

C6611522

MODEL 700TM M24

Model **SWS** TM

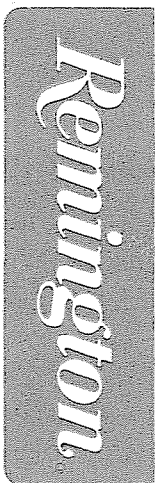
Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.






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

MODEL 700TM M24

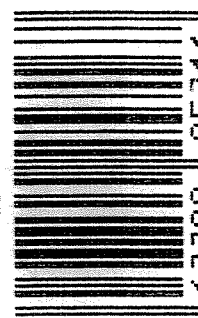
SERIAL NO.
C6611522

ORDER NO.
5716

20

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

LPC



0 47700 25716 7



5716 C6611522

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6611522

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/13/91	K.S.
600	Proof		3/13/91	K.S.
607	Check Headspace		3/13/91	K.S.
610	Dis-assemble Gun		3/13/91	K.S.
612	Magnaflux Barrel Action		3/24/91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		3/27/91	LS.
617	Drill and Tap Sight Holes		APR 3 1991	LB
618	Polish Barrel		APR 3 1991	WB
620	Apply Coatings (Barrel Action)		4-12-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/18/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/18/91	KS
	C) Inspect Ejector Hole for Chamfer		4/18/91	KS
	D) Oil Firing Pin Ass'y		4/18/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		4/19/91	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			4-24-91	DH
	G) Safety Off Force	3	3	3			4-24-91	DH
	H) Trigger Pull Test & Retainability						4/10/91	JK
	I) Firing Pin Indent	.021	.021	.022			4-19-91	DH
	J) Assemble Stock						4/25/91	KS
	K) Assemble Swivel Studs						5-11-91	DH
	L) Attach Front and Rear Sight Assemblies						4/25/91	KS
	M) Iron Sight Alignment						4/25/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/25/91	KS
	O) Attach Scope to Rifle						4/25/91	KS
	P) Detach & Attach Scope 20 Times						4/25/91	KS
640	Gallery Target & Test						4-26-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						4-26-91	NF
655	Final Inspection							
	A) Headspace						5-11-91	DH
	B) Trigger Pull	2.42	2.18	2.20	2.29	2.20	5/10/91	JK
	C) Function						5-11-91	DH
660	Pack						6/18/91	WB

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6611522DATE 4/19/94TESTER JF

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.33	2.28	2.30	2.42	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.21	2.28	2.36	2.18	
PULL #3	2.34	2.34	2.36	2.20	
PULL #4	2.31	2.32	2.34	2.29	
PULL #5	2.31	2.34	2.31	2.20	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES			COMMENTS
PULL #1	3.46	3.35			
PULL #2	3.40	3.38			
PULL #3	3.35	3.35			
PULL #4	3.13	3.45			
PULL #5	3.31	3.13			
TOTAL					
AVG.					

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.59	4.40		4.25
PULL #2	4.41	4.49		4.39
PULL #3	4.44	4.47		4.35
PULL #4	4.46	4.56		4.50
PULL #5	4.39	4.39		4.42
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611522
26 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.060208
1 TO	2	.148637
1 TO	3	.226861
1 TO	4	.30399
1 TO	5	.129541

4.5

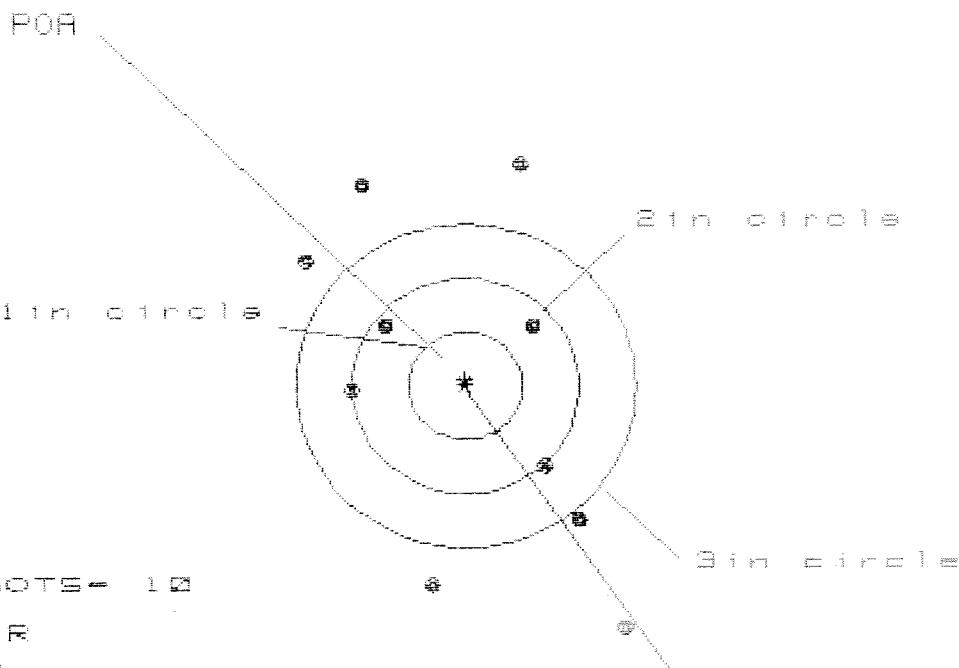
-----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.028
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.091
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .171
THE AMR FOR THIS RIFLE IS: .9214

26 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8B11522

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 3

3 in = 4

HS = 2.748

VS = 4.295

GS = 4.643

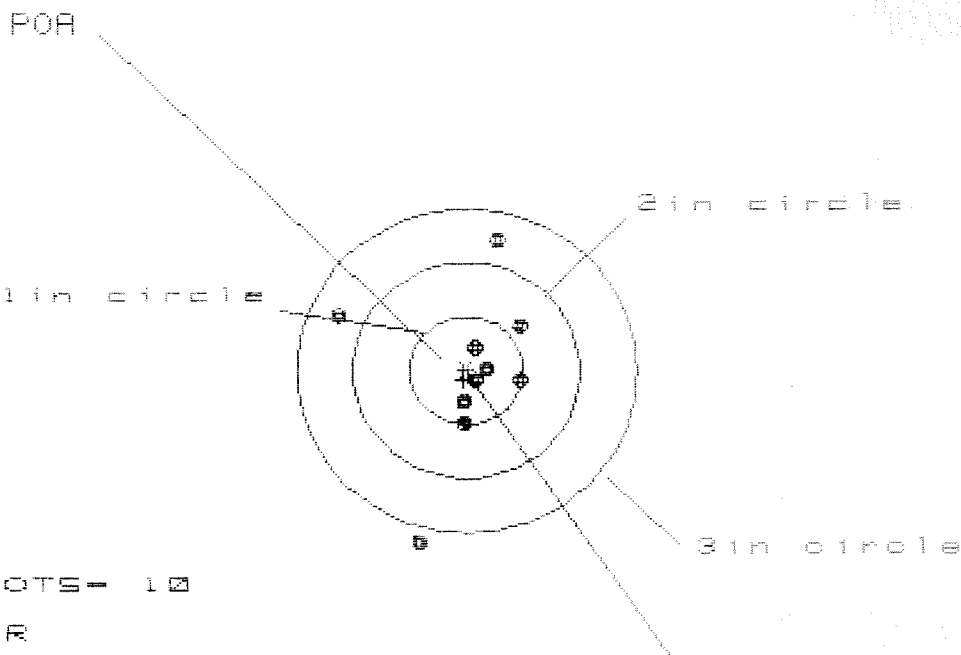
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.372	1.160	1.246
MINIMUM X	:	-1.376	-1.224	-1.137
MAXIMUM Y	:	2.055	1.806	1.809
MINIMUM Y	:	-2.240	-2.093	-1.867
CENTROID X	:	.005	-.147	-.234
CENTROID Y	:	-.060	.189	-.037
POR TO CENTROID in.	:	.060	.240	.236
MIN RADIUS	:	.846	.631	.698
MEAN RADIUS	:	1.581	1.429	1.358
MAX RADIUS	:	2.627	2.099	1.912
HORIZONTAL SPREAD	:	2.748	2.384	2.384
VERTICAL SPREAD	:	4.295	3.899	3.676
EXTREME SPREAD	:	4.643	3.989	3.717
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		4	

26 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08611522

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 6

2 in = 7

3 in = 9

HS = 1.685

VS = 2.794

GS = 2.888

CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.521	.474	.323
MINIMUM X	:	-1.164	-1.211	-.252
MAXIMUM Y	:	1.236	1.063	1.110
MINIMUM Y	:	-1.558	-.640	-.593
CENTROID X	:	.027	.074	.225
CENTROID Y	:	.087	.260	.213
POR TO CENTROID in.	:	.091	.270	.310
MIN RADIUS	:	.104	.094	.125
MEAN RADIUS	:	.666	.566	.446
MAX RADIUS	:	1.613	1.268	1.116
HORIZONTAL SPREAD	:	1.685	1.685	.575
VERTICAL SPREAD	:	2.794	1.703	1.703
EXTREME SPREAD	:	2.888	1.750	1.742
NUMBER IN ONE INCH CIRCLE	=		6	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

26 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611522

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 1

2in = 8

3in = 9

HS= 1.700

VS= 3.066

GS= 3.069

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.871	.906	.933
MINIMUM X	:	-.829	-.794	-.767
MAXIMUM Y	:	1.066	.844	.525
MINIMUM Y	:	-2.000	-.947	-.841
CENTROID X	:	-.024	-.059	-.086
CENTROID Y	:	-.285	-.063	-.169
POA TO CENTROID in.	:	.286	.086	.189
MIN RADIUS	:	.232	.234	.247
MEAN RADIUS	:	.835	.668	.641
MAX RADIUS	:	2.025	.987	.937
HORIZONTAL SPREAD	:	1.700	1.700	1.700
VERTICAL SPREAD	:	3.066	1.791	1.366
EXTREME SPREAD	:	3.069	1.857	1.723
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

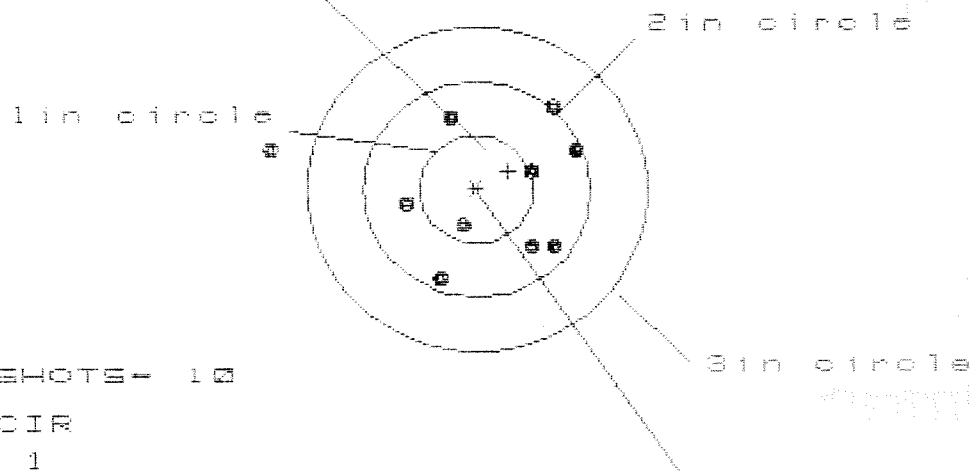
26 Apr 1991

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CENTERFIRE PATTERNS

4

POA



OF SHOTS- 10

IN CIR

1in = 1

2in = 9

3in = 8

HS= 2.675

VS= 1.622

GS= 2.678

CENTROID *

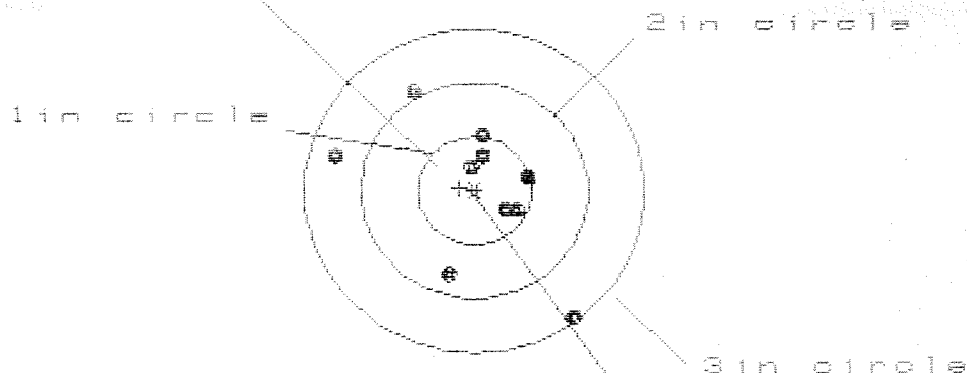
PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.831	.626	.680
MINIMUM X	-1.844	-.795	-.741
MAXIMUM Y	.747	.791	.836
MINIMUM Y	-.875	-.831	-.732
CENTROID X	-.278	-.073	-.127
CENTROID Y	-.171	-.215	-.314
POA TO CENTROID in.	.327	.227	.338
MIN RADIUS	.343	.390	.322
MEAN RADIUS	.852	.707	.672
MAX RADIUS	1.885	.980	.931
HORIZONTAL SPREAD	2.675	1.421	1.421
VERTICAL SPREAD	1.622	1.622	1.568
EXTREME SPREAD	2.678	1.878	1.703
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		9	

26 Apr 1991

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CENTERFIRE PATTERNS # 5

POA



OF SHOTS = 10

IN CIR

1in = 5

2in = 7

3in = 10

HS = 2.078

VS = 2.017

GS = 2.519

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.821	.580	.434
MINIMUM X	:	-1.257	-1.166	-.545
MAXIMUM Y	:	.880	.754	.774
MINIMUM Y	:	-1.137	-.917	-.897
CENTROID X	:	.130	.039	.184
CENTROID Y	:	-.026	.100	.080
POA TO CENTROID in.	:	.133	.107	.201
MIN RADIUS	:	.181	.106	.094
MEAN RADIUS	:	.673	.586	.474
MAX RADIUS	:	1.402	1.177	.947
HORIZONTAL SPREAD	:	2.078	1.746	.980
VERTICAL SPREAD	:	2.017	1.671	1.671
EXTREME SPREAD	:	2.519	1.759	1.690
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	