

C6636144

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.

MODEL 700TM H24

SERIAL NO.
C6636144

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

ORDER NO.
5716



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636144

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		5/3/91	KS
600	Proof		5/3/91	KS
607	Check Headspace		5/3/91	KS
610	Dis-assemble Gun		5/3/91	KS
612	Magnaflux Barrel Action	5 6 9 1		KCR
	Magnaflux Bolt	5 6 9 1		KCR
615	Rollmark Caliber	5 6 9 1		GS
617	Drill and Tap Sight Holes	5 15 9 1		LSB
618	Polish Barrel	5 15 9 1		WLB
620	Apply Coatings (Barrel Action)		5-25-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/30/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/91	KS
	C) Inspect Ejector Hole for Chamfer		5/30/91	KS
	D) Oil Firing Pin Ass'y		5/30/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		6-5-91	JA

op. #	BARBER - M24 0038228	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	5			6-5-91	JK
	G) Safety Off Force	3	3	3			6-5-91	JK
	H) Trigger Pull Test & Retainability						6-5-91	JK
	I) Firing Pin Indent	.0215	.021	.021			6-5-91	JK
	J) Assemble Stock						6/5/91	KS
	K) Assemble Swivel Studs						6-13-91	K
	L) Attach Front and Rear Sight Assemblies						6/5/91	KS
	M) Iron Sight Alignment						6/5/91	KS
	N) Detach Front & Rear Sights & place in numbered container						6/5/91	KS
	O) Attach Scope to Rifle						6/5/91	KS
	P) Detach & Attach Scope 20 Times						6/5/91	KS
640	Gallery Target & Test						6-6-91	AC
	A) Time						6-6-91	AC
	B) Malfunctions						6-6-91	AC
	C) Pierced Primers						6-6-91	AC
	D) Optical Clarity of Scope						6-6-91	AC
645	Inspect for Live Ammo						6-6-91	AC
655	Final Inspection							
	A) Headspace						6-13-91	K
	B) Trigger Pull	2.73	2.74	2.72	2.67	2.68	6-13-91	JK
	C) Function						6-13-91	AC
660	Pack						6-19-91	NE

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C 6636144

DATE 6-4-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.55	2.39	2.31	2.73	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.45	2.46	2.34	2.74	
PULL #3	2.42	2.45	2.22	2.72	
PULL #4	2.49	2.43	2.40	2.67	
PULL #5	2.46	2.48	2.35	2.68	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.20	3.40		
PULL #2	3.27	3.39		
PULL #3	3.23	3.44		
PULL #4	3.51	3.43		
PULL #5	3.42	3.47		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.57	4.35		4.25
PULL #2	4.56	4.29		4.22
PULL #3	4.56	4.28		4.46
PULL #4	4.36	4.21		4.23
PULL #5	4.19	4.28		4.51
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636144
6 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.479004
1 TO	2	.162631
1 TO	3	.500025
1 TO	4	.206228
1 TO	5	.461276

$\frac{4\frac{1}{2}}{790}$ <----POA

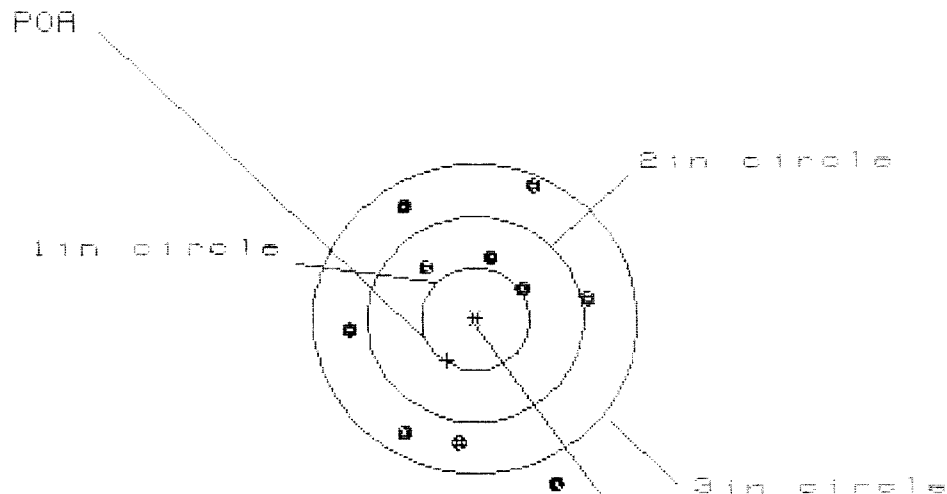
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .3026
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1756
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .34996

THE AMR FOR THIS RIFLE IS: 1.013

6 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636144

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 3

3 in = 8

HS= 2.130

VS= 2.929

GS= 3.029

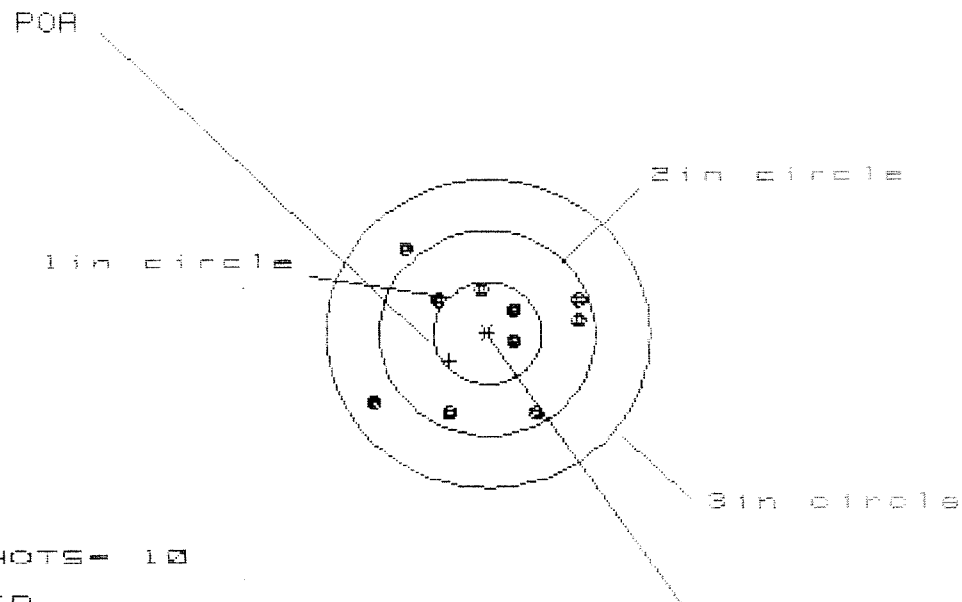
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.010	1.096	1.179
MINIMUM X	-1.120	-1.034	-.951
MAXIMUM Y	1.313	1.133	1.032
MINIMUM Y	-1.616	-1.360	-1.218
CENTROID X	.262	.176	.093
CENTROID Y	.401	.501	.439
POA TO CENTROID in.	.479	.607	.449
MIN RADIUS	.565	.448	.566
MEAN RADIUS	1.093	.979	.952
MAX RADIUS	1.793	1.394	1.231
HORIZONTAL SPREAD	2.130	2.130	2.130
VERTICAL SPREAD	2.929	2.493	2.250
EXTREME SPREAD	3.029	2.703	2.300
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	9		

5 Jun 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 8

3 in = 10

HS= 1.903

VS= 1.644

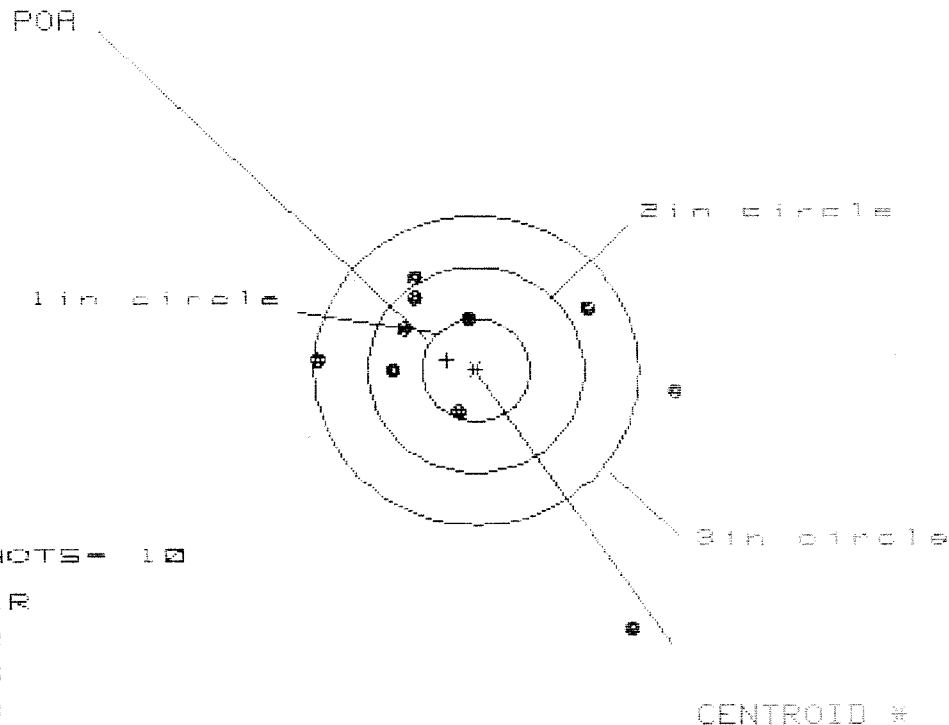
GS= 2.103

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.891	.778	.668
MINIMUM X	:	-1.012	-.877	-.691
MAXIMUM Y	:	.834	.757	.463
MINIMUM Y	:	-.810	-.887	-.792
CENTROID X	:	.357	.470	.580
CENTROID Y	:	.269	.346	.252
POA TO CENTROID in.	:	.447	.584	.632
MIN RADIUS	:	.233	.179	.045
MEAN RADIUS	:	.749	.668	.593
MAX RADIUS	:	1.227	1.158	.907
HORIZONTAL SPREAD	:	1.903	1.655	1.359
VERTICAL SPREAD	:	1.644	1.644	1.256
EXTREME SPREAD	:	2.103	2.043	1.576
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

6 Jun 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 3.256

VS= 3.377

GS= 3.917

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.784	1.941	1.391
MINIMUM X	-1.472	-1.315	-1.072
MAXIMUM Y	.881	.603	.539
MINIMUM Y	-2.497	-.678	-.742
CENTROID X	.267	.110	-.133
CENTROID Y	-.099	.179	.243
POA TO CENTROID in.	.285	.210	.277
MIN RADIUS	.420	.235	.265
MEAN RADIUS	1.167	.880	.673
MAX RADIUS	2.872	2.009	1.416
HORIZONTAL SPREAD	3.256	3.256	2.463
VERTICAL SPREAD	3.377	1.281	1.281
EXTREME SPREAD	3.917	3.276	2.509
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		8	

6 Jun 1981

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CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS = 2.180

VS = 3.204

GS = 3.261

CENTROID #

PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	.928
MINIMUM X	-1.252
MAXIMUM Y	1.881
MINIMUM Y	-1.323
CENTROID X	.095
CENTROID Y	.280
POA TO CENTROID in.	.296
MIN RADIUS	.215
MEAN RADIUS	.955
MAX RADIUS	1.977
HORIZONTAL SPREAD	2.180
VERTICAL SPREAD	3.204
EXTREME SPREAD	3.261
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	9

6 Jun 1991

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CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 0

2 in = 5

3 in = 9

HS = 2.779

VS = 2.705

GS = 2.979

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.489
MINIMUM X	-1.290
MAXIMUM Y	1.403
MINIMUM Y	-1.302
CENTROID X	.532
CENTROID Y	.027
POA TO CENTROID in.	.533
MIN RADIUS	.566
MEAN RADIUS	1.101
MAX RADIUS	1.539
HORIZONTAL SPREAD	2.779
VERTICAL SPREAD	2.705
EXTREME SPREAD	2.979
NUMBER IN ONE INCH CIRCLE =	0
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	9