

C6649138

MODEL 700™ M24

Model SWS™

Action _____

Barrel Length _____

Capacity _____

Order No. 5715

*Includes 1 in chamber.





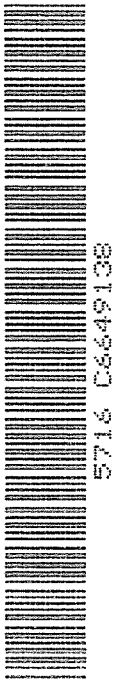

VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700TH H24

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

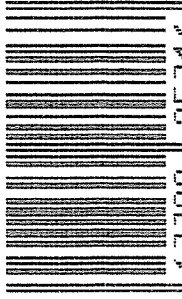
SERIAL NO.
C6649138

ORDER NO.
5716



5716 C6649138

LPC



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649138

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 2	9 1	RW
600	Proof	7 2	9 1	RW
607	Check Headspace	9	9 1	RW
610	Dis-assemble Gun	8	9 1	RW
612	Magnaflux Barrel Action		JUL 22 1991	GS
	Magnaflux Bolt		JUL 22 1991	GS
615	Rollmark Caliber		JUL 22 1991	GS
617	Drill and Tap Sight Holes		JUL 22 1991	LB
618	Polish Barrel		7/22/91	WB
620	Apply Coatings (Barrel Action)		8/23/91	LB
	Apply Coating (Bolt)		8/23/91	LB
625	Final Assembly A) Clean inside of Bolt Assembly		8/28/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/28/91	RW
	C) Inspect Ejector Hole for Chamfer		8/28/91	RW
	D) Oil Firing Pin Ass'y		8/28/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/30/91	SM

op. #	OP. NAME	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	5	5	5	8-30-91	SH		
	G) Safety Off Force	4	4	4	8-30-91	SH		
	H) Trigger Pull Test & Retainability				8/30/91	SH		
	I) Firing Pin Indent	.0225	.0235	.0235	8/30/91	SH		
	J) Assemble Stock				8/31/91	RW		
	K) Assemble Swivel Studs				9-4-91	D/H		
	L) Attach Front and Rear Sight Assemblies				8/31/91	RW		
	M) Iron Sight Alignment				8/31/91	RW		
	N) Detach Front & Rear Sights & place in numbered container				8/31/91	RW		
	O) Attach Scope to Rifle				8/31/91	RW		
	P) Detach & Attach Scope 20 Times				8/31/91	RW		
640	Gallery Target & Test				9-3-91	D/H		
	A) Time				9-3-91	D/H		
	B) Malfunctions				9-3-91	D/H		
	C) Pierced Primers				9-3-91	D/H		
	D) Optical Clarity of Scope				9-3-91	D/H		
645	Inspect for Live Ammo				9-3-91	D/H		
655	Final Inspection				9-4-91	D/H		
	A) Headspace							
	B) Trigger Pull	2.18	2.18	2.25	2.21	2.18	9-3-91	D/H
	C) Function						9-4-91	D/H
660	Pack				9-18-91	N		

SWS TRIGGER PULL TEST

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

SERIAL NO. C 6649138
DATE 8/30/91
TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.31	2.39	2.30	2.18	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.31	2.34	2.23	2.18	
PULL #3	2.48	2.42	2.28	2.25	
PULL #4	2.39	2.51	2.35	2.21	
PULL #5	2.40	2.45	2.38	2.18	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.55	3.39		
PULL #2	3.62	3.38		
PULL #3	3.25	3.38		
PULL #4	3.46	3.35		
PULL #5	3.39	3.46		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.28	4.60		4.57
PULL #2	4.60	4.29		4.39
PULL #3	4.35	4.63		4.51
PULL #4	4.57	4.47		4.44
PULL #5	4.57	4.46		4.31
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06649138
2 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.0659697
1 TO	2	.263837
1 TO	3	.267643
1 TO	4	.343105
1 TO	5	.386929

$\frac{5}{24}$ <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1115
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1142
THE AVERAGE RANGE POI RADIUS FOR THIS RIFLE IS: .1691
THE RNF FOR THIS RIFLE IS: .8392

3 Sep 1931

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CENTERFIRE PATTERNS

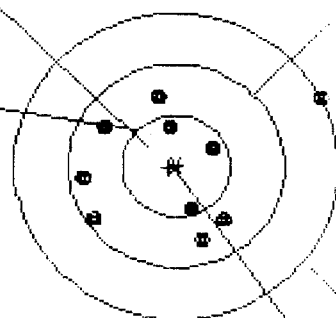
1

POA

1 in circle

2 in circle

3 in circle



CENTROID *

OF SHOTS- 10

IN CIR

1 in - 3

2 in - 9

3 in - 9

HS- 2.187

VS- 1.463

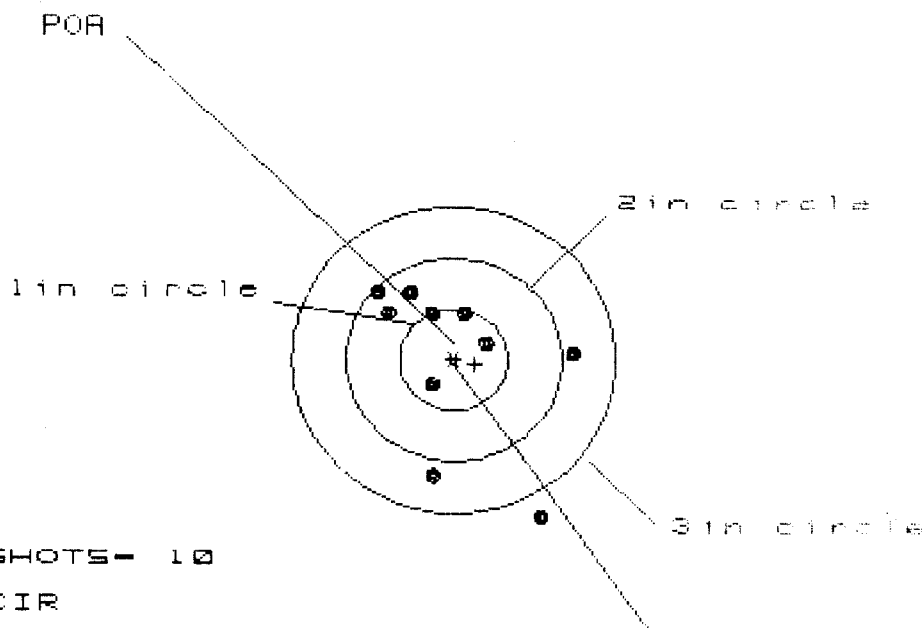
GS- 2.490

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.348	.556	.473
MINIMUM X	-.839	-.689	-.772
MAXIMUM Y	.721	.797	.736
MINIMUM Y	-.742	-.666	-.727
CENTROID X	.064	-.086	-.003
CENTROID Y	.016	-.060	.001
POA TO CENTROID in.	.066	.104	.004
MIN RADIUS	.399	.459	.408
MEAN RADIUS	.761	.672	.641
MAX RADIUS	1.511	.818	.798
HORIZONTAL SPREAD	2.187	1.245	1.245
VERTICAL SPREAD	1.463	1.463	1.463
EXTREME SPREAD	2.490	1.528	1.528
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	9		
NUMBER IN THREE INCH CIRCLE =	9		

3 Sep 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 3

2in = 7

3in = 9

HS = 1.736

VS = 2.208

GS = 2.640

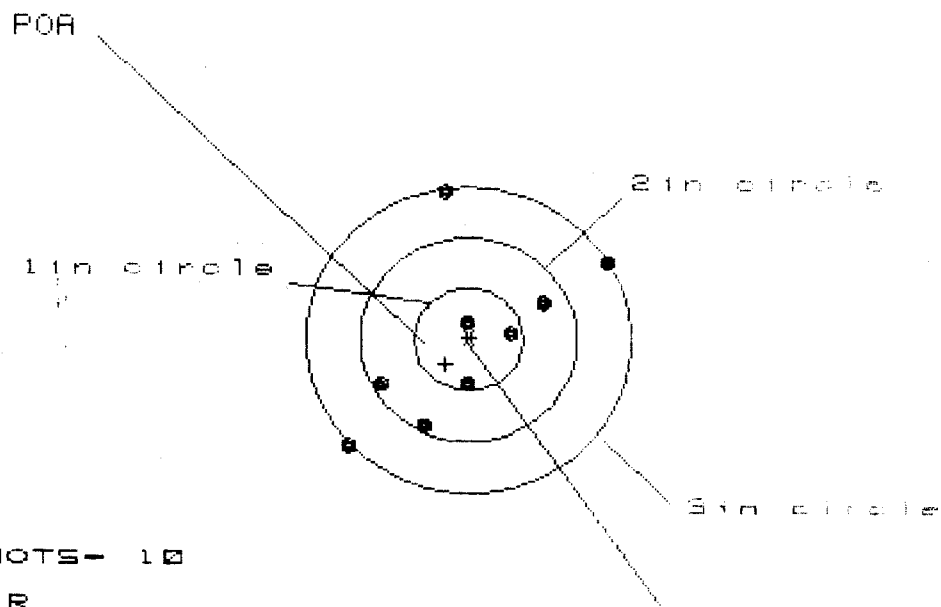
CENTROID +

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.083	1.171	1.163
MINIMUM X	:	-.653	-.565	-.573
MAXIMUM Y	:	.700	.532	.369
MINIMUM Y	:	-1.508	-1.306	-.585
CENTROID X	:	-.199	-.287	-.279
CENTROID Y	:	.037	.205	.368
POA TO CENTROID in.	:	.202	.353	.462
MIN RADIUS	:	.320	.295	.172
MEAN RADIUS	:	.794	.641	.519
MAX RADIUS	:	1.704	1.307	1.188
HORIZONTAL SPREAD	:	1.736	1.736	1.736
VERTICAL SPREAD	:	2.208	1.838	.954
EXTREME SPREAD	:	2.640	1.904	1.842
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 10

HS= 2.353

VS= 2.435

GS= 2.942

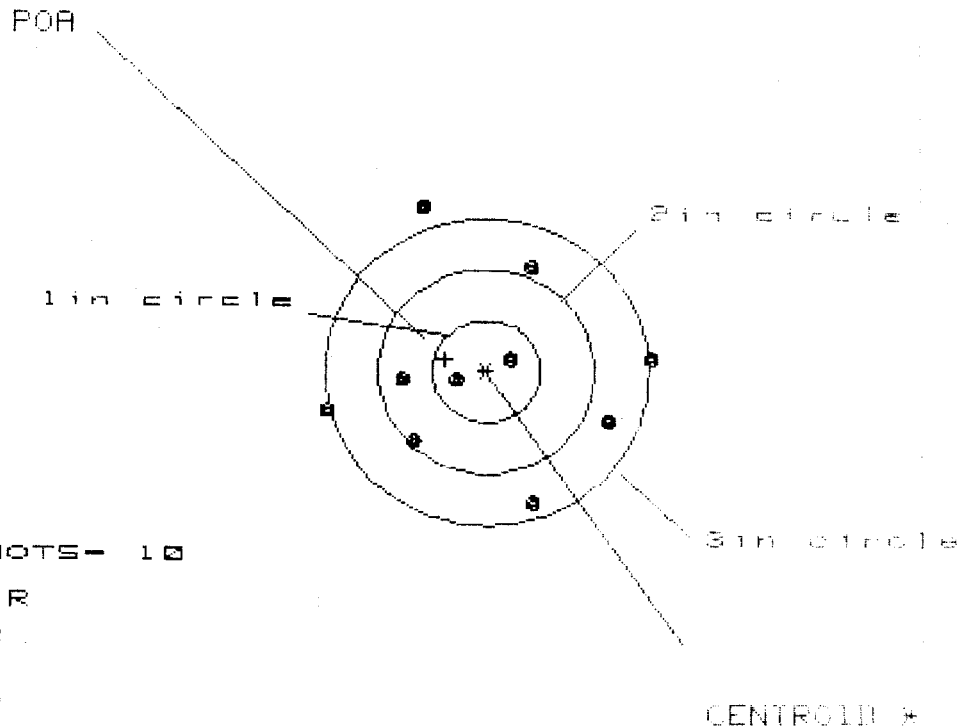
CENTROID #

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.258	1.137	.673
MINIMUM X	:	-1.095	-.928	-.786
MAXIMUM Y	:	1.433	1.322	1.404
MINIMUM Y	:	-1.002	-.943	-.861
CENTROID X	:	.212	.333	.191
CENTROID Y	:	.239	.350	.268
FOR TO CENTROID IN.	:	.319	.483	.329
MIN RADIUS	:	.143	.174	.108
MEAN RADIUS	:	.830	.742	.671
MAX RADIUS	:	1.484	1.368	1.419
HORIZONTAL SPREAD	:	2.353	2.065	1.459
VERTICAL SPREAD	:	2.435	2.265	2.365
EXTREME SPREAD	:	2.942	2.382	2.275
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1in = 2

2in = 4

3in = 7

HS = 2.989

VS = 2.932

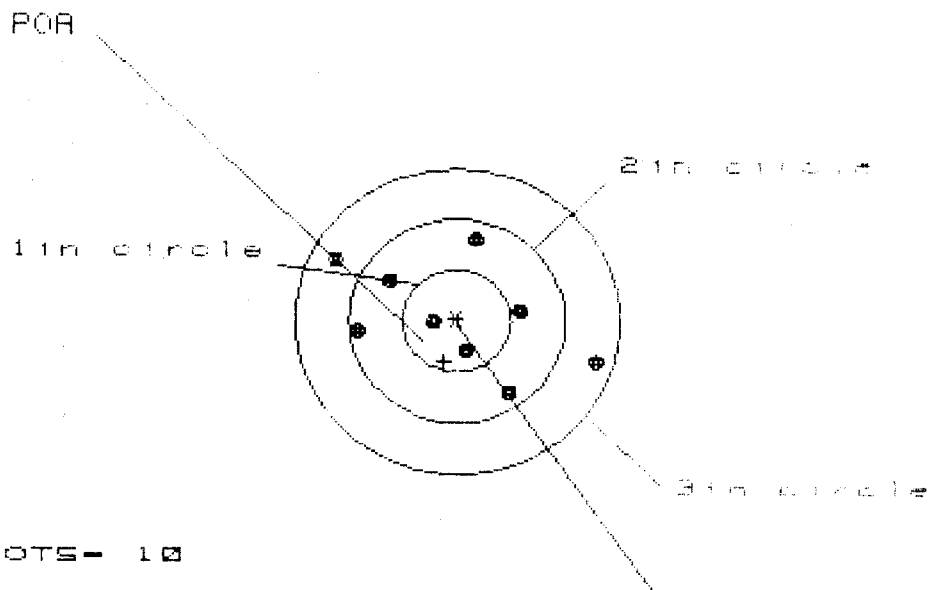
GS = 3.100

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.589	1.443	1.249
MINIMUM X	:	-1.480	-1.546	-1.026
MAXIMUM Y	:	1.625	1.212	1.189
MINIMUM Y	:	-1.307	-1.127	-1.150
CENTROID X	:	.379	.445	.638
CENTROID Y	:	-.120	-.300	-.277
PORA TO CENTROID IN.	:	.398	.537	.696
MIN RADIUS	:	.267	.362	.299
MEAN RADIUS	:	1.080	1.008	.939
MAX RADIUS	:	1.730	1.558	1.280
HORIZONTAL SPREAD	:	2.989	2.989	2.276
VERTICAL SPREAD	:	2.932	2.339	2.339
EXTREME SPREAD	:	3.100	3.029	2.340
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in - 3

2in - 8

3in = 10

HS= 2.362

VS= 1.540

GS= 2.579

CENTROID *

PATTERN #	5		
SHOTS - BEST OF	10	9	8
MAXIMUM X	1.281	.720	.609
MINIMUM X	-1.081	-.939	-.844
MAXIMUM Y	.805	.755	.821
MINIMUM Y	-.735	-.785	-.717
CENTROID X	.119	-.023	.094
CENTROID Y	.399	.449	.311
POA TO CENTROID	.417	.449	.399
MIN RADIUS	.178	.089	.151
MEAN RADIUS	.731	.656	.586
MAX RADIUS	1.356	1.083	.895
HORIZONTAL SPREAD	2.362	1.659	1.447
VERTICAL SPREAD	1.540	1.540	1.540
EXTREME SPREAD	2.579	2.070	1.540
NUMBER IN ONE INCH CIRCLE	=	3	
NUMBER IN TWO INCH CIRCLE	=	8	
NUMBER IN THREE INCH CIRCLE	=	10	