

C6636103

MODEL 700™ M24

Model **SWS**™

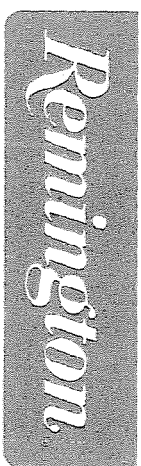
Action

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.

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

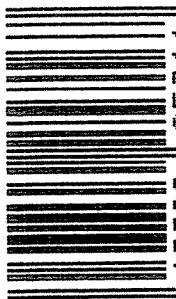
	SERIAL NO.	C6636103
	ORDER NO.	5716

20



5716 C6636103

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636103

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 8	91	RW
600	Proof	4 8	91	RW
607	Check Headspace	4 8	91	RW
610	Dis-assemble Gun	4 8	91	RW
612	Magnaflux Barrel Action		APR 9 1991	KR
	Magnaflux Bolt		APR 9 1991	ic
615	Rollmark Caliber		APR 9 1991	LL
617	Drill and Tap Sight Holes		APR 19 1991	LB
618	Polish Barrel		APR 19 1991	LB
620	Apply Coatings (Barrel Action)		5-10-91	TH
	Apply Coating (Bolt)		5-10-91	TH
625	Final Assembly A) Clean inside of Bolt Assembly		5/10/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/10/91	RW
	C) Inspect Ejector Hole for Chamfer		5/10/91	RW
	D) Oil Firing Pin Ass'y		5/10/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5-16-91	TH

op. #	OP. NAME	READINGS			DATE	INIT	
625 cont.	F) Safety On Force	5	5	5	5-17-91	AC	
	G) Safety Off Force	3	4	3	5-17-91	AC	
	H) Trigger Pull Test & Retainability				5-16-91	AC	
	I) Firing Pin Indent	.021	.020	.020	5-17-91	AC	
	J) Assemble Stock				5/25/91	Rev	
	K) Assemble Swivel Studs				6-1-91	D/H	
	L) Attach Front and Rear Sight Assemblies				5/25/91	Rev	
	M) Iron Sight Alignment				5/25/91	Rev	
	N) Detach Front & Rear Sights & place in numbered container				5/25/91	Rev	
	O) Attach Scope to Rifle				5/25/91	Rev	
	P) Detach & Attach Scope 20 Times				5/25/91	Rev	
640	Gallery Target & Test				5-28-91	NF	
	A) Time				"	NF	
	B) Malfunctions				"	NF	
	C) Pierced Primers				"	NF	
	D) Optical Clarity of Scope				"	NF	
645	Inspect for Live Ammo				5-28-91	NF	
655	Final Inspection						
	A) Headspace				6-1-91	D/H	
	B) Trigger Pull	2.68	2.65	2.55	2.62	6/1/91	AC
	C) Function				6-1-91	D/H	
660	Pack				6-20-91	NF	

SWS TRIGGER PULL TEST

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

SERIAL NO. 26636/03

DATE 5-16-91

TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.48	2.41	2.44	2.58	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.47	2.38	2.36	2.55	
PULL #3	2.45	2.31	2.47	2.53	
PULL #4	2.34	2.33	2.40	2.55	
PULL #5	2.44	2.35	2.41	2.62	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.44	3.55		
PULL #2	3.30	3.24		
PULL #3	3.54	3.59		
PULL #4	3.58	3.55		
PULL #5	3.57	3.54		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.35	4.43		4.35
PULL #2	4.24	4.44		4.37
PULL #3	4.37	4.35		4.42
PULL #4	4.31	4.35		4.32
PULL #5	4.41	4.32		4.37
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636103
28 May 1991

CENTROIDAL DISTANCES

0 TO 1	.454368
1 TO 2	.574948
1 TO 3	.51788
1 TO 4	.461088
1 TO 5	.485235

44
1

<----POI

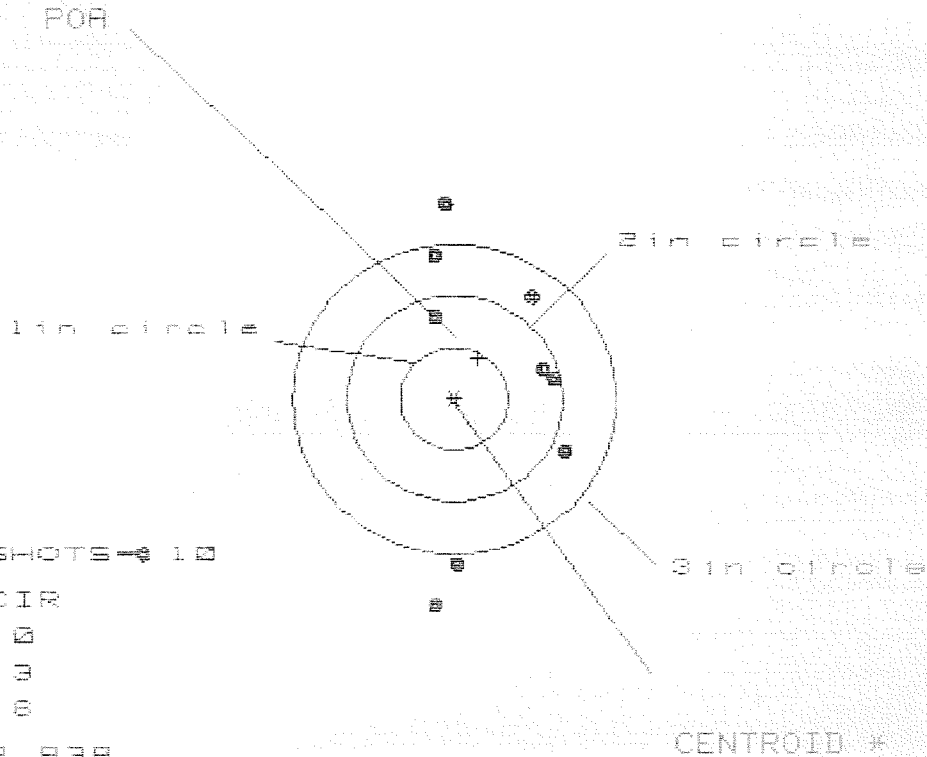
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1434
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0142
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .144101

THE AMR FOR THIS RIFLE IS: 1.192

28 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8836103

CENTERFIRE PATTERNS # 1



PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.978	.660	.596
MINIMUM X	:	-2.860	-.511	-.573
MAXIMUM Y	:	1.943	1.773	1.500
MINIMUM Y	:	-2.015	-2.185	-1.999
CENTROID X	:	-.221	.097	.161
CENTROID Y	:	-.397	-.227	.046
POA TO CENTROID in.	:	.454	.247	.167
MIN RADIUS	:	.801	.541	.471
MEAN RADIUS	:	1.517	1.217	1.027
MAX RADIUS	:	3.242	2.244	2.039
HORIZONTAL SPREAD	:	3.838	1.171	1.169
VERTICAL SPREAD	:	3.958	3.958	3.499
EXTREME SPREAD	:	4.454	3.960	3.499
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		6	

28 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C683E103

CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 1

2in = 5

3in = 7

HS = 2.860

VS = 2.721

ES = 3.416

CENTROID *

PATTERN #

2

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.537

1.018

.973

MINIMUM X

-1.323

-1.153

-1.025

MAXIMUM Y

1.153

1.273

1.093

MINIMUM Y

-1.568

-1.440

-1.189

CENTROID X

.020

-.150

-.278

CENTROID Y

.125

-.003

.177

POA TO CENTROID in.

.127

.150

.329

MIN RADIUS

.324

.395

.243

MEAN RADIUS

1.131

1.033

.986

MAX RADIUS

1.921

1.764

1.281

HORIZONTAL SPREAD

2.860

2.171

1.998

VERTICAL SPREAD

2.721

2.713

2.282

EXTREME SPREAD

3.416

2.930

2.388

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

5

NUMBER IN THREE INCH CIRCLE =

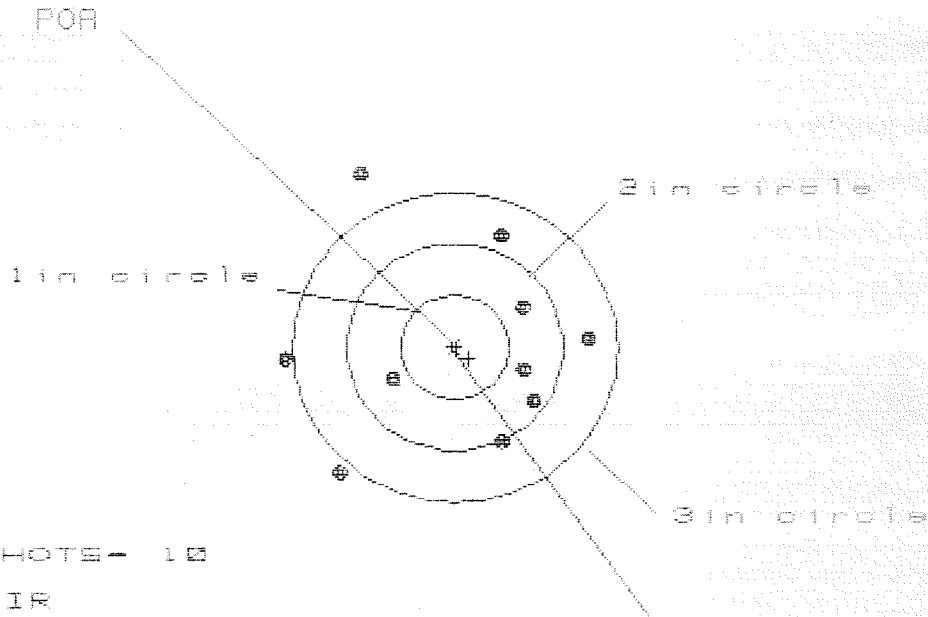
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CENTERFIRE PATTERNS

3



OF SHOTS - 10

IN CIR

1 in = 0

2 in = 4

3 in = 7

HS = 2.735

VS = 2.917

GS = 2.924

CENTROID *

PATTERN #

:

3

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

1.243

1.148

1.005

MINIMUM X

:

-1.552

-1.647

-1.790

MAXIMUM Y

:

1.699

1.284

1.155

MINIMUM Y

:

-1.218

-1.029

-0.878

CENTROID X

:

-0.131

-0.036

.107

CENTROID Y

:

.113

-0.076

.053

POR TO CENTROID in.

:

.173

.084

.119

MIN RADIUS

:

.659

.536

.425

MEAN RADIUS

:

1.147

1.028

.930

MAX RADIUS

:

1.901

1.650

1.790

HORIZONTAL SPREAD

:

2.795

2.795

2.795

VERTICAL SPREAD

:

2.917

2.313

2.033

EXTREME SPREAD

:

2.924

2.802

2.802

NUMBER IN ONE INCH CIRCLE =

0

NUMBER IN TWO INCH CIRCLE =

4

NUMBER IN THREE INCH CIRCLE =

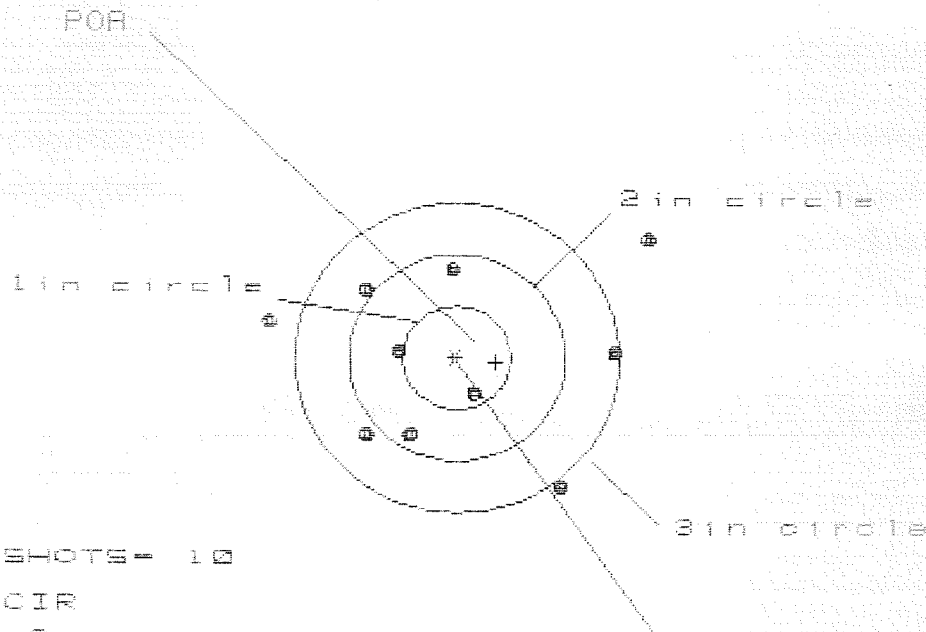
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CENTERFIRE PATTERNS

4



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 4

3 in = 7

HS= 3.409

VS= 2.424

GS= 3.502

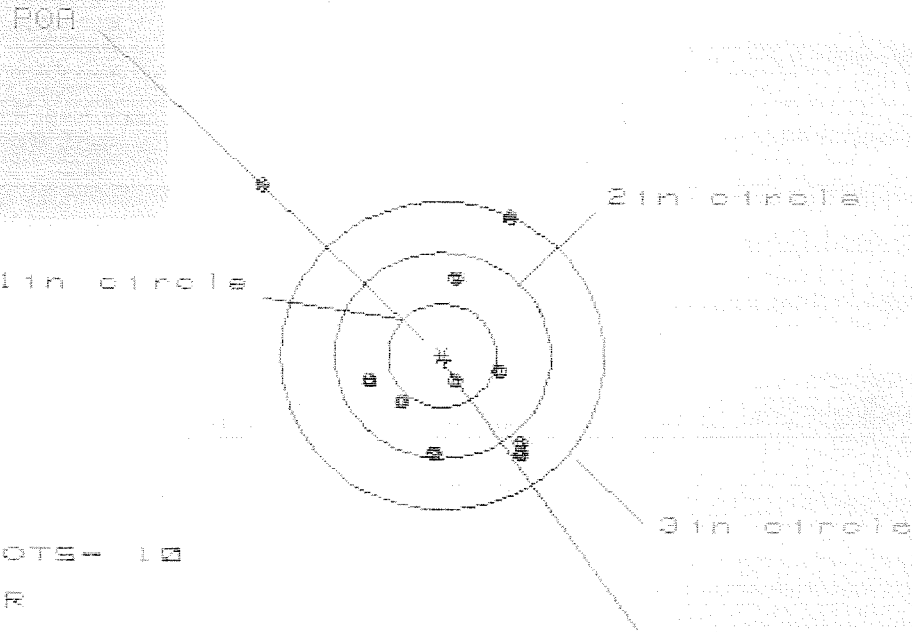
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.720	1.672	1.485
MINIMUM X	:	-1.689	-1.498	-1.871
MAXIMUM Y	:	1.165	.981	1.042
MINIMUM Y	:	-1.259	-1.129	-1.068
CENTROID X	:	-.362	-.553	-.366
CENTROID Y	:	.042	-.038	-.150
POA TO CENTROID in.	:	.365	.560	.395
MIN RADIUS	:	.387	.345	.223
MEAN RADIUS	:	1.165	1.020	.955
MAX RADIUS	:	2.078	1.686	1.510
HORIZONTAL SPREAD	:	3.409	3.170	2.356
VERTICAL SPREAD	:	2.424	2.110	2.110
EXTREME SPREAD	:	3.502	3.182	2.600
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/C8836103

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 8

HS= 2.446

VS= 2.601

GS= 3.489

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.759	.571	.625
MINIMUM X	:	-1.687	-.866	-.812
MAXIMUM Y	:	1.616	1.566	1.136
MINIMUM Y	:	-.985	-.886	-.610
CENTROID X	:	-.023	.165	.111
CENTROID Y	:	.046	-.133	-.329
POA TO CENTROID in.	:	.052	.212	.347
MIN RADIUS	:	.238	.072	.171
MEAN RADIUS	:	.999	.791	.667
MAX RADIUS	:	2.336	1.623	1.136
HORIZONTAL SPREAD	:	2.446	1.437	1.437
VERTICAL SPREAD	:	2.601	2.372	1.746
EXTREME SPREAD	:	3.489	2.472	1.794
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	