

C6611566

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.





MODEL 700™ H24

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



5716 C6611566

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

SERIAL NO. C6611566
ORDER NO. 5716

20

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611566

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	2 1 91		Rw
600	Proof	2 1 91		Rw
607	Check Headspace	2 1 91		Rw
610	Dis-assemble Gun	2 1 91		Rw
612	Magnaflux Barrel Action	2 1 1 91		Kcd
	Magnaflux Bolt	2 1 1 91		Kcd
615	Rollmark Caliber	2 1 1 91		GS
617	Drill and Tap Sight Holes	2 1 3 91		LB
618	Polish Barrel <i>RB</i>	2 1 3 91		WB
620	Apply Coatings (Barrel Action)		<i>h 12 91</i>	<i>AS</i>
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		3/24/91	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		3/25/91	WB
	C) Inspect Ejector Hole for Chamfer		3/25/91	WB
	D) Oil Firing Pin Ass'y		3/25/91	WB
	E) Adjust Trigger Pull to Min Setting and Stake		4/8/91	<i>JS</i>

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			4/9/91	JL
	G) Safety Off Force	2	2	2			4/9/91	JL
	H) Trigger Pull Test & Retainability						4/8/91	JL
	I) Firing Pin Indent	.0235	.0235	.0235			4/9/91	JL
	J) Assemble Stock						4/9/91	RW
	K) Assemble Swivel Studs						4-10-91	DH
	L) Attach Front and Rear Sight Assemblies						4/9/91	RW
	M) Iron Sight Alignment						4/9/91	RW
	N) Detach Front & Rear Sights & place in numbered container						4/9/91	RW
	O) Attach Scope to Rifle						4/9/91	RW
	P) Detach & Attach Scope 20 Times						4/9/91	RW
640	Gallery Target & Test						4-9-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						4-9-91	NF
655	Final Inspection							
	A) Headspace						4-10-91	DH
	B) Trigger Pull	2.54	2.55	2.55	2.43	2.46	4/10/91	JL
	C) Function						4-10-91	DH
660	Pack						6-17-91	NF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6611366
DATE 4/8/91
TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.43	2.46	2.54	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.37	2.39	2.50	2.55	
PULL #3	2.37	2.38	2.43	2.55	
PULL #4	2.38	2.45	2.39	2.43	
PULL #5	2.38	2.46	2.44	2.46	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.39	3.41		
PULL #2	3.50	3.35		
PULL #3	3.57	3.32		
PULL #4	3.13	3.20		
PULL #5	3.24	3.35		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.30	4.22		4.34
PULL #2	4.24	4.17		4.47
PULL #3	4.27	4.15		4.50
PULL #4	4.26	4.20		4.45
PULL #5	4.28	4.20		4.56
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611566
9 Apr 1991

CENTROIDAL DISTANCES

0 TO 1	.532414
1 TO 2	.572894
1 TO 3	.661511
1 TO 4	.516312
1 TO 5	.456422

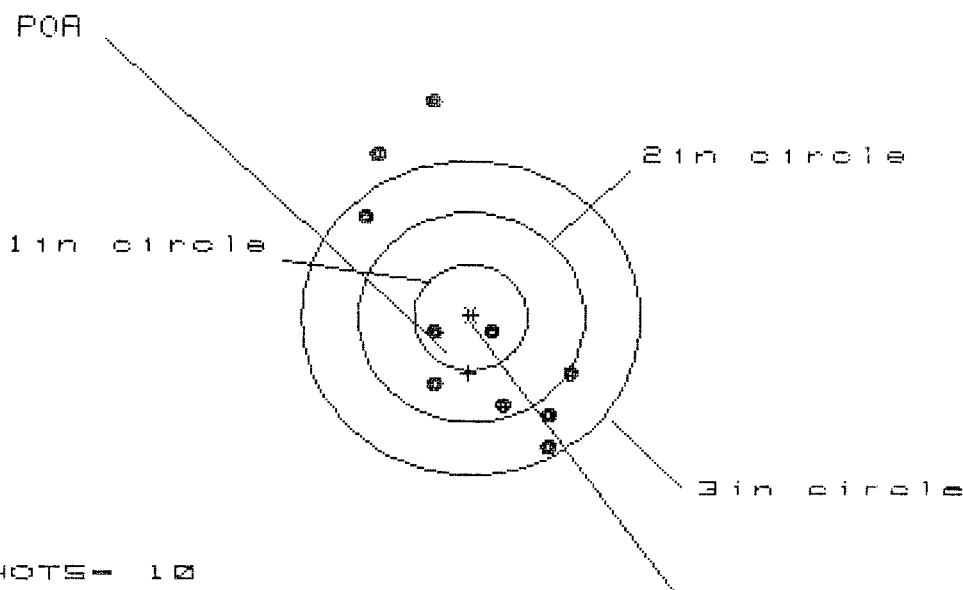
1
4 5 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0596
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .123
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .136679
THE AMR FOR THIS RIFLE IS: .7506

9 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611566

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 1.727

VS= 3.253

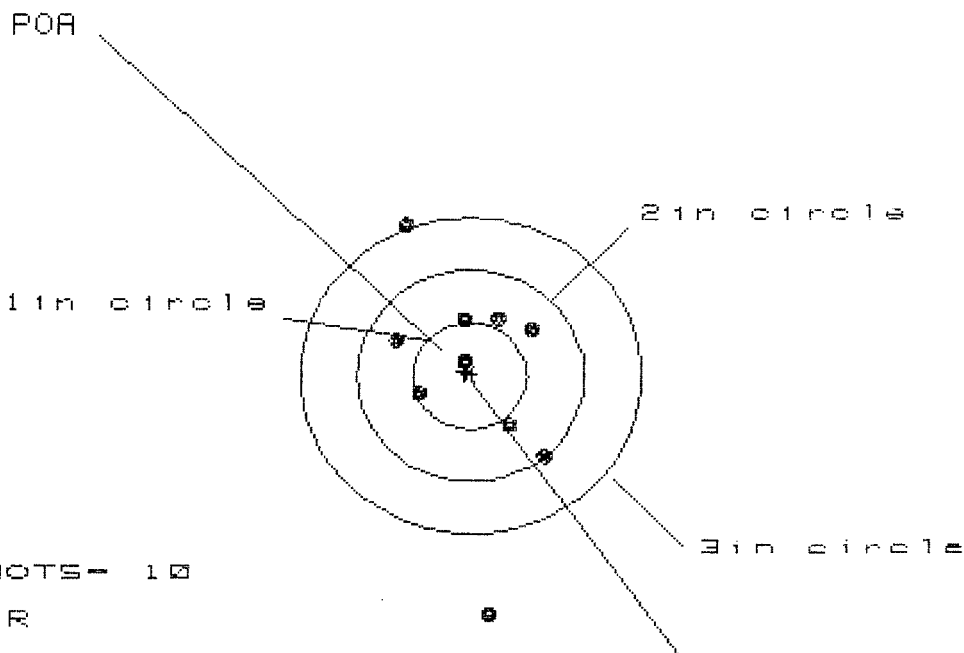
GS= 3.401

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.856	.822	.716
MINIMUM X	-.871	-.905	-1.011
MAXIMUM Y	2.022	1.823	1.409
MINIMUM Y	-1.231	-1.006	-.778
CENTROID X	.021	.055	.161
CENTROID Y	.532	.307	.079
POA TO CENTROID in.	.532	.312	.179
MIN RADIUS	.229	.143	.291
MEAN RADIUS	1.097	.924	.739
MAX RADIUS	2.044	2.011	1.734
HORIZONTAL SPREAD	1.727	1.727	1.727
VERTICAL SPREAD	3.253	2.829	2.187
EXTREME SPREAD	3.401	3.208	2.690
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

9 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611566

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 8

3in = 8

HS= 1.273

VS= 3.695

GS= 3.755

CENTROID #

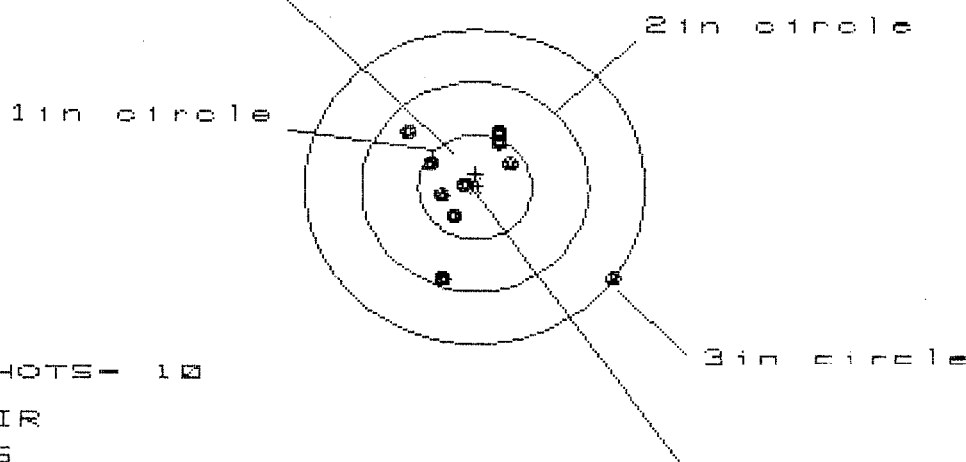
PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.624	.637	.571
MINIMUM X	:	-.649	-.636	-.702
MAXIMUM Y	:	1.485	1.240	.471
MINIMUM Y	:	-2.210	-.956	-.801
CENTROID X	:	.053	.040	.106
CENTROID Y	:	-.040	.205	.050
POA TO CENTROID in.	:	.067	.209	.117
MIN RADIUS	:	.134	.163	.141
MEAN RADIUS	:	.844	.654	.569
MAX RADIUS	:	2.213	1.348	.984
HORIZONTAL SPREAD	:	1.273	1.273	1.273
VERTICAL SPREAD	:	3.695	2.196	1.272
EXTREME SPREAD	:	3.755	2.487	1.634
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	8		
NUMBER IN THREE INCH CIRCLE	=	8		

9 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611566

CENTERFIRE PATTERNS # 3

POA



OF SHOTS- 10

IN CIR

1in = 5

2in = 9

3in = 10

HS= 1.798

VS= 1.403

GS= 2.247

CENTROID #

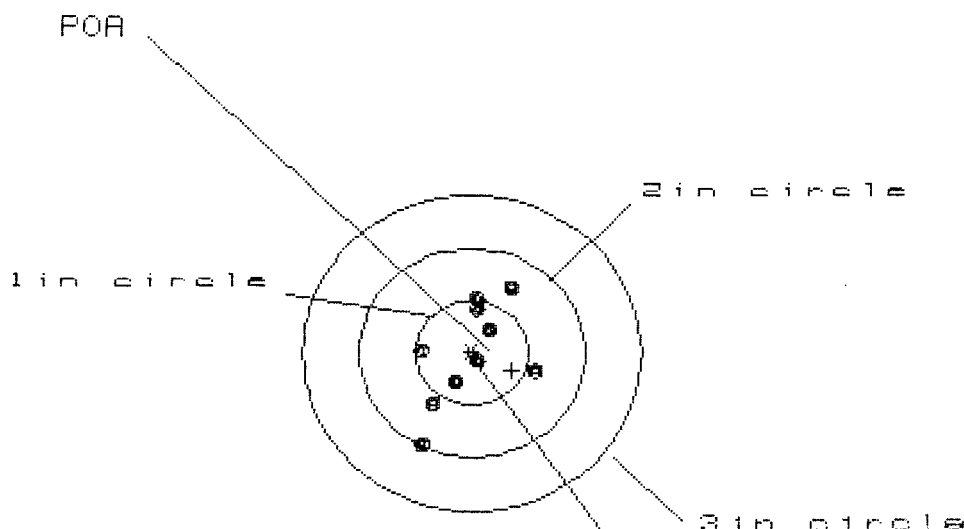
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.209	.410	.386
MINIMUM X	:	-.589	-.454	-.478
MAXIMUM Y	:	.558	.466	.349
MINIMUM Y	:	-.845	-.937	-.493
CENTROID X	:	-.005	-.140	-.116
CENTROID Y	:	-.129	-.037	.080
POA TO CENTROID in.	:	.129	.145	.141
MIN RADIUS	:	.141	.045	.164
MEAN RADIUS	:	.587	.452	.396
MAX RADIUS	:	1.463	.956	.574
HORIZONTAL SPREAD	:	1.798	.864	.864
VERTICAL SPREAD	:	1.403	1.403	.842
EXTREME SPREAD	:	2.247	1.502	.929
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

9 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611566

CENTERFIRE PATTERNS

4



OF SHOTS - 10

IN CIR

1 in = 5

2 in = 10

3 in = 10

HS = 1.036

VS = 1.463

GS = 1.656

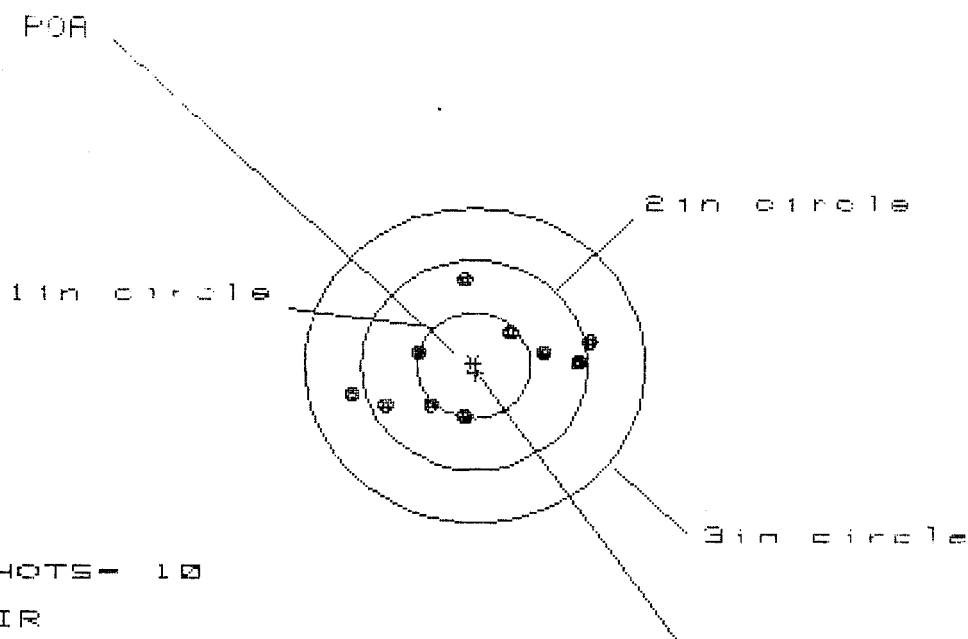
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.598	.552	.592
MINIMUM X	:	-.438	-.484	-.444
MAXIMUM Y	:	.634	.542	.517
MINIMUM Y	:	-.829	-.532	-.465
CENTROID X	:	-.352	-.306	-.346
CENTROID Y	:	.175	.267	.200
POA TO CENTROID in.	:	.393	.406	.399
MIN RADIUS	:	.067	.138	.082
MEAN RADIUS	:	.491	.436	.407
MAX RADIUS	:	.926	.667	.632
HORIZONTAL SPREAD	:	1.036	1.036	1.036
VERTICAL SPREAD	:	1.463	1.074	.982
EXTREME SPREAD	:	1.656	1.292	1.077
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		10	
NUMBER IN THREE INCH CIRCLE	=		10	

9 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8811566

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 2.125

VS= 1.328

GS= 2.167

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.000	.876	.878
MINIMUM X	:	-1.125	-.878	-.769
MAXIMUM Y	:	.836	.810	.832
MINIMUM Y	:	-.492	-.518	-.496
CENTROID X	:	-.015	.110	.001
CENTROID Y	:	.077	.103	.081
POA TO CENTROID in.	:	.078	.151	.081
MIN RADIUS	:	.458	.350	.443
MEAN RADIUS	:	.734	.679	.647
MAX RADIUS	:	1.148	.970	.878
HORIZONTAL SPREAD	:	2.125	1.754	1.647
VERTICAL SPREAD	:	1.328	1.328	1.328
EXTREME SPREAD	:	2.167	1.848	1.695
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			10	