

C6649290

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.

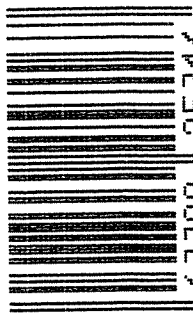
MODEL 700TM H24

SERIAL NO.
C6649290

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 C6649290

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649290

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	7 2 9 1		RW
610	Dis-assemble Gun	7 2 9 1		RW
612	Magnaflux Barrel Action		JUL 22 1991	JS
	Magnaflux Bolt		JUL 22 1991	JS
615	Rollmark Caliber		JUL 22 1991	JS
617	Drill and Tap Sight Holes		JUL 22 1991	LB
618	Polish Barrel		7/22/91	WB
620	Apply Coatings (Barrel Action)		8-2-91	JS
	Apply Coating (Bolt)		8-2-91	JS
625	Final Assembly A) Clean inside of Bolt Assembly		8/9/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/9/91	RW
	C) Inspect Ejector Hole for Chamfer		8/9/91	RW
	D) Oil Firing Pin Ass'y		8/9/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8-15-91	JH

Op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8-15-91	JH
	G) Safety Off Force	3	3	3			8-15-91	JH
	H) Trigger Pull Test & Retainability						8-15-91	JH
	I) Firing Pin Indent	0205	0205	020			8-15-91	JH
	J) Assemble Stock						8-16-91	RW
	K) Assemble Swivel Studs						8-17-91	D/H
	L) Attach Front and Rear Sight Assemblies						8-16-91	RW
	M) Iron Sight Alignment						8-16-91	RW
	N) Detach Front & Rear Sights & place in numbered container						8-16-91	RW
	O) Attach Scope to Rifle						8-16-91	RW
	P) Detach & Attach Scope 20 Times						8-16-91	RW
640	Gallery Target & Test						8-16-91	AC
	A) Time						8-16-91	AC
	B) Malfunctions						8-16-91	AC
	C) Pierced Primers						8-16-91	AC
	D) Optical Clarity of Scope						8-16-91	AC
645	Inspect for Live Ammo						8-16-91	AC
655	Final Inspection						8-17-91	D/H
	A) Headspace						8-17-91	D/H
	B) Trigger Pull	266	2.78	2.78	2.78	2.42	8-17-91	D/H
	C) Function						8-17-91	D/H
660	Pack						8-17-91	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-6649290

DATE 8-15-91

TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.55	2.37	2.40	2.66	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.65	2.36	2.38	2.78	
PULL #3	2.58	2.46	2.35	2.78	
PULL #4	2.56	2.43	2.42	2.78	
PULL #5	2.66	2.35	2.44	2.42	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.31	3.18		
PULL #2	3.25	3.22		
PULL #3	3.24	3.14		
PULL #4	3.23	3.22		
PULL #5	3.26	3.18		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.21	4.22		4.38
PULL #2	4.56	4.38		4.48
PULL #3	4.53	4.30		4.44
PULL #4	4.56	4.31		4.46
PULL #5	4.60	4.43		4.45
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649290
22 Aug 1991

CENTROIDAL DISTANCES

0 TO 1	.435178
1 TO 2	.181397
1 TO 3	.495371
1 TO 4	.484451
1 TO 5	.214133

4
12

-----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0704
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2306
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .241107
THE AMR FOR THIS RIFLE IS: 1.053

22 Aug 1961

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CENTERFIRE PATTERNS

1

POB

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 1

2 in = 3

3 in = 4

HS = 2.033

VS = 3.595

GS = 3.812

PATTERN #

1

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.016

.670

.729

MINIMUM X

-1.017

-.904

-.845

MAXIMUM Y

1.804

2.002

1.945

MINIMUM Y

-1.791

-1.593

-1.343

CENTROID X

-.098

-.211

-.270

CENTROID Y

-.424

-.622

-.872

POB TO CENTROID in.

.436

.657

.913

MIN RADIUS

.463

.475

.397

MEAN RADIUS

1.339

1.231

1.086

MAX RADIUS

2.046

2.057

2.077

HORIZONTAL SPREAD

2.033

1.574

1.574

VERTICAL SPREAD

3.595

3.595

3.288

EXTREME SPREAD

3.812

3.599

3.344

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

3

NUMBER IN THREE INCH CIRCLE =

4

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CAB45290

CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 3

2in = 4

3in = 8

HS= 2.973

VS= 1.938

GS= 3.267

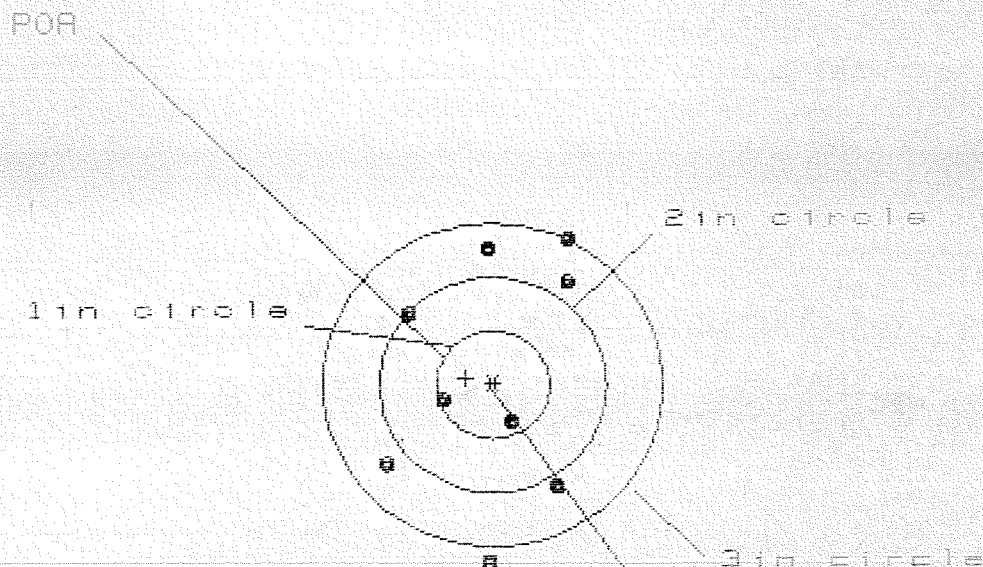
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.430	1.182	1.009
MINIMUM X	:	-1.543	-1.384	-1.365
MAXIMUM Y	:	.958	.849	.882
MINIMUM Y	:	-.980	-1.066	-1.033
CENTROID X	:	.083	-.076	.097
CENTROID Y	:	-.412	-.303	-.336
POA TO CENTROID in.	:	.420	.312	.349
MIN RADIUS	:	.258	.241	.182
MEAN RADIUS	:	1.070	.993	.902
MAX RADIUS	:	1.734	1.452	1.553
HORIZONTAL SPREAD	:	2.973	2.566	2.374
VERTICAL SPREAD	:	1.938	1.915	1.915
EXTREME SPREAD	:	3.267	2.824	2.824
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

22 Aug 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 4

3in = 8

HS= 1.567

VS= 3.027

GS= 3.105

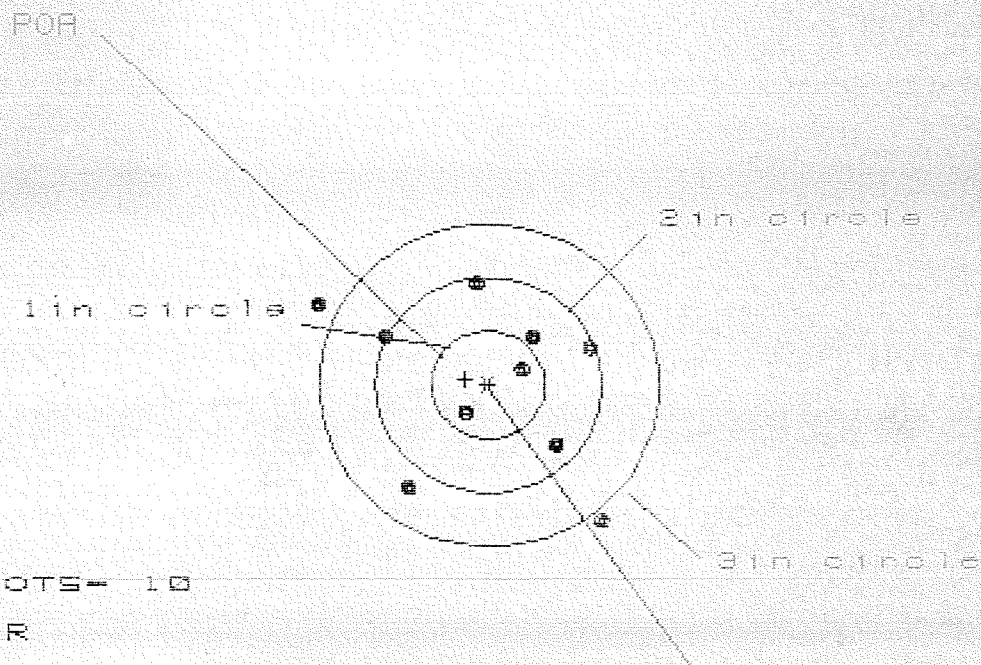
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.655	.651	.720
MINIMUM X	:	-.911	-.916	-.834
MAXIMUM Y	:	1.377	1.193	1.183
MINIMUM Y	:	-1.651	-1.085	-.936
CENTROID X	:	.238	.243	.161
CENTROID Y	:	-.060	.123	-.026
POA TO CENTROID in.	:	.246	.272	.163
MIN RADIUS	:	.387	.556	.416
MEAN RADIUS	:	1.003	.943	.858
MAX RADIUS	:	1.651	1.359	1.184
HORIZONTAL SPREAD	:	1.567	1.567	1.554
VERTICAL SPREAD	:	3.027	2.278	2.119
EXTREME SPREAD	:	3.105	2.668	2.327
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

22 Aug 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 2.479

VS= 2.213

GS= 3.137

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.015	.852	.847
MINIMUM X	:	-1.464	-1.018	-.912
MAXIMUM Y	:	.991	1.069	.926
MINIMUM Y	:	-1.222	-1.144	-1.026
CENTROID X	:	.205	.368	.262
CENTROID Y	:	-.046	-.124	.019
POA TO CENTROID in.	:	.210	.388	.262
MIN RADIUS	:	.348	.253	.278
MEAN RADIUS	:	.953	.859	.779
MAX RADIUS	:	1.623	1.427	1.249
HORIZONTAL SPREAD	:	2.479	1.870	1.759
VERTICAL SPREAD	:	2.213	2.213	1.952
EXTREME SPREAD	:	3.137	2.525	2.020
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

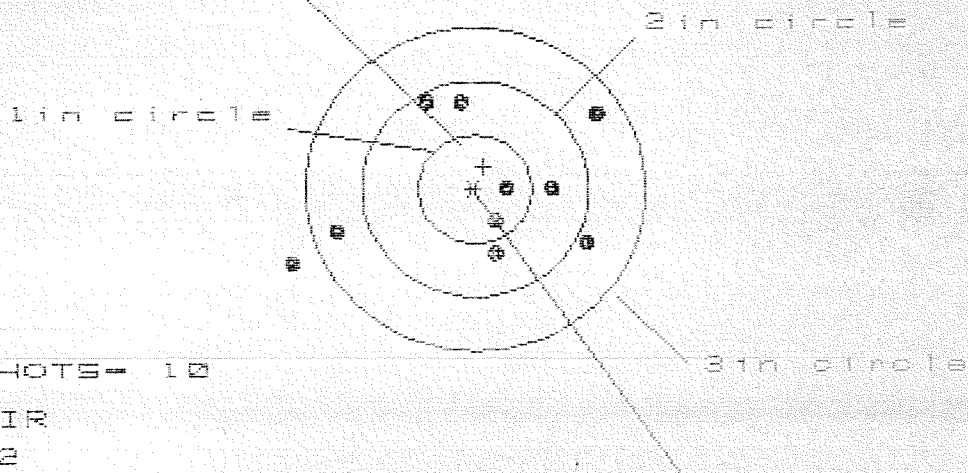
22 Aug 1991

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CENTERFIRE PATTERNS

5

POB



OF SHOTS- 10

IN CIR

1in. = 2

2in = 5

3in = 9

HS= 2.720

VS= 1.513

GS= 3.076

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.083	.901	.933
MINIMUM X	-1.637	-1.383	-1.271
MAXIMUM Y	.825	.749	.833
MINIMUM Y	-.688	-.617	-.533
CENTROID X	-.076	.106	-.006
CENTROID Y	-.211	-.135	-.219
POB TO CENTROID in.	.224	.172	.219
MIN RADIUS	.244	.086	.176
MEAN RADIUS	.898	.757	.717
MAX RADIUS	1.776	1.462	1.329
HORIZONTAL SPREAD	2.720	2.284	2.204
VERTICAL SPREAD	1.513	1.366	1.366
EXTREME SPREAD	3.076	2.556	2.205
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	