

C6611811

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.
MODEL 700TM H24		SERIAL NO. C6611811
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		ORDER NO. 5716



5716 C6611811



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611811

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 28	91	RW
600	Proof	3 28	91	RW
607	Check Headspace	3 28	91	RW
610	Dis-assemble Gun	3 28	91	RW
612	Magnaflux Barrel Action	APR	2 1991	KR
	Magnaflux Bolt	APR	2 1991	U
615	Rollmark Caliber	APR	2 1991	GS
617	Drill and Tap Sight Holes	APR	5 1991	FB
618	Polish Barrel	APR	5 1991	WB
620	Apply Coatings (Barrel Action)		4-9-91	JA
	Apply Coating (Bolt)			JA
625	Final Assembly A) Clean inside of Bolt Assembly		4/10/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/10/91	RW
	C) Inspect Ejector Hole for Chamfer		4/10/91	RW
	D) Oil Firing Pin Ass'y		4/10/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4-16-91	DH

op. #	BARBER - M24 0036379 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4.5	4	4			4-16-91	AF
	G) Safety Off Force	2	2	2.5			4-16-91	AC
	H) Trigger Pull Test & Retainability						4-16-91	D/H
	I) Firing Pin Indent	.021	.023	.022			4-16-91	AC
	J) Assemble Stock						4-17-91	RW
	K) Assemble Swivel Studs						4-24-91	D/H
	L) Attach Front and Rear Sight Assemblies						4-17-91	RW
	M) Iron Sight Alignment						4-17-91	RW
	N) Detach Front & Rear Sights & place in numbered container						4-17-91	RW
	O) Attach Scope to Rifle						4-17-91	RW
	P) Detach & Attach Scope 20 Times						4-17-91	RW
640	Gallery Target & Test						4-17-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						4-17-91	AF
655	Final Inspection							
	A) Headspace						4-24-91	D/H
	B) Trigger Pull	2.34	2.27	2.39	2.31	2.30	4-22-91	RW
	C) Function						4-24-91	D/H
660	Pack						6-15-91	AF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. CG61181

DATE 4-16-91

TESTER D/H

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.55	2.60	2.48	2.34	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.27	2.54	2.46	2.27	
PULL #3	2.54	2.59	2.51	2.39	
PULL #4	2.57	2.64	2.52	2.31	
PULL #5	2.61	2.65	2.49	2.30	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.02	3.08		
PULL #2	2.98	3.13		
PULL #3	3.05	3.18		
PULL #4	2.98	3.17		
PULL #5	2.95	3.22		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.41	4.53		4.01
PULL #2	4.44	4.63		3.98
PULL #3	4.46	4.70		3.95
PULL #4	4.45	4.30		4.34
PULL #5	4.55	4.76		4.16
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611811
17 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.202181
1 TO	2	.246489
1 TO	3	.371016
1 TO	4	.168929
1 TO	5	.175932

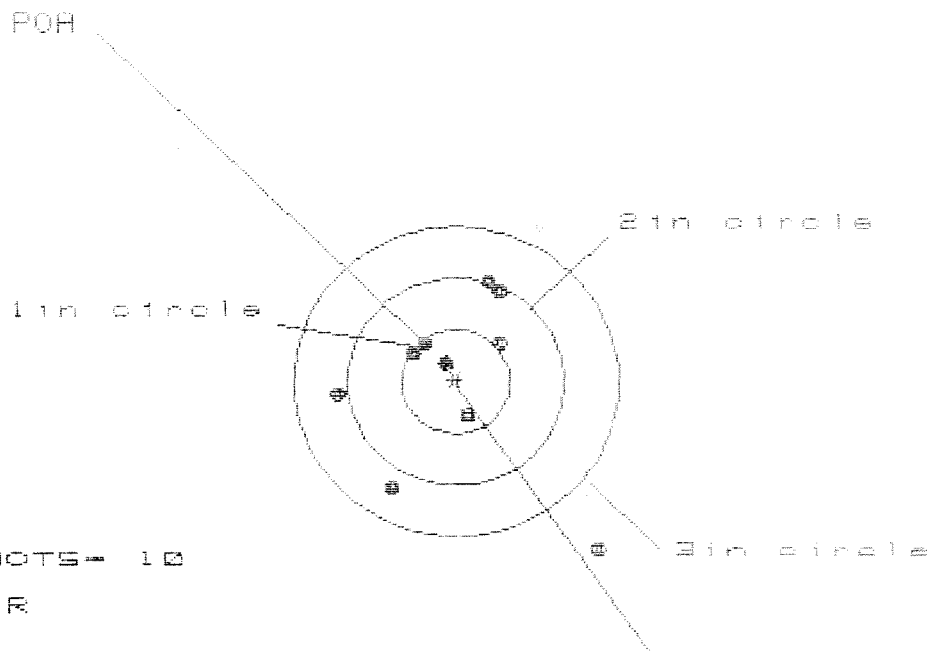
3.4 <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0136
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0396
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0419703
THE AMR FOR THIS RIFLE IS: .937

17 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CBB11811

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 4

2in = 5

3in = 8

HS = 2.369

VS = 2.594

GS = 2.813

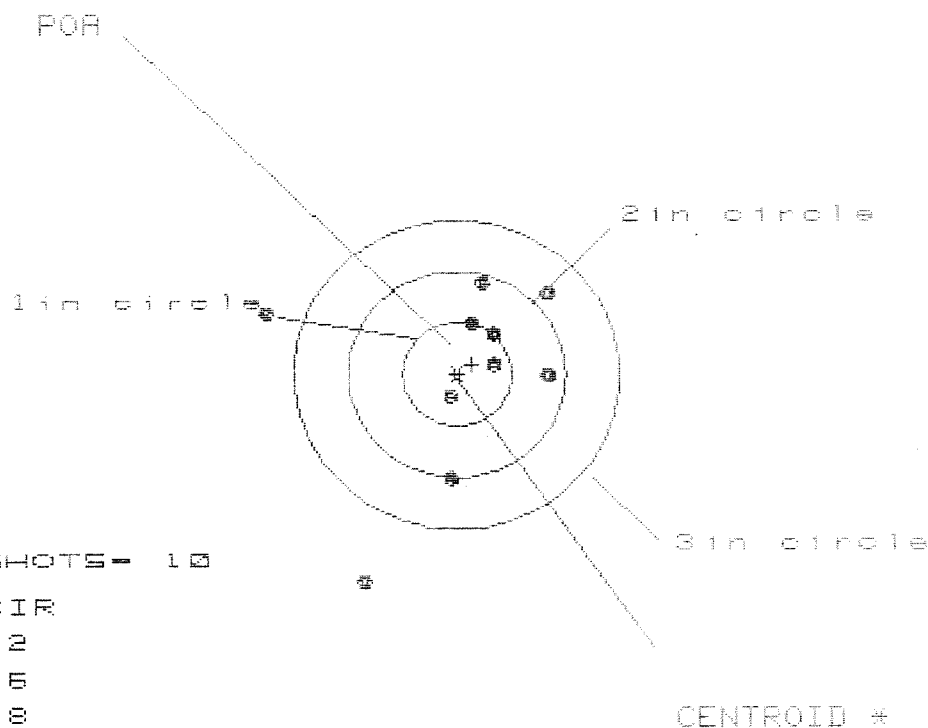
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.260	.594	.538
MINIMUM X	-1.109	-.969	-1.025
MAXIMUM Y	.990	.812	.663
MINIMUM Y	-1.604	-1.189	-.613
CENTROID X	.094	-.046	.010
CENTROID Y	-.179	-.001	.148
POA TO CENTROID in.	.202	.046	.148
MIN RADIUS	.244	.052	.110
MEAN RADIUS	.832	.637	.549
MAX RADIUS	2.040	1.270	1.106
HORIZONTAL SPREAD	2.369	1.563	1.563
VERTICAL SPREAD	2.594	2.001	1.276
EXTREME SPREAD	2.813	2.184	1.828
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS = 2.590

VS = 2.871

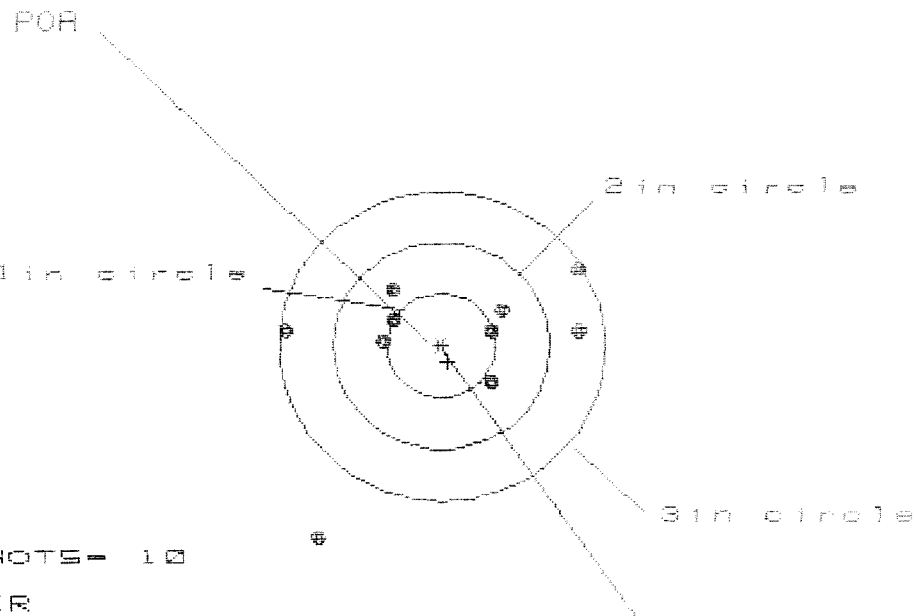
GS = 3.194

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.817	.725	.492
MINIMUM X	:	-1.773	-1.865	-1.433
MAXIMUM Y	:	.905	.686	.734
MINIMUM Y	:	-1.966	-1.260	-1.212
CENTROID X	:	-.137	-.045	.188
CENTROID Y	:	-.093	.126	.078
POA TO CENTROID in.	:	.165	.134	.203
MIN RADIUS	:	.220	.258	.034
MEAN RADIUS	:	.954	.763	.558
MAX RADIUS	:	2.131	1.984	1.287
HORIZONTAL SPREAD	:	2.590	2.590	.925
VERTICAL SPREAD	:	2.871	1.946	1.946
EXTREME SPREAD	:	3.194	2.669	2.039
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	8		

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS= 2.705

VS= 2.578

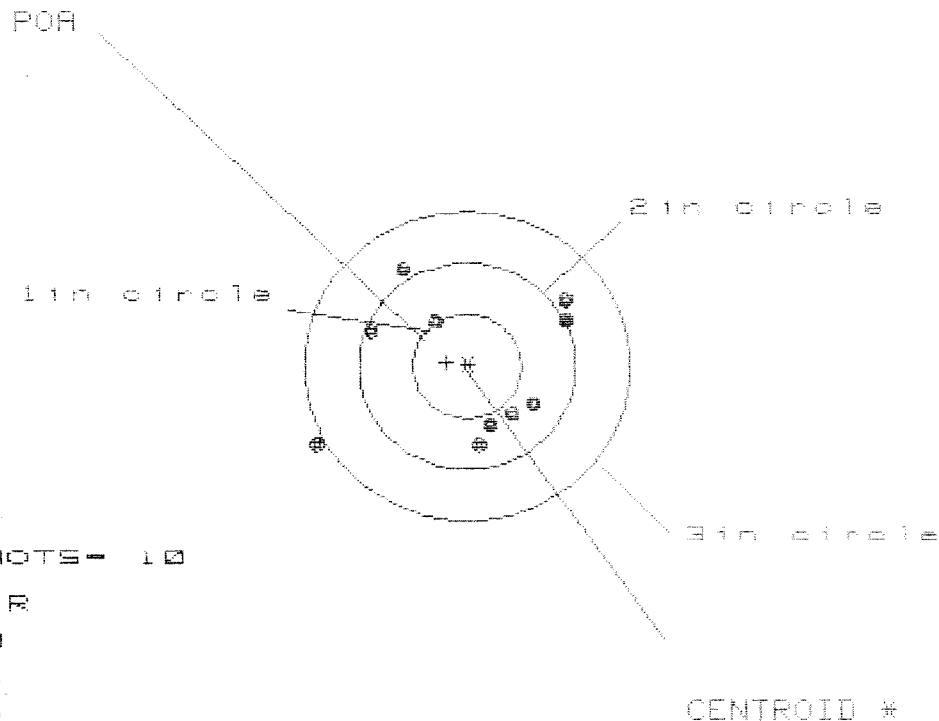
GS= 3.509

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.264
MINIMUM X	-1.441
MAXIMUM Y	.701
MINIMUM Y	-1.877
CENTROID X	-.059
CENTROID Y	.159
POA TO CENTROID in.	.169
MIN RADIUS	.467
MEAN RADIUS	.982
MAX RADIUS	2.196
HORIZONTAL SPREAD	2.705
VERTICAL SPREAD	2.578
EXTREME SPREAD	3.509
NUMBER IN ONE INCH CIRCLE	2
NUMBER IN TWO INCH CIRCLE	6
NUMBER IN THREE INCH CIRCLE	9

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FILE:/PATTERNING/CENTERFIRE_PATT/C8611811

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 6

3 in = 8

HS= 2.360

VS= 1.698

GS= 2.763

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.954	.797	.880
MINIMUM X	:	-1.406	-1.023	-.923
MAXIMUM Y	:	.933	.849	.922
MINIMUM Y	:	-.763	-.824	-.751
CENTROID X	:	.190	.347	.247
CENTROID Y	:	-.040	.044	-.029
POA TO CENTROID in.	:	.195	.349	.240
MIN RADIUS	:	.568	.608	.590
MEAN RADIUS	:	.910	.821	.799
MAX RADIUS	:	1.600	1.156	1.149
HORIZONTAL SPREAD	:	2.360	1.820	1.803
VERTICAL SPREAD	:	1.696	1.673	1.673
EXTREME SPREAD	:	2.763	1.852	1.831
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS

5

3.61 0000

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 0

2in = 7

3in = 9

CENTROID #

HS= 2.386

VS= 2.623

GS= 2.786

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.954	1.050	.883
MINIMUM X	:	-1.432	-1.336	-.859
MAXIMUM Y	:	1.313	1.039	1.025
MINIMUM Y	:	-1.310	-1.164	-1.178
CENTROID X	:	-.020	-.116	.051
CENTROID Y	:	-.045	-.191	-.177
POA TO CENTROID in.	:	.049	.223	.184
MIN RADIUS	:	.623	.660	.524
MEAN RADIUS	:	1.007	.934	.865
MAX RADIUS	:	1.575	1.340	1.179
HORIZONTAL SPREAD	:	2.386	2.386	1.742
VERTICAL SPREAD	:	2.623	2.203	2.203
EXTREME SPREAD	:	2.786	2.416	2.235
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	