

C6611525

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.



REGISTERED TRADE MARK

MODEL 700™ H24

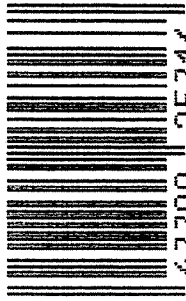
SERIAL NO.
C6611525

ORDER NO.
5716

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

48

UPC



0 47700 25716 2



5716 C6611525

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611525

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 25 91		Rw
600	Proof	3 25 91		Rw
607	Check Headspace	3 25 91		Rw
610	Dis-assemble Gun	3 25 91		Rw
612	Magnaflux Barrel Action	3 28 91		KR
	Magnaflux Bolt	3 28 91		11
615	Rollmark Caliber	3 28 91		LS
617	Drill and Tap Sight Holes	APR 3 1991		FB
618	Polish Barrel	APR 3 1991		WB
620	Apply Coatings (Barrel Action)		4-11-91	TJH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/16/91	Rw
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/16/91	Rw
	C) Inspect Ejector Hole for Chamfer		4/16/91	Rw
	D) Oil Firing Pin Ass'y		4/16/91	Rw
	E) Adjust Trigger Pull to Min Setting and Stake		5/4/91	JH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6 $\frac{1}{4}$	6	6			5-4-91	DH
	G) Safety Off Force	3 $\frac{1}{4}$	3	3			5-4-91	DH
	H) Trigger Pull Test & Retainability						5/4/91	JH
	I) Firing Pin Indent	.020	.020	.020			5-4-91	DH
	J) Assemble Stock						5/6/91	RW
	K) Assemble Swivel Studs						5-9-91	A
	L) Attach Front and Rear Sight Assemblies						5/6/91	RW
	M) Iron Sight Alignment						5/6/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/6/91	RW
	O) Attach Scope to Rifle						5/6/91	RW
	P) Detach & Attach Scope 20 Times						5/6/91	RW
640	Gallery Target & Test						5-6-91	DH
	A) Time						5-6-91	DH
	B) Malfunctions						5-6-91	DH
	C) Pierced Primers						5-6-91	DH
	D) Optical Clarity of Scope						5-6-91	DH
645	Inspect for Live Ammo						5-6-91	DH
655	Final Inspection							
	A) Headspace						5-9-91	A
	B) Trigger Pull	2.36	2.35	2.36	2.33	2.34	5/9/91	JH
	C) Function						5-9-91	A
660	Pack						6-18-91	N

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6611525

DATE 5-4-91

TESTER JM.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.25	2.30	2.36	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.36	2.32	2.31	2.35	
PULL #3	2.36	2.43	2.38	2.36	
PULL #4	2.45	2.36	2.36	2.33	
PULL #5	2.36	2.20	2.36	2.34	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.44	3.44		
PULL #2	3.50	3.49		
PULL #3	3.37	3.46		
PULL #4	3.33	3.41		
PULL #5	3.22	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	4.14	4.38		4.46
PULL #2	4.56	4.50		4.51
PULL #3	4.53	4.27		4.43
PULL #4	4.52	4.45		4.57
PULL #5	4.40	4.48		4.58
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611525
6 May 1991

CENTROIDAL DISTANCES

0 TO	1	.24244
1 TO	2	.0855249
1 TO	3	.257049
1 TO	4	.337831
1 TO	5	.838452

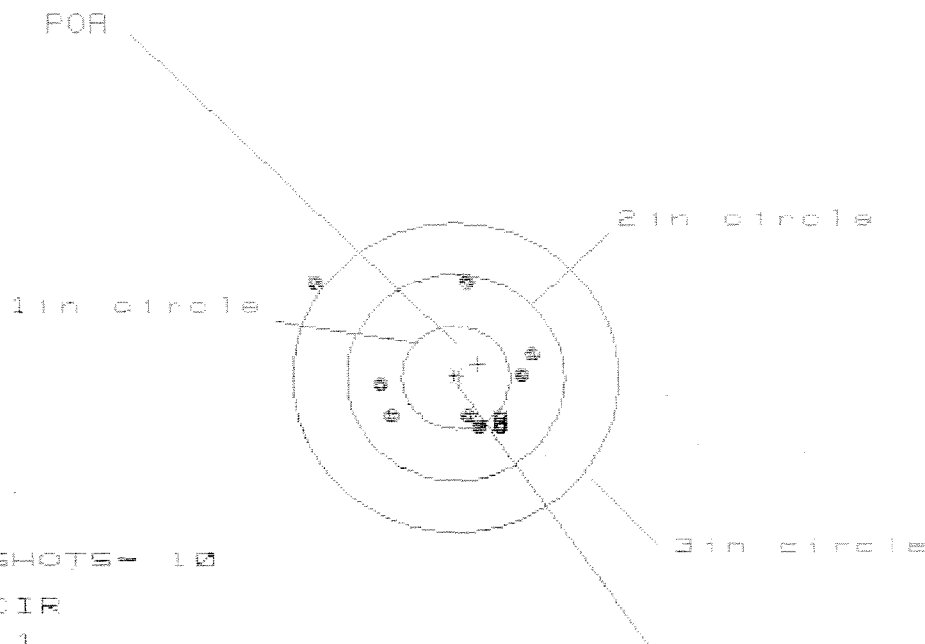
4 5 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .039
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0372
THE RESULTING AVERAGE PCI RADIUS FOR THIS RIFLE IS: .0538960
THE AMR FOR THIS RIFLE IS: 1.000

8 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611525

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 8

3in = 9

HS= 1.998

VS= 1.438

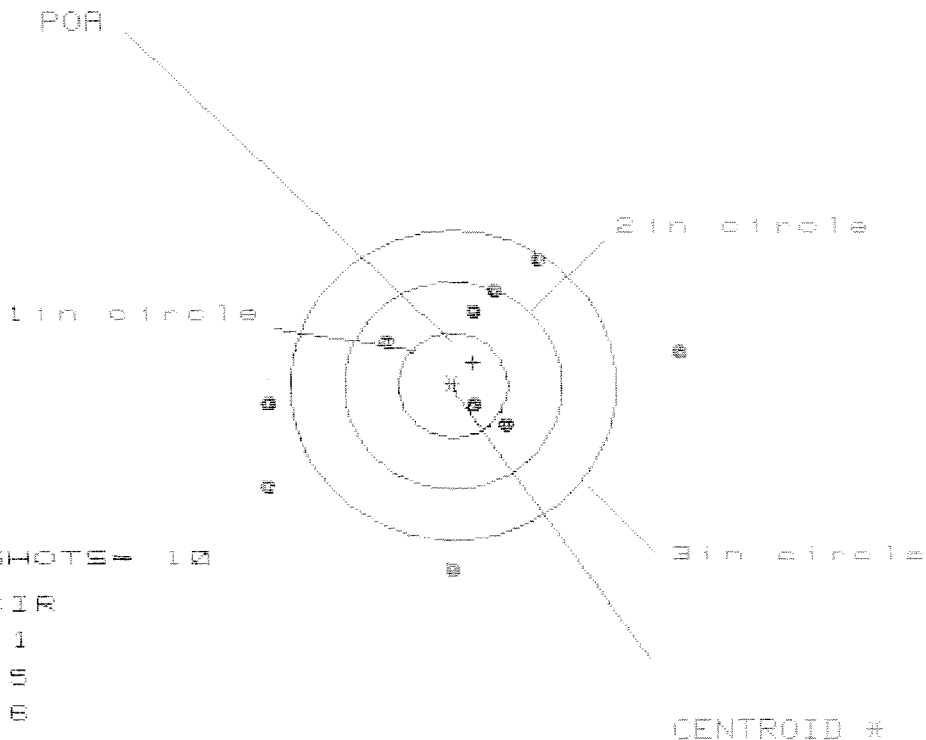
GS= 2.194

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.735	.595	.586
MINIMUM X	:	-1.263	-.857	-.866
MAXIMUM Y	:	.933	1.029	.494
MINIMUM Y	:	-.505	-.401	-.273
CENTROID X	:	-.204	-.064	-.055
CENTROID Y	:	-.131	-.235	-.363
POA TO CENTROID in.	:	.243	.243	.367
MIN RADIUS	:	.359	.248	.129
MEAN RADIUS	:	.745	.600	.506
MAX RADIUS	:	1.570	1.031	.877
HORIZONTAL SPREAD	:	1.998	1.452	1.452
VERTICAL SPREAD	:	1.438	1.430	.767
EXTREME SPREAD	:	2.194	1.494	1.494
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		9	

6 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B11525

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 4

HS = 3.793

VS = 3.002

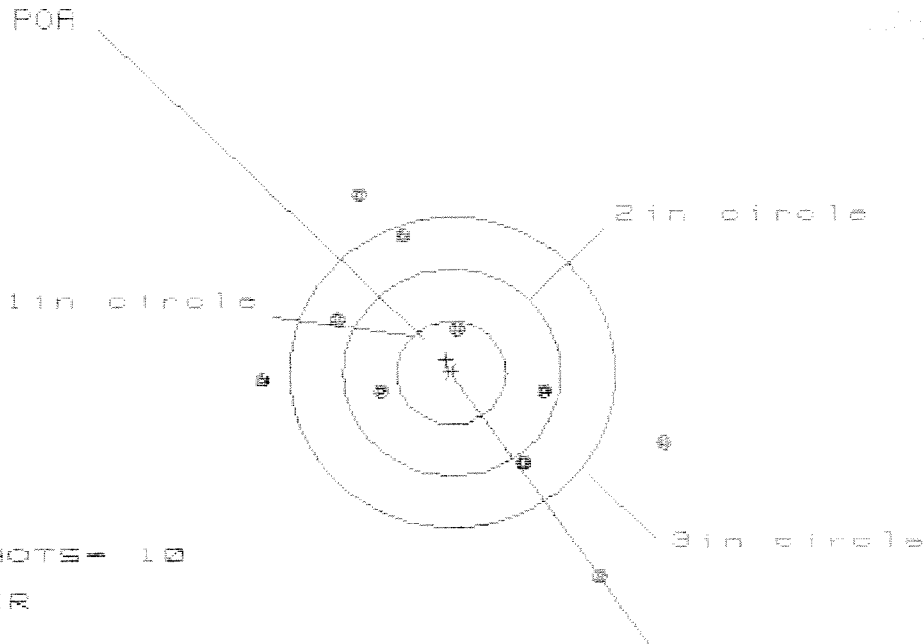
GS = 4.014

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.066	.985	.797
MINIMUM X	:	-1.727	-1.497	-1.660
MAXIMUM Y	:	1.183	1.216	1.094
MINIMUM Y	:	-1.819	-1.786	-1.908
CENTROID X	:	-1.187	-.417	-.229
CENTROID Y	:	-.225	-.258	-.136
POA TO CENTROID in.	:	.292	.490	.267
MIN RADIUS	:	.255	.455	.343
MEAN RADIUS	:	1.232	1.156	1.025
MAX RADIUS	:	2.088	1.798	1.908
HORIZONTAL SPREAD	:	3.793	2.482	2.458
VERTICAL SPREAD	:	3.002	3.002	3.002
EXTREME SPREAD	:	4.014	3.312	3.100
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		6	

6 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08611525

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 1

2in = 3

3in = 6

HS = 3.677

VS = 3.701

GS = 4.326

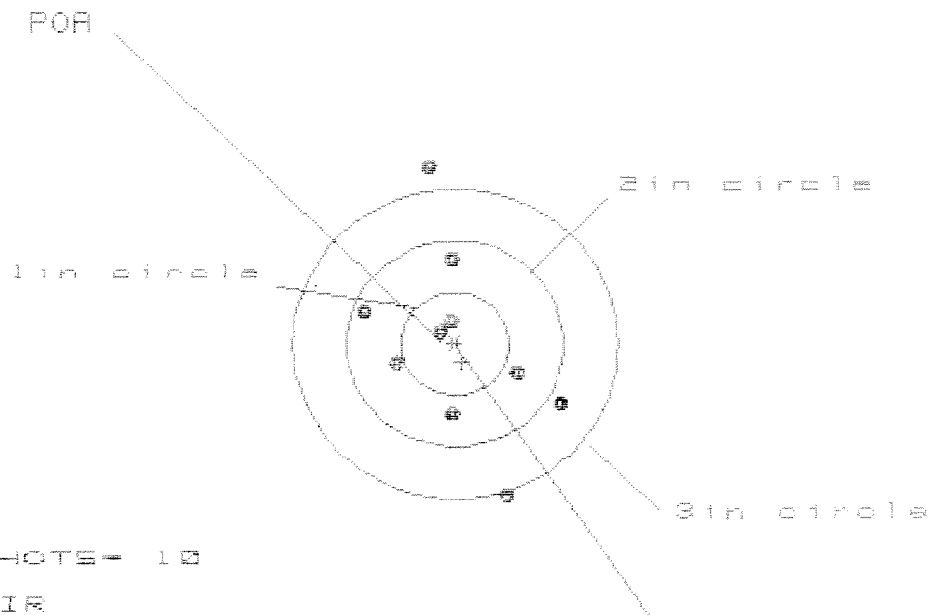
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.925	2.079	1.320
MINIMUM X	:	-1.752	-1.598	-1.338
MAXIMUM Y	:	1.691	1.468	1.358
MINIMUM Y	:	-2.010	-1.075	-1.185
CENTROID X	:	.053	-.101	-.361
CENTROID Y	:	-.126	.097	.207
POA TO CENTROID in.	:	.137	.140	.416
MIN RADIUS	:	.428	.260	.432
MEAN RADIUS	:	1.370	1.210	1.052
MAX RADIUS	:	2.442	2.256	1.590
HORIZONTAL SPREAD	:	3.677	3.677	2.558
VERTICAL SPREAD	:	3.701	2.543	2.543
EXTREME SPREAD	:	4.326	3.719	2.952
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			3	
NUMBER IN THREE INCH CIRCLE =			6	

6 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CGB11525

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 7

3 in = 8

HS= 1.774

VS= 3.290

GS= 3.376

CENTROID #

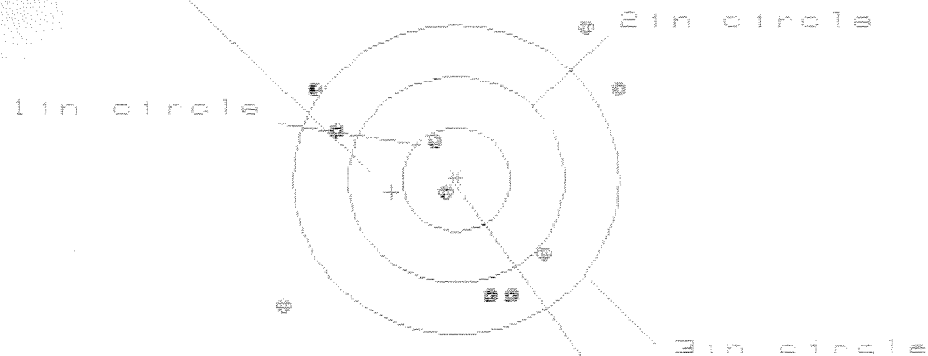
PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.917	.886	.941
MINIMUM X	-.857	-.888	-.833
MAXIMUM Y	1.768	1.037	.871
MINIMUM Y	-1.522	-1.326	-.672
CENTROID X	-.863	-.832	-.887
CENTROID Y	.176	-.020	.146
POA TO CENTROID in.	.187	.037	.178
MIN RADIUS	.174	.364	.198
MEAN RADIUS	.858	.766	.651
MAX RADIUS	1.790	1.398	1.099
HORIZONTAL SPREAD	1.774	1.774	1.774
VERTICAL SPREAD	3.290	2.363	1.543
EXTREME SPREAD	3.376	2.424	1.997
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		

8 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611525

CENTERFIRE PATTERNS # 5

POA



OF SHOTS- 10

IN CIR

1in = 2

2in = 2

3in = 6

HS= 3.141

VS= 2.698

GS= 3.887

CENTROID +

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.501	1.319	1.441
MINIMUM X	-1.640	-1.443	-1.321
MAXIMUM Y	1.524	1.394	.953
MINIMUM Y	-1.174	-1.236	-1.062
CENTROID X	.596	.778	.656
CENTROID Y	.120	.250	.076
POA TO CENTROID in.	.608	.818	.661
MIN RADIUS	.142	.366	.178
MEAN RADIUS	1.234	1.163	1.054
MAX RADIUS	2.017	1.701	1.727
HORIZONTAL SPREAD	3.141	2.762	2.762
VERTICAL SPREAD	2.698	2.630	2.015
EXTREME SPREAD	3.887	2.769	2.763
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	6		