002	-0.759
MAXIMUM Y	1.015	.924	.875
MINIMUM Y	-1.094	-.981	-1.030
CENTROID X	.095	-.044	.082
CENTROID Y	.182	.069	.118
POA TO CENTROID in.	.205	.082	.143
MIN RADIUS	.226	.241	.257
MEAN RADIUS	.857	.768	.717
MAX RADIUS	1.609	1.241	1.132
HORIZONTAL SPREAD	2.389	2.212	1.843
VERTICAL SPREAD	2.109	1.905	1.905
EXTREME SPREAD	2.832	2.215	2.023
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

22 Aug 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 2.290

VS= 1.727

GS= 2.460

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.924	.773	.812
MINIMUM X	-1.365	-1.063	-1.023
MAXIMUM Y	.625	.684	.554
MINIMUM Y	-1.103	-1.043	-.723
CENTROID X	.095	.246	.207
CENTROID Y	-.013	-.072	.052
POA TO CENTROID in.	.095	.257	.215
MIN RADIUS	.280	.160	.168
MEAN RADIUS	.806	.707	.639
MAX RADIUS	1.467	1.167	1.192
HORIZONTAL SPREAD	2.290	1.836	1.836
VERTICAL SPREAD	1.727	1.727	1.277
EXTREME SPREAD	2.460	1.958	1.958
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	