

C6636321

MODEL 706™ M24

Model SWS™

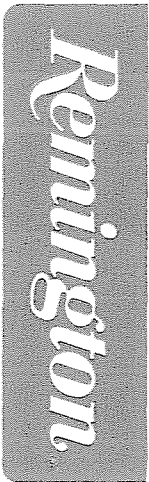
Action _____

Barrel Length _____

Capacity _____

Order No. 5715

* Includes 1 in chamber.






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

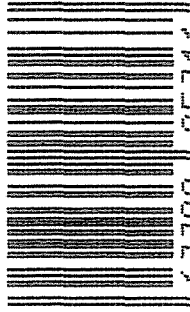
MODEL 700TM H24

SERIAL NO.
C6636321

ORDER NO.
5716

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

UPC



0 47700 25746 7



5716 C6636321

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF	Test OK AC Aug 15, 1991	
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

MOD. _____ GA. CAL. _____ GUN # 6321

#	TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
		1st		
NF		8/14	Shaves Brass + Ejector Stuck	KS
		2nd		
		8/14	REAMED EJECTOR POLISHED FACE OF BOLT	KS
		3rd		
		4th		
			FUNCTION	RD 6654 Rev 1

GUN SERIAL #

C 6636321

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/25/91	KL
600	Proof		6/25/91	KL
607	Check Headspace		6/25/91	KL
610	Dis-assemble Gun		6/25/91	KL
612	Magnaflux Barrel Action	JUL 1 1991	1 1991	KR
	Magnaflux Bolt	JUL 1 1991	1 1991	KR
615	Rollmark Caliber	JUL 1 1991	1 1991	LS.
617	Drill and Tap Sight Holes	JUL 1 1991	1 1991	LB
618	Polish Barrel	JUL 2 1991	2 1991	WB
620	Apply Coatings (Barrel Action)		7-23-91	DA
	Apply Coating (Bolt)			
625	Final Assembly		8/5/91	KA
	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	DA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			8-6-91	DH
	G) Safety Off Force	3	2 1/2	2 1/2			8-6-91	DH
	H) Trigger Pull Test & Retainability						8-6-91	JH
	I) Firing Pin Indent	.021	.020	.020			8-6-91	DH
	J) Assemble Stock						8/9/91	KH
	K) Assemble Swivel Studs						8-17-91	DH
	L) Attach Front and Rear Sight Assemblies						8/9/91	KH
	M) Iron Sight Alignment						8/9/91	KH
	N) Detach Front & Rear Sights & place in numbered container						8/9/91	KH
	O) Attach Scope to Rifle						8/9/91	KH
	P) Detach & Attach Scope 20 Times						8/9/91	KH
640	Gallery Target & Test						8-14-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						8-14-91	NF
655	Final Inspection						8-17-91	DH
	A) Headspace						8-17-91	DH
	B) Trigger Pull	2.57	2.46	2.55	2.61	2.51	8-17-91	JH
	C) Function						8-17-91	DH
660	Pack						9-19-91	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6636321

DATE 8-6-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.48	2.39	2.40	2.57	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.40	2.34	2.44	2.45	
PULL #3	2.40	2.53	2.52	2.55	
PULL #4	2.46	2.33	2.50	2.61	
PULL #5	2.47	2.44	2.53	2.59	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.30	3.60		
PULL #2	3.18	3.51		
PULL #3	3.27	3.51		
PULL #4	3.37	3.32		
PULL #5	3.26	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	4.51	4.53		4.45
PULL #2	4.49	4.48		4.60
PULL #3	4.47	4.46		4.60
PULL #4	4.49	4.35		4.59
PULL #5	4.43	4.26		4.56
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636921
20 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.0496488
1 TO	2	.13306
1 TO	3	.0126491
1 TO	4	.0993177
1 TO	5	.0240832

←----POR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0706
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.023
THE RESULTING AVERAGE FOOT RADIUS FOR THIS RIFLE IS: .074252
THE SMP FOR THIS RIFLE IS: .9104

13 Aug 1931

FILE:/PATTERNING/CENTERFIRE_PATT/C6636321

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

* OF SHOTS- 10

IN CIR

1in - 1

2in - 6

3in = 10

MS- 1.855

VS= 2.582

GS= 2.649.

CENTROID *

PATTERN #

10

SHOT (BEST OF)

10

9

8

MAXIMUM X : .965

.965

.879

MINIMUM X : -.890

-.890

-.976

MAXIMUM Y : 1.099

.934

.774

MINIMUM Y : -1.483

-1.278

-1.135

CENTROID X : -.049

-.049

-.037

CENTROID Y : .008

.173

.333

POA TO CENTROID in. : .050

.180

.335

MIN RADIUS : .291

.322

.363

MEAN RADIUS : .958

.878

.781

MAX RADIUS : 1.483

1.451

1.173

HORIZONTAL SPREAD : 1.855

1.855

1.855

VERTICAL SPREAD : 2.582

2.212

1.909

EXTREME SPREAD : 2.649

2.285

1.948

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

6

NUMBER IN THREE INCH CIRCLE =

10

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636321

CENTERFIRE PATTERNS

2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 2.099

VS= 2.718

GS= 2.920

CENTROID #

PATTERN #

21

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.971

.960

.706

MINIMUM X

-1.129

-1.139

-1.019

MAXIMUM Y

1.725

.801

.701

MINIMUM Y

-.994

-.802

-.673

CENTROID X

-.053

-.042

-.162

CENTROID Y

-.125

-.316

-.216

POA TO CENTROID in.

.135

.319

.270

MIN RADIUS

.333

.249

.245

MEAN RADIUS

.810

.679

.603

MAX RADIUS

1.727

1.393

1.237

HORIZONTAL SPREAD

2.099

2.099

1.725

VERTICAL SPREAD

2.718

1.603

1.374

EXTREME SPREAD

2.920

2.641

1.921

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

7

NUMBER IN THREE INCH CIRCLE =

9

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636321

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in - 4

2in - 5

3in = 10

HS= 2.409

VS= 1.900

GS= 2.411

PATTERN #

3

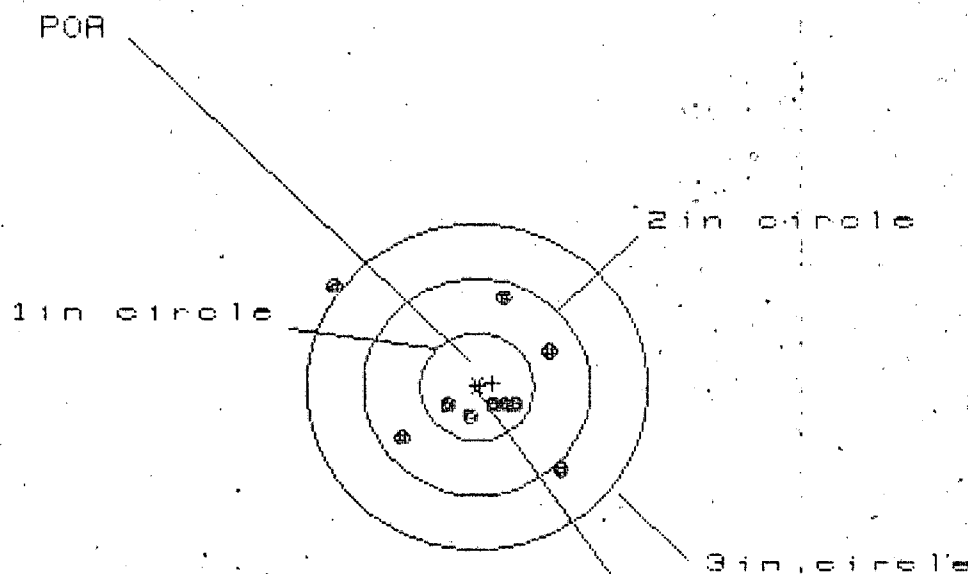
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.233	.629	.499
MINIMUM X	:	-1.176	-1.039	-.910
MAXIMUM Y	:	.990	.989	.977
MINIMUM Y	:	-.910	-.911	-.923
CENTROID X	:	-.061	-.198	-.068
CENTROID Y	:	.004	.004	.016
POA TO CENTROID in.	:	.061	.198	.069
MIN RADIUS	:	.268	.341	.259
MEAN RADIUS	:	.810	.773	.710
MAX RADIUS	:	1.233	1.145	1.081
HORIZONTAL SPREAD	:	2.409	1.668	1.409
VERTICAL SPREAD	:	1.900	1.900	1.900
EXTREME SPREAD	:	2.411	2.118	2.118
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636321

CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1in = 5

2in = 8

3in = 9

HS= 2.027

VS= 1.671

GS= 2.627

CENTROID #

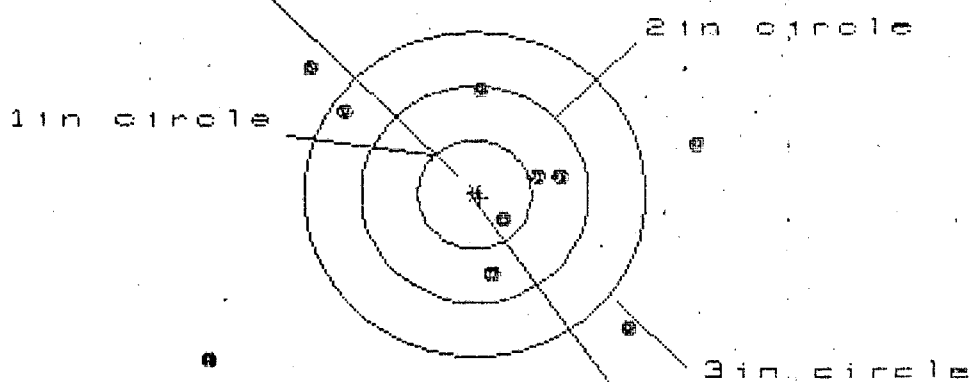
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.755	.613	.565
MINIMUM X	-1.272	-.794	-.717
MAXIMUM Y	.943	.945	.867
MINIMUM Y	-.728	-.623	-.437
CENTROID X	-.139	.003	-.074
CENTROID Y	-.034	-.139	-.061
POA TO CENTROID in.	.143	.139	.096
MIN RADIUS	.224	.083	.170
MEAN RADIUS	.646	.492	.463
MAX RADIUS	1.584	.948	.881
HORIZONTAL SPREAD	2.027	1.407	1.282
VERTICAL SPREAD	1.671	1.568	1.304
EXTREME SPREAD	2.627	1.656	1.569
NUMBER IN ONE INCH CIRCLE =	5		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	9		

23 Aug 1981

FILE:/PATTERNING/CENTERFIRE_PATT/C6636321

CENTERFIRE PATTERNS # 5

POA



OF SHOTS- 10

IN CIR

1in - 1

2in - 5

3in - 6

HS- 4.261

VS- 2.724

GS- 4.738

CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.904	1.642	1.293
MINIMUM X	-2.357	-1.756	-1.551
MAXIMUM Y	1.162	.989	1.031
MINIMUM Y	-1.562	-1.378	-1.336
CENTROID X	-.051	.211	.006
CENTROID Y	.032	.205	.163
POA TO CENTROID in.	.060	.294	.163
MIN RADIUS	.362	.286	.436
MEAN RADIUS	1.328	1.099	1.050
MAX RADIUS	2.828	2.015	1.862
HORIZONTAL SPREAD	4.261	3.398	2.844
VERTICAL SPREAD	2.724	2.367	2.367
EXTREME SPREAD	4.738	3.700	3.700
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	6		