

C6349118

MODEL 700TM M24

Model **SWS**TM

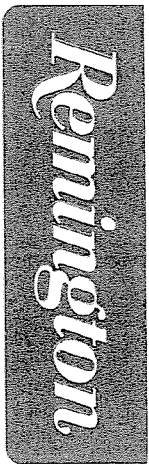
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Still
Smart.




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

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

MODEL 700TM H24

SERIAL NO.
C6349118

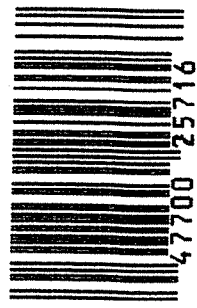
ORDER NO.
5716

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



5716 C6349118

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349118

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 12 90		RW
600	Proof	4 12 90		K
607	Check Headspace	4 12 90		K
610	Dis-assemble Gun	4 12 90		RW
612	Magnaflux Barrel Action	4-19-90		KCR
	Magnaflux Bolt	4-19-90		KCR
615	Rollmark Caliber	4-19-90		SL
617	Drill and Tap Sight Holes		4/23/90	FB
618	Polish Barrel RB		4/24/90	WB
620	Apply Coatings (Barrel Action)		4-30-90	TSA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/1/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/1/90	RW
	C) Inspect Ejector Hole for Chamfer		5/1/90	RW
	D) Oil Firing Pin Ass'y		5/1/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/1/90	RM

op. #	OP. NAME	READINGS					DATE	INIT
625- cont.	F) Safety On Force	5	5	5			5/11/90	JK
	G) Safety Off Force	2	2	2			5/11/90	JK
	H) Trigger Pull Test & Retainability						5/11/90	JK
	I) Firing Pin Indent	.020	.0205	.020			5/11/90	JK
	J) Assemble Stock						5/15/90	RW
	K) Assemble Swivel Studs						5/17/90	W.B
	L) Attach Front and Rear Sight Assemblies						5/15/90	RW
	M) Iron Sight Alignment						5/15/90	RW
	N) Detach Front & Rear Sights & place in numbered container						5/15/90	RW
	O) Attach Scope to Rifle						5/15/90	JK
	P) Detach & Attach Scope 20 Times						5/15/90	JK
640	Gallery Target & Test						5-15-90	AC
	A) Time						5-15-90	AC
	B) Malfunctions						5-15-90	AC
	C) Pierced Primers						5-15-90	AC
	D) Optical Clarity of Scope						5-15-90	AC
645	Inspect for Live Ammo						5-15-90	AC
655	Final Inspection						5/17/90	W.B
	A) Headspace							
	B) Trigger Pull	2.52	2.43	2.43	2.41	2.42	5/16/90	W.B
	C) Function						5/17/90	W.B
660	Pack						9/19/90	AF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6349118

DATE 5/11/90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.45	2.20	2.25	2.52	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.23	2.30	2.43	
PULL #3	2.48	2.21	2.22	2.43	
PULL #4	2.56	2.28	2.21	2.41	
PULL #5	2.44	2.22	2.30	2.42	
TOTAL	12.34	11.14	11.28		
AVG.	2.468	2.228	2.256		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.39	3.22		
PULL #2	3.48	3.33		
PULL #3	3.29	3.03		
PULL #4	3.29	3.23		
PULL #5	3.47	3.25		
TOTAL	16.92	16.06		
AVG.	3.384	3.212		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.54	4.34		4.25
PULL #2	4.40	4.34		4.26
PULL #3	4.31	4.40		4.23
PULL #4	4.41	4.34		4.18
PULL #5	4.36	4.33		4.20
TOTAL	22.02	21.75		21.12
AVG.	4.404	4.35		4.224

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349118
16 May 1990

CENTROIDAL DISTANCES

0 TO 1	.22809
1 TO 2	.182157
1 TO 3	.455448
1 TO 4	.234079
1 TO 5	.222847

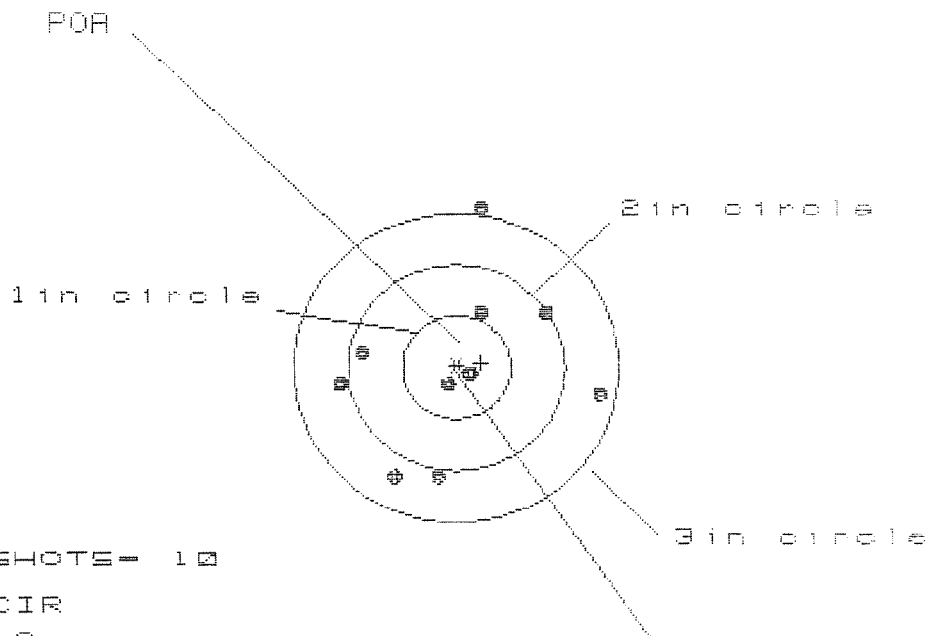
53 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0264
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0042
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .026732
THE AMR FOR THIS RIFLE IS: .9492

15 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/ C6349118

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 9

HS= 2.402

VS= 2.614

GS= 2.731

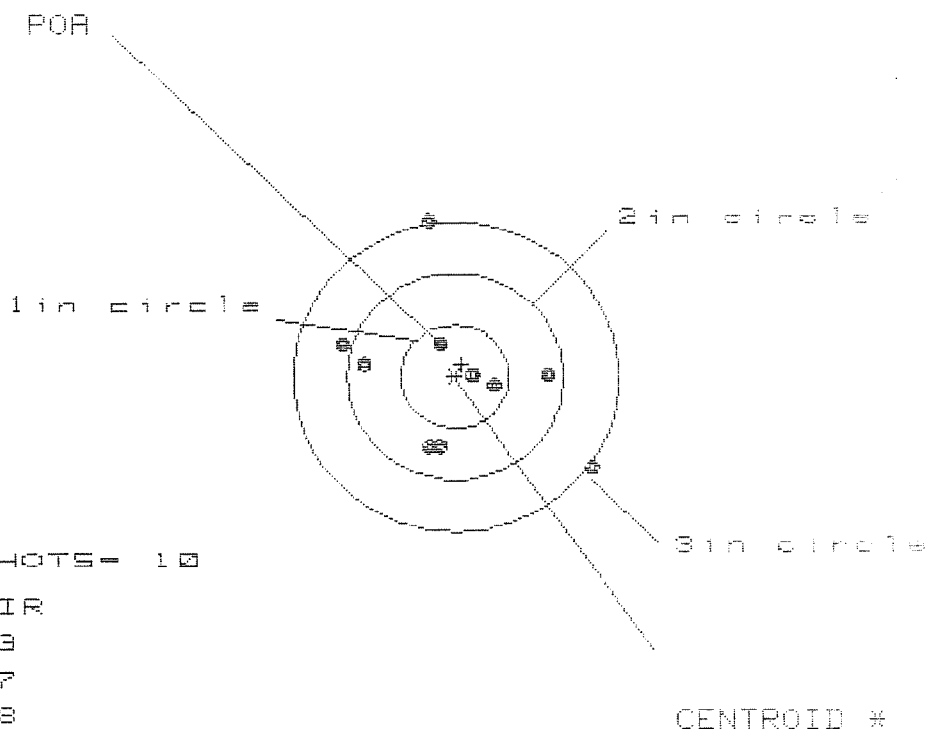
CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.367	1.399	1.049
MINIMUM X	:	-1.035	-1.013	-0.839
MAXIMUM Y	:	1.540	.752	.743
MINIMUM Y	:	-1.074	-.903	-.912
CENTROID X	:	-.224	-.246	-.420
CENTROID Y	:	-.043	-.214	-.205
POR TO CENTROID in.	:	.228	.326	.467
MIN RADIUS	:	.134	.029	.150
MEAN RADIUS	:	.901	.812	.744
MAX RADIUS	:	1.552	1.391	1.285
HORIZONTAL SPREAD	:	2.402	2.402	1.888
VERTICAL SPREAD	:	2.614	1.655	1.655
EXTREME SPREAD	:	2.731	2.403	2.200
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

15 May 1998

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 7

3 in = 8

HS= 2.327

VS= 2.437

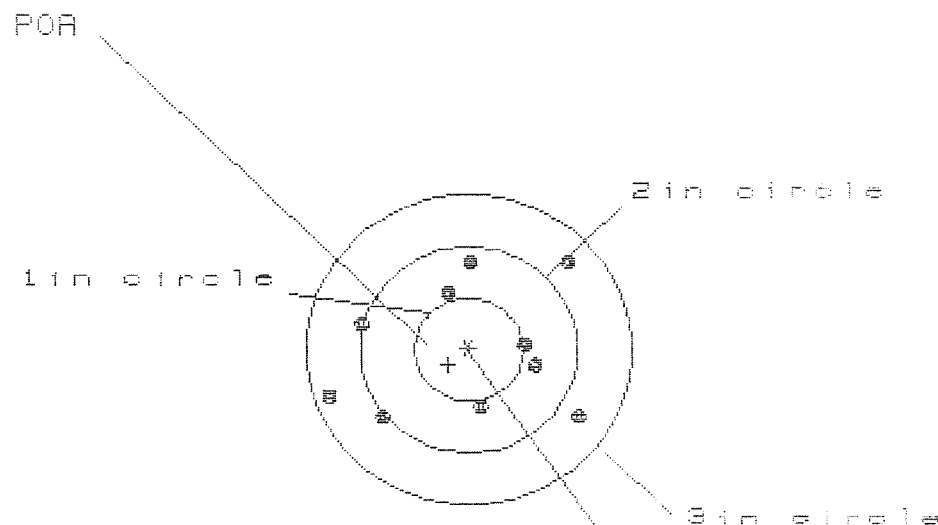
GS= 2.875

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.295	.975	.964
MINIMUM X	:	-1.032	-.888	-.899
MAXIMUM Y	:	1.520	1.418	.437
MINIMUM Y	:	-.917	-.825	-.648
CENTROID X	:	-.058	-.202	-.191
CENTROID Y	:	-.118	-.016	-.193
POA TO CENTROID in.	:	.131	.202	.272
MIN RADIUS	:	.177	.239	.330
MEAN RADIUS	:	.829	.747	.652
MAX RADIUS	:	1.587	1.421	1.000
HORIZONTAL SPREAD	:	2.327	1.963	1.863
VERTICAL SPREAD	:	2.437	2.243	1.085
EXTREME SPREAD	:	2.875	2.243	1.898
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

15 May 1998

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

HS = 2.349

VS = 1.540

GS = 2.569

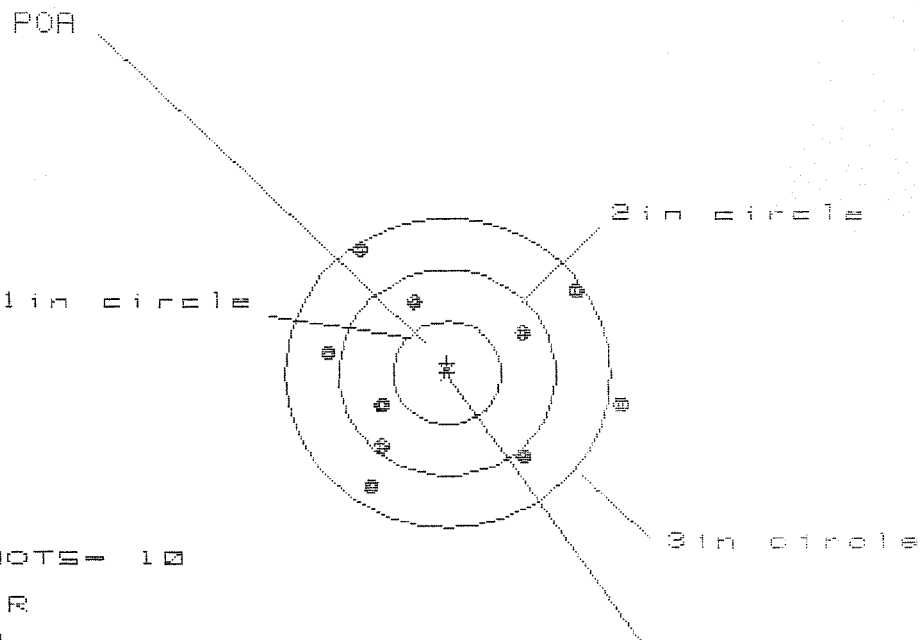
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.047	.902	.996
MINIMUM X	:	-1.302	-1.146	-1.052
MAXIMUM Y	:	.074	.023	.097
MINIMUM Y	:	-.666	-.717	-.614
CENTROID X	:	.189	.334	.240
CENTROID Y	:	.149	.200	.097
POA TO CENTROID in.	:	.241	.389	.259
MIN RADIUS	:	.499	.353	.436
MEAN RADIUS	:	.908	.833	.801
MAX RADIUS	:	1.380	1.166	1.170
HORIZONTAL SPREAD	:	2.349	2.048	2.048
VERTICAL SPREAD	:	1.540	1.540	1.511
EXTREME SPREAD	:	2.569	2.271	2.229
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

15 May 1998

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 4

3 in = 9

HS= 2.729

VS= 2.299

GS= 2.813

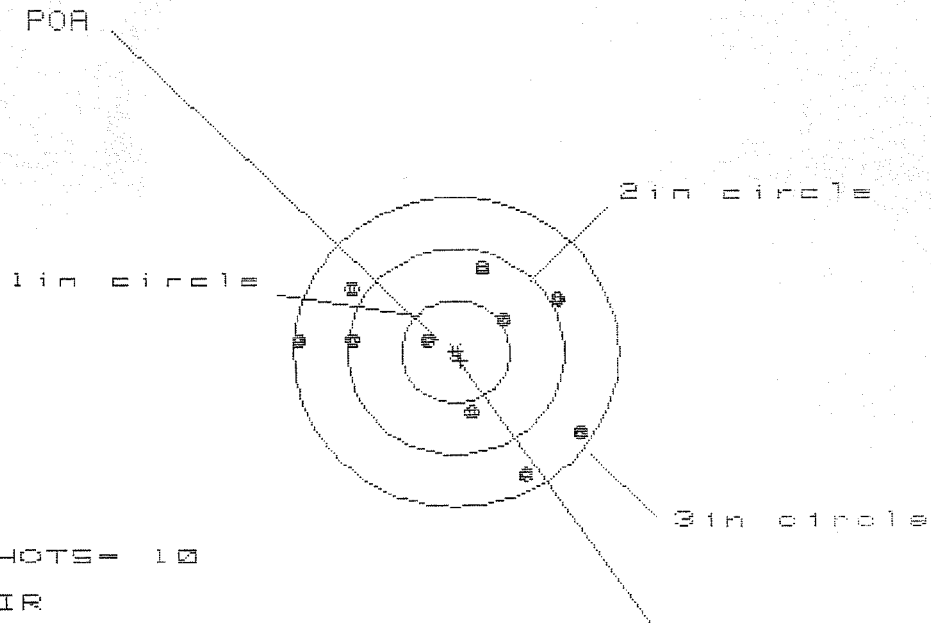
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.607	1.421	1.018
MINIMUM X	:	-1.122	-.943	-.765
MAXIMUM Y	:	1.198	1.169	1.263
MINIMUM Y	:	-1.101	-1.130	-1.037
CENTROID X	:	.004	-.175	-.353
CENTROID Y	:	-.096	-.067	-.160
POA TO CENTROID in.	:	.096	.188	.387
MIN RADIUS	:	.664	.532	.339
MEAN RADIUS	:	1.121	1.039	.932
MAX RADIUS	:	1.627	1.604	1.339
HORIZONTAL SPREAD	:	2.729	2.364	1.783
VERTICAL SPREAD	:	2.299	2.299	2.299
EXTREME SPREAD	:	2.813	2.725	2.503
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

15 May 1988

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

HS= 2.654

VS= 2.025

GS= 2.804

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.189	1.026	.928
MINIMUM X	:	-1.465	-1.115	-.987
MAXIMUM Y	:	.835	.843	.740
MINIMUM Y	:	-1.190	-1.182	-1.285
CENTROID X	:	-.043	.120	-.008
CENTROID Y	:	.087	.079	.182
POA TO CENTROID in.	:	.097	.143	.163
MIN RADIUS	:	.324	.410	.334
MEAN RADIUS	:	.987	.928	.858
MAX RADIUS	:	1.467	1.318	1.443
HORIZONTAL SPREAD	:	2.654	2.141	1.915
VERTICAL SPREAD	:	2.025	2.025	2.025
EXTREME SPREAD	:	2.804	2.597	2.458
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	