

C6636303

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



MOD. _____ GA. CAL. _____ GUN # _____

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st	Shaver brass ejector stuck	
	<u>2nd</u> 8/16/91	WIRE BRUSHED SHROUD CHG'D EXTRACTOR REAMED ESC. HOLE POLISHED EJECTOR	23
	3rd 8/18/91	Re-reamed Re-cleaned NEW EJECTOR NEW EXTRACTOR	23
	4th		
		FUNCTION	RD 6554 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF	100 Rd. Test OK AC	
TEST		
TGT		
PROOF	8-9-91	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		




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

RES. U.S. PAT. & TM. OFF.

MODEL 700™ H24

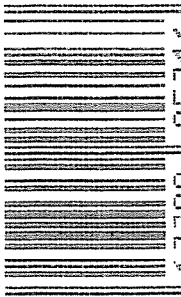
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada. Marque Deposee.

SERIAL NO.
C66036303

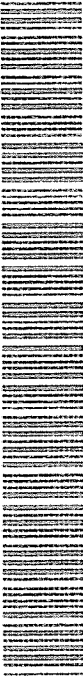
ORDER NO.
5716

20

UPC



0 47700 25716 2



5716 C66036303

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6636303**

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

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	6	5			8-2-91	SH
	G) Safety Off Force	3 1/2	3 1/2	3 1/2			8-2-91	SH
	H) Trigger Pull Test & Retainability						8-2-91	SH
	I) Firing Pin Indent	.0205	.0205	.0205			8-2-91	SH
	J) Assemble Stock						8-2-91	SH
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies						8/2/91	SH
	M) Iron Sight Alignment						8/2/91	SH
	N) Detach Front & Rear Sights & place in numbered container						8/2/91	SH
	O) Attach Scope to Rifle						8/2/91	SH
	P) Detach & Attach Scope 20 Times						8/2/91	SH
640	Gallery Target & Test						8-5-91	AC
	A) Time						8-5-91	AC
	B) Malfunctions						8-5-91	AC
	C) Pierced Primers						8-5-91	AC
	D) Optical Clarity of Scope						8-5-91	AC
645	Inspect for Live Ammo						8-5-91	AC
655	Final Inspection							
	A) Headspace						8-5-91	AC
	B) Trigger Pull	2.51	2.48	2.51	2.65	2.56	8-5-91	SH
	C) Function						8-6-91	AC
660	Pack						8-17-91	SH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6636303

DATE 8-2-91

TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.63	2.41	2.59	2.51	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.49	2.48	2.43	2.48	
PULL #3	2.43	2.49	2.38	2.51	
PULL #4	2.37	2.40	2.51	2.65	
PULL #5	2.45	2.48	2.50	2.56	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.32	3.61		
PULL #2	3.58	3.27		
PULL #3	3.33	3.56		
PULL #4	3.58	3.56		
PULL #5	3.59	3.64		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.38	4.55		4.28
PULL #2	4.39	4.22		4.27
PULL #3	4.38	4.25		4.47
PULL #4	4.27	4.42		4.27
PULL #5	4.27	4.29		4.46
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636303
5 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.633285
1 TO	2	.768118
1 TO	3	.986554
1 TO	4	.759287
1 TO	5	.524812

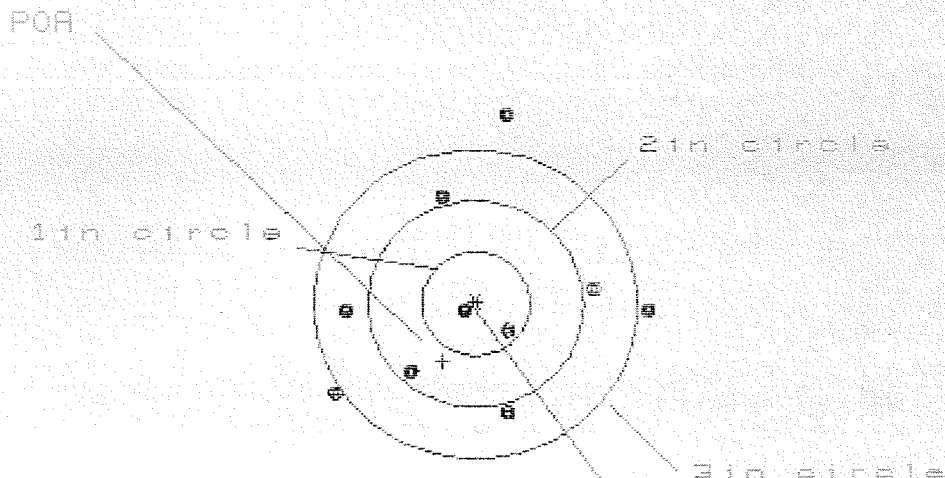
1
32 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .041
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0136
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0431963
THE AMF FOR THIS RIFLE IS: .8604

3 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636303

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 2

2in = 3

3in = 7

HS= 2.895

VS= 2.854

GS= 3.108

CENTROID *

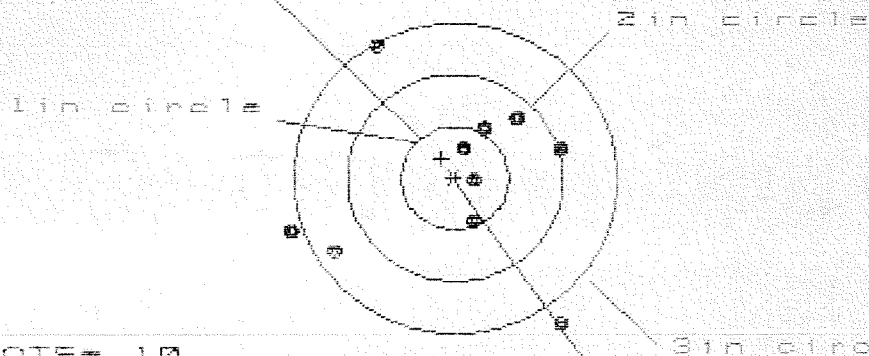
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.585	1.620	1.341
MINIMUM X	-1.310	-1.275	-1.072
MAXIMUM Y	1.813	1.239	1.259
MINIMUM Y	-1.041	-0.940	-0.820
CENTROID X	0.305	0.270	0.067
CENTROID Y	0.555	0.354	0.334
POR TO CENTROID in.	0.633	0.445	0.341
MIN RADIUS	0.155	0.205	0.207
MEAN RADIUS	1.101	0.995	0.907
MAX RADIUS	1.841	1.627	1.396
HORIZONTAL SPREAD	2.895	2.895	2.413
VERTICAL SPREAD	2.854	2.079	2.079
EXTREME SPREAD	3.108	3.000	2.613
NUMBER IN ONE INCH CIRCLE =	2	2	2
NUMBER IN TWO INCH CIRCLE =	3	3	3
NUMBER IN THREE INCH CIRCLE =	7	7	7

5 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6635303

CENTERFIRE PATTERNS # 2

POA



OF SHOTS = 10

IN CIR

1in = 3

2in = 5

3in = 8

HS= 2.566

VS= 2.700

GS= 3.159

CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.021	1.126	.947
MINIMUM X	:	-1.545	-1.440	-1.181
MAXIMUM Y	:	1.308	1.153	1.071
MINIMUM Y	:	-1.392	-.884	-.967
CENTROID X	:	.122	.017	.197
CENTROID Y	:	-.191	-.036	.047
POA TO CENTROID in.	:	.227	.040	.202
MIN RADIUS	:	.187	.243	.048
MEAN RADIUS	:	.953	.879	.715
MAX RADIUS	:	1.685	1.584	1.526
HORIZONTAL SPREAD	:	2.566	2.566	2.128
VERTICAL SPREAD	:	2.700	2.037	2.037
EXTREME SPREAD	:	3.159	2.701	2.379
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

5 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06536303

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 4

2in = 9

3in = 9

HS= 1.197

VS= 2.259

GS= 2.378

CENTROID *

PATTERN #

3

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.584

.515

.523

MINIMUM X

-.613

-.615

-.607

MAXIMUM Y

.707

.534

.476

MINIMUM Y

-1.552

-.558

-.491

CENTROID X

-.135

-.066

-.074

CENTROID Y

-.328

-.155

-.222

POA TO CENTROID in.

.354

.169

.234

MIN RADIUS

.206

.021

.088

MEAN RADIUS

.616

.434

.436

MAX RADIUS

1.669

.769

.724

HORIZONTAL SPREAD

1.197

1.130

1.130

VERTICAL SPREAD

2.259

1.092

.967

EXTREME SPREAD

2.378

1.204

1.199

NUMBER IN ONE INCH CIRCLE =

4

NUMBER IN TWO INCH CIRCLE =

9

NUMBER IN THREE INCH CIRCLE =

9

5 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6638383

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 2

2in = 7

3in = 8

HS = 2.360

VS = 2.579

GS = 3.161

CENTROID #

PATTERN #

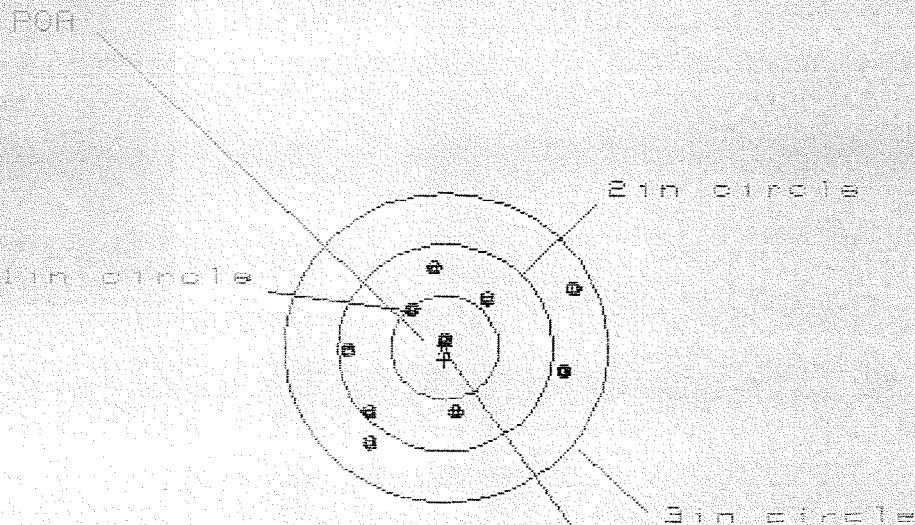
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SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.504	1.463	.551
MINIMUM X	-.826	-.897	-.714
MAXIMUM Y	1.004	.829	.898
MINIMUM Y	-1.575	-.990	-.921
CENTROID X	-.094	-.023	-.206
CENTROID Y	-.091	.084	.015
POA TO CENTROID in.	.131	.087	.207
MIN RADIUS	.148	.334	.267
MEAN RADIUS	.828	.729	.612
MAX RADIUS	1.699	1.562	.966
HORIZONTAL SPREAD	2.360	2.360	1.265
VERTICAL SPREAD	2.579	1.819	1.819
EXTREME SPREAD	3.161	2.606	1.985
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	

5 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8B353B3

CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1in = 2

2in = 7

3in = 10

HS = 2.070

VS = 1.727

GS = 2.413

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.162	1.176	1.181
MINIMUM X	-.908	-.779	-.854
MAXIMUM Y	.818	.884	.779
MINIMUM Y	-.909	-.843	-.684
CENTROID X	.007	-.122	-.047
CENTROID Y	.123	.057	.162
POA TO CENTROID in.	.123	.134	.169
MIN RADIUS	.008	.204	.077
MEAN RADIUS	.804	.748	.688
MAX RADIUS	1.306	1.185	1.131
HORIZONTAL SPREAD	2.070	1.955	1.955
VERTICAL SPREAD	1.727	1.727	1.463
EXTREME SPREAD	2.413	1.969	1.969
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	