

C6611800

MODEL 700™ M24

Model SWS™

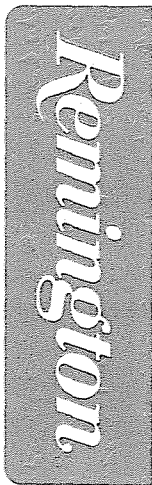
Action _____

Barrel Length _____

Capacity _____

Order No. 5716

*Includes 1 in chamber.






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

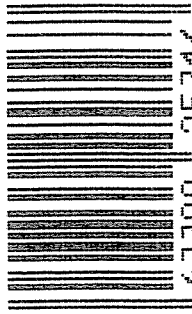
MODEL 700™ H24	SERIAL NO. C6611800
20	ORDER NO. 5716

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



5716 C6611800

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611800

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		1/24/91	KS
600	Proof		1/24/91	KS
607	Check Headspace		1/24/91	KS
610	Dis-assemble Gun		1/24/91	KS
612	Magnaflux Barrel Action		1/29/91	KR
	Magnaflux Bolt		11	KR
615	Rollmark Caliber		11	LG.
617	Drill and Tap Sight Holes	2 2	91	FB
618	Polish Barrel <i>RBB</i>	2 2	91	WB
620	Apply Coatings (Barrel Action)		2-11-91	FA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		3/5/91	Kd
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		3/5/91	Kd
	C) Inspect Ejector Hole for Chamfer		3/5/91	Kd
	D) Oil Firing Pin Ass'y		3/5/91	Kd
	E) Adjust Trigger Pull to Min Setting and Stake		3/7/91	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	3 1/2	3 1/2	3 1/2			3/7/91	WB
	G) Safety Off Force	2	2	2			3/7/91	WB
	H) Trigger Pull Test & Retainability						3/7/91	WB
	I) Firing Pin Indent	.022	.023	.0225			3/7/91	WB
	J) Assemble Stock						3/7/91	KL
	K) Assemble Swivel Studs						3-11-91	D/H
	L) Attach Front and Rear Sight Assemblies						3/7/91	KL
	M) Iron Sight Alignment						3/7/91	KL
	N) Detach Front & Rear Sights & place in numbered container						3/7/91	KL
	O) Attach Scope to Rifle						3/7/91	KL
	P) Detach & Attach Scope 20 Times						3/7/91	KL
640	Gallery Target & Test						3/8/91	KL
	A) Time							159
	B) Malfunctions							159
	C) Pierced Primers							159
	D) Optical Clarity of Scope							159
645	Inspect for Live Ammo						3/8/91	159
655	Final Inspection							
	A) Headspace						3-11-91	D/H
	B) Trigger Pull	2.46	2.36	2.42	2.43	2.44	3/8/91	801
	C) Function						3-11-91	D/H
660	Pack						3-20-91	D/H

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6611800

DATE 3/7/91

TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.50	2.42	2.35	2.45	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.54	2.47	2.34	2.36	
PULL #3	2.52	2.43	2.30	2.42	
PULL #4	2.43	2.53	2.34	2.43	
PULL #5	2.53	2.55	2.32	2.44	
TOTAL	12.52	12.40	11.65		
AVG.	2.50	2.48	2.33		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.18	3.08		
PULL #2	3.12	3.09		
PULL #3	3.12	3.02		
PULL #4	3.07	3.12		
PULL #5	3.13	3.14		
TOTAL	15.62	15.45		
AVG.	3.12	3.09		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.06	4.05		4.06
PULL #2	4.11	4.01		4.08
PULL #3	4.13	4.03		4.09
PULL #4	4.06	4.03		4.08
PULL #5	4.12	4.06		4.15
TOTAL	20.48	20.18		20.46
AVG.	4.10	4.03		4.09

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611800
8 Mar 1991

CENTROIDAL DISTANCES

0 TO	1	.0340588
1 TO	2	.120071
1 TO	3	.178877
1 TO	4	.136015
1 TO	5	.165702

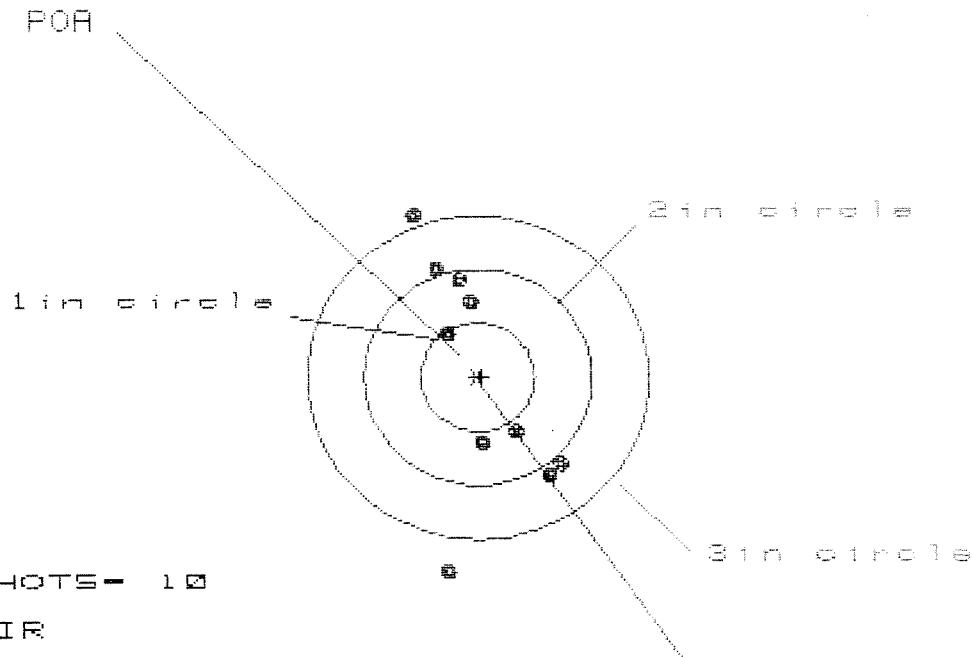
58 <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0022
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0328
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0328737
THE AMR FOR THIS RIFLE IS: 1.002

8 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06611800

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in - 0

2in - 5

3in - 8

HS - 1.255

VS - 3.345

GS - 3.352

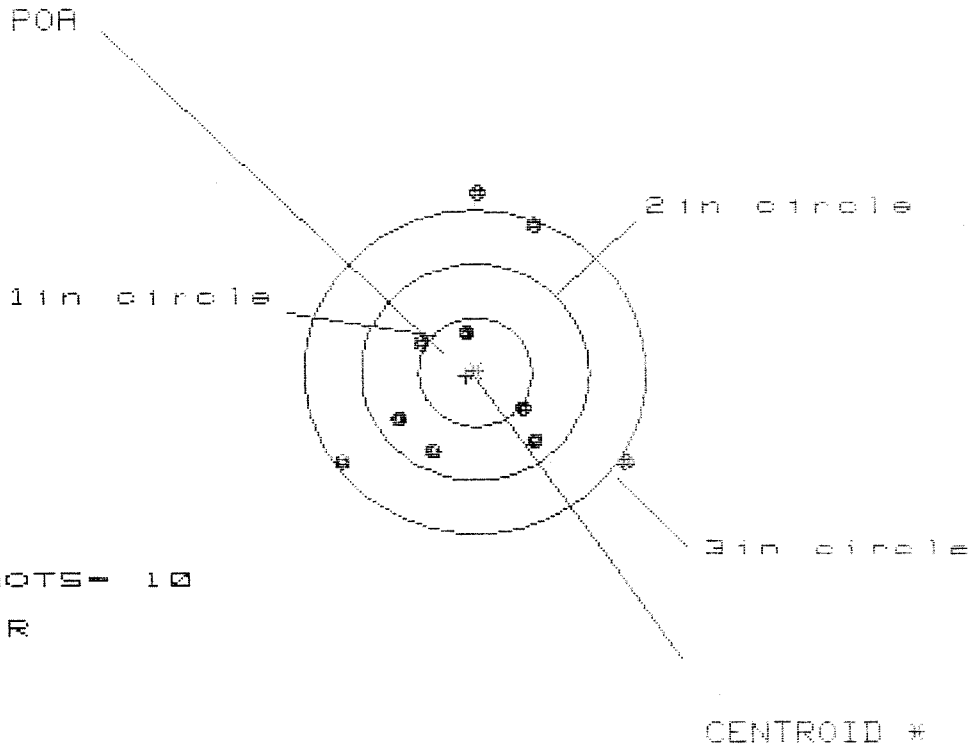
CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.725	.690	.619
MINIMUM X	:	-.530	-.565	-.455
MAXIMUM Y	:	1.538	1.338	.936
MINIMUM Y	:	-1.807	-1.048	-.881
CENTROID X	:	-.034	.001	.072
CENTROID Y	:	-.002	.198	.031
POA TO CENTROID in.	:	.034	.198	.078
MIN RADIUS	:	.534	.410	.559
MEAN RADIUS	:	.987	.870	.798
MAX RADIUS	:	1.834	1.452	1.040
HORIZONTAL SPREAD	:	1.255	1.255	1.074
VERTICAL SPREAD	:	3.345	2.386	1.817
EXTREME SPREAD	:	3.352	2.639	2.056
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	8		

8 Mar 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 8

HS= 2.426

VS= 2.516

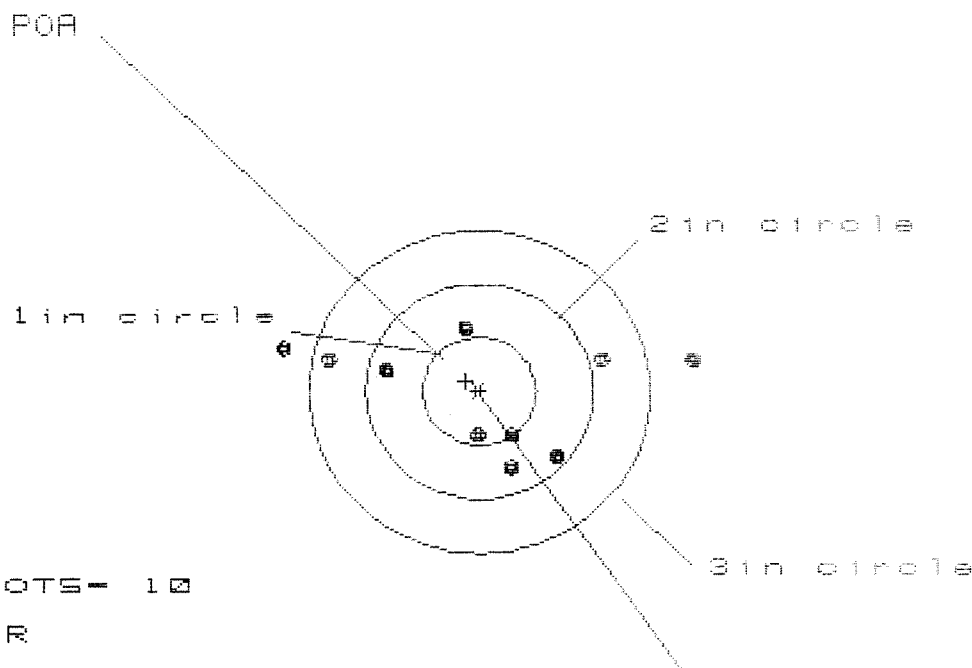
GS= 2.811

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.275	1.277	.691
MINIMUM X	:	-1.151	-1.149	-.989
MAXIMUM Y	:	1.712	1.583	1.506
MINIMUM Y	:	-.804	-.613	-.687
CENTROID X	:	.082	.080	-.080
CENTROID Y	:	.029	-.162	-.085
POA TO CENTROID in.	:	.087	.180	.117
MIN RADIUS	:	.417	.474	.499
MEAN RADIUS	:	1.015	.917	.841
MAX RADIUS	:	1.712	1.669	1.657
HORIZONTAL SPREAD	:	2.426	2.426	1.680
VERTICAL SPREAD	:	2.516	2.196	2.193
EXTREME SPREAD	:	2.811	2.763	2.763
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

8 Mar 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS = 3.585

VS = 1.290

GS = 3.585

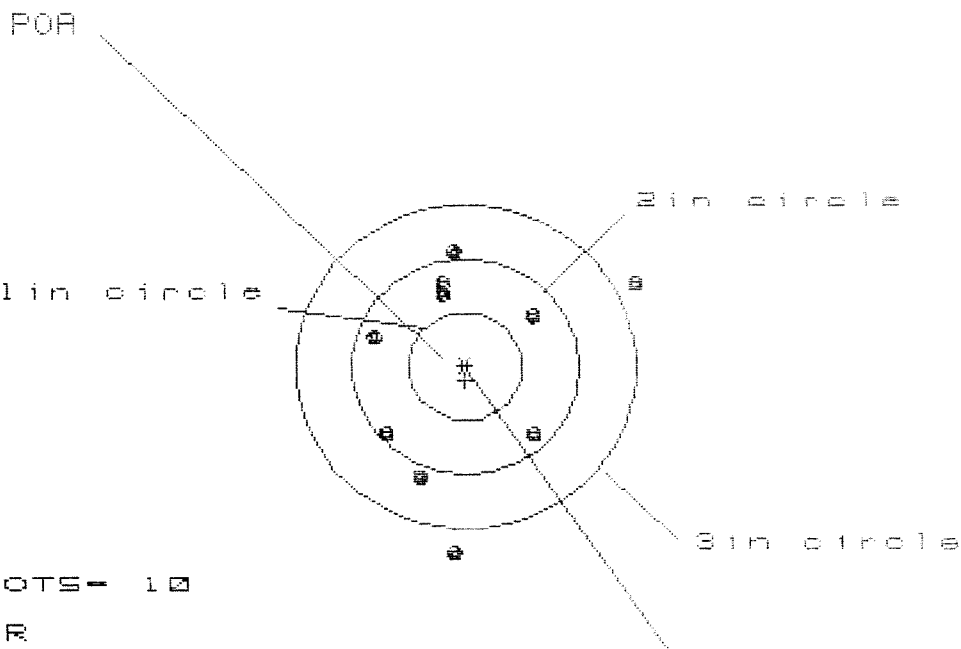
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.841	1.236	1.044
MINIMUM X	:	-1.744	-1.540	-1.313
MAXIMUM Y	:	.591	.627	.676
MINIMUM Y	:	-.699	-.663	-.614
CENTROID X	:	.120	-.084	.108
CENTROID Y	:	-.093	-.129	-.178
POA TO CENTROID in.	:	.152	.154	.208
MIN RADIUS	:	.431	.416	.346
MEAN RADIUS	:	1.006	.907	.786
MAX RADIUS	:	1.869	1.589	1.380
HORIZONTAL SPREAD	:	3.585	2.776	2.357
VERTICAL SPREAD	:	1.290	1.290	1.290
EXTREME SPREAD	:	3.585	2.776	2.357
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

8 Mar 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in - 0

2 in - 6

3 in = 8

HS= 2.314

VS= 2.776

GS= 2.906

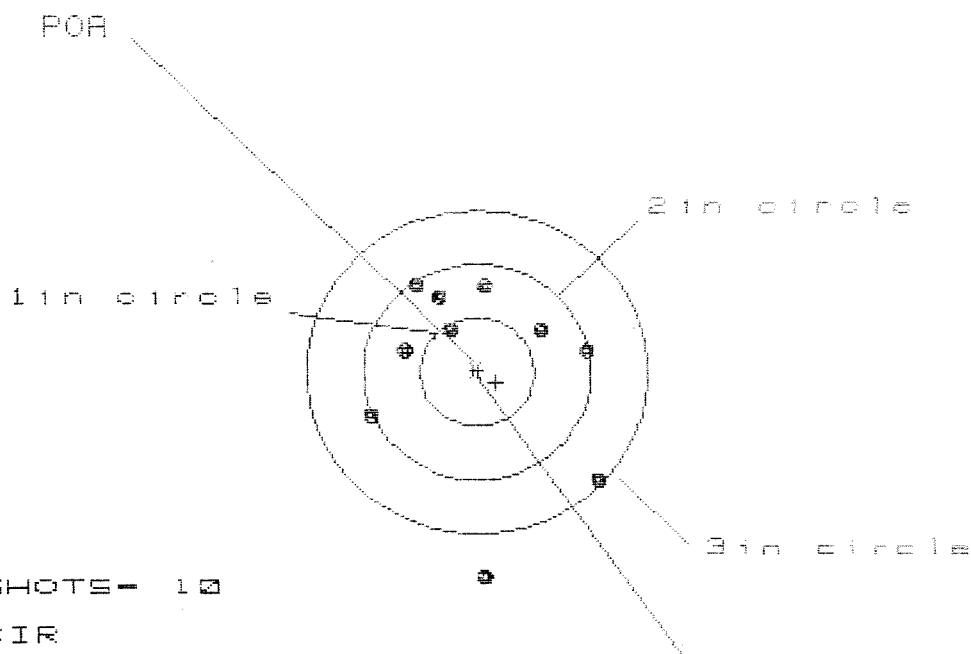
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.495	1.480	.756
MINIMUM X	:	-.819	-.834	-.649
MAXIMUM Y	:	1.094	.907	.974
MINIMUM Y	:	-1.682	-1.251	-1.104
CENTROID X	:	.006	.021	-.164
CENTROID Y	:	.128	.315	.248
POA TO CENTROID in.	:	.128	.316	.297
MIN RADIUS	:	.704	.534	.555
MEAN RADIUS	:	1.052	.949	.860
MAX RADIUS	:	1.688	1.574	1.212
HORIZONTAL SPREAD	:	2.314	2.314	1.405
VERTICAL SPREAD	:	2.776	2.158	2.158
EXTREME SPREAD	:	2.906	2.626	2.176
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

B Mar 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 8

3 in = 9

HS= 1.908

VS= 2.681

GS= 2.747

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.017	1.023	1.082
MINIMUM X	:	-.891	-.885	-.758
MAXIMUM Y	:	.774	.563	.413
MINIMUM Y	:	-1.907	-1.199	-.764
CENTROID X	:	-.163	-.169	-.296
CENTROID Y	:	.102	.313	.463
POA TO CENTROID in.	:	.192	.356	.550
MIN RADIUS	:	.476	.326	.152
MEAN RADIUS	:	.951	.781	.617
MAX RADIUS	:	1.907	1.576	1.092
HORIZONTAL SPREAD	:	1.908	1.908	1.839
VERTICAL SPREAD	:	2.681	1.762	1.177
EXTREME SPREAD	:	2.747	2.357	1.938
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	