

C6611561

MODEL 700TM M24

Model **SWS** TM

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 M24		SERIAL NO. C6611561
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		ORDER NO. 5716



5716 C6611561



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611561

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 11	91	KCH
	Magnaflux Bolt	2 11	91	KCH
615	Rollmark Caliber	2 11	91	ES
617	Drill and Tap Sight Holes	2 13	91	FB
618	Polish Barrel <i>AB</i>	2 13	91	WB
620	Apply Coatings (Barrel Action)		3/25/91	WB
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		3/25/91	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		4/4/91	<i>JP</i>

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			4/15/91	JL
	G) Safety Off Force	3	3	3			4/15/91	JL
	H) Trigger Pull Test & Retainability						4/4/91	JL
	I) Firing Pin Indent	.0235	.0235	.0235	.0235		4/15/91	JL
	J) Assemble Stock						4/11/91	RW
	K) Assemble Swivel Studs						4-16-91	A
	L) Attach Front and Rear Sight Assemblies						4/11/91	RW
	M) Iron Sight Alignment						4/11/91	RW
	N) Detach Front & Rear Sights & place in numbered container						4/11/91	RW
	O) Attach Scope to Rifle						4/11/91	RW
	P) Detach & Attach Scope 20 Times						4/11/91	RW
640	Gallery Target & Test						4-12-91	DH
	A) Time						4-12-91	DH
	B) Malfunctions						4-12-91	DH
	C) Pierced Primers						4-12-91	DH
	D) Optical Clarity of Scope						4-12-91	DH
645	Inspect for Live Ammo						4-12-91	DH
655	Final Inspection							
	A) Headspace						4-16-91	A
	B) Trigger Pull	2.13	2.15	2.17	2.19	2.19	4/14/91	JL
660	C) Function						4-16-91	A
660	Pack						6-17-91	N

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6611561DATE 4/4/91TESTER JRL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.50	2.50	2.52	2.13	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.49	2.51	2.50	2.15	
PULL #3	2.50	2.45	2.54	2.17	
PULL #4	2.45	2.43	2.50	2.19	
PULL #5	2.52	2.50	2.53	2.19	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.20	3.26		
PULL #2	3.56	3.24		
PULL #3	3.30	3.24		
PULL #4	3.52	3.19		
PULL #5	3.55	3.24		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.31	4.35		4.32
PULL #2	4.11	4.33		4.33
PULL #3	4.32	4.44		4.20
PULL #4	4.35	4.49		4.60
PULL #5	4.32	4.45		4.44
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611561
12 Apr 1991

CENTROIDAL DISTANCES

Ø TO	1	.14384
1 TO	2	.481191
1 TO	3	.689655
1 TO	4	.409649
1 TO	5	.434236

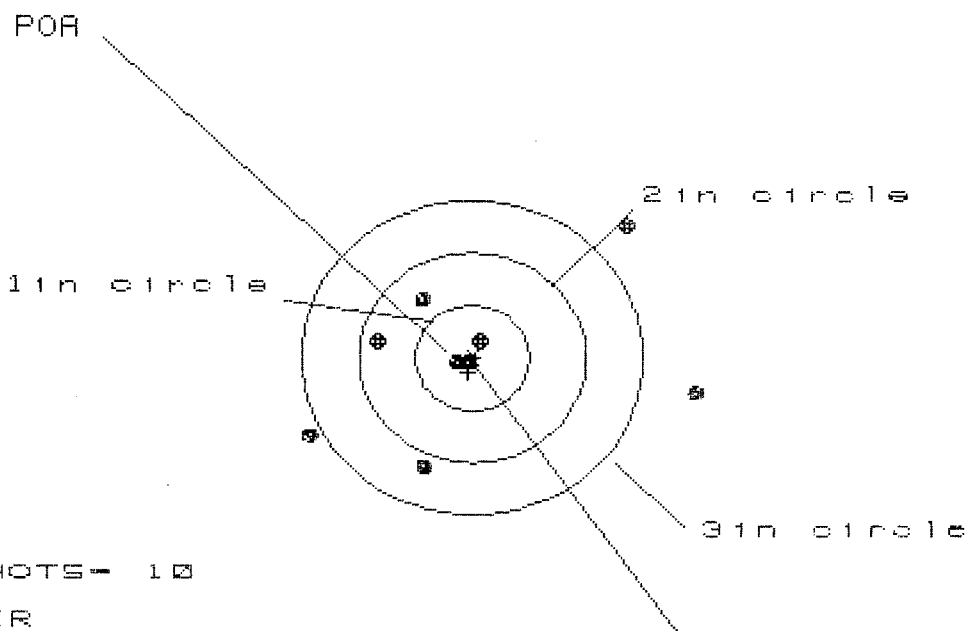
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THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .275
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1538
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .015086
AND FOR THIS RIFLE IS: .8856

13 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6811561

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 4

2in = 6

3in = 7

HS = 3.335

VS = 2.354

GS = 3.418

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.942	1.596	.502
MINIMUM X	-1.393	-1.177	-.978
MAXIMUM Y	1.304	1.271	.645
MINIMUM Y	-1.050	-1.083	-.925
CENTROID X	.037	-.179	-.378
CENTROID Y	.139	.172	.014
PCA TO CENTROID in.	.143	.248	.378
MIN RADIUS	.068	.066	.252
MEAN RADIUS	.069	.716	.595
MAX RADIUS	1.966	2.040	1.131
HORIZONTAL SPREAD	3.335	2.773	1.480
VERTICAL SPREAD	2.354	2.354	1.570
EXTREME SPREAD	3.418	3.418	1.716
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	7		

(2 Apr 1991

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CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 2.960

VS= 1.142

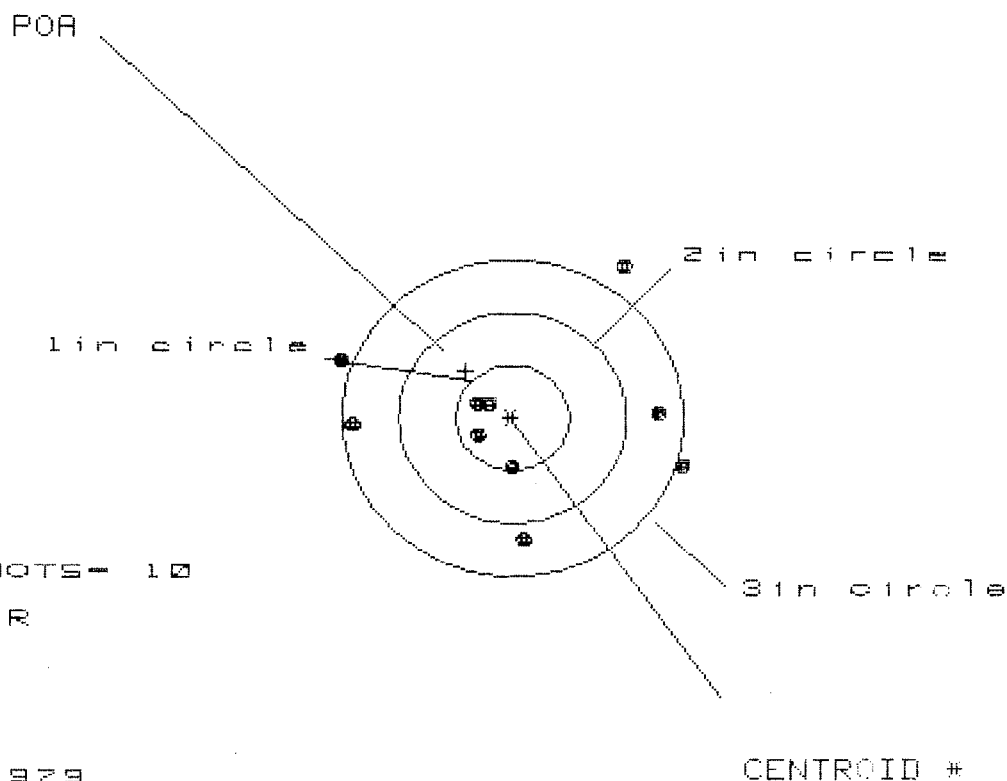
GS= 2.963

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.012	1.607	.644
MINIMUM X	:	-.948	-.724	-.523
MAXIMUM Y	:	.445	.479	.506
MINIMUM Y	:	-.697	-.663	-.637
CENTROID X	:	.504	.280	.079
CENTROID Y	:	.023	-.011	-.037
POA TO CENTROID in.	:	.504	.280	.088
MIN RADIUS	:	.388	.166	.062
MEAN RADIUS	:	.833	.599	.397
MAX RADIUS	:	2.035	1.621	.905
HORIZONTAL SPREAD	:	2.960	2.331	1.167
VERTICAL SPREAD	:	1.142	1.142	1.142
EXTREME SPREAD	:	2.963	2.346	1.633
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 4

2 in = 4

3 in = 7

HS = 2.979

VS = 2.676

GS = 3.161

PATTERN #	:	3
SHOTS (BEST OF)	:	10
MAXIMUM X	:	1.470
MINIMUM X	:	-1.509
MAXIMUM Y	:	1.473
MINIMUM Y	:	-1.203
CENTROID X	:	.407
CENTROID Y	:	-.443
POA TO CENTROID in.	:	.602
MIN RADIUS	:	.276
MEAN RADIUS	:	1.013
MAX RADIUS	:	1.774
HORIZONTAL SPREAD	:	2.979
VERTICAL SPREAD	:	2.676
EXTREME SPREAD	:	3.161
NUMBER IN ONE INCH CIRCLE	=	4
NUMBER IN TWO INCH CIRCLE	=	4
NUMBER IN THREE INCH CIRCLE	=	7

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CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 4

2 in = 5

3 in = 8

HS= 3.009

VS= 1.984

GS= 3.384

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.382	1.201	.841
MINIMUM X	:	-1.627	-1.217	-1.067
MAXIMUM Y	:	1.185	1.268	1.178
MINIMUM Y	:	-.799	-.716	-.645
CENTROID X	:	.221	.402	.252
CENTROID Y	:	-.227	-.310	-.220
POA TO CENTROID in.	:	.317	.508	.335
MIN RADIUS	:	.015	.198	.046
MEAN RADIUS	:	.807	.698	.589
MAX RADIUS	:	1.791	1.444	1.448
HORIZONTAL SPREAD	:	3.009	2.418	1.908
VERTICAL SPREAD	:	1.984	1.984	1.823
EXTREME SPREAD	:	3.384	2.473	2.407
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

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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 = 1

2 in = 5

3 in = 9

HS = 1.660

VS = 2.940

GS = 3.108

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.763	.695	.737
MINIMUM X	:	-.897	-.965	-.923
MAXIMUM Y	:	1.513	1.326	1.168
MINIMUM Y	:	-1.427	-1.258	-.864
CENTROID X	:	.206	.274	.232
CENTROID Y	:	-.261	-.429	-.271
POA TO CENTROID in.	:	.332	.509	.357
MIN RADIUS	:	.268	.434	.295
MEAN RADIUS	:	.906	.827	.745
MAX RADIUS	:	1.631	1.328	1.169
HORIZONTAL SPREAD	:	1.660	1.660	1.660
VERTICAL SPREAD	:	2.940	2.584	2.032
EXTREME SPREAD	:	3.108	2.616	2.075
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	