

C6636314

MODEL 760™ M24

Model **SWS**™

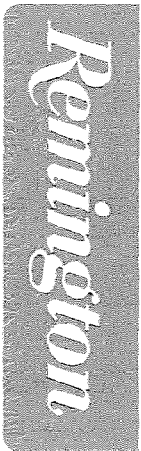
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.





MODEL 700™ H24



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

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

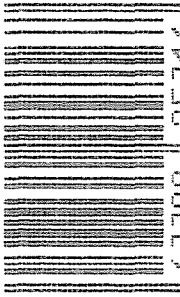
SERIAL NO.
C66C6314

ORDER NO.
5716

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

20

UPC



0 47700 25716 7



5716 C66C6314

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6636314**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/27/91	YH
600	Proof		6/27/91	YH
607	Check Headspace		6/27/91	YH
610	Dis-assemble Gun		6/27/91	YH
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	EB
618	Polish Barrel		JUL 17 1991	WB
620	Apply Coatings (Barrel Action)		8-15-91	YH
	Apply Coating (Bolt)		8-15-91	YH
625	Final Assembly A) Clean inside of Bolt Assembly		8/17/91	YH
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/17/91	YH
	C) Inspect Ejector Hole for Chamfer		8/17/91	YH
	D) Oil Firing Pin Ass'y		8/17/91	YH
	E) Adjust Trigger Pull to Min Setting and Stake		8-19-91	YH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6		6		6	8-19-91	SH
	G) Safety On Force	2		2		2	8-19-91	SH
	H) Trigger Pull Test & Retainability						8-19-91	SH
	I) Firing Pin Indent	.0215		.0225		.0225	8-19-91	SH
	J) Assemble Stock						8/19/91	SH
	K) Assemble Swivel Studs						8/22/91	SH
	L) Attach Front and Rear Sight Assemblies						8/19/91	SH
	M) Iron Sight Alignment						8/19/91	SH
	N) Detach Front & Rear Sights & place in numbered container						8/19/91	SH
	O) Attach Scope to Rifle						8/19/91	SH
	P) Detach & Attach Scope 20 Times						8/19/91	SH
640	Gallery Target & Test						8-20-91	NE
	A) Time						"	NE
	B) Malfunctions						"	NE
	C) Pierced Primers						"	NE
	D) Optical Clarity of Scope						"	NE
645	Inspect for Live Ammo						8-20-91	NE
655	Final Inspection A) Headspace						8/22/91	SH
	B) Trigger Pull	224	260	242	252	239	8-21-91	D/H
	C) Function						8/22/91	SH
660	Pack						9-19-91	NE

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636314
23 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.18071
1 TO	2	.17066
1 TO	3	.182477
1 TO	4	.36662
1 TO	5	.355179

24
25

<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0326
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0144
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0356387
THE AMR FOR THIS RIFLE IS: .9072

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636314

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 0

2 in = 4

3 in = 7

HS= 2.442

VS= 3.067

CS= 3.074

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 =

27

10

9

8

1.513

1.509

1.258

-.929

-.933

-.744

1.572

1.489

1.549

-1.495

-1.320

-1.250

-.180

-.176

-.365

.016

-.159

-.219

.181

.237

.425

.635

.650

.487

1.182

1.127

1.020

1.373

1.583

1.549

2.442

2.442

2.002

3.067

2.909

2.809

3.074

2.835

2.835

0

4

7

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636314

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS= 2.555

VS= 1.821

ES= 2.835

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.277	1.135	.895
MINIMUM X	-1.278	-1.041	-.899
MAXIMUM Y	.953	.857	.755
MINIMUM Y	-.868	-.812	-.675
CENTROID X	-.053	.089	-.053
CENTROID Y	-.098	-.002	.100
POA TO CENTROID in.	.112	.089	.113
MIN RADIUS	.425	.412	.387
MEAN RADIUS	.942	.866	.784
MAX RADIUS	1.545	1.395	1.171
HORIZONTAL SPREAD	2.555	2.176	1.794
VERTICAL SPREAD	1.821	1.669	1.431
EXTREME SPREAD	2.835	2.298	2.294
NUMBER IN ONE INCH CIRCLE	= 2		
NUMBER IN TWO INCH CIRCLE	= 6		
NUMBER IN THREE INCH CIRCLE	= 9		

25 Aug 1991

FILE://PATTERNING-CENTERFIRE_PATT/C863B314

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 4

2in = 3

3in = 10

HS= 2.434

VS= 1.346

GS= 2.538

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.222	.478	.344
MINIMUM X	:	-1.212	-1.677	-1.578
MAXIMUM Y	:	.697	.525	.512
MINIMUM Y	:	-.739	-.772	-.785
CENTROID X	:	-.087	-.222	-.098
CENTROID Y	:	.173	.255	.268
POA TO CENTROID in.	:	.193	.338	.282
MIN RADIUS	:	.060	.112	.049
MEAN RADIUS	:	.535	.541	.439
MAX RADIUS	:	1.428	1.082	.805
HORIZONTAL SPREAD	:	2.434	1.555	.922
VERTICAL SPREAD	:	1.346	1.297	1.297
EXTREME SPREAD	:	2.538	1.618	1.385
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636314

CENTERFIRE PATTERNS # 4

POB

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS= 2.218

VS= 2.932

GS= 3.489

CENTROID *

PATTERN #

4

SHOTS (BEST OF)

10

9

6

MAXIMUM X

.950

1.012

.866

MINIMUM X

-1.268

-1.162

-1.091

MAXIMUM Y

2.052

.752

.731

MINIMUM Y

-.880

-.652

-.673

CENTROID X

.111

.005

.151

CENTROID Y

.239

.011

.032

POB TO CENTROID in.

.263

.012

.154

MIN RADIUS

.291

.192

.243

MEAN RADIUS

.981

.813

.748

MAX RADIUS

2.261

1.189

1.189

HORIZONTAL SPREAD

2.218

2.174

1.958

VERTICAL SPREAD

2.932

1.404

1.404

EXTREME SPREAD

3.489

2.221

2.177

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

5

NUMBER IN THREE INCH CIRCLE =

9

28 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C0636314

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 1.405

VS= 2.850

GS= 3.062

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.714	.594	.590
MINIMUM X	:	-.691	-.611	-.615
MAXIMUM Y	:	1.427	1.257	.918
MINIMUM Y	:	-1.528	-.709	-.851
CENTROID X	:	.046	-.034	-.030
CENTROID Y	:	-.258	-.038	-.246
POA TO CENTROID in.	:	.262	.095	.247
MIN RADIUS	:	.130	.148	.170
MEAN RADIUS	:	.796	.703	.603
MAX RADIUS	:	1.683	1.258	1.034
HORIZONTAL SPREAD	:	1.405	1.205	1.205
VERTICAL SPREAD	:	2.958	1.966	1.469
EXTREME SPREAD	:	3.062	2.016	1.729
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6636314
DATE 8-19-91
TESTER RL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.22	2.24	2.35	224	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.19	2.30	2.38	260	
PULL #3	2.22	2.31	2.44	242	
PULL #4	2.24	2.30	2.36	252	
PULL #5	2.18	2.17	2.30	239	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.40	3.53		
PULL #2	3.32	3.55		
PULL #3	3.42	3.40		
PULL #4	3.53	3.52		
PULL #5	3.46	3.46		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.44	4.53		4.55
PULL #2	4.46	4.50		4.30
PULL #3	4.40	4.53		4.63
PULL #4	4.48	4.18		4.19
PULL #5	4.45	4.49		4.62
TOTAL				
AVG.				