

C6636348

MODEL 700™ M24

Model SWS™

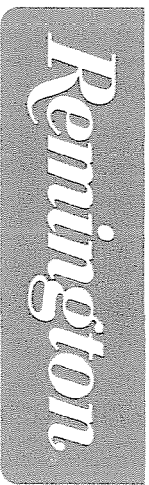
Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.






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

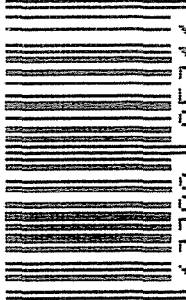
MODEL 700™ H24

SERIAL NO.
C6636348

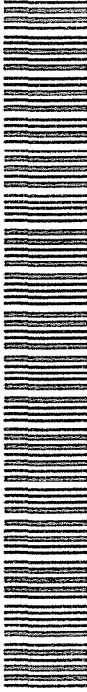
ORDER NO.
5716

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

UPC



0 47700 25716 7



5716 C6636348

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636348

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 27 9 1		RW
600	Proof	6 27 9 1		RW
607	Check Headspace	6 27 9 1		RW
610	Dis-assemble Gun	6 27 9 1		RW
612	Magnaflux Barrel Action		1 JUL 2 1991	HR
	Magnaflux Bolt		1 JUL 2 1991	HR
615	Rollmark Caliber		1 JUL 2 1991	LS
617	Drill and Tap Sight Holes		1 JUL 2 1991	LB
618	Polish Barrel		JUL 1 7 1991	WB
620	Apply Coatings (Barrel Action)		7-22-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/23/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/23/91	RW
	C) Inspect Ejector Hole for Chamfer		7/23/91	RW
	D) Oil Firing Pin Ass'y		7/23/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8-7-91	JM

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8-7-91	AC
	G) Safety Off Force	3	3	4			8-7-91	AC
	H) Trigger Pull Test & Retainability						8-7-91	JH
	I) Firing Pin Indent	.021	.021	.021			8-7-91	AC
	J) Assemble Stock						8/7/91	RW
	K) Assemble Swivel Studs						8-12-91	DH
	L) Attach Front and Rear Sight Assemblies						8/7/91	RW
	M) Iron Sight Alignment						8/7/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/7/91	RW
	O) Attach Scope to Rifle						8/7/91	RW
	P) Detach & Attach Scope 20 Times						8/7/91	RW
640	Gallery Target & Test						8-8-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						8-8-91	AF
655	Final Inspection							
	A) Headspace						8-12-91	DH
	B) Trigger Pull	2.66	2.29	2.36	2.36	2.37	8-9-91	JH
	C) Function						8-12-91	DH
660	Pack						9-19-91	AF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO C-6636348

DATE 8-7-91

TESTER JLP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.37	2.14	2.40	2.66	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.34	2.44	2.45	2.29	
PULL #3	2.35	2.46	2.38	2.36	
PULL #4	2.38	2.34	2.44	2.36	
PULL #5	2.39	2.44	2.38	2.37	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.43	3.47		
PULL #2	3.43	3.43		
PULL #3	3.52	3.48		
PULL #4	3.50	3.37		
PULL #5	3.50	3.45		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.33	4.26		4.36
PULL #2	4.45	4.25		4.40
PULL #3	4.66	4.28		4.37
PULL #4	4.56	4.18		4.38
PULL #5	4.65	4.36		4.28
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636348
8 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.257932
1 TO	2	.426747
1 TO	3	.358537
1 TO	4	.358622
1 TO	5	.558158

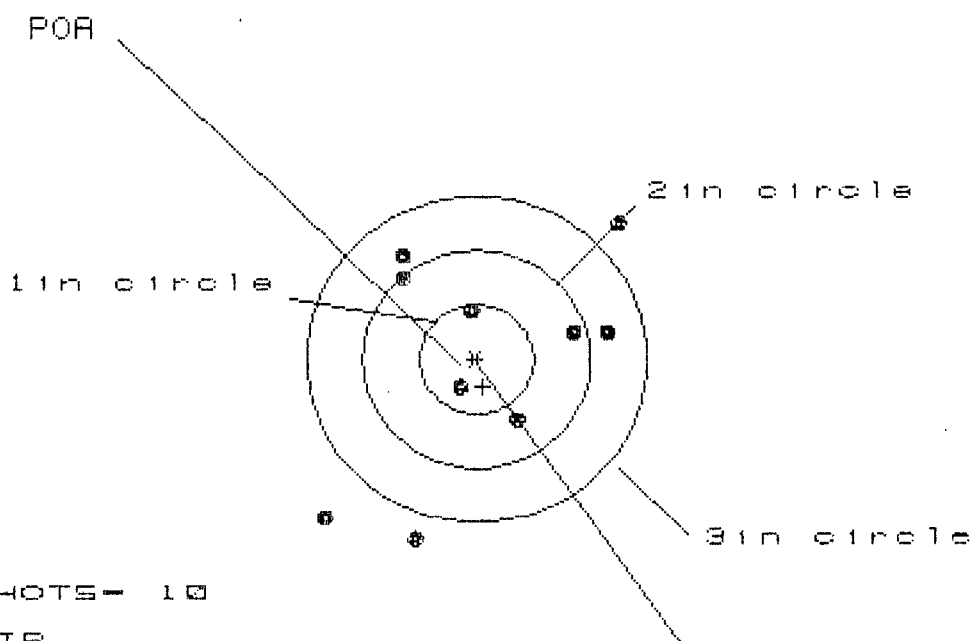
$\frac{L^4}{12}$ < ---- FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2284
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1386
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .067164
THE AMR FOR THIS RIFLE IS: 1.025

8 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6536348

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 7

HS= 2.642

VS= 2.880

GS= 3.758

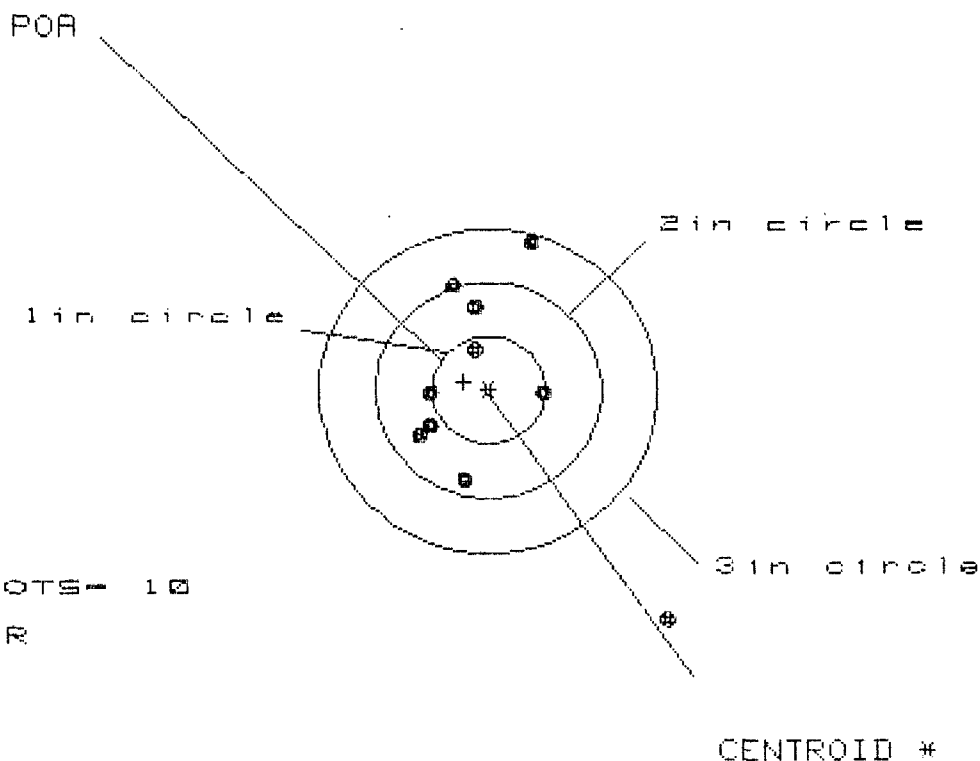
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.261	1.108	1.135
MINIMUM X	:	-1.381	-.845	-.707
MAXIMUM Y	:	1.267	1.110	.947
MINIMUM Y	:	-1.613	-1.770	-1.631
CENTROID X	:	-.055	.098	-.040
CENTROID Y	:	.252	.409	.270
POA TO CENTROID in.	:	.258	.420	.273
MIN RADIUS	:	.345	.390	.368
MEAN RADIUS	:	1.112	1.000	.919
MAX RADIUS	:	1.971	1.903	1.725
HORIZONTAL SPREAD	:	2.642	1.953	1.842
VERTICAL SPREAD	:	2.880	2.880	2.578
EXTREME SPREAD	:	3.758	3.400	2.582
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

8 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636348

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS= 2.201

VS= 3.484

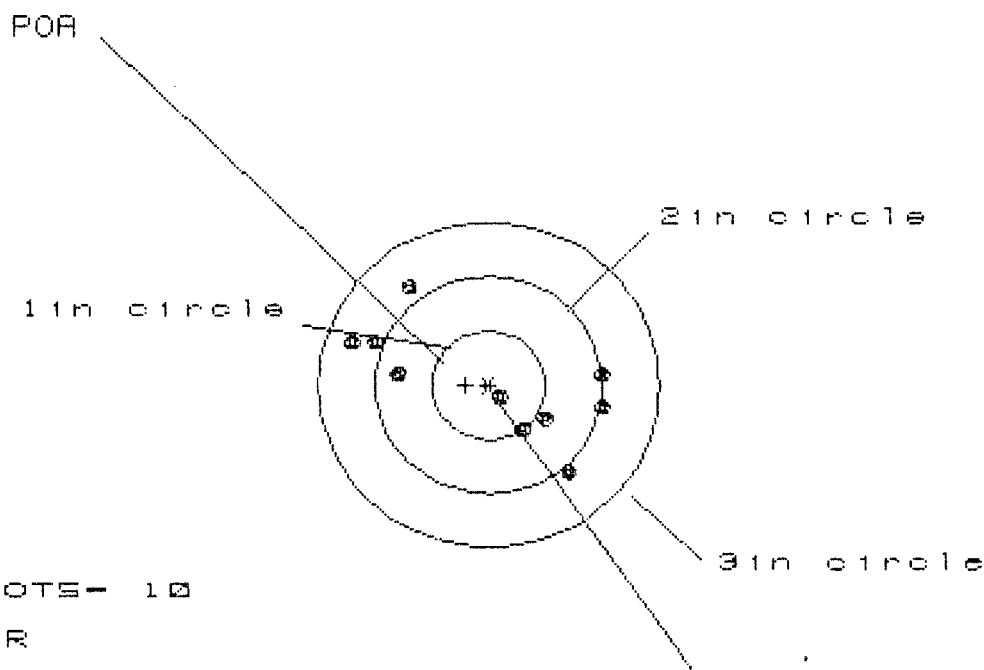
GS= 3.685

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.568	.692	.759
MINIMUM X	:	-.633	-.458	-.391
MAXIMUM Y	:	1.391	1.159	.922
MINIMUM Y	:	-2.093	-1.085	-.941
CENTROID X	:	.218	.043	-.024
CENTROID Y	:	-.076	.156	.012
POA TO CENTROID in.	:	.231	.162	.027
MIN RADIUS	:	.420	.159	.249
MEAN RADIUS	:	.960	.715	.631
MAX RADIUS	:	2.615	1.279	.941
HORIZONTAL SPREAD	:	2.201	1.150	1.150
VERTICAL SPREAD	:	3.484	2.244	1.862
EXTREME SPREAD	:	3.685	2.321	1.867
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

8 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636348

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 10

HS= 2.222

VS= 1.703

GS= 2.277

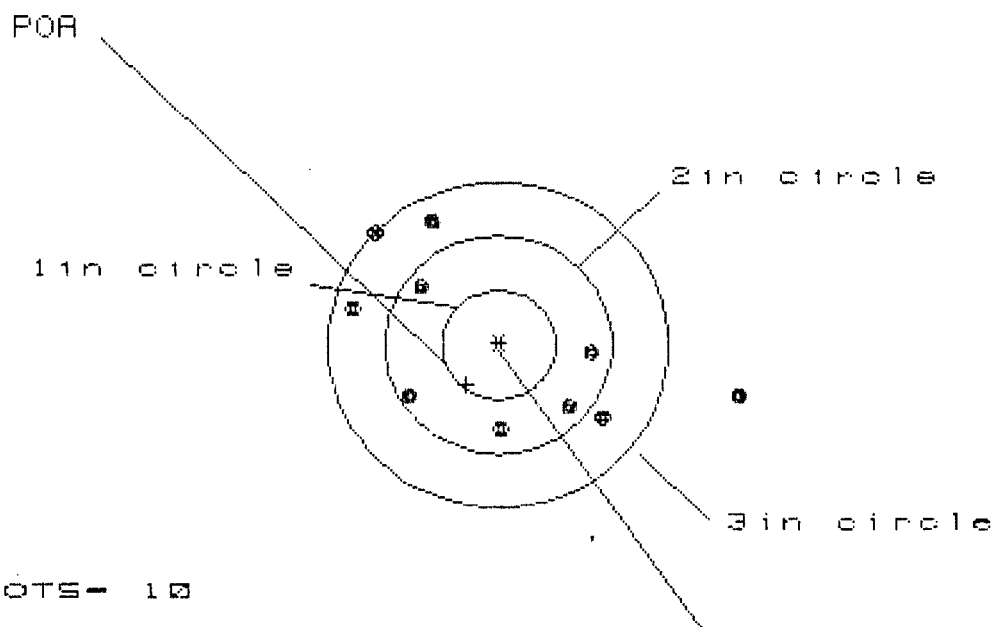
CENTROID #

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.019	.886	.781
MINIMUM X	-1.203	-1.090	-1.195
MAXIMUM Y	.879	.920	.572
MINIMUM Y	-.824	-.783	-.668
CENTROID X	.202	.335	.440
CENTROID Y	.002	-.039	-.154
POA TO CENTROID in.	.202	.338	.466
MIN RADIUS	.133	.067	.157
MEAN RADIUS	.857	.780	.686
MAX RADIUS	1.257	1.243	1.325
HORIZONTAL SPREAD	2.222	1.976	1.976
VERTICAL SPREAD	1.703	1.703	1.240
EXTREME SPREAD	2.277	2.218	2.085
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	10		

8 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636348

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 0

2in = 5

3in = 8

HS= 3.432

VS= 1.890

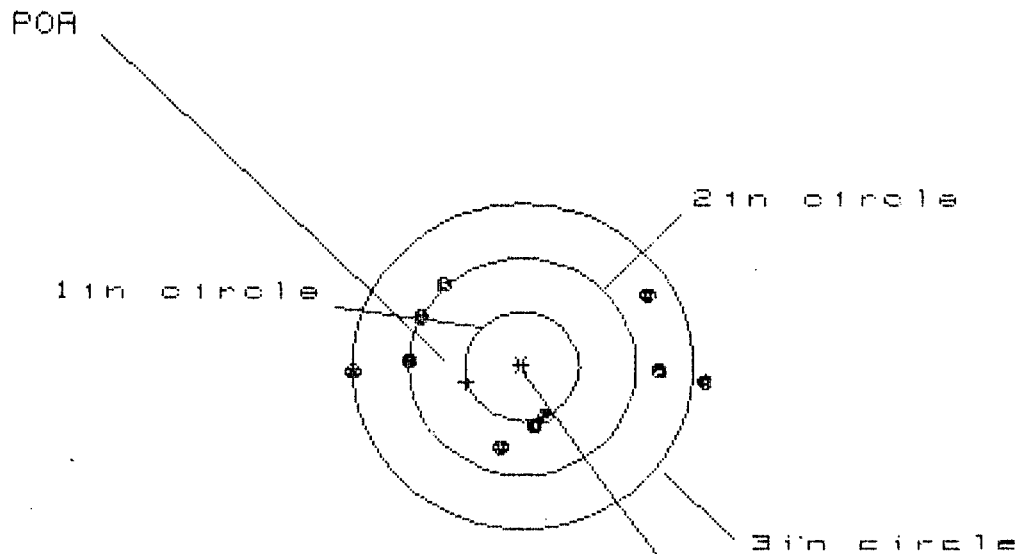
GS= 3.588

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.140	1.143	1.031
MINIMUM X	:	-1.292	-1.054	-1.166
MAXIMUM Y	:	1.144	1.091	1.210
MINIMUM Y	:	-.746	-.799	-.680
CENTROID X	:	.284	.046	.158
CENTROID Y	:	.369	.422	.303
POA TO CENTROID in.	:	.466	.424	.341
MIN RADIUS	:	.746	.635	.689
MEAN RADIUS	:	1.159	1.023	.975
MAX RADIUS	:	2.192	1.341	1.292
HORIZONTAL SPREAD	:	3.432	2.197	2.197
VERTICAL SPREAD	:	1.890	1.890	1.890
EXTREME SPREAD	:	3.588	2.621	2.400
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

8 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636348

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in - 0

2in - 5

3in - 8

HS- 3.108

VS= 1.537

GS= 3.108

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.576	1.343	1.173
MINIMUM X	-1.532	-1.357	-0.970
MAXIMUM Y	.783	.771	.761
MINIMUM Y	-.754	-.766	-.776
CENTROID X	.493	.318	.488
CENTROID Y	.146	.158	.168
POA TO CENTROID in.	.514	.355	.516
MIN RADIUS	.518	.596	.541
MEAN RADIUS	1.038	.964	.911
MAX RADIUS	1.579	1.451	1.295
HORIZONTAL SPREAD	3.108	2.700	2.143
VERTICAL SPREAD	1.537	1.537	1.537
EXTREME SPREAD	3.108	2.761	2.187
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		