

C6649166

MODEL 700TM M24

Model **SWS** TM

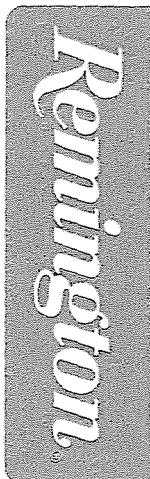
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.






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

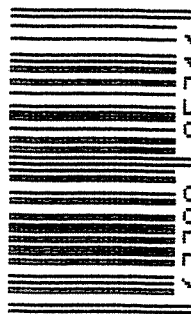
MODEL 700TM H24

SERIAL NO.
C6649166

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 C6649166

06

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6649166

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		8/2/91	KL
600	Proof		8/2/91	KL
607	Check Headspace		8/2/91	KL
610	Dis-assemble Gun		8/2/91	KL
612	Magnaflux Barrel Action		AUG 7 1991	RR
	Magnaflux Bolt		AUG 7 1991	RR
615	Rollmark Caliber		AUG 7 1991	DB
617	Drill and Tap Sight Holes		AUG 7 1991	FB
618	Polish Barrel		AUG 13 1991	WB
620	Apply Coatings (Barrel Action)		8/27/91	KL
	Apply Coating (Bolt)		8/27/91	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	6	6	6	9/10/91	JH		
	G) Safety Off Force	3	3	3	9/10/91	JH		
	H) Trigger Pull Test & Retainability				9/10/91	JH		
	I) Firing Pin Indent	.0205	.0205	.0205	9/10/91	JH		
	J) Assemble Stock				9/11/91	JH		
	K) Assemble Swivel Studs				9-13-91	A		
	L) Attach Front and Rear Sight Assemblies				9/11/91	JH		
	M) Iron Sight Alignment				9/11/91	JH		
	N) Detach Front & Rear Sights & place in numbered container				9/11/91	JH		
	O) Attach Scope to Rifle				9/11/91	JH		
	P) Detach & Attach Scope 20 Times				9/11/91	JH		
640	Gallery Target & Test				9-12-91	AC		
	A) Time				9-12-91	AC		
	B) Malfunctions				9-12-91	AC		
	C) Pierced Primers				9-12-91	AC		
	D) Optical Clarity of Scope				9-12-91	AC		
645	Inspect for Live Ammo				9-12-91	AC		
655	Final Inspection							
	A) Headspace				9-13-91	A		
	B) Trigger Pull	2.64	2.67	2.63	2.63	2.60	9-12-91	DH
	C) Function						9-13-91	A
660	Pack						9-19-91	NF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6649/66
DATE 9-10-91
TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.24	2.50	2.48	2.64	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.20	2.55	2.53	2.67	
PULL #3	2.29	2.60	2.50	2.63	
PULL #4	2.32	2.36	2.38	2.63	
PULL #5	2.31	2.46	2.44	2.60	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.22	3.40		
PULL #2	3.51	3.53		
PULL #3	3.55	3.44		
PULL #4	3.55	3.41		
PULL #5	3.32	3.57		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.41	4.37		4.52
PULL #2	4.60	4.20		4.52
PULL #3	4.55	4.39		4.51
PULL #4	4.36	4.25		4.51
PULL #5	4.52	4.44		4.56
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649166
12 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.414039
1 TO	2	.577313
1 TO	3	.315886
1 TO	4	.862766
1 TO	5	.365437

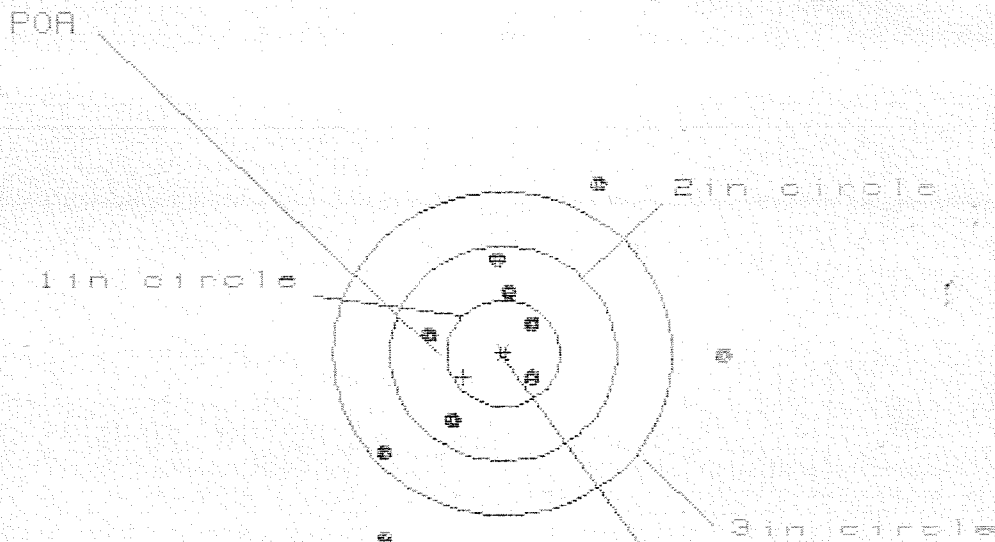
25.1
4 $\leftarrow$ POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0446
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0948
THE AVERAGE POI RADIUS FOR THIS RIFLE IS: .104767
THE AVERAGE POI RADIUS FOR THIS RIFLE IS: 1.013

12 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649166

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 7

HS= 3.035

VS= 3.238

GS= 3.771

PATTERN #

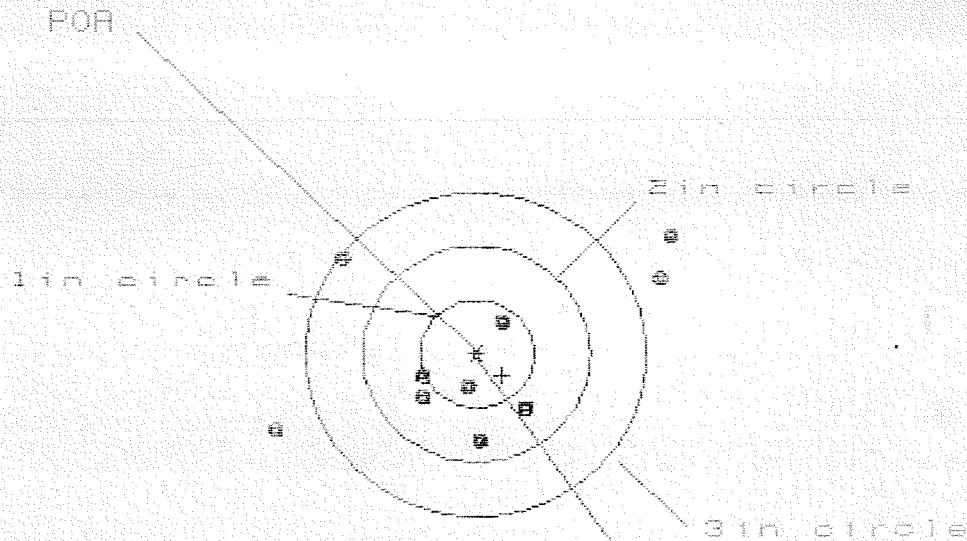
1

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.939	1.820	.974
MINIMUM X	:	-1.096	-1.215	-.987
MAXIMUM Y	:	1.548	1.360	1.338
MINIMUM Y	:	-1.690	-1.129	-1.151
CENTROID X	:	.352	.471	.243
CENTROID Y	:	.218	.406	.428
POA TO CENTROID in.	:	.414	.622	.492
MIN RADIUS	:	.307	.183	.350
MEAN RADIUS	:	1.066	.934	.809
MAX RADIUS	:	2.000	1.828	1.655
HORIZONTAL SPREAD	:	3.035	3.035	1.961
VERTICAL SPREAD	:	3.238	2.489	2.489
EXTREME SPREAD	:	3.771	3.183	3.169
NUMBER IN ONE INCH CIRCLE =	:	2		
NUMBER IN TWO INCH CIRCLE =	:	6		
NUMBER IN THREE INCH CIRCLE =	:	7		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 7

HS= 3.563

VS= 1.881

GS= 4.002

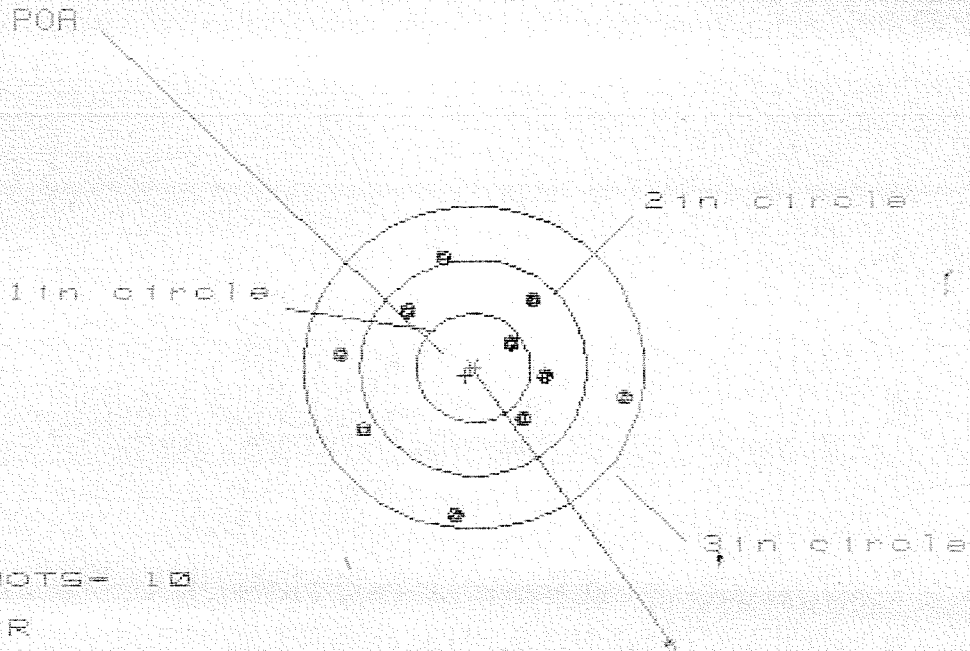
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.770	1.815	1.616
MINIMUM X	:	-1.793	-1.597	-1.218
MAXIMUM Y	:	1.080	.986	.908
MINIMUM Y	:	-.801	-.681	-.759
CENTROID X	:	-.225	-.421	-.222
CENTROID Y	:	.199	.079	.157
POA TO CENTROID in.	:	.300	.429	.272
MIN RADIUS	:	.290	.165	.253
MEAN RADIUS	:	1.059	.899	.813
MAX RADIUS	:	2.073	1.976	1.762
HORIZONTAL SPREAD	:	3.563	3.412	2.834
VERTICAL SPREAD	:	1.881	1.667	1.667
EXTREME SPREAD	:	4.002	3.689	2.841
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 2.443

VS= 2.443

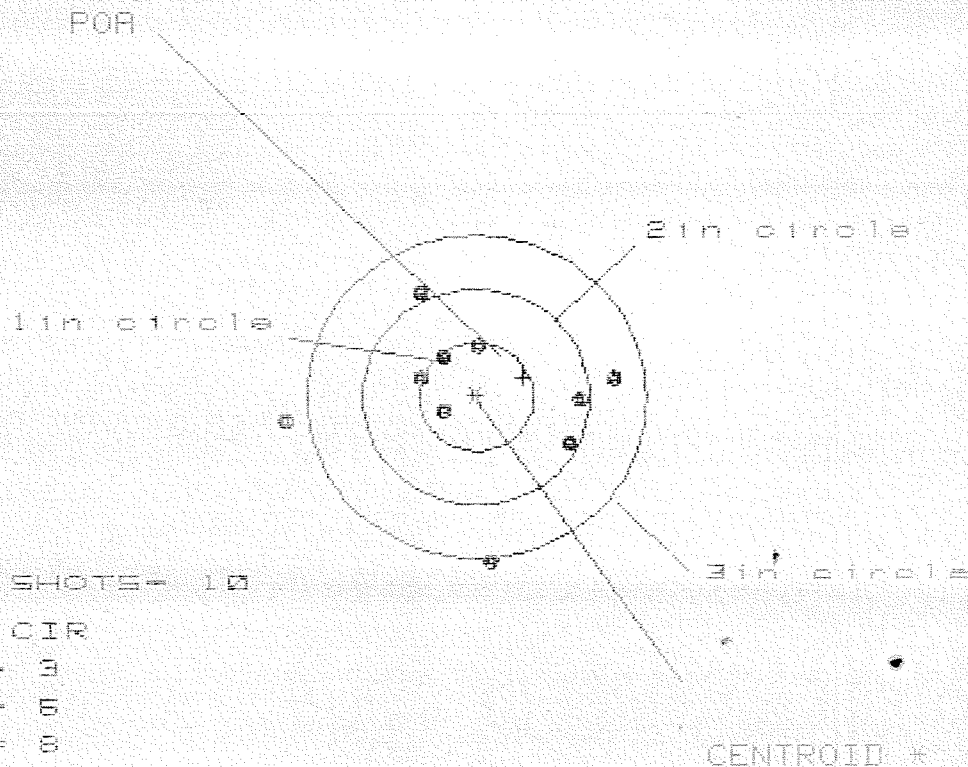
GS= 2.469

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.316	1.292	.736
MINIMUM X	:	-1.127	-1.151	-.989
MAXIMUM Y	:	1.052	.897	.850
MINIMUM Y	:	-1.391	-.746	-.793
CENTROID X	:	.074	.098	-.064
CENTROID Y	:	.068	.223	.270
POA TO CENTROID in.	:	.101	.244	.278
MIN RADIUS	:	.445	.347	.493
MEAN RADIUS	:	.945	.870	.815
MAX RADIUS	:	1.408	1.346	1.178
HORIZONTAL SPREAD	:	2.443	2.443	1.725
VERTICAL SPREAD	:	2.443	1.643	1.643
EXTREME SPREAD	:	2.469	2.469	1.967
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 8

HS= 2.860

VS= 2.494

GS= 2.889

PATTERN #

4

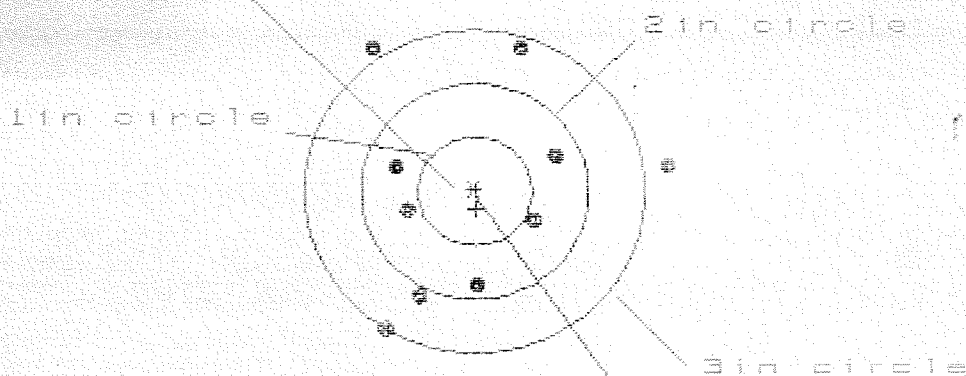
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.224	1.042	1.031
MINIMUM X	-1.636	-1.667	-1.678
MAXIMUM Y	.989	.967	.777
MINIMUM Y	-1.505	-1.527	-1.585
CENTROID X	-.414	-.232	-.221
CENTROID Y	-.179	-.157	.034
POR TO CENTROID in.	.451	.280	.224
MIN RADIUS	.250	.431	.298
MEAN RADIUS	.902	.823	.710
MAX RADIUS	1.648	1.529	1.031
HORIZONTAL SPREAD	2.860	1.709	1.709
VERTICAL SPREAD	2.494	2.494	1.361
EXTREME SPREAD	2.889	2.561	1.912
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

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CENTERFIRE PATTERNS # 5

POA



OF SHOTS= 10

IN CIR

1in = 0

2in = 5

3in = 7

HS= 2.666

VS= 2.663

GS= 2.918

CENTROID #

PATTERN #

5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.744	.918	.827
MINIMUM X	-.922	-.729	-.663
MAXIMUM Y	1.372	1.394	1.531
MINIMUM Y	-1.291	-1.269	-1.094
CENTROID X	-.010	-.203	-.112
CENTROID Y	.168	.146	-.029
POA TO CENTROID in.	.168	.250	.116
MIN RADIUS	.572	.410	.456
MEAN RADIUS	1.093	.998	.902
MAX RADIUS	1.755	1.573	1.620
HORIZONTAL SPREAD	2.666	1.647	1.490
VERTICAL SPREAD	2.663	2.663	2.625
EXTREME SPREAD	2.918	2.883	2.983
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		7	