

C6636142

MODEL 700TM M24

Model **SWS** TM

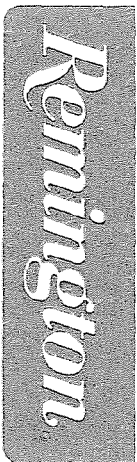
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.






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

MODEL 700TM H24

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

SERIAL NO.
C6636142

ORDER NO.
5716

20



UPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636142

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		4/9/91	K.S.
600	Proof		4/9/91	K.S.
607	Check Headspace		4/9/91	K.S.
610	Dis-assemble Gun		4/9/91	K.S.
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	TA
	Apply Coating (Bolt)			TA
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		5/28/91	SA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5/28/91	JK
	G) Safety Off Force	4	4	4			5/28/91	JK
	H) Trigger Pull Test & Retainability						5/28/91	JK
	I) Firing Pin Indent	.020	.021	.021			5/28/91	JK
	J) Assemble Stock						5/28/91	KS
	K) Assemble Swivel Studs						6-1-91	DH
	L) Attach Front and Rear Sight Assemblies						5/28/91	KS
	M) Iron Sight Alignment						5/28/91	KS
	N) Detach Front & Rear Sights & place in numbered container						5/28/91	KS
	O) Attach Scope to Rifle						5/28/91	KS
	P) Detach & Attach Scope 20 Times						5/28/91	KS
640	Gallery Target & Test						5-29-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						5-29-91	NF
655	Final Inspection							
	A) Headspace						6-1-91	DH
	B) Trigger Pull	2.27	2.28	2.26	2.42	2.28	6/1/91	JK
	C) Function						6-1-91	DH
660	Pack						6-20-91	NF

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

SERIAL NO C663642
DATE 5/28/91
TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.51	2.48	2.46	2.27	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.44	2.46	2.50	2.28	
PULL #3	2.40	2.51	2.50	2.26	
PULL #4	2.33	2.48	2.52	2.42	
PULL #5	2.36	2.51	2.43	2.28	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.51	3.40		
PULL #2	3.51	3.49		
PULL #3	3.36	3.44		
PULL #4	3.45	3.20		
PULL #5	3.39	3.48		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.21	4.43		4.36
PULL #2	4.18	4.42		4.41
PULL #3	4.39	4.37		4.42
PULL #4	4.32	4.26		4.39
PULL #5	4.37	4.40		4.38
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636142
29 May 1991

CENTROIDAL DISTANCES

0 TO	1	.218289
1 TO	2	.293471
1 TO	3	.170178
1 TO	4	.0628172
1 TO	5	.260849

3 (----POA

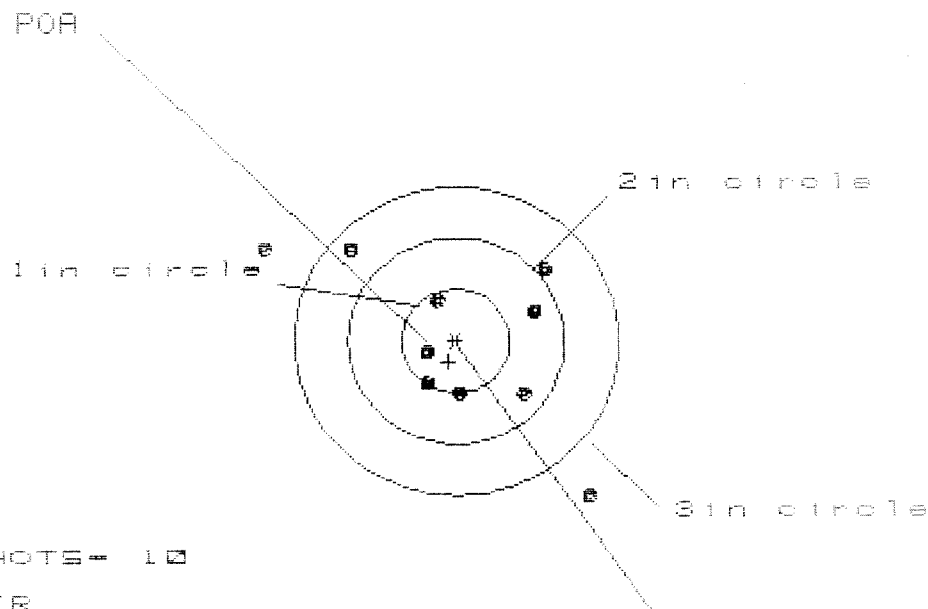
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0176
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0622
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0646421

THE AMR FOR THIS RIFLE IS: .99

29 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636142

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 3

2in = 6

3in = 8

HS= 3.023

VS= 2.410

GS= 3.847

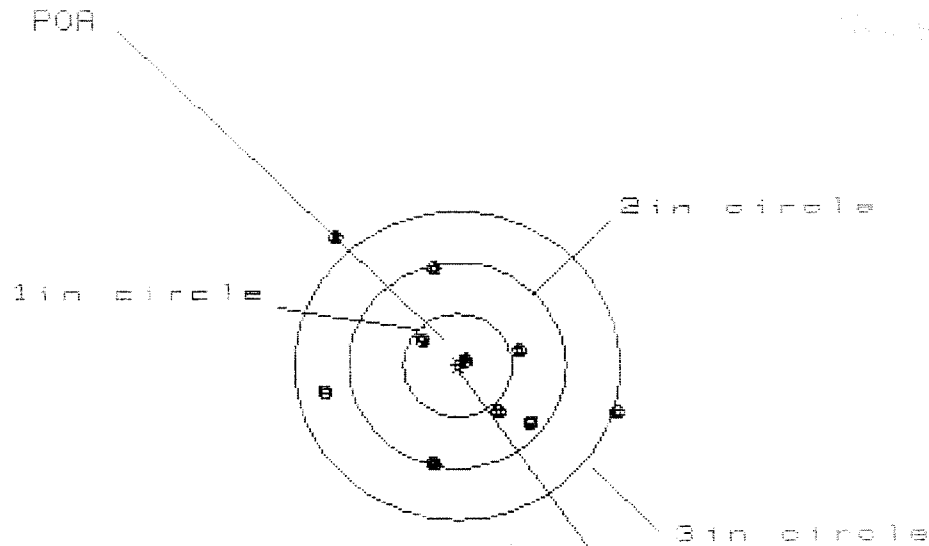
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.229	1.030	.712
MINIMUM X	:	-1.794	-1.222	-1.093
MAXIMUM Y	:	.881	.975	.796
MINIMUM Y	:	-1.529	-1.435	-.607
CENTROID X	:	.075	.274	.146
CENTROID Y	:	.205	.111	.290
POA TO CENTROID in.	:	.218	.296	.324
MIN RADIUS	:	.262	.440	.363
MEAN RADIUS	:	.972	.854	.729
MAX RADIUS	:	1.985	1.766	1.353
HORIZONTAL SPREAD	:	3.023	2.252	1.805
VERTICAL SPREAD	:	2.410	2.410	1.483
EXTREME SPREAD	:	3.847	3.298	2.198
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 8

HS= 2.788

VS= 2.160

GS= 3.139

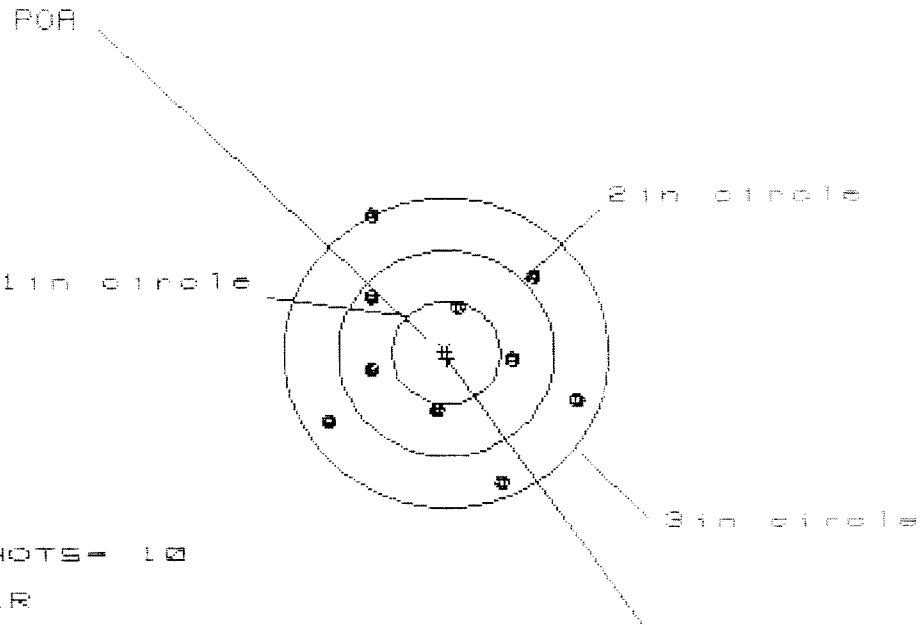
CENTROID #

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.517	1.394	.697
MINIMUM X	:	-1.271	-1.394	-1.220
MAXIMUM Y	:	1.227	1.092	1.047
MINIMUM Y	:	-.933	-.797	-.842
CENTROID X	:	-.072	.051	-.123
CENTROID Y	:	-.049	-.195	-.140
POA TO CENTROID in.	:	.087	.192	.186
MIN RADIUS	:	.077	.180	.175
MEAN RADIUS	:	.896	.799	.724
MAX RADIUS	:	1.653	1.439	1.228
HORIZONTAL SPREAD	:	2.788	2.788	1.917
VERTICAL SPREAD	:	2.160	1.889	1.889
EXTREME SPREAD	:	3.139	2.801	1.942
NUMBER IN ONE INCH CIRCLE =	:	2		
NUMBER IN TWO INCH CIRCLE =	:	7		
NUMBER IN THREE INCH CIRCLE =	:	8		

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 2.233

VS= 2.665

GS= 2.931

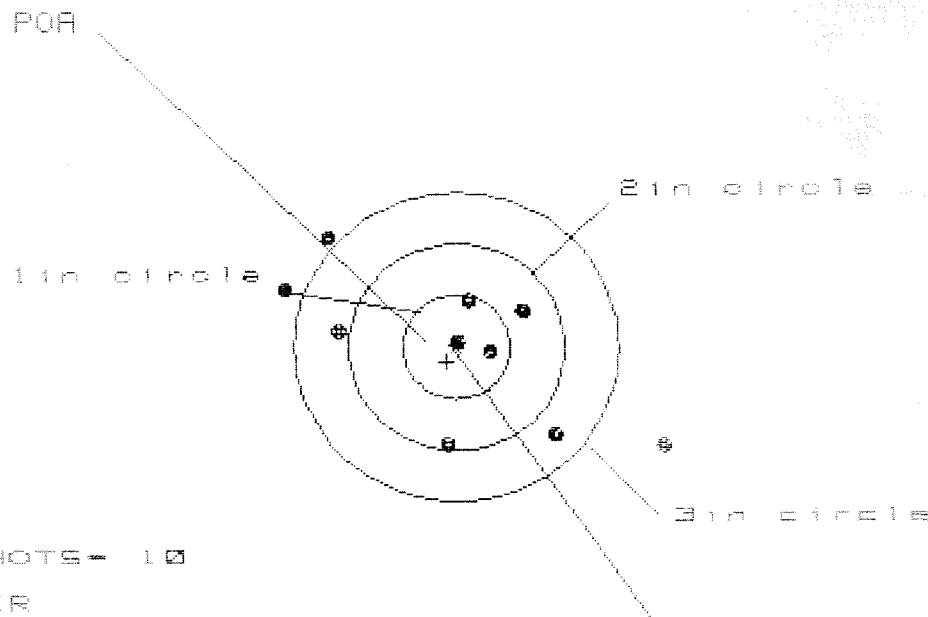
CENTROID #

PATTERN #	:	3
SHOTS (BEST OF)	:	10
MAXIMUM X	:	1.192
MINIMUM X	:	-1.041
MAXIMUM Y	:	1.376
MINIMUM Y	:	-1.289
CENTROID X	:	-.009
CENTROID Y	:	.057
POA TO CENTROID in.	:	.057
MIN RADIUS	:	.479
MEAN RADIUS	:	.988
MAX RADIUS	:	1.541
HORIZONTAL SPREAD	:	2.233
VERTICAL SPREAD	:	2.665
EXTREME SPREAD	:	2.931
NUMBER IN ONE INCH CIRCLE	=	1
NUMBER IN TWO INCH CIRCLE	=	5
NUMBER IN THREE INCH CIRCLE	=	9

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 7

HS= 3.555

VS= 2.057

GS= 3.882

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.948	1.173	.999
MINIMUM X	:	-1.607	-1.390	-1.116
MAXIMUM Y	:	1.101	.995	1.058
MINIMUM Y	:	-.956	-1.050	-.988
CENTROID X	:	.090	-.127	.047
CENTROID Y	:	.144	.251	.189
POA TO CENTROID in.	:	.170	.281	.194
MIN RADIUS	:	.098	.253	.092
MEAN RADIUS	:	1.040	.935	.816
MAX RADIUS	:	2.170	1.493	1.538
HORIZONTAL SPREAD	:	3.555	2.563	2.115
VERTICAL SPREAD	:	2.057	2.045	2.045
EXTREME SPREAD	:	3.882	2.931	2.856
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 1.823

VS= 4.268

GS= 4.386

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.545
MINIMUM X	-1.278
MAXIMUM Y	1.769
MINIMUM Y	-2.499
CENTROID X	.004
CENTROID Y	-.046
POA TO CENTROID in.	.047
MIN RADIUS	.432
MEAN RADIUS	1.054
MAX RADIUS	2.500
HORIZONTAL SPREAD	1.823
VERTICAL SPREAD	4.268
EXTREME SPREAD	4.386
NUMBER IN ONE INCH CIRCLE	= 2
NUMBER IN TWO INCH CIRCLE	= 6
NUMBER IN THREE INCH CIRCLE	= 8