

CB594650

MODEL 700™ M24

Model **SWS**™

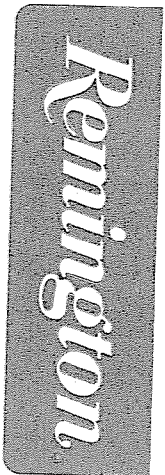
Action

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.

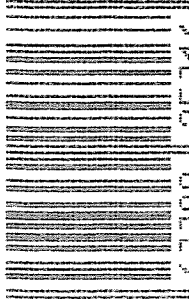
MODEL 700™ M24

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

SERIAL NO.
C6594650

ORDER NO.
5716

UPC



0 47700 25716 2



5716 C6594650

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6594650

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		12/27/90	KS.
600	Proof		12/27/90	KS.
607	Check Headspace		12/27/90	KS.
610	Dis-assemble Gun		12/27/90	KS.
612	Magnaflux Barrel Action		1-9-91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	GS
617	Drill and Tap Sight Holes	1 10 91		FB
618	Polish Barrel	1 10 91		WB
620	Apply Coatings (Barrel Action)		1-22-91	TA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		1/29/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/29/91	KS
	C) Inspect Ejector Hole for Chamfer		1/29/91	KS
	D) Oil Firing Pin Ass'y		1/29/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		2/20/91	JK

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/2	5 1/2	5 1/2			1/30/91	WB
	G) Safety Off Force	3	3	3			1/30/91	WB
	H) Trigger Pull Test & Retainability						2/21/91	X/
	I) Firing Pin Indent	.020	.020	.020			1/30/91	WB
	J) Assemble Stock						1/31/91	KS
	K) Assemble Swivel Studs						2-21-91	A
	L) Attach Front and Rear Sight Assemblies						1/31/91	KS
	M) Iron Sight Alignment						1/31/91	KS
	N) Detach Front & Rear Sights & place in numbered container						1/31/91	KS
	O) Attach Scope to Rifle						1/31/91	KS
	P) Detach & Attach Scope 20 Times						1/31/91	KS
640	Gallery Target & Test						1-31-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect. for Live Ammo						1-31-91	NF
655	Final Inspection							
	A) Headspace						2-21-91	A
	B) Trigger Pull	2.48	2.49	2.42	2.40	2.38	2/20/91	WB
	C) Function						2-21-91	A
660	Pack						3-19-91	NF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6594650

DATE 2/11/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.31	2.26	2.48	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.44	2.29	2.24	2.49	
PULL #3	2.44	2.20	2.24	2.47	
PULL #4	2.42	2.24	2.25	2.40	
PULL #5	2.43	2.24	2.23	2.38	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.18	3.49		
PULL #2	3.16	3.43		
PULL #3	3.47	3.41		
PULL #4	3.44	3.44		
PULL #5	3.44	3.39		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.19	4.21		4.14
PULL #2	4.19	4.18		4.16
PULL #3	4.20	4.20		4.17
PULL #4	4.20	4.22		4.18
PULL #5	4.20	4.17		4.19
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594650
31 Jan 1991

CENTROIDAL DISTANCES

0 TO 1	.184011
1 TO 2	.0451885
1 TO 3	.441328
1 TO 4	.206787
1 TO 5	.335622

5
4
3

<----POA

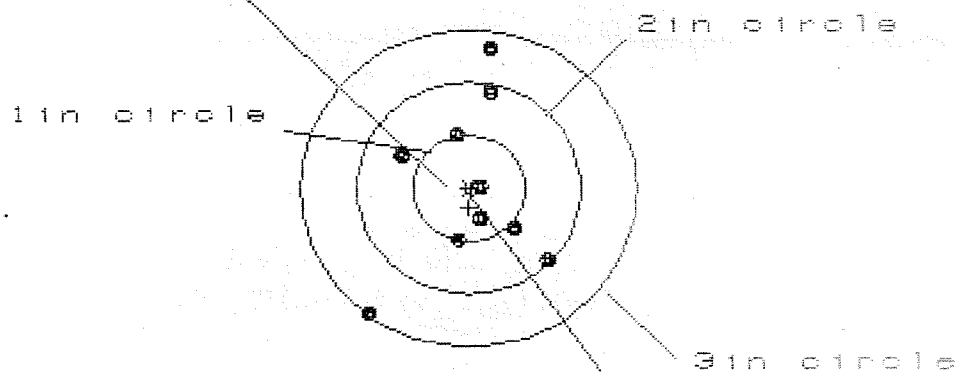
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0552
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1218
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .133725
THE AMR FOR THIS RIFLE IS: .8472

31 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594850

CENTERFIRE PATTERNS # 1

POA



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.610

VS= 2.443

GS= 2.677

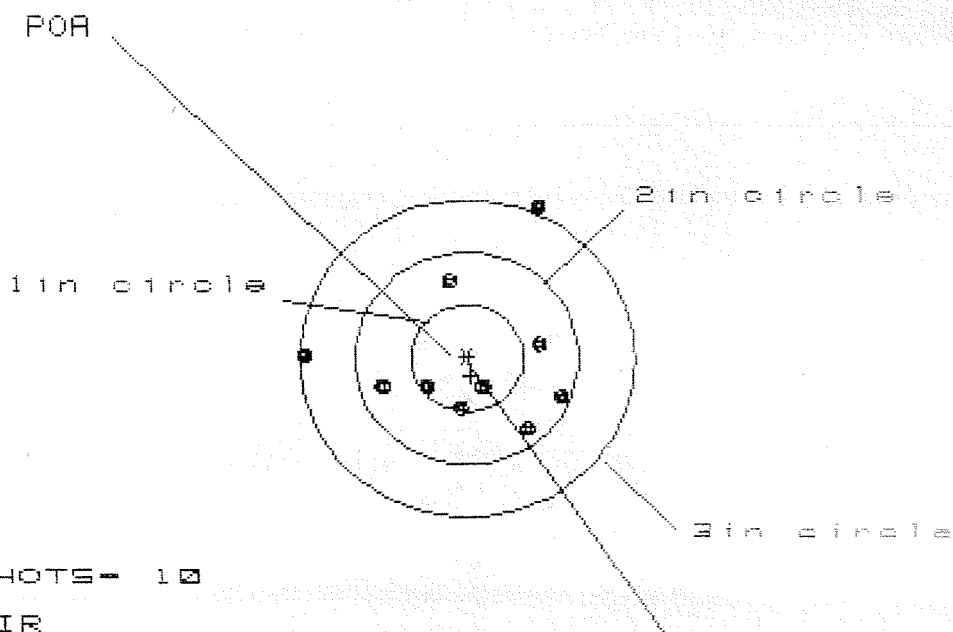
CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.700	.599	.610
MINIMUM X	:	-.910	-.726	-.715
MAXIMUM Y	:	1.298	1.171	.943
MINIMUM Y	:	-1.145	-.803	-.656
CENTROID X	:	.002	.103	.092
CENTROID Y	:	.184	.311	.164
POA TO CENTROID in.	:	.184	.327	.188
MIN RADIUS	:	.134	.096	.067
MEAN RADIUS	:	.741	.659	.565
MAX RADIUS	:	1.462	1.174	.951
HORIZONTAL SPREAD	:	1.610	1.325	1.325
VERTICAL SPREAD	:	2.443	1.974	1.599
EXTREME SPREAD	:	2.677	2.040	1.670
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

31 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594650

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 8

3 in = 9

HS= 2.262

VS= 2.096

GS= 2.517

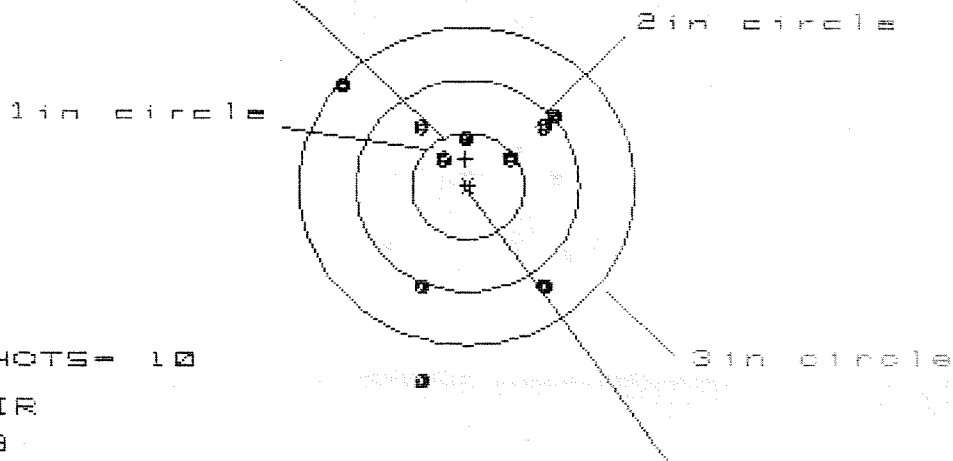
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.811	.880	.707
MINIMUM X	:	-1.451	-1.382	-.862
MAXIMUM Y	:	1.411	.924	.942
MINIMUM Y	:	-.685	-.528	-.510
CENTROID X	:	-.039	-.108	.065
CENTROID Y	:	.165	.008	-.010
POA TO CENTROID in.	:	.169	.108	.065
MIN RADIUS	:	.323	.228	.131
MEAN RADIUS	:	.823	.704	.602
MAX RADIUS	:	1.543	1.389	.976
HORIZONTAL SPREAD	:	2.262	2.262	1.569
VERTICAL SPREAD	:	2.096	1.452	1.452
EXTREME SPREAD	:	2.517	2.291	1.614
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

31 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8594650

CENTERFIRE PATTERNS # 3

POA



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 5

3 in = 8

HS= 1.916

VS= 2.822

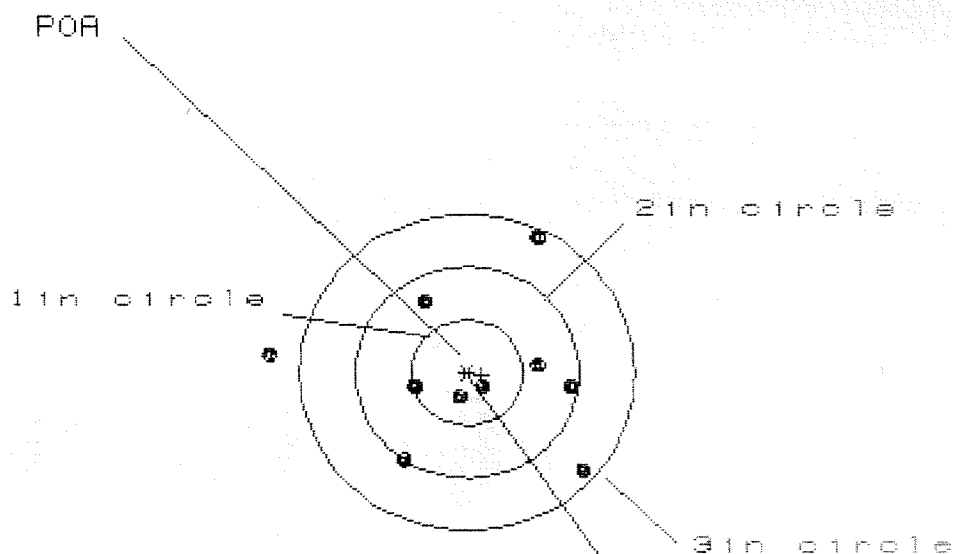
GS= 2.912

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.771	.724	.575
MINIMUM X	:	-1.145	-1.192	-.606
MAXIMUM Y	:	1.004	.802	.540
MINIMUM Y	:	-1.818	-1.175	-1.075
CENTROID X	:	.019	.066	.215
CENTROID Y	:	-.257	-.055	-.155
POA TO CENTROID in.	:	.258	.086	.265
MIN RADIUS	:	.342	.248	.279
MEAN RADIUS	:	.937	.771	.701
MAX RADIUS	:	1.867	1.436	1.198
HORIZONTAL SPREAD	:	1.916	1.916	1.181
VERTICAL SPREAD	:	2.822	1.977	1.615
EXTREME SPREAD	:	2.912	2.721	1.954
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

31 Jan 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 2.746

VS= 2.127

GS= 2.958

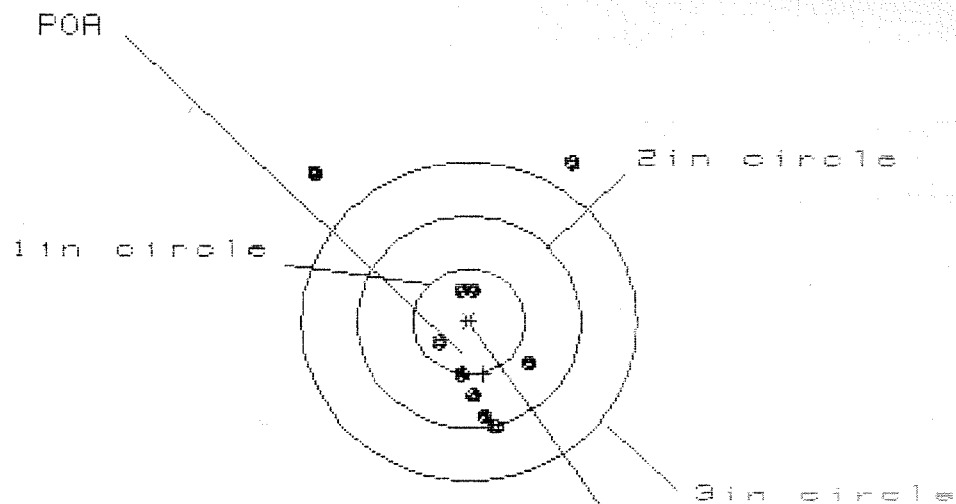
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.987	.792	.846
MINIMUM X	:	-1.759	-.726	-.672
MAXIMUM Y	:	1.247	1.271	.895
MINIMUM Y	:	-.880	-.856	-.697
CENTROID X	:	-.129	.066	.012
CENTROID Y	:	.024	-.000	-.159
POA TO CENTROID in.	:	.131	.066	.159
MIN RADIUS	:	.148	.125	.086
MEAN RADIUS	:	.875	.766	.673
MAX RADIUS	:	1.773	1.343	1.096
HORIZONTAL SPREAD	:	2.746	1.518	1.518
VERTICAL SPREAD	:	2.127	2.127	1.592
EXTREME SPREAD	:	2.958	2.356	2.087
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

31 Jan 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 8

HS= 2.384

VS= 2.544

GS= 2.927

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.971	.814	.513
MINIMUM X	:	-1.413	-.466	-.364
MAXIMUM Y	:	1.544	1.705	.729
MINIMUM Y	:	-1.000	-.839	-.626
CENTROID X	:	-.129	.028	-.073
CENTROID Y	:	.493	.332	.119
POA TO CENTROID in.	:	.510	.333	.140
MIN RADIUS	:	.277	.433	.200
MEAN RADIUS	:	.860	.704	.490
MAX RADIUS	:	2.026	1.889	.732
HORIZONTAL SPREAD	:	2.384	1.280	.878
VERTICAL SPREAD	:	2.544	2.544	1.355
EXTREME SPREAD	:	2.927	2.663	1.368
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	