

06587512

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

SERIAL NO.

C6587512

ORDER NO.

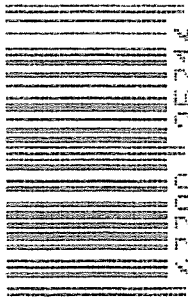
5716

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



5716 C6587512

UPC



0 47700 25746 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6587512

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY CONTROL LOG	10/31/90	Kd
600	Proof		10/31/90	Kd
607	Check Headspace		10/31/90	Kd
610	Dis-assemble Gun		10/31/90	Kd
612	Magnaflux Barrel Action		11/1/90	KCR
	Magnaflux Bolt		11/1/90	KCR
615	Rollmark Caliber		11/1/90	KCR
617	Drill and Tap Sight Holes		11/6/90	LB
618	Polish Barrel <i>LB</i>		11/7/90	LB
620	Apply Coatings (Barrel Action)		12/26/90	<i>LB</i>
	Apply Coating (Bolt)		12/26/90	
625	Final Assembly A) Clean inside of Bolt Assembly		12/28/90	K.S.
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/28/90	K.S.
	C) Inspect Ejector Hole for Chamfer		12/28/90	K.S.
	D) Oil Firing Pin Ass'y		12/28/90	K.S.
	E) Adjust Trigger Pull to Min Setting and Stake		1-4-91	<i>LB</i>

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4.75	4.50	4.75			1/2/91	KZ
	G) Safety Off Force	2.75	2.75	2.75			1/2/91	KZ
	H) Trigger Pull Test & Retainability						1-4-91	JH
	I) Firing Pin Indent	.021	.021	.021			1/2/91	KZ
	J) Assemble Stock						1-4-91	KS
	K) Assemble Swivel Studs						1-14-91	JH
	L) Attach Front and Rear Sight Assemblies						1-4-91	KS
	M) Iron Sight Alignment						1-4-91	KS
	N) Detach Front & Rear Sights & place in numbered container						1-4-91	KS
	O) Attach Scope to Rifle						1-4-91	KS
	P) Detach & Attach Scope 20 Times						1-4-91	KS
640	Gallery Target & Test						1-13-91	AC
	A) Time						1-13-91	AC
	B) Malfunctions						1-13-91	AC
	C) Pierced Primers						1-13-91	AC
	D) Optical Clarity of Scope						1-13-91	AC
645	Inspect for Live Ammo						1-13-91	AC
655	Final Inspection							
	A) Headspace						1-14-91	JH
	B) Trigger Pull	2.54	2.26	2.24	2.13	2.13	1-14-91	JH
	C) Function						1-14-91	JH
660	Pack						3-18-91	VF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 06587512

DATE 1-4-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.35	2.29	2.54	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.27	2.40	2.33	2.26	
PULL #3	2.47	2.36	2.27	2.21	
PULL #4	2.29	2.38	2.28	2.13	
PULL #5	2.33	2.37	2.20	2.13	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.39	3.33		
PULL #2	3.35	3.31		
PULL #3	3.30	3.33		
PULL #4	3.29	3.24		
PULL #5	3.31	3.33		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.47	4.33		4.28
PULL #2	4.39	4.30		4.20
PULL #3	4.30	4.30		4.24
PULL #4	4.30	4.31		4.24
PULL #5	4.29	4.38		4.30
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587512
14 Jan 1991

CENTROIDAL DISTANCES

0 TO	1	.272413
1 TO	2	.690566
1 TO	3	.384064
1 TO	4	.290043
1 TO	5	.479517

51 <----POA
2

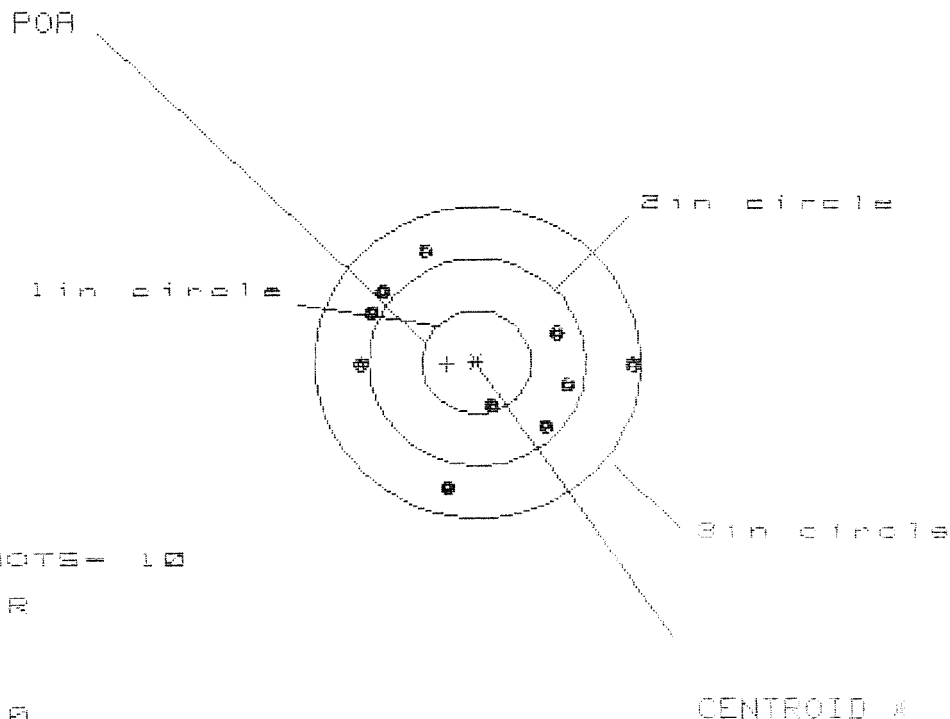
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .066
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0818
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .105106

THE AMR FOR THIS RIFLE IS: .919

14 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6587512

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 10

HS= 2.548

VS= 2.318

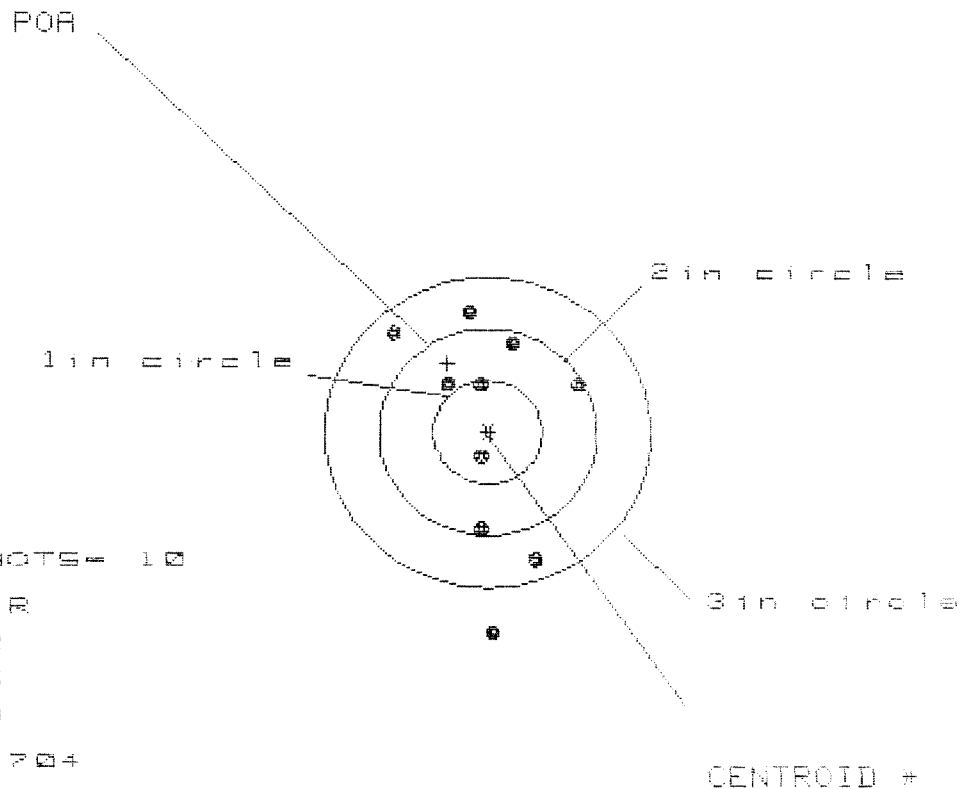
GS= 2.548

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.435	1.000	.990
MINIMUM X	:	-1.113	-.954	-.964
MAXIMUM Y	:	1.089	1.089	.936
MINIMUM Y	:	-1.229	-1.229	-.792
CENTROID X	:	.272	.113	.123
CENTROID Y	:	.015	.016	.169
POA TO CENTROID in.	:	.273	.114	.209
MIN RADIUS	:	.480	.553	.681
MEAN RADIUS	:	1.024	.979	.940
MAX RADIUS	:	1.435	1.231	1.109
HORIZONTAL SPREAD	:	2.548	1.954	1.954
VERTICAL SPREAD	:	2.318	2.318	1.728
EXTREME SPREAD	:	2.548	2.333	2.063
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

14 Jan 1981

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

ME = 1.704

VS = 3.126

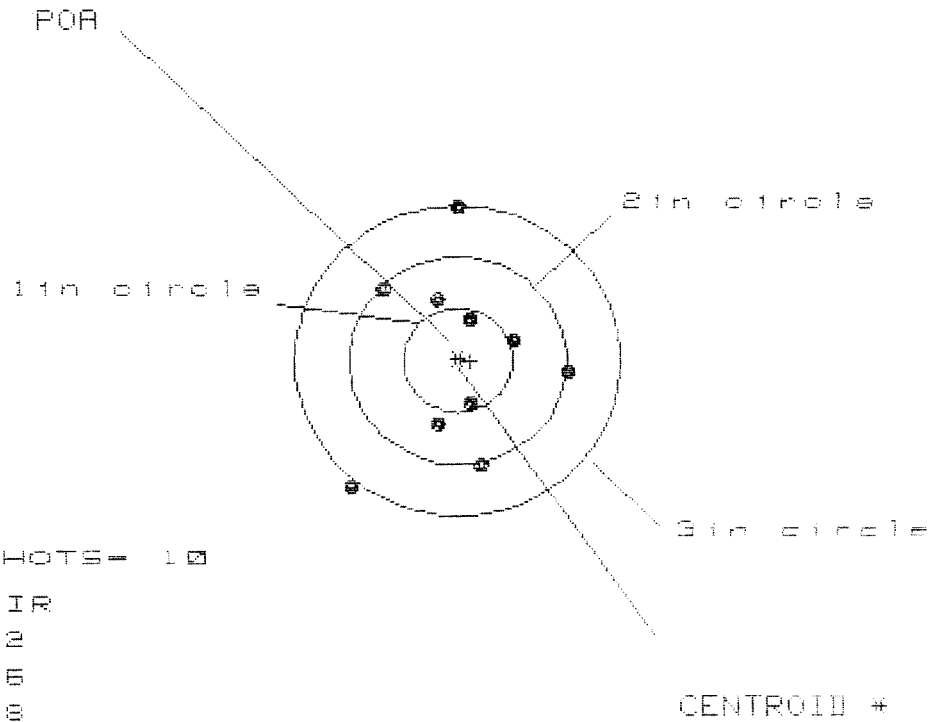
GS = 3.131

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.836	.837	.889
MINIMUM X	:	-.868	-.867	-.815
MAXIMUM Y	:	1.193	.978	.796
MINIMUM Y	:	-1.933	-1.458	-1.365
CENTROID X	:	.367	.366	.314
CENTROID Y	:	-.669	-.454	-.272
POA TO CENTROID in.	:	.763	.583	.415
MIN RADIUS	:	.217	.285	.107
MEAN RADIUS	:	.980	.833	.700
MAX RADIUS	:	1.933	1.516	1.365
HORIZONTAL SPREAD	:	1.704	1.704	1.704
VERTICAL SPREAD	:	3.126	2.436	2.161
EXTREME SPREAD	:	3.131	2.532	2.164
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

14 Jan 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 2.056

VS= 2.714

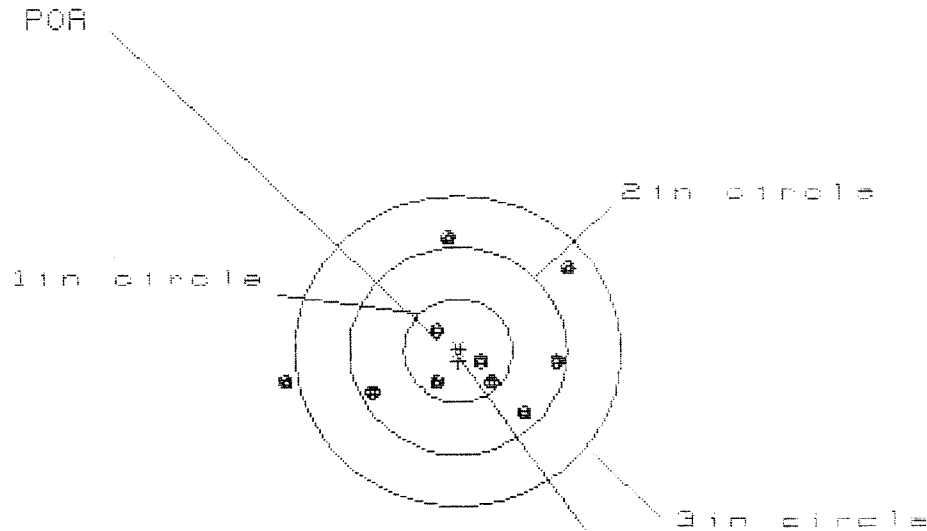
GS= 2.921

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.029	.915	.907
MINIMUM X	:	-1.027	-.756	-.764
MAXIMUM Y	:	1.504	1.369	.749
MINIMUM Y	:	-1.210	-1.184	-1.013
CENTROID X	:	-.112	.002	.010
CENTROID Y	:	.008	.143	-.028
POA TO CENTROID in.	:	.112	.143	.030
MIN RADIUS	:	.406	.265	.375
MEAN RADIUS	:	.872	.772	.691
MAX RADIUS	:	1.588	1.371	1.070
HORIZONTAL SPREAD	:	2.056	1.671	1.671
VERTICAL SPREAD	:	2.714	2.553	1.762
EXTREME SPREAD	:	2.921	2.558	1.955
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

14 Jan 1981

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 4

2in = 7

3in = 9

HS= 2.654

VS= 1.665

CS= 2.877

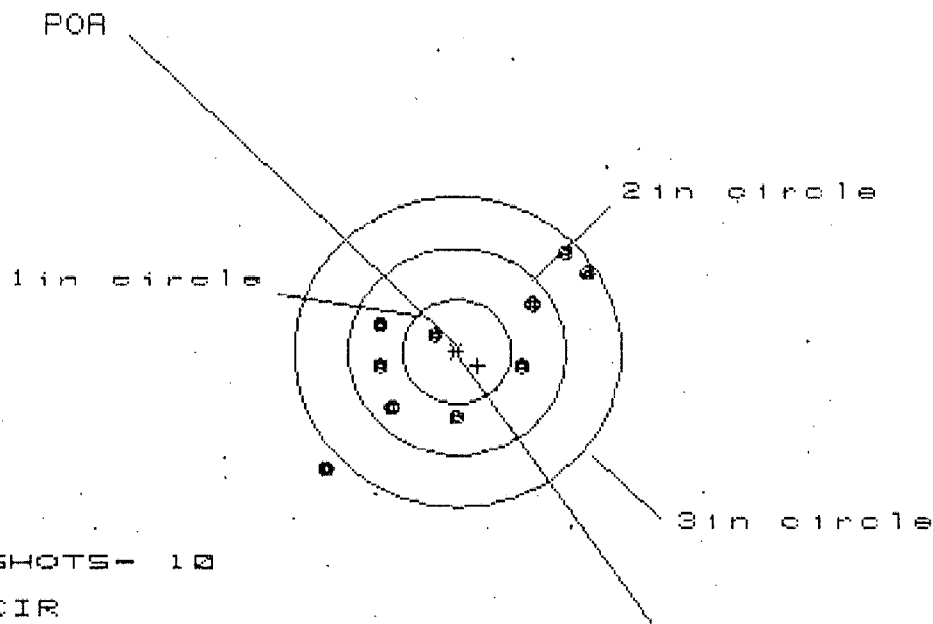
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.019	.837	.795
MINIMUM X	:	-1.635	-.964	-.859
MAXIMUM Y	:	1.077	1.042	1.138
MINIMUM Y	:	-.588	-.623	-.527
CENTROID X	:	-.005	.177	.072
CENTROID Y	:	.101	.136	.040
POA TO CENTROID in.	:	.101	.223	.082
MIN RADIUS	:	.234	.104	.149
MEAN RADIUS	:	.795	.682	.687
MAX RADIUS	:	1.664	1.134	1.151
HORIZONTAL SPREAD	:	2.654	1.801	1.654
VERTICAL SPREAD	:	1.665	1.665	1.665
EXTREME SPREAD	:	2.877	2.177	1.792
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

14 Jan 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 9

HS= 2.415

VS= 2.187

GS= 3.122

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.236	1.105	1.036
MINIMUM X	:	-1.179	-.874	-.736
MAXIMUM Y	:	1.013	.882	.967
MINIMUM Y	:	-1.174	-.815	-.730
CENTROID X	:	-.192	-.061	-.199
CENTROID Y	:	.136	.267	.182
POA TO CENTROID in.	:	.235	.273	.270
MIN RADIUS	:	.222	.309	.192
MEAN RADIUS	:	.924	.847	.762
MAX RADIUS	:	1.664	1.294	1.417
HORIZONTAL SPREAD	:	2.415	1.979	1.772
VERTICAL SPREAD	:	2.187	1.697	1.697
EXTREME SPREAD	:	3.122	2.331	2.303
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	