

C6649251

MODEL 700™ M24

Model **SWS**™

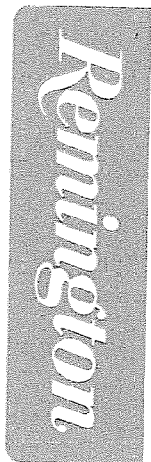
Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.






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

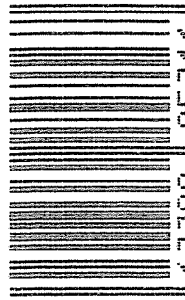
MODEL 700TM H24

SERIAL NO. C6649251

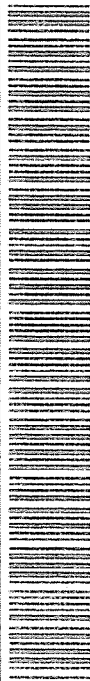
ORDER NO. 5716

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

UPC



0 47700 25716 7



5716 C6649251

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649251

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 25	9 1	RW
600	Proof	6 25	9 1	RW
607	Check Headspace	6 25	9 1	RW
610	Dis-assemble Gun	6 25	9 1	RW
612	Magnaflux Barrel Action		JUL 1 1991	KR
	Magnaflux Bolt		JUL 1 1991	KR
615	Rollmark Caliber		JUL 1 1991	JS
617	Drill and Tap Sight Holes		JUL 1 1991	LB
618	Polish Barrel		JUL 2 1991	WB
620	Apply Coatings (Barrel Action)		8-7-91	AA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/27/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/27/91	RW
	C) Inspect Ejector Hole for Chamfer		8/27/91	RW
	D) Oil Firing Pin Ass'y		8/27/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/27/91	RW

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8/28/91	JK
	G) Safety Off Force	3	3	3			8/28/91	JK
	H) Trigger Pull Test & Retainability						8/27/91	JK
	I) Firing Pin Indent	0225	021	022			8/28/91	JK
	J) Assemble Stock						8/28/91	RW
	K) Assemble Swivel Studs						8-31-91	D/H
	L) Attach Front and Rear Sight Assemblies						8/28/91	RW
	M) Iron Sight Alignment						8/28/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/28/91	RW
	O) Attach Scope to Rifle						8/28/91	RW
	P) Detach & Attach Scope 20 Times						8/28/91	RW
640	Gallery Target & Test						8/28/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						8/28/91	KT
655	Final Inspection							
	A) Headspace						8-31-91	D/H
	B) Trigger Pull	2.32	2.30	2.23	2.53	2.41	8/29/91	JK
	C) Function						8-31-91	D/H
660	Pack						7-18-91	D/H

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6649251
DATE 8/27/91
TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.22	2.27	2.33	2.52	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.43	2.34	2.21	2.30	
PULL #3	2.35	2.25	2.38	2.23	
PULL #4	2.26	2.36	2.44	2.53	
PULL #5	2.35	2.31	2.36	2.41	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.42	3.54		
PULL #2	3.40	3.57		
PULL #3	3.60	3.49		
PULL #4	3.51	3.52		
PULL #5	3.60	3.55		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.29	4.35		4.49
PULL #2	4.41	4.25		4.48
PULL #3	4.40	4.41		4.22
PULL #4	4.24	4.40		4.19
PULL #5	4.38	4.35		4.27
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649251
29 Aug 1991

CENTROIDAL DISTANCES

0 TO 1	.184092
1 TO 2	.312554
1 TO 3	.0431045
1 TO 4	.0902109
1 TO 5	.00412311

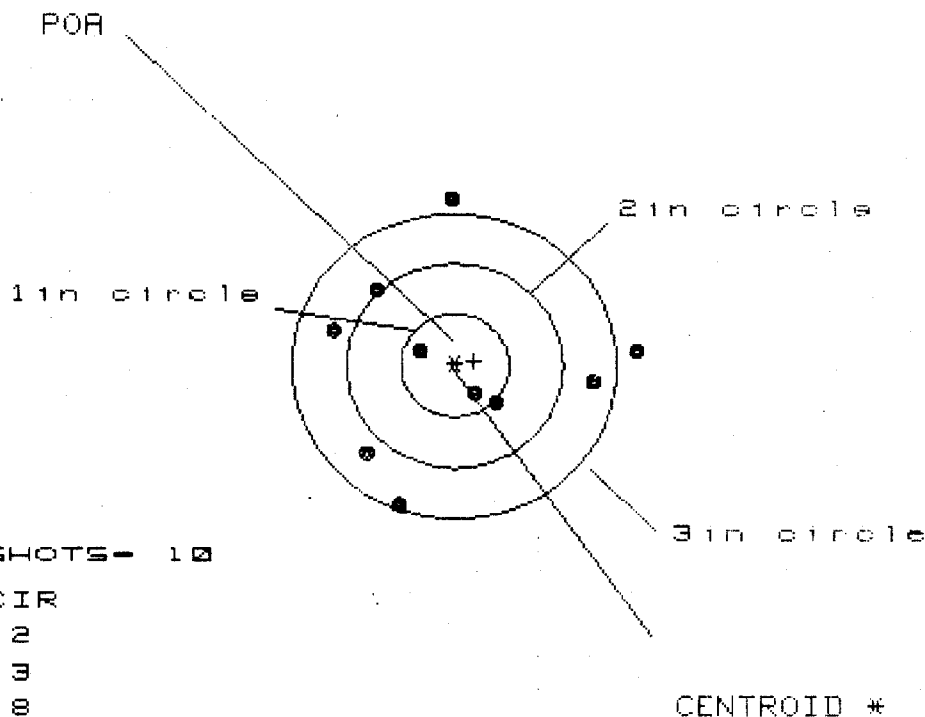
231 <----PQR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2356
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0434
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .239564
THE DCR FOR THIS RIFLE IS: 1.06

25 Aug 1981

FILE:/PATTERNING/CENTERFIRE_PATT/C8649251

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 3

3in = 8

HS= 2.848

VS= 3.019

GS= 3.058

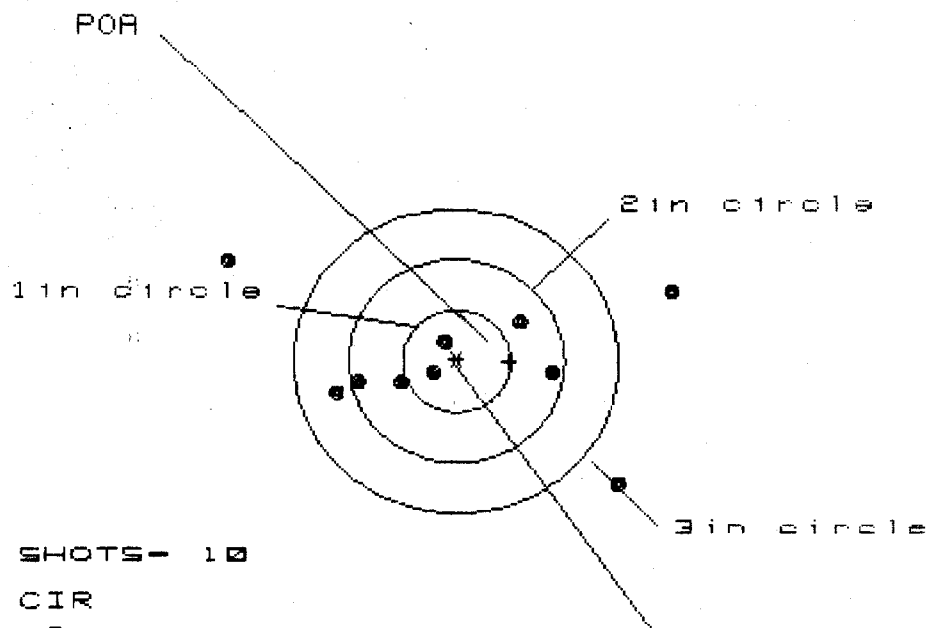
CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.679	1.514	1.537
MINIMUM X	-1.169	-.982	-.959
MAXIMUM Y	1.621	1.641	.993
MINIMUM Y	-1.398	-1.378	-1.173
CENTROID X	-.179	-.366	-.389
CENTROID Y	-.043	-.063	-.268
POR TO CENTROID in.	.184	.371	.472
MIN RADIUS	.315	.211	.358
MEAN RADIUS	1.075	.989	.898
MAX RADIUS	1.689	1.651	1.538
HORIZONTAL SPREAD	2.848	2.496	2.496
VERTICAL SPREAD	3.019	3.019	2.166
EXTREME SPREAD	3.058	3.058	2.543
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =			8

29 Aug 1991

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CENTERFIRE PATTERNS # 2



* OF SHOTS- 10

* IN CIR

1in = 2

2in = 6

3in = 7

HS= 4.055

VS= 2.108

GS= 4.199

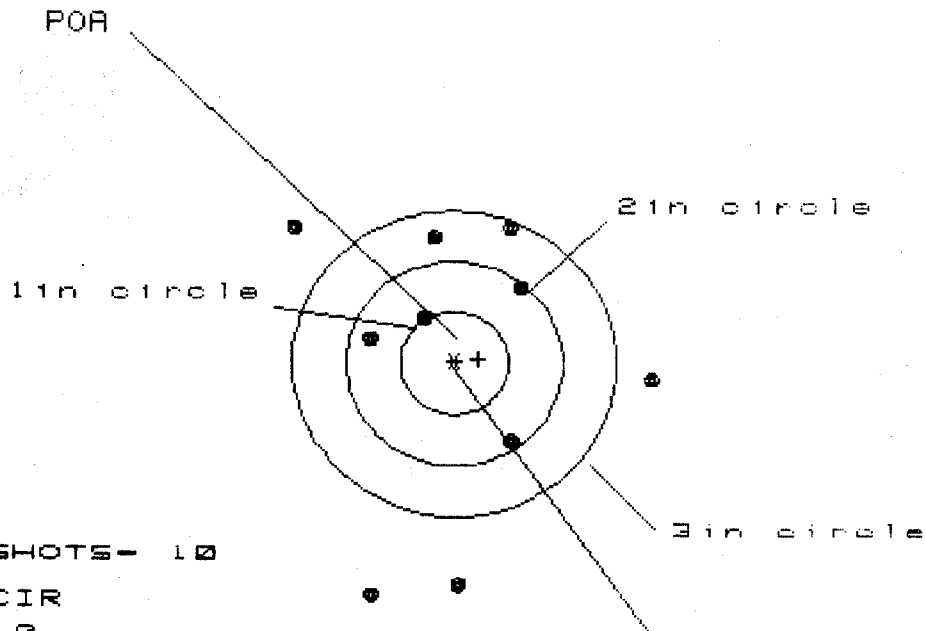
CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.955	1.722	1.513
MINIMUM X	:	-2.100	-1.297	-1.082
MAXIMUM Y	:	.948	.754	.588
MINIMUM Y	:	-1.160	-1.055	-.961
CENTROID X	:	-.488	-.255	-.470
CENTROID Y	:	.004	-.101	-.195
POA TO CENTROID in.	:	.488	.274	.509
MIN RADIUS	:	.167	.394	.226
MEAN RADIUS	:	1.089	.985	.829
MAX RADIUS	:	2.304	1.880	1.792
HORIZONTAL SPREAD	:	4.055	3.019	2.595
VERTICAL SPREAD	:	2.108	1.809	1.549
EXTREME SPREAD	:	4.199	3.165	2.734
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	7		

29 Aug 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 6

HS= 3.292

VS= 3.611

GS= 3.836

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.777	1.696	1.693
MINIMUM X	-1.515	-1.596	-1.599
MAXIMUM Y	1.345	1.093	.792
MINIMUM Y	-2.266	-2.410	-1.303
CENTROID X	-.222	-.141	-.138
CENTROID Y	-.040	.212	.513
POA TO CENTROID in.	.226	.254	.531
MIN RADIUS	.561	.456	.422
MEAN RADIUS	1.435	1.276	1.075
MAX RADIUS	2.381	2.410	1.854
HORIZONTAL SPREAD	3.292	3.292	3.292
VERTICAL SPREAD	3.611	3.503	2.095
EXTREME SPREAD	3.836	3.808	3.623
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	6		

29 Aug 1991

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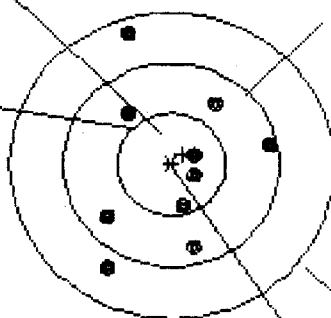
CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle



OF SHOTS- 10

IN CIR

1 in - 3

2 in - 8

3 in - 10

HS- 1.490

VS= 2.275

GS= 2.281

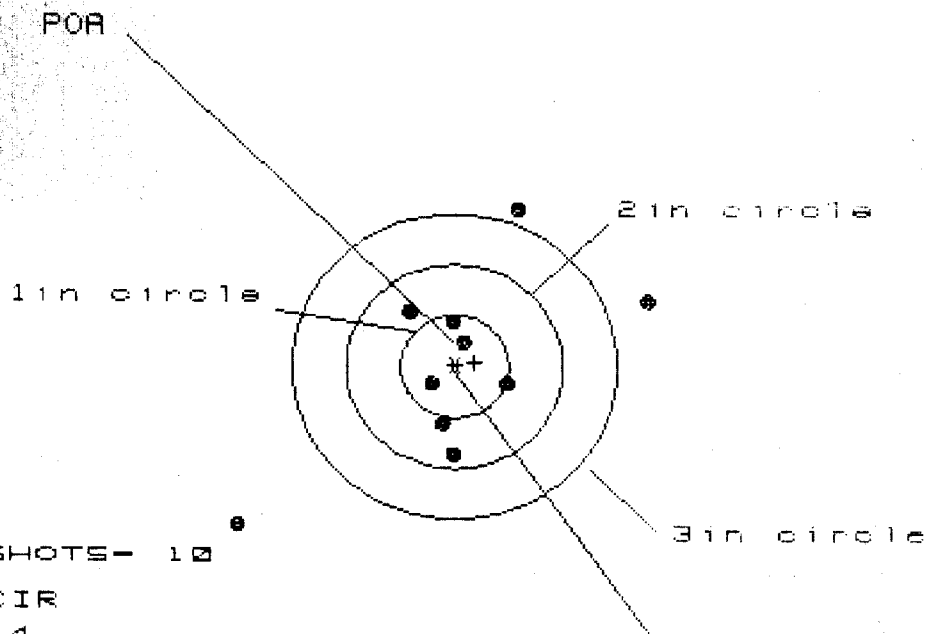
CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.898	.854	.779
MINIMUM X	:	-.592	-.636	-.711
MAXIMUM Y	:	1.303	.737	.634
MINIMUM Y	:	-.972	-.827	-.742
CENTROID X	:	-.106	-.062	.013
CENTROID Y	:	-.096	-.241	-.138
POA TO CENTROID in.	:	.143	.249	.138
MIN RADIUS	:	.216	.129	.105
MEAN RADIUS	:	.729	.634	.573
MAX RADIUS	:	1.361	1.021	.875
HORIZONTAL SPREAD	:	1.490	1.490	1.490
VERTICAL SPREAD	:	2.275	1.564	1.376
EXTREME SPREAD	:	2.281	1.890	1.686
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

28 Aug (94)

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 7

HS= 3.884

VS= 3.116

GS= 4.466

CENTROID #

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.829	1.600	.544
MINIMUM X	:	-2.055	-.685	-.485
MAXIMUM Y	:	1.525	1.349	1.403
MINIMUM Y	:	-1.591	-1.075	-1.021
CENTROID X	:	-.183	.046	-.154
CENTROID Y	:	-.042	.134	.080
POR TO CENTROID in.	:	.188	.142	.174
MIN RADIUS	:	.248	.188	.123
MEAN RADIUS	:	.974	.804	.644
MAX RADIUS	:	2.599	1.659	1.505
HORIZONTAL SPREAD	:	3.884	2.285	1.029
VERTICAL SPREAD	:	3.116	2.424	2.424
EXTREME SPREAD	:	4.466	2.495	2.495
NUMBER IN ONE INCH CIRCLE =	:	4	7	7
NUMBER IN TWO INCH CIRCLE =	:	7	7	7
NUMBER IN THREE INCH CIRCLE =	:	7	7	7