

C6649288

MODEL 700™ M24

Model **SWS**™

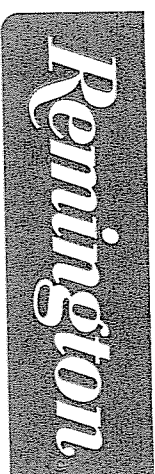
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.





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



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

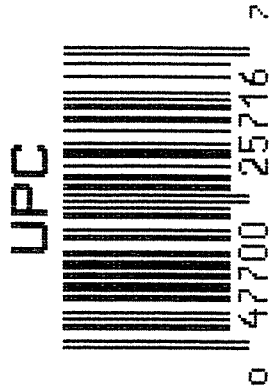
MODEL 700TM H24

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

SERIAL NO.
C6649288

ORDER NO.
5716

20



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649288

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 27 9 1		RW
600	Proof	6 27 9 1		RW
607	Check Headspace	6 27 9 1		RW
610	Dis-assemble Gun	6 27 9 1		RW
612	Magnaflux Barrel Action	1 JUL	2 1991	KR
	Magnaflux Bolt	1 JUL	2 1991	KR
615	Rollmark Caliber	1 JUL	2 1991	GS
617	Drill and Tap Sight Holes	1 JUL	2 1991	FB
618	Polish Barrel	JUL 1	7 1991	WB
620	Apply Coatings (Barrel Action)		7-22-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/23/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/23/91	RW
	C) Inspect Ejector Hole for Chamfer		7/23/91	RW
	D) Oil Firing Pin Ass'y		7/23/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8-7-91	GU

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7	7	7			8-7-91	DH
	G) Safety Off Force	3 $\frac{1}{2}$	3 $\frac{1}{4}$	3 $\frac{1}{4}$			8-7-91	DH
	H) Trigger Pull Test & Retainability						8-7-91	SH
	I) Firing Pin Indent	.020	.021	.020			8-7-91	DH
	J) Assemble Stock						8/10/91	RW
	K) Assemble Swivel Studs						8-13-91	DH
	L) Attach Front and Rear Sight Assemblies						8/10/91	RW
	M) Iron Sight Alignment						8/10/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/10/91	RW
	O) Attach Scope to Rifle						8/10/91	RW
	P) Detach & Attach Scope 20 Times						8/10/91	RW
640	Gallery Target & Test						8-12-91	DH
	A) Time						8-12-91	DH
	B) Malfunctions						8-12-91	DH
	C) Pierced Primers						8-12-91	DH
	D) Optical Clarity of Scope						8-12-91	DH
645	Inspect for Live Ammo						8-12-91	DH
655	Final Inspection						8-13-91	DH
	A) Headspace						8-13-91	DH
	B) Trigger Pull	2.28	2.19	2.21	2.22	2.23	8-13-91	DH
	C) Function						8-13-91	DH
660	Pack						9-19-91	AF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6649288

DATE 8-7-91

TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.42	2.25	2.50	2.28	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.45	2.42	2.48	2.19	
PULL #3	2.43	2.49	2.44	2.21	
PULL #4	2.46	2.48	2.51	2.22	
PULL #5	2.37	2.47	2.35	2.23	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.40	3.43		
PULL #2	3.35	3.52		
PULL #3	3.46	3.54		
PULL #4	3.36	3.39		
PULL #5	3.43	3.49		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.20	4.33		4.44
PULL #2	4.43	4.24		4.48
PULL #3	4.69	4.32		4.39
PULL #4	4.29	4.36		4.25
PULL #5	4.30	4.36		4.36
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649288
12 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.157648
1 TO	2	.0386005
1 TO	3	.262667
1 TO	4	.067897
1 TO	5	.212659

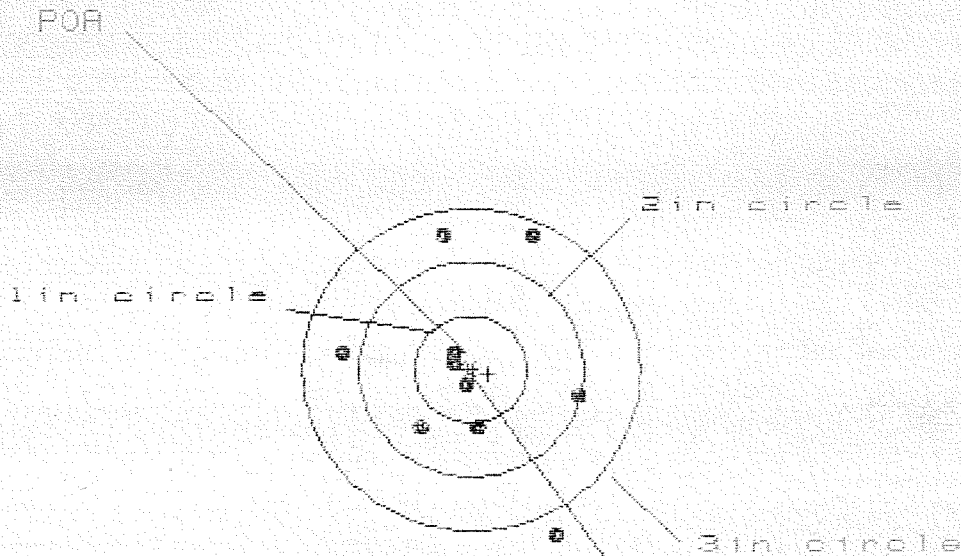
 <----POI

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2056
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1062
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .231400
THE AMR FOR THIS RIFLE IS: .8866

12 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649288

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 5

3 in = 9

HS= 2.151

VS= 2.858

GS= 3.016

CENTROID +

PATTERN #

1

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.995

1.074

1.148

MINIMUM X

-1.156

-1.077

-1.003

MAXIMUM Y

1.290

1.116

1.247

MINIMUM Y

-1.568

-1.732

-1.601

CENTROID X

-1.153

-1.232

-1.306

CENTROID Y

.038

.212

.081

POA TO CENTROID in.

.158

.315

.316

MIN RADIUS

.094

.076

.046

MEAN RADIUS

.833

.731

.635

MAX RADIUS

1.722

1.208

1.251

HORIZONTAL SPREAD

2.151

2.151

2.151

VERTICAL SPREAD

2.858

1.848

1.948

EXTREME SPREAD

3.016

2.189

2.189

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

5

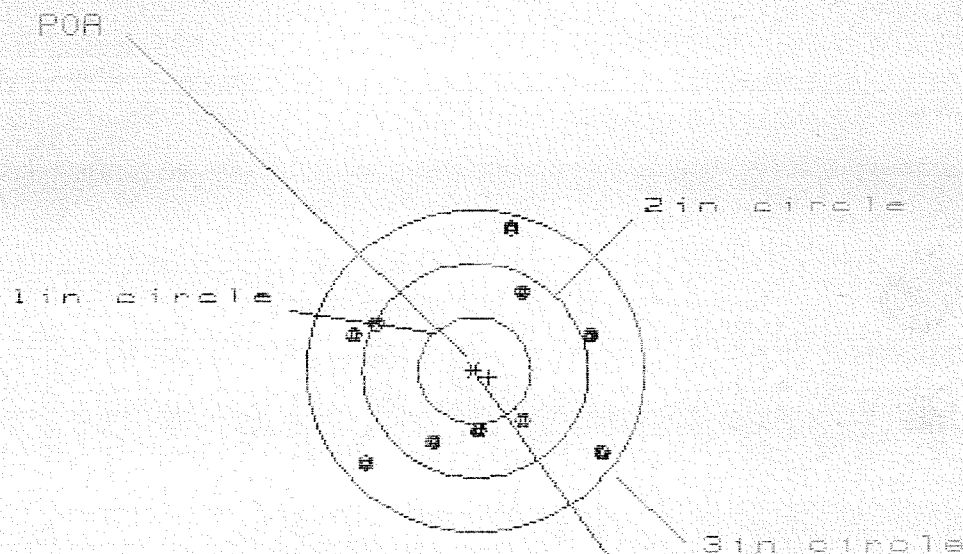
NUMBER IN THREE INCH CIRCLE =

9

12 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/056492B8

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 4

3 in = 10

HS = 2.149

VS = 2.248

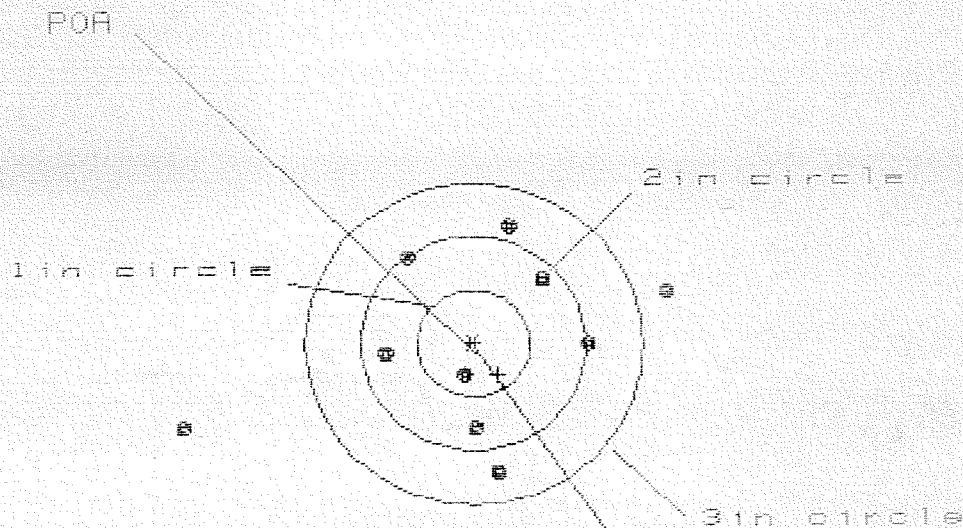
GS = 2.564

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.116	1.149	1.236
MINIMUM X	:	-1.033	-1.000	-0.856
MAXIMUM Y	:	1.354	.924	.848
MINIMUM Y	:	-.894	-.743	-.819
CENTROID X	:	-.122	-.155	-.299
CENTROID Y	:	.061	-.090	-.015
POR TO CENTROID in.	:	.137	.179	.299
MIN RADIUS	:	.534	.390	.511
MEAN RADIUS	:	1.001	.932	.887
MAX RADIUS	:	1.386	1.297	1.311
HORIZONTAL SPREAD	:	2.149	2.149	2.092
VERTICAL SPREAD	:	2.248	1.667	1.667
EXTREME SPREAD	:	2.564	2.409	2.360
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

12 Aug 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 1

2in = 6

3in = 8

HS = 4.243

VS = 2.246

GS = 4.434

CENTROID *

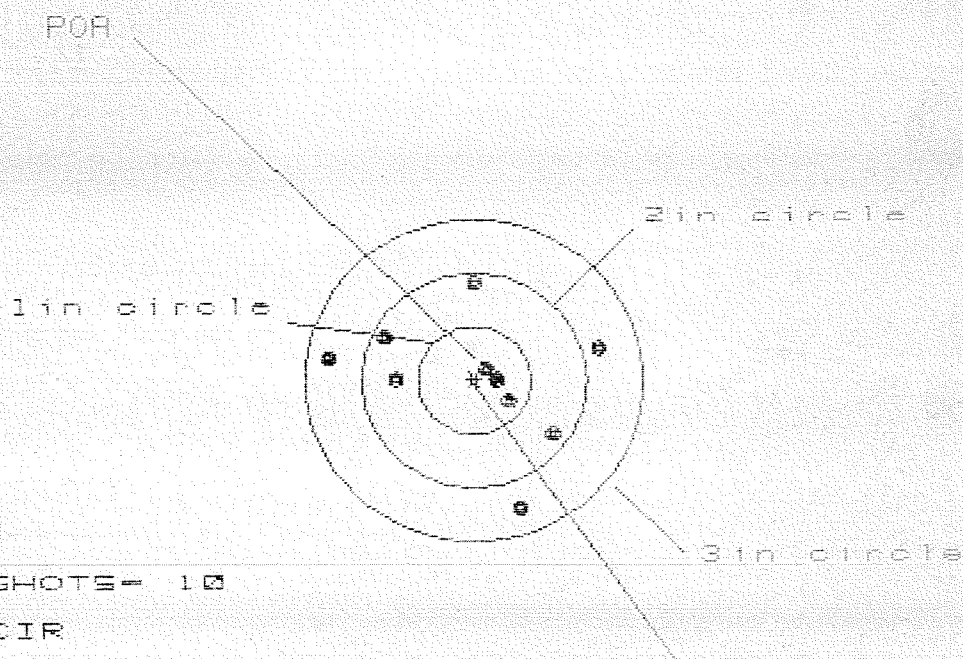
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.694	1.411	.885
MINIMUM X	:	-2.549	-1.018	-.841
MAXIMUM Y	:	1.072	.986	1.039
MINIMUM Y	:	-1.174	-1.260	-1.207
CENTROID X	:	-.216	.067	-.109
CENTROID Y	:	.293	.379	.326
POA TO CENTROID in.	:	.364	.385	.344
MIN RADIUS	:	.259	.481	.330
MEAN RADIUS	:	1.135	.951	.865
MAX RADIUS	:	2.664	1.473	1.214
HORIZONTAL SPREAD	:	4.243	2.429	1.726
VERTICAL SPREAD	:	2.246	2.246	2.246
EXTREME SPREAD	:	4.434	2.499	2.248
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS

4



OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 2.400

VS= 2.128

GS= 2.403

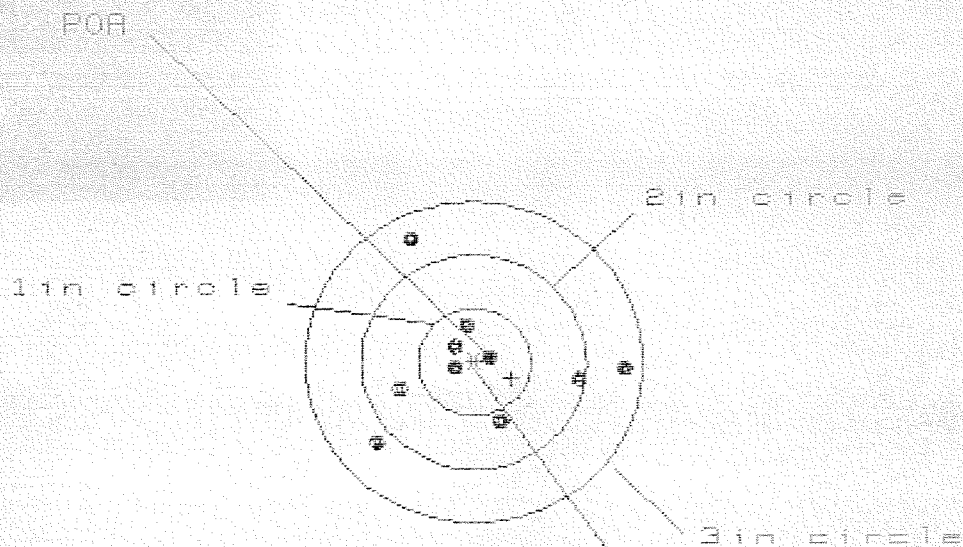
CENTROID #

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.053	.903	.936
MINIMUM X	:	-1.347	-.906	-.873
MAXIMUM Y	:	.911	.931	.782
MINIMUM Y	:	-1.217	-1.197	-.634
CENTROID X	:	-.202	-.052	-.085
CENTROID Y	:	-.009	-.029	.120
POA TO CENTROID in.	:	.202	.060	.147
MIN RADIUS	:	.112	.079	.063
MEAN RADIUS	:	.776	.681	.619
MAX RADIUS	:	1.360	1.225	.950
HORIZONTAL SPREAD	:	2.400	1.809	1.809
VERTICAL SPREAD	:	2.128	2.128	1.416
EXTREME SPREAD	:	2.403	2.168	1.812
NUMBER IN ONE INCH CIRCLE =	:		3	
NUMBER IN TWO INCH CIRCLE =	:		7	
NUMBER IN THREE INCH CIRCLE =	:		10	

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FILE:/PATTERNING/CENTERFIRE_PATT/C86452B8

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 4

2in = 7

3in = 10

HS= 2.274

VS= 1.839

GS= 2.385

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.377	1.050	.994
MINIMUM X	:	-.897	-.743	-.799
MAXIMUM Y	:	1.106	1.105	.463
MINIMUM Y	:	-.733	-.734	-.596
CENTROID X	:	-.335	-.488	-.432
CENTROID Y	:	.148	.149	.011
POA TO CENTROID in.	:	.366	.510	.432
MIN RADIUS	:	.162	.035	.146
MEAN RADIUS	:	.688	.593	.538
MAX RADIUS	:	1.378	1.191	.997
HORIZONTAL SPREAD	:	2.274	1.793	1.793
VERTICAL SPREAD	:	1.839	1.839	1.059
EXTREME SPREAD	:	2.385	1.942	1.891
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	