

06349182

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.

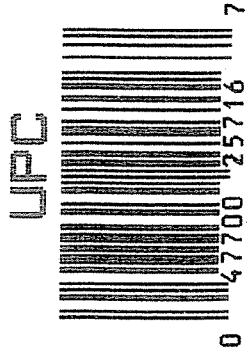
REG. U.S. PAT. & TM. OFF.

MODEL 700™ H24

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

SERIAL NO.
C6349182

ORDER NO.
5716



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349182

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 31	90	RW
600	Proof	3 31	90	RW
607	Check Headspace	3 31	90	RW
610	Dis-assemble Gun	3 31	90	RW
612	Magnaflux Barrel Action	4-2-90		KER
	Magnaflux Bolt	4-2-90		KER
615	Rollmark Caliber	4-2-90		GB
617	Drill and Tap Sight Holes		4/4/90	FB
618	Polish Barrel RB		4/5/90	WB
620	Apply Coatings (Barrel Action)		4-9-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/18/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/18/90	RW
	C) Inspect Ejector Hole for Chamfer		4/18/90	RW
	D) Oil Firing Pin Ass'y		4/18/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4/24/90	DL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			4/25/90	JH
	G) Safety Off Force	2	2	2			4/25/90	JH
	H) Trigger Pull Test & Retainability						4/24/90	JH
	I) Firing Pin Indent	.0205	.020	.020			4/26/90	JH
	J) Assemble Stock						4/25/90	RW
	K) Assemble Swivel Studs						5/1/90	WB
	L) Attach Front and Rear Sight Assemblies						4/25/90	RW
	M) Iron Sight Alignment						4/25/90	RW
	N) Detach Front & Rear Sights & place in numbered container						4/25/90	RW
	O) Attach Scope to Rifle						4/25/90	WB
	P) Detach & Attach Scope 20 Times						4/25/90	WB
640	Gallery Target & Test						4-26-90	DH
	A) Time						4-26-90	DH
	B) Malfunctions						4-26-90	DH
	C) Pierced Primers						4-26-90	DH
	D) Optical Clarity of Scope						4-26-90	DH
645	Inspect for Live Ammo						4-26-90	DH
655	Final Inspection						5/1/90	WB
	A) Headspace							
	B) Trigger Pull	2.72	2.76	2.73	2.76	2.75	5/1/90	WB
	C) Function						5/1/90	WB
660	Pack						6/19/90	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO C6349182

DATE 4/24/90

TESTER JPI

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.50	2.39	2.40	2.72	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.39	2.43	2.38	2.76	
PULL #3	2.45	2.49	2.41	2.73	
PULL #4	2.40	2.43	2.48	2.76	
PULL #5	2.36	2.38	2.34	2.75	
TOTAL	12.10	12.12	12.01		
AVG.	2.42	2.424	2.401		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.41	3.38		
PULL #2	3.35	3.40		
PULL #3	3.40	3.44		
PULL #4	3.32	3.39		
PULL #5	3.42	3.32		
TOTAL	16.90	16.93		
AVG.	3.38	3.386		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.27	4.42		4.25
PULL #2	4.25	4.39		4.09
PULL #3	4.38	4.43		4.13
PULL #4	4.13	4.19		4.29
PULL #5	4.35	4.45		4.31
TOTAL	21.38	21.85		21.04
AVG.	4.276	4.37		4.208

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349182
26 Apr 1990

CENTROIDAL DISTANCES

0 TO	1	.8369
1 TO	2	.858164
1 TO	3	.838648
1 TO	4	.745952
1 TO	5	.812252

$\frac{2}{3}$ 1 <----POA

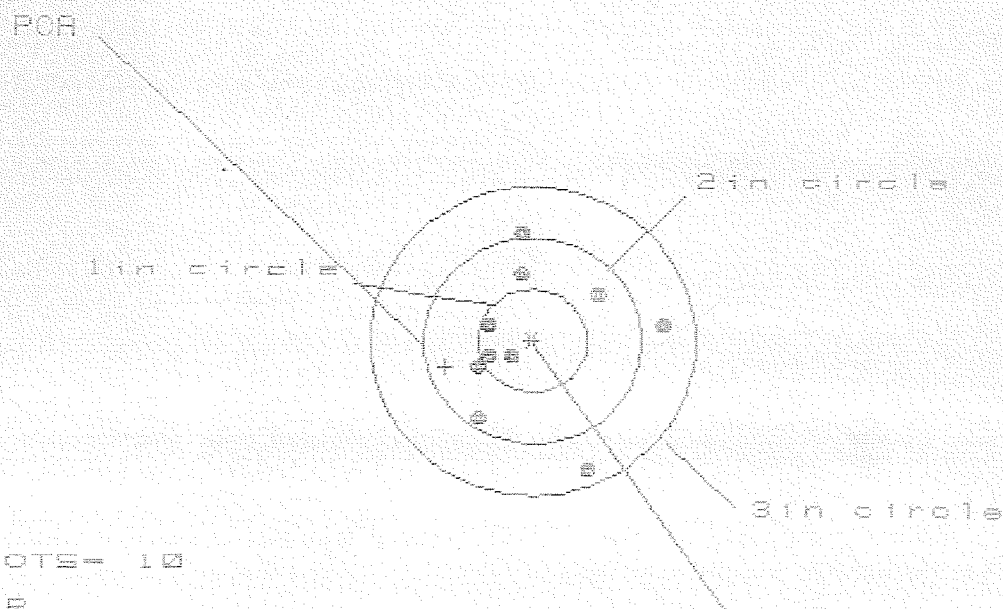
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1814
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .270011

THE AMR FOR THIS RIFLE IS: .8696

26 Apr 1990

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CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 1.749

VS= 2.279

GS= 2.363

CENTROID *

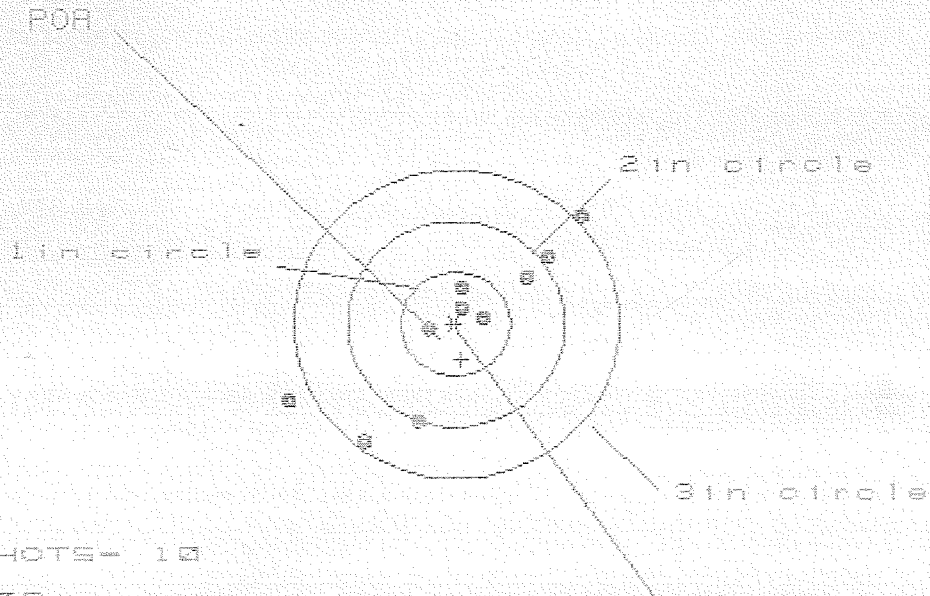
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.201	1.261	.822
MINIMUM X	-.547	-.488	-.330
MAXIMUM Y	1.045	.908	.915
MINIMUM Y	-1.234	-.873	-.866
CENTROID X	.799	.740	.582
CENTROID Y	.249	.386	.379
POB TO CENTROID in.	.837	.835	.695
MIN RADIUS	.270	.297	.140
MEAN RADIUS	.765	.679	.561
MAX RADIUS	1.345	1.262	.927
HORIZONTAL SPREAD	1.749	1.749	1.152
VERTICAL SPREAD	2.279	1.781	1.781
EXTREME SPREAD	2.363	1.983	1.838
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

26 Apr 1998

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CENTERFIRE PATTERNS

2



OF SHOTS- 10

IN CIR

1in = 4

2in = 6

3in = 6

HS= 2.609

VS= 2.139

GS= 3.176

CENTROID *

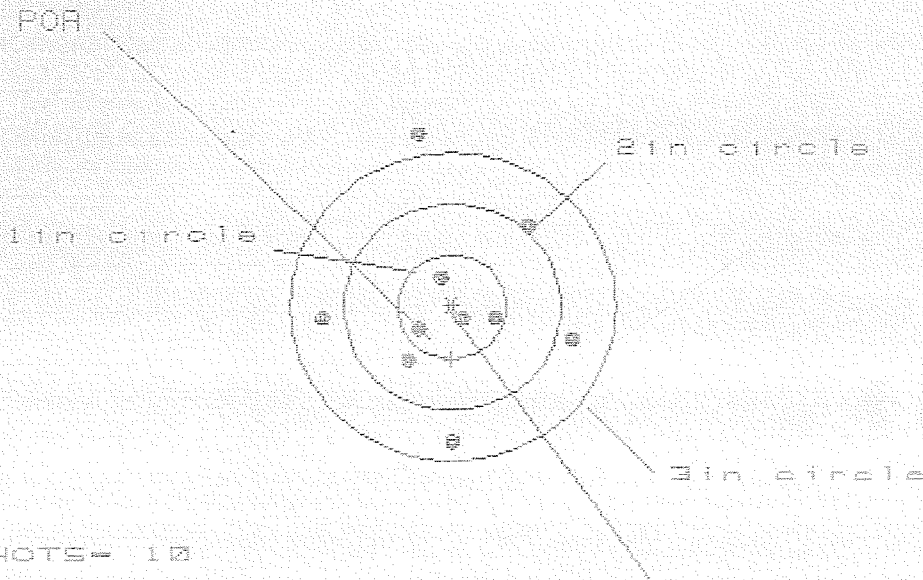
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.107	.940	.770
MINIMUM X	-1.502	-.983	-.865
MAXIMUM Y	1.037	.951	.667
MINIMUM Y	-1.102	-1.188	-1.070
CENTROID X	-.054	.113	-.085
CENTROID Y	.343	.429	.310
POB TO CENTROID in.	.348	.444	.311
MIN RADIUS	.168	.094	.200
MEAN RADIUS	.839	.711	.653
MAX RADIUS	1.690	1.542	1.376
HORIZONTAL SPREAD	2.609	1.923	1.643
VERTICAL SPREAD	2.139	2.139	1.737
EXTREME SPREAD	3.176	2.876	2.391
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

26 Apr 1990

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CENTERFIRE PATTERNS

3



OF SHOTS= 10

IN CIR

1in = 4

2in = 5

3in = 9

HS= 2.325

VS= 2.969

GS= 2.980

CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.095	1.066	1.062
MINIMUM X	:	-1.230	-1.259	-1.253
MAXIMUM Y	:	1.640	1.019	.876
MINIMUM Y	:	-1.329	-1.147	-.462
CENTROID X	:	.002	.031	.035
CENTROID Y	:	.510	.328	.471
POA TO CENTROID in.	:	.510	.329	.473
MIN RADIUS	:	.158	.072	.108
MEAN RADIUS	:	.836	.723	.665
MAX RADIUS	:	1.661	1.262	1.265
HORIZONTAL SPREAD	:	2.325	2.325	2.325
VERTICAL SPREAD	:	2.969	2.166	1.338
EXTREME SPREAD	:	2.980	2.338	2.338
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

26 Apr 1998

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CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 2.868

VS= 1.825

GS= 2.972

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.536	1.375	1.230
MINIMUM X	:	-1.332	-1.161	-1.086
MAXIMUM Y	:	.978	.911	.926
MINIMUM Y	:	-.847	-.914	-.899
CENTROID X	:	.113	-.058	.087
CENTROID Y	:	-.044	.023	.008
POA TO CENTROID in.	:	.121	.062	.087
MIN RADIUS	:	.394	.440	.359
MEAN RADIUS	:	.969	.884	.837
MAX RADIUS	:	1.649	1.376	1.231
HORIZONTAL SPREAD	:	2.868	2.536	2.316
VERTICAL SPREAD	:	1.825	1.825	1.825
EXTREME SPREAD	:	2.972	2.537	2.317
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

26 Apr 1998

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CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 10

HS= 2.474

VS= 1.980

GS= 2.481

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.390	1.046	1.132
MINIMUM X	-1.084	-.930	-.799
MAXIMUM Y	1.036	1.064	.949
MINIMUM Y	-.944	-.916	-.986
CENTROID X	.047	-.107	-.238
CENTROID Y	-.058	-.086	.029
POA TO CENTROID in.	.075	.137	.240
MIN RADIUS	.327	.232	.294
MEAN RADIUS	.939	.865	.785
MAX RADIUS	1.411	1.391	1.216
HORIZONTAL SPREAD	2.474	1.976	1.931
VERTICAL SPREAD	1.980	1.900	1.935
EXTREME SPREAD	2.481	2.410	2.087
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	10		