

C6649111

MODEL 700TM M24

Model SWSTM

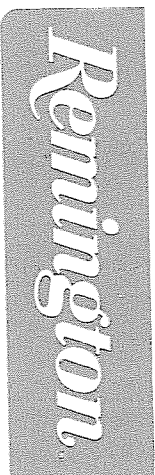
Action

Barrel Length

Capacity

Order No. 5715

*Includes 1 in chamber.






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

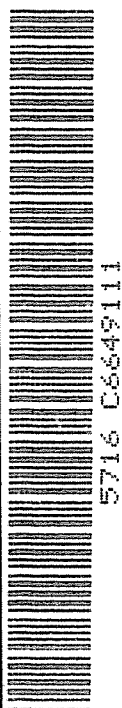
REG. U.S. PAT. & TM. OFF.

MODEL 700™ H24

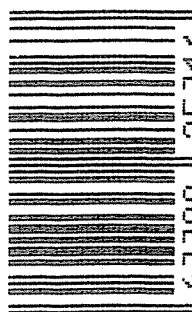
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

SERIAL NO.
C6649111

ORDER NO.
5716



UPC



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6649111

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		7/24/91	KL
600	Proof		7/24/91	KL
607	Check Headspace		7/24/91	KL
610	Dis-assemble Gun		7/24/91	KL
612	Magnaflux Barrel Action		AUG 7 1991	KR
	Magnaflux Bolt		AUG 7 1991	KR
615	Rollmark Caliber		AUG 7 1991	DS
617	Drill and Tap Sight Holes		AUG 7 1991	LB
618	Polish Barrel		AUG 13 1991	WB
620	Apply Coatings (Barrel Action)		7-27-91	KL
	Apply Coating (Bolt)			KL
625	Final Assembly A) Clean inside of Bolt Assembly		9/4/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/4/91	KL
	C) Inspect Ejector Hole for Chamfer		9/4/91	KL
	D) Oil Firing Pin Ass'y		9/4/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		9/10/91	KL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			9/10/91	SM
	G) Safety Off Force	3	3	3			9/10/91	SM
	H) Trigger Pull Test & Retainability						9/10/91	SM
	I) Firing Pin Indent	1022	1022	1022			9/10/91	SM
	J) Assemble Stock						9/12/91	KA
	K) Assemble Swivel Studs						9-13-91	D/H
	L) Attach Front and Rear Sight Assemblies						9/12/91	KA
	M) Iron Sight Alignment						9/12/91	KA
	N) Detach Front & Rear Sights & place in numbered container						9/12/91	KA
	O) Attach Scope to Rifle						9/12/91	KA
	P) Detach & Attach Scope 20 Times						9/12/91	KA
640	Gallery Target & Test						9-13-91	D/H
	A) Time						9-13-91	D/H
	B) Malfunctions						9-13-91	D/H
	C) Pierced Primers						9-13-91	D/H
	D) Optical Clarity of Scope						9-13-91	D/H
645	Inspect for Live Ammo						9-13-91	D/H
655	Final Inspection						9-13-91	D/H
	A) Headspace						9-13-91	D/H
	B) Trigger Pull	258	262	243	250	252	9/13/91	SM
	C) Function						9-13-91	D/H
660	Pack						9-18-91	VF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6649 111

DATE 9/10/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.30	2.58	2.51	2.58	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.36	2.58	2.55	2.62	
PULL #3	2.47	2.53	2.50	2.43	
PULL #4	2.54	2.54	2.56	2.56	
PULL #5	2.57	2.59	2.58	2.52	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.53	3.51		
PULL #2	3.62	3.35		
PULL #3	3.62	3.55		
PULL #4	3.60	3.58		
PULL #5	3.50	3.52		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.27	4.49		4.36
PULL #2	4.31	4.48		4.48
PULL #3	4.43	4.41		4.47
PULL #4	4.49	4.49		4.49
PULL #5	4.41	4.47		4.38
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06649111
13 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.210623
1 TO	2	.323446
1 TO	3	.503051
1 TO	4	.410183
1 TO	5	.156605

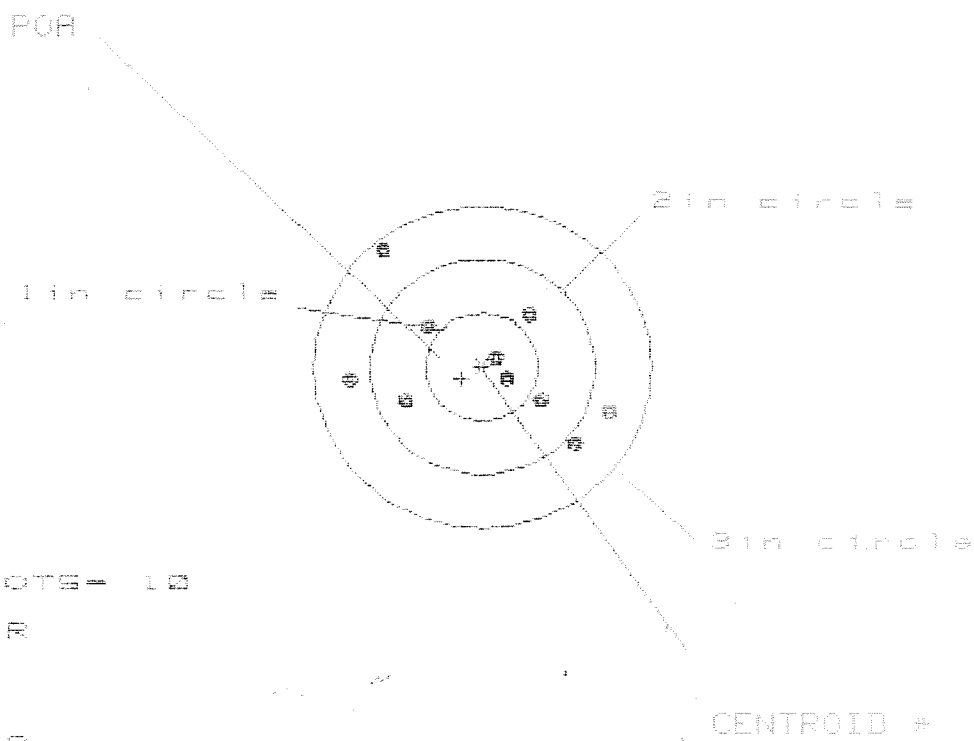
25
3ft <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0292
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1088
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .11265
THE AMR FOR THIS RIFLE IS: .0852

13 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08049111

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 10

HS= 2.235

VS= 1.789

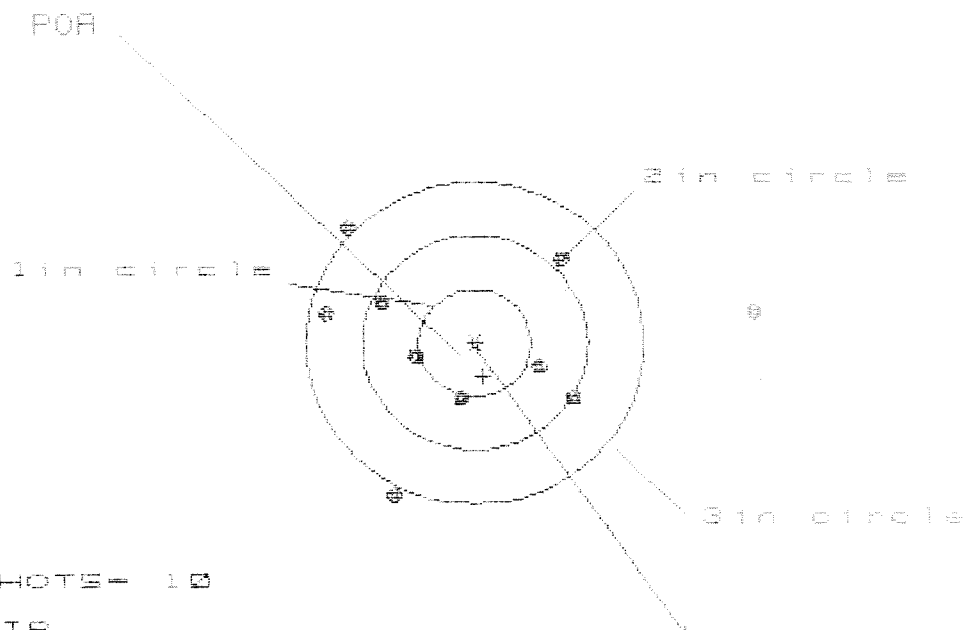
GS= 2.453

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.099	1.001	.828
MINIMUM X	:	-1.136	-1.234	-1.109
MAXIMUM Y	:	1.039	.650	.616
MINIMUM Y	:	-.750	-.635	-.669
CENTROID X	:	.179	.277	.151
CENTROID Y	:	.111	-.004	.030
POA TO CENTROID in.	:	.211	.277	.154
MIN RADIUS	:	.182	.149	.260
MEAN RADIUS	:	.781	.700	.666
MAX RADIUS	:	1.361	1.234	1.110
HORIZONTAL SPREAD	:	2.235	2.235	1.936
VERTICAL SPREAD	:	1.789	1.285	1.285
EXTREME SPREAD	:	2.453	2.250	2.031
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

13 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08649111

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 4

3 in = 7

HE = 3.827

VS = 2.544

GS = 3.827

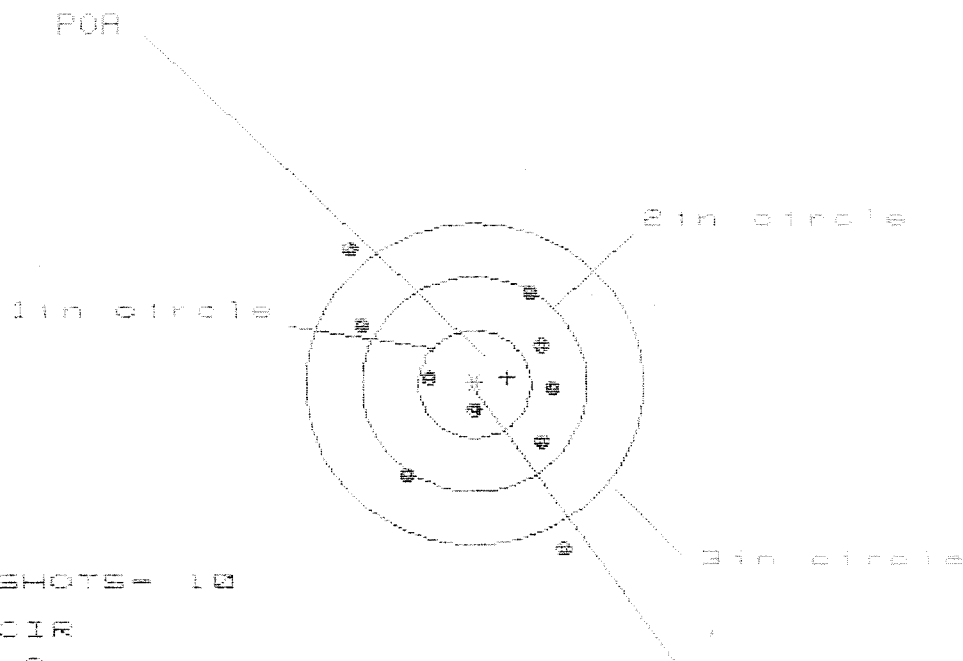
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.472	1.188	1.135
MINIMUM X	:	-1.355	-1.080	-1.133
MAXIMUM Y	:	1.101	1.132	.956
MINIMUM Y	:	-1.444	-1.412	-.655
CENTROID X	:	-.072	-.347	-.295
CENTROID Y	:	.315	.283	.460
POR TO CENTROID in.	:	.323	.448	.546
MIN RADIUS	:	.534	.295	.441
MEAN RADIUS	:	1.186	1.002	.953
MAX RADIUS	:	2.489	1.473	1.325
HORIZONTAL SPREAD	:	3.827	2.268	2.268
VERTICAL SPREAD	:	2.544	2.544	1.610
EXTREME SPREAD	:	3.827	2.667	2.687
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 8

HS = 1.863

VS = 2.750

GS = 3.322

CENTROID #

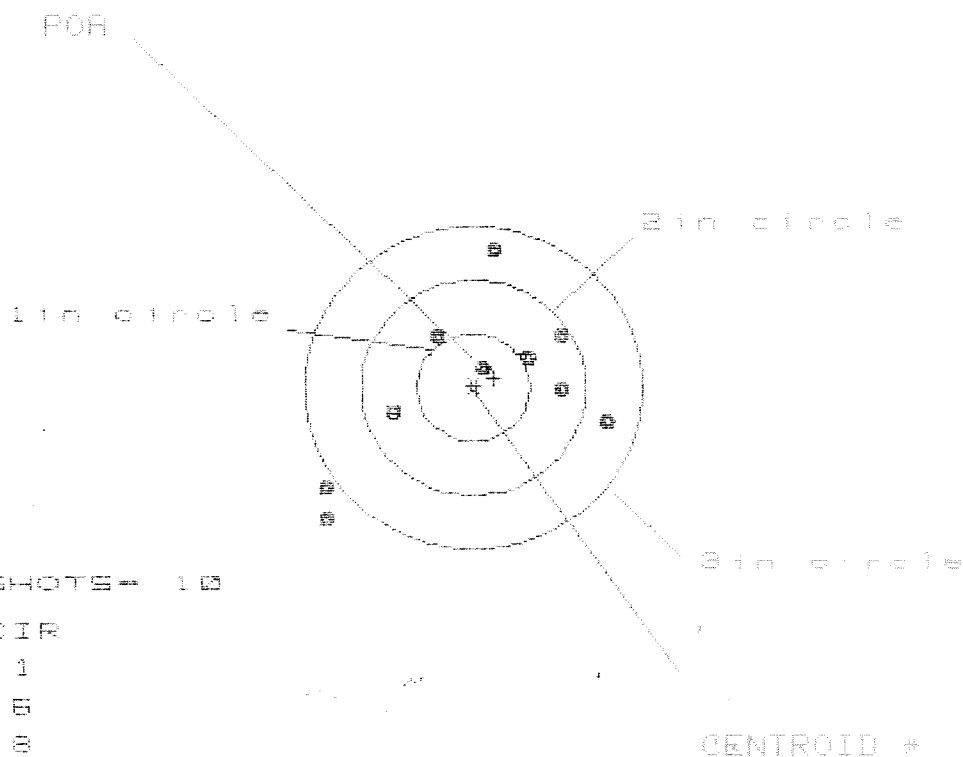
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.751	.779	.658
MINIMUM X	-1.112	-1.028	-1.024
MAXIMUM Y	1.244	1.076	.814
MINIMUM Y	-1.506	-1.005	-.870
CENTROID X	-.293	-.377	-.248
CENTROID Y	-.063	.105	-.030
POA TO CENTROID in.	.300	.391	.250
MIN RADIUS	.256	.352	.289
MEAN RADIUS	.932	.857	.744
MAX RADIUS	1.683	1.489	1.167
HORIZONTAL SPREAD	1.863	1.807	1.674
VERTICAL SPREAD	2.750	2.081	1.684
EXTREME SPREAD	3.322	2.401	2.036
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

13 Sep 1991

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CENTERFIRE PATTERNS

4



OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 8

HS= 2.531

VS= 2.434

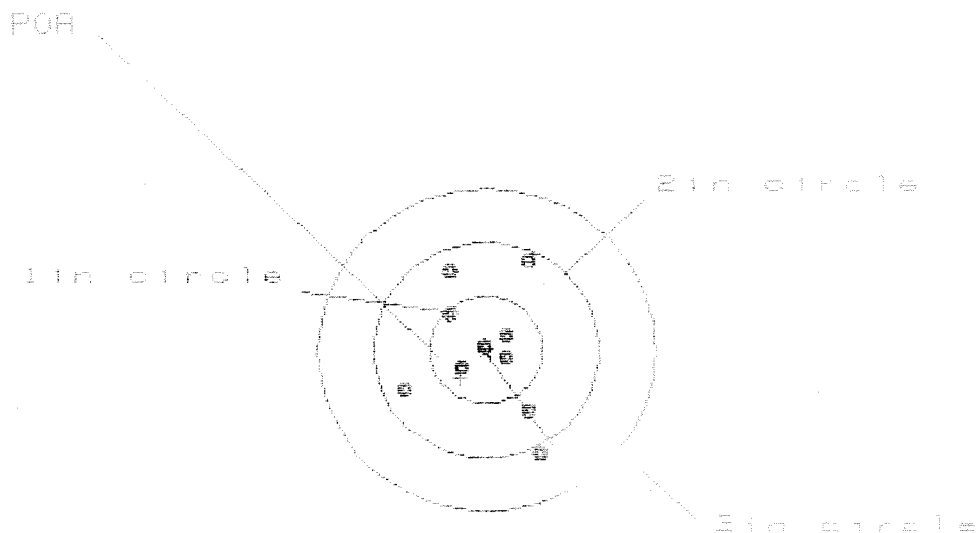
GS= 2.869

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.191	1.046	.860
MINIMUM X	-1.340	-1.485	-1.072
MAXIMUM Y	1.252	1.121	.992
MINIMUM Y	-1.182	-1.029	-.628
CENTROID X	-.184	-.039	.146
CENTROID Y	-.088	.051	.180
POA TO CENTROID in.	.201	.064	.232
MIN RADIUS	.182	.095	.197
MEAN RADIUS	.981	.841	.685
MAX RADIUS	1.753	1.807	1.190
HORIZONTAL SPREAD	2.531	2.531	1.932
VERTICAL SPREAD	2.434	2.150	1.620
EXTREME SPREAD	2.869	2.651	1.935
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

13 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649111

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 5

2in = 8

3in = 10

HS= 1.251

VS= 1.751

GS= 1.874

CENTROID =

PATTERN #		5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.497	.477	.507
MINIMUM X	:	-.764	-.710	-.650
MAXIMUM Y	:	.822	.719	.766
MINIMUM Y	:	-.929	-.712	-.622
CENTROID X	:	.224	.170	.110
CENTROID Y	:	.261	.364	.274
POA TO CENTROID in.	:	.344	.402	.296
MIN RADIUS	:	.042	.115	.078
MEAN RADIUS	:	.546	.496	.439
MAX RADIUS	:	1.049	.863	.803
HORIZONTAL SPREAD	:	1.251	1.187	1.157
VERTICAL SPREAD	:	1.751	1.431	1.399
EXTREME SPREAD	:	1.874	1.658	1.545
NUMBER IN ONE INCH CIRCLE	=	5		
NUMBER IN TWO INCH CIRCLE	=	9		
NUMBER IN THREE INCH CIRCLE	=	10		