

C6636324

MODEL 700™ M24

Model SWS™

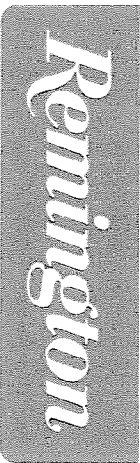
Action _____

Barrel Length _____

Capacity _____

Order No. 5715

*Includes 1 in chamber.



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




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

MODEL 700™ H24

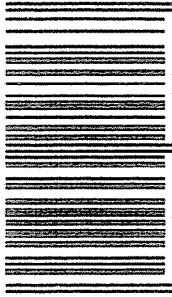
SERIAL NO.
C6636324

ORDER NO.
5716

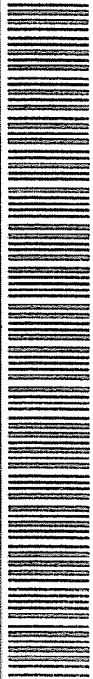
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

UPC



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5716 C6636324

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636324

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 25	9 1	RW
600	Proof	6 25	9 1	RW
607	Check Headspace	6 25	9 1	RW
610	Dis-assemble Gun	6 25	9 1	RW
612	Magnaflux Barrel Action	JUL	1 1991	KR
	Magnaflux Bolt	JUL	1 1991	KR
615	Rollmark Caliber	JUL	1 1991	JS
617	Drill and Tap Sight Holes	JUL	1 1991	FB
618	Polish Barrel	JUL	2 1991	WB
620	Apply Coatings (Barrel Action)		8/28/91	WB
	Apply Coating (Bolt)			WB
625	Final Assembly A) Clean inside of Bolt Assembly		8/28/91	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/28/91	WB
	C) Inspect Ejector Hole for Chamfer		8/28/91	WB
	D) Oil Firing Pin Ass'y		8/28/91	WB
	E) Adjust Trigger Pull to Min Setting and Stake		8/28/91	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5	5	5	8/26/91	DH
	G) Safety Off Force	3	3	3	3	3	8/26/91	DH
	H) Trigger Pull Test & Retainability						8/26/91	gV
	I) Firing Pin Indent	.022	.024	.024	.024	.024	8/26/91	DH
	J) Assemble Stock							
	K) Assemble Swivel Studs						8-28-91	DH
	L) Attach Front and Rear Sight Assemblies						9/2/91	DR
	M) Iron Sight Alignment						9/2/91	DR
	N) Detach Front & Rear Sights & place in numbered container						9/2/91	DR
	O) Attach Scope to Rifle						9/2/91	DR
	P) Detach & Attach Scope 20 Times						9/2/91	DR
640	Gallery Target & Test							DH
	A) Time							DH
	B) Malfunctions						9-1-91	DH
	C) Pierced Primers							DH
	D) Optical Clarity of Scope							DH
645	Inspect for Live Ammo							DH
655	Final Inspection						8-28-91	DH
	A) Headspace							
	B) Trigger Pull	2.46	2.46	2.52	2.53	2.54	8-27-91	DH
	C) Function						8-28-91	DH
660	Pack						7-17-91	DH

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6636324DATE 8/26-91TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.41	2.40	2.46	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.47	2.39	2.44	2.46	
PULL #3	2.40	2.38	2.36	2.52	
PULL #4	2.41	2.42	2.40	2.53	
PULL #5	2.41	2.44	2.43	2.54	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.56	3.59		
PULL #2	3.61	3.60		
PULL #3	3.65	3.55		
PULL #4	3.63	3.65		
PULL #5	3.55	3.58		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.25	4.18		4.23
PULL #2	4.27	4.24		4.43
PULL #3	4.28	4.58		4.52
PULL #4	4.22	4.56		4.21
PULL #5	4.18	4.29		4.40
TOTAL				
AVG.				

TABLE CALCULATIONS

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IDEAL DISTANCES

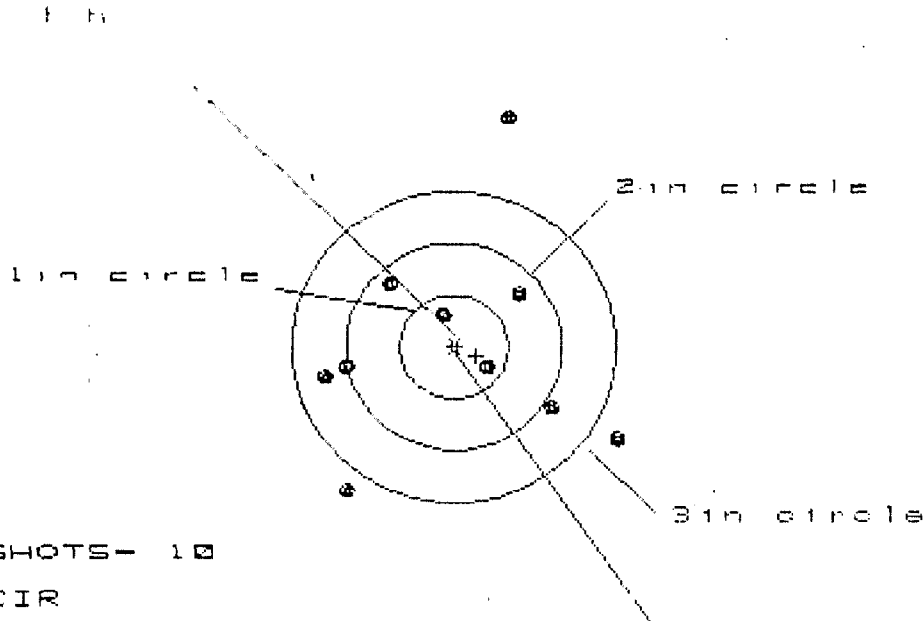
0 TO	1	.222847
1 TO	2	.259586
1 TO	3	.167287
1 TO	4	.220592
1 TO	5	.201693

3 (----POA.

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.09
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0208
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0923723
 THE AVE FOR THIS RIFLE IS: .9906

FILE: PATTERNING-CENTERFIRE_PATT/C6636524

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 7

HS= 2.745

VS= 3.554

CS= 3.854

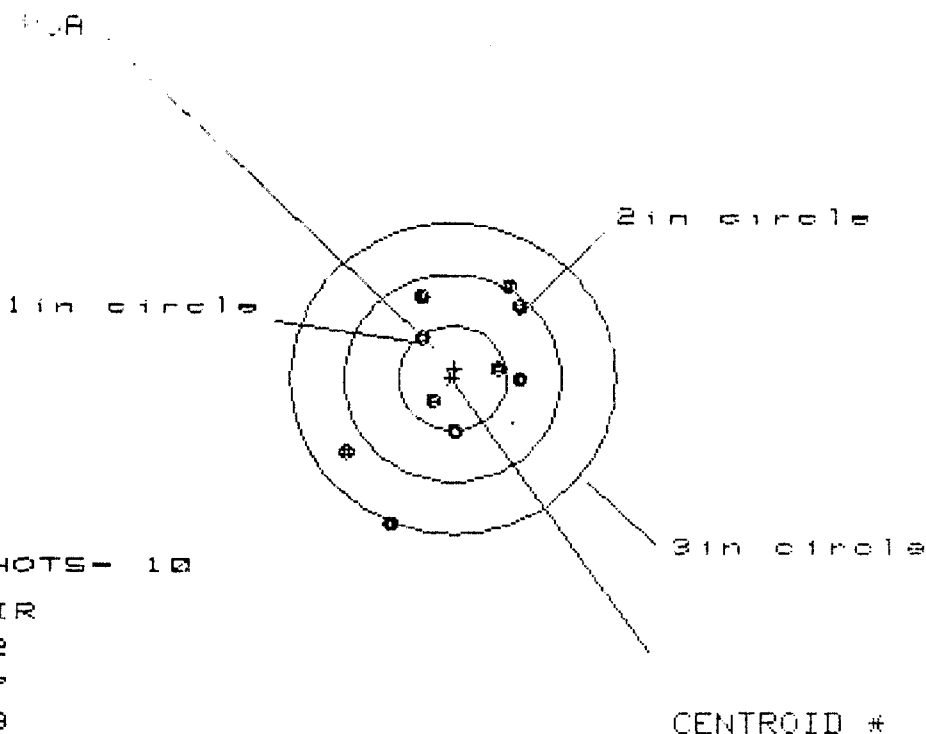
CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.504	1.562	1.110
MINIMUM X	-1.241	-1.183	-.988
MAXIMUM Y	2.168	.871	.788
MINIMUM Y	-1.386	-1.145	-1.228
CENTROID X	-.206	-.264	-.459
CENTROID Y	.085	-.156	-.073
POH TO CENTROID in.	.223	.306	.465
MIN RADIUS	.349	.397	.526
MEAN RADIUS	1.139	1.026	.926
MAX RADIUS	2.229	1.696	1.423
HORIZONTAL SPREAD	2.745	2.745	2.098
VERTICAL SPREAD	3.554	2.016	2.016
EXTREME SPREAD	3.854	2.815	2.452
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

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FILE: PATTERNING/CENTERFIRE_PATT/C6636324

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS = 1.604

VS = 2.368

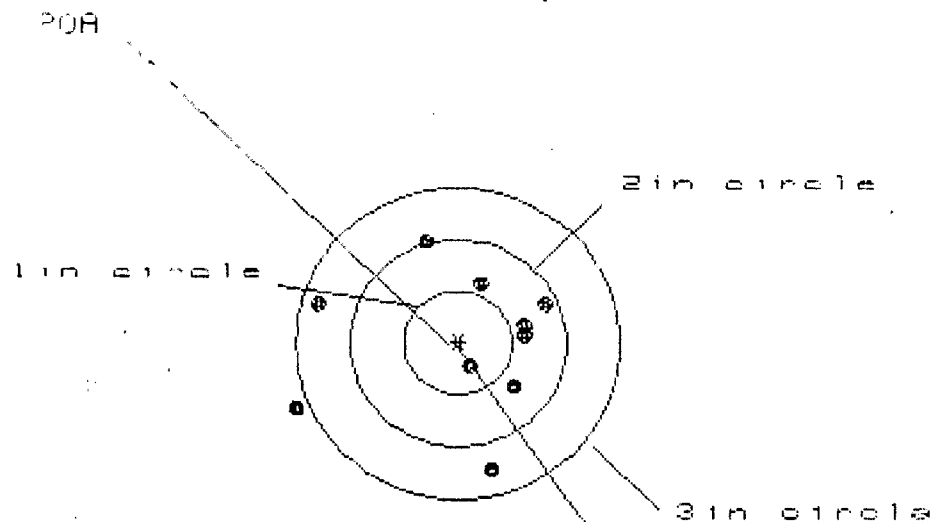
GS = 2.611

PATTERN #	:	12		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.655	.587	.460
MINIMUM X	:	-.949	-1.017	-.520
MAXIMUM Y	:	.916	.754	.652
MINIMUM Y	:	-1.452	-.822	-.784
CENTROID X	:	-.018	.050	.177
CENTROID Y	:	-.094	.068	.170
POA TO CENTROID in.	:	.095	.084	.246
MIN RADIUS	:	.281	.407	.340
MEAN RADIUS	:	.800	.700	.610
MAX RADIUS	:	1.575	1.307	.796
HORIZONTAL SPREAD	:	1.604	1.604	.980
VERTICAL SPREAD	:	2.368	1.576	1.436
EXTREME SPREAD	:	2.611	2.136	1.501
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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FILE: PATTERNING/CENTERFIRE_PATT/C6636324

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HST 2.287

VST 2.117

GST 2.490

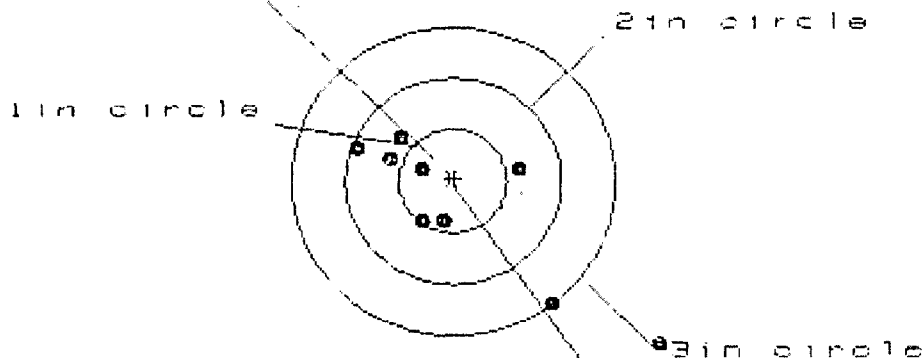
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.784	.617	.434
MINIMUM X	-1.503	-1.467	-.638
MAXIMUM Y	.943	.872	.914
MINIMUM Y	-1.174	-1.245	-1.203
CENTROID X	-.110	.057	.240
CENTROID Y	.222	.293	.251
POA TO CENTROID in.	.248	.298	.347
MIN RADIUS	.243	.317	.225
MEAN RADIUS	.881	.748	.605
MAX RADIUS	1.634	1.505	1.204
HORIZONTAL SPREAD	2.287	2.084	1.072
VERTICAL SPREAD	2.117	2.117	2.117
EXTREME SPREAD	2.490	2.241	2.193
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

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FILE: PATTERNING/CENTERFIRE_PATT/06836324

CENTERFIRE PATTERNS # 4

POH



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 7

HS= 2.929

VS= 3.829

GS= 4.821

CENTROID *

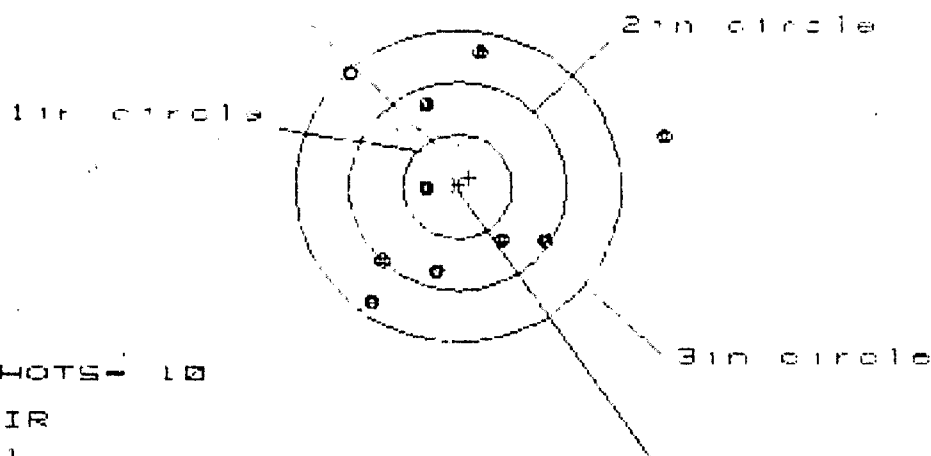
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.949	1.151	1.055
MINIMUM X	-.980	-.763	-.815
MAXIMUM Y	2.280	2.108	.522
MINIMUM Y	-1.549	-1.387	-1.123
CENTROID X	-.012	-.229	-.133
CENTROID Y	-.020	.152	-.112
POA TO CENTROID in.	.024	.275	.174
MIN RADIUS	.266	.074	.231
MEAN RADIUS	1.048	.836	.656
MAX RADIUS	2.490	2.242	1.541
HORIZONTAL SPREAD	2.929	1.914	1.870
VERTICAL SPREAD	3.829	3.495	1.645
EXTREME SPREAD	4.821	3.985	2.411
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		7	

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FILE: PATTERNING/CENTERFIRE_PATT-C6836324

CENTERFIRE PATTERNS # 5

FOR



OF SHOTS- 10

IN CIR

1st = 1

2nd = 6

3rd = 3

HSE 2.914

VSE 2.358

GSE 3.206

CENTROID #

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.921	1.031	.933
MINIMUM X	:	-.999	-.780	-.717
MAXIMUM Y	:	1.240	1.299	1.448
MINIMUM Y	:	-1.118	-1.059	-.910
CENTROID X	:	-.104	-.317	-.220
CENTROID Y	:	-.089	-.148	-.297
POA TO CENTROID in.	:	.137	.350	.370
MIN RADIUS	:	.330	.141	.313
MEAN RADIUS	:	1.005	.948	.874
MAX RADIUS	:	1.991	1.428	1.485
HORIZONTAL SPREAD	:	2.914	1.811	1.650
VERTICAL SPREAD	:	2.358	2.358	2.358
EXTREME SPREAD	:	3.206	2.580	2.580
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	8		