

C6636138

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.






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

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

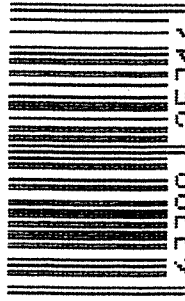
MODEL 700™ H24

SERIAL NO. C6636138

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 C6636138

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6634138**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		4/9/91	KS
600	Proof		4/9/91	KS
607	Check Headspace		4/9/91	KS
610	Dis-assemble Gun		4/9/91	KS
612	Magnaflux Barrel Action		4/10/91	KR
	Magnaflux Bolt		4/10/91	"
615	Rollmark Caliber		4/10/91	GL
617	Drill and Tap Sight Holes		APR 19 1991	KB
618	Polish Barrel		APR 19 1991	WB
620	Apply Coatings (Barrel Action)		5-10-91	DB
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/22/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/22/91	KS
	C) Inspect Ejector Hole for Chamfer		5/22/91	KS
	D) Oil Firing Pin Ass'y		5/22/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		5/24/91	GL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5/24/91	JK
	G) Safety Off Force	4	4	4			5/24/91	JK
	H) Trigger Pull Test & Retainability						5/24/91	JK
	I) Firing Pin Indent	.021	.021	.021			5/24/91	JK
	J) Assemble Stock						5/24/91	KS
	K) Assemble Swivel Studs						6-1-91	DH
	L) Attach Front and Rear Sight Assemblies						5/24/91	KS
	M) Iron Sight Alignment						5/24/91	KS
	N) Detach Front & Rear Sights & place in numbered container						5/24/91	KS
	O) Attach Scope to Rifle						5/24/91	KS
	P) Detach & Attach Scope 20 Times						5/24/91	KS
640	Gallery Target & Test						5-28-91	AC
	A) Time						5-28-91	AC
	B) Malfunctions						5-28-91	AC
	C) Pierced Primers						5-28-91	AC
	D) Optical Clarity of Scope						5-28-91	AC
645	Inspect for Live Ammo						5-28-91	AC
655	Final Inspection							
	A) Headspace						6-1-91	DH
	B) Trigger Pull	2.61	2.61	2.62	2.58	2.58	6/1/91	JK
	C) Function						6-1-91	DH
660	Pack						6-20-91	JK

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#
 3.00# + .75#
 4.00# + 1.00#

SERIAL NO. 66636138DATE 5-24-91TESTER JLP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.62	2.57	2.38	2.61	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.62	2.59	2.52	2.61	
PULL #3	2.56	2.56	2.43	2.62	
PULL #4	2.50	2.60	2.43	2.58	
PULL #5	2.55	2.36	2.48	2.58	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.44	3.15		
PULL #2	3.46	3.41		
PULL #3	3.58	3.48		
PULL #4	3.48	3.47		
PULL #5	3.47	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	4.17	4.31		4.26
PULL #2	4.23	4.21		4.29
PULL #3	4.21	4.21		4.27
PULL #4	4.23	4.24		4.18
PULL #5	4.28	4.26		4.23
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636138
20 May 1991

CENTROIDAL DISTANCES

0 TO	1	.310736
1 TO	2	.10224
1 TO	3	.300593
1 TO	4	.483828
1 TO	5	.659755

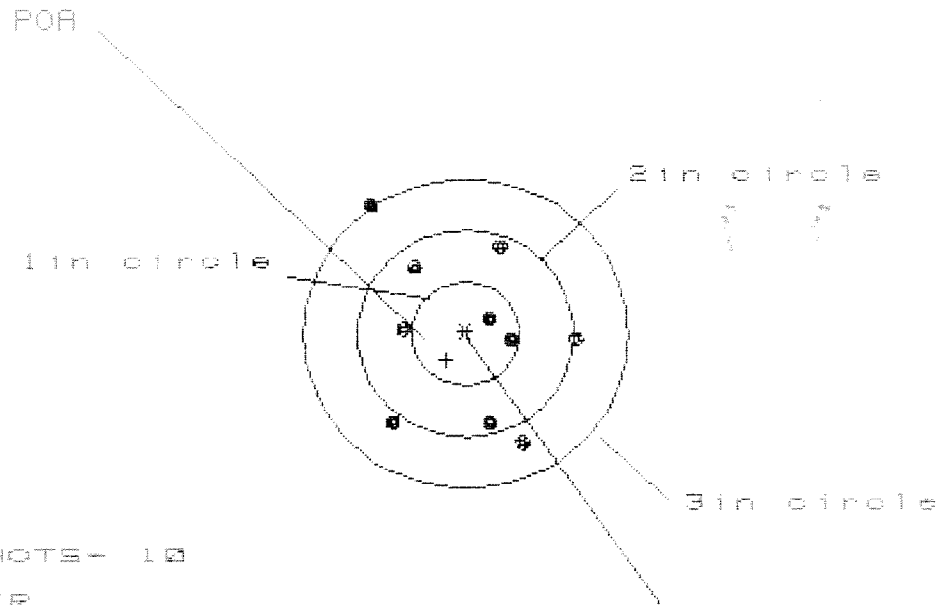
Unit 2 <----POI

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0074
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0224
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0235907
THE AMR FOR THIS RIFLE IS: .8816

28 May 1991

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CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 10

HS= 1.897

VS= 2.261

GS= 2.626

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.038	.943	.991
MINIMUM X	:	-.859	-.735	-.687
MAXIMUM Y	:	1.200	.947	.831
MINIMUM Y	:	-1.061	-.928	-.846
CENTROID X	:	.179	.275	.227
CENTROID Y	:	.254	.121	.237
POA TO CENTROID in.	:	.311	.300	.328
MIN RADIUS	:	.237	.301	.217
MEAN RADIUS	:	.858	.781	.739
MAX RADIUS	:	1.475	1.021	1.074
HORIZONTAL SPREAD	:	1.897	1.678	1.678
VERTICAL SPREAD	:	2.261	1.875	1.677
EXTREME SPREAD	:	2.626	1.996	1.898
NUMBER IN ONE INCH CIRCLE =	:	2		
NUMBER IN TWO INCH CIRCLE =	:	6		
NUMBER IN THREE INCH CIRCLE =	:	10		

28 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8838138

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 10

HS = 1.791

VS = 1.710

GS = 2.017

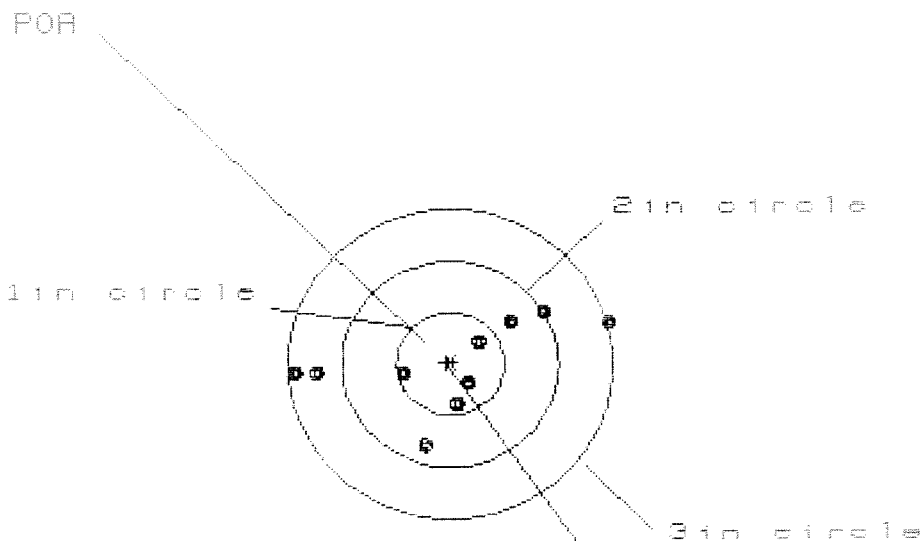
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.918	.917	1.020
MINIMUM X	:	-.873	-.874	-.772
MAXIMUM Y	:	.659	.542	.608
MINIMUM Y	:	-1.051	-.987	-.921
CENTROID X	:	.077	.078	-.025
CENTROID Y	:	.261	.378	.312
POA TO CENTROID in.	:	.272	.386	.313
MIN RADIUS	:	.082	.172	.195
MEAN RADIUS	:	.738	.687	.655
MAX RADIUS	:	1.051	1.113	1.051
HORIZONTAL SPREAD	:	1.791	1.791	1.791
VERTICAL SPREAD	:	1.710	1.529	1.529
EXTREME SPREAD	:	2.017	2.017	1.791
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

28 May 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 9

HS= 2.804

VS= 1.286

GS= 2.852

CENTROID #

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.494	.981	.826
MINIMUM X	-1.410	-1.244	-1.256
MAXIMUM Y	.529	.580	.577
MINIMUM Y	-.757	-.706	-.709
CENTROID X	.039	-.127	.028
CENTROID Y	-.012	-.063	-.060
POA TO CENTROID in.	.040	.142	.067
MIN RADIUS	.256	.322	.237
MEAN RADIUS	.818	.740	.647
MAX RADIUS	1.563	1.244	1.257
HORIZONTAL SPREAD	2.904	2.225	2.082
VERTICAL SPREAD	1.286	1.286	1.286
EXTREME SPREAD	2.952	2.305	2.175
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

28 May 1991

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CENTERFIRE PATTERNS

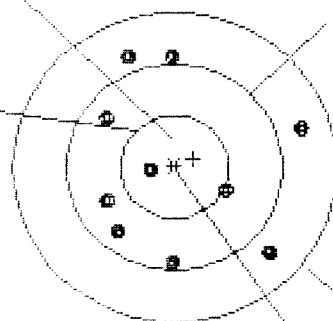
4

POA

1in circle

2in circle

3in circle



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 1.798

VS= 1.987

GS= 2.251

CENTROID *

PATTERN #

:

4

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

1.161

1.038

.697

MINIMUM X

:

-.637

-.508

-.378

MAXIMUM Y

:

1.075

1.119

1.025

MINIMUM Y

:

-.912

-.868

-.962

CENTROID X

:

-.172

-.301

-.431

CENTROID Y

:

-.079

-.123

-.029

POA TO CENTROID in.:

.190

.326

.432

MIN RADIUS

:

.216

.098

.065

MEAN RADIUS

:

.856

.786

.708

MAX RADIUS

:

1.226

1.280

1.043

HORIZONTAL SPREAD

:

1.798

1.546

1.075

VERTICAL SPREAD

:

1.987

1.987

1.987

EXTREME SPREAD

:

2.251

2.251

1.987

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

6

NUMBER IN THREE INCH CIRCLE =

10

28 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8635138

CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 7

HS= 2.715

VS= 3.340

GS= 3.830

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.443

1.516

1.373

MINIMUM X

-1.272

-1.199

-1.342

MAXIMUM Y

1.488

1.193

.757

MINIMUM Y

-1.932

-1.082

-.932

CENTROID X

-.160

-.233

-.090

CENTROID Y

-.312

-.097

-.247

POA TO CENTROID in.

.351

.252

.263

MIN RADIUS

.325

.220

.366

MEAN RADIUS

1.138

1.005

.931

MAX RADIUS

2.041

1.652

1.420

HORIZONTAL SPREAD

2.715

2.715

2.715

VERTICAL SPREAD

3.340

2.275

1.689

EXTREME SPREAD

3.830

2.924

2.787

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

5

NUMBER IN THREE INCH CIRCLE =

7