

C6636290

MODEL 700™ M24

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.





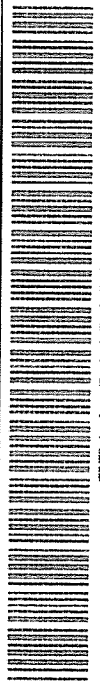

VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700™ M24

SERIAL NO.
06606290

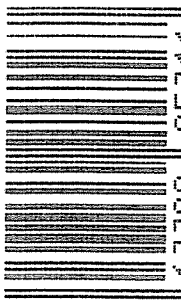
ORDER NO.
5716

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



5716 06606290

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6636290**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/24/91	KL
600	Proof		6/24/91	KL
607	Check Headspace		6/24/91	KL
610	Dis-assemble Gun		6/24/91	KL
612	Magnaflux Barrel Action	JUL	1 1991	KR
	Magnaflux Bolt	JUL	1 1991	KR
615	Rollmark Caliber	JUL	1 1991	LS
617	Drill and Tap Sight Holes	JUL	1 1991	LS
618	Polish Barrel	JUL	2 1991	LS
620	Apply Coatings (Barrel Action)		7-23-91	KL
	Apply Coating (Bolt)			KL
625	Final Assembly A) Clean inside of Bolt Assembly		8/1/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/1/91	KL
	C) Inspect Ejector Hole for Chamfer		8/1/91	KL
	D) Oil Firing Pin Ass'y		8/1/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		8-5-91	D/H

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7	7	6			8-5-91	AC
	G) Safety Off Force	4	3	4			8-5-91	AC
	H) Trigger Pull Test & Retainability						8-5-91	DH
	I) Firing Pin Indent	.021	.021	.021			8-5-91	AC
	J) Assemble Stock						8/5/91	KS
	K) Assemble Swivel Studs						8-15-91	DH
	L) Attach Front and Rear Sight Assemblies						8/5/91	KS
	M) Iron Sight Alignment						8/5/91	KS
	N) Detach Front & Rear Sights & place in numbered container						8/5/91	KS
	O) Attach Scope to Rifle						8/5/91	KS
	P) Detach & Attach Scope 20 Times						8/5/91	KS
640	Gallery Target & Test						8-14-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						8-14-91	AF
655	Final Inspection						8-15-91	DH
	A) Headspace						8-15-91	DH
	B) Trigger Pull	2.70	2.77	2.69	2.76	2.64	8-15-91	8/4
	C) Function						8-15-91	DH
660	Pack						8-15-91	AF

CENTROIDAL DISTANCE CALCULATIONS

AMR RIFLE # C6636290

13 Aug 1991

CENTROIDAL DISTANCES

0 TO 1	.189623
1 TO 2	.0523927
1 TO 3	.256759
1 TO 4	.195433
1 TO 5	.124036

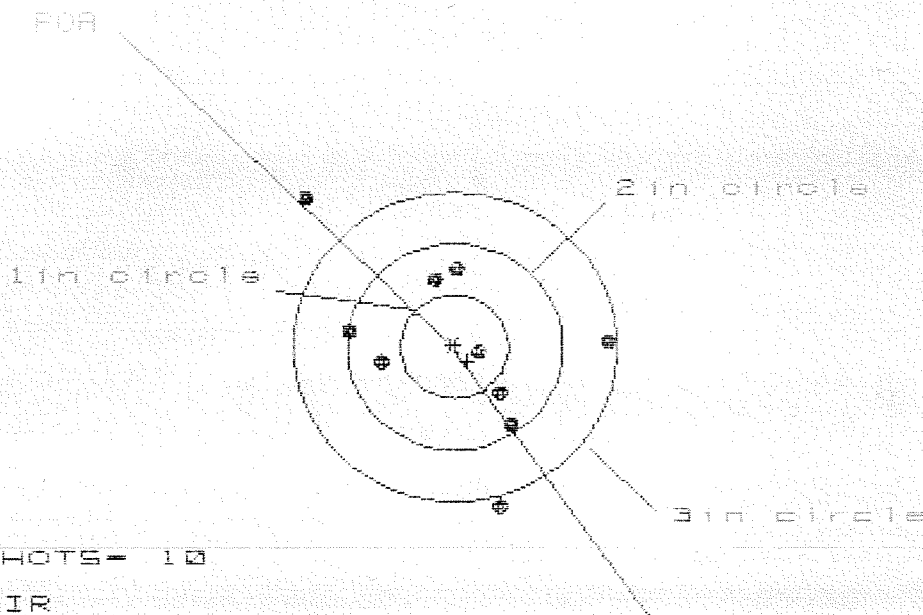
号 (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0842
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0946
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .126644

THE AMR FOR THIS RIFLE IS: .9546

FILE:/PATTERNING/CENTERFIRE_PATT/C0635290

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 1

2in = 7

3in = 8

HS= 2.858

VS= 3.005

GS= 3.528

CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.465	1.310	1.348
MINIMUM X	:	-1.393	-1.115	-1.077
MAXIMUM Y	:	1.419	.895	.716
MINIMUM Y	:	-1.586	-1.428	-.762
CENTROID X	:	-.121	.034	-.004
CENTROID Y	:	.146	-.012	.167
POA TO CENTROID in.	:	.190	.036	.167
MIN RADIUS	:	.259	.155	.152
MEAN RADIUS	:	.999	.868	.783
MAX RADIUS	:	1.988	1.460	1.348
HORIZONTAL SPREAD	:	2.858	2.425	2.425
VERTICAL SPREAD	:	3.005	2.323	1.478
EXTREME SPREAD	:	3.528	2.427	2.427
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

22 Aug 1981

FILE:/PATTERNING/CENTERFIRE_PATT/C6536290

CENTERFIRE PATTERNS # 2

POB

1 in circle =

2 in circle =

3 in circle =

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS = 3.039

VS = 3.257

GS = 3.991

CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.944	.711	.708
MINIMUM X	:	-2.095	-.711	-.714
MAXIMUM Y	:	1.493	1.297	1.204
MINIMUM Y	:	-1.764	-1.142	-.979
CENTROID X	:	-.070	.162	.165
CENTROID Y	:	.158	.354	.191
POB TO CENTROID in.	:	.173	.389	.253
MIN RADIUS	:	.170	.203	.073
MEAN RADIUS	:	1.071	.867	.782
MAX RADIUS	:	2.739	1.298	1.223
HORIZONTAL SPREAD	:	3.039	1.422	1.422
VERTICAL SPREAD	:	3.257	2.439	2.183
EXTREME SPREAD	:	3.991	2.496	2.209
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			8	

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08636290

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 3

2in = 5

3in = 7

HS = 3.104

VS = 3.206

CS = 4.088

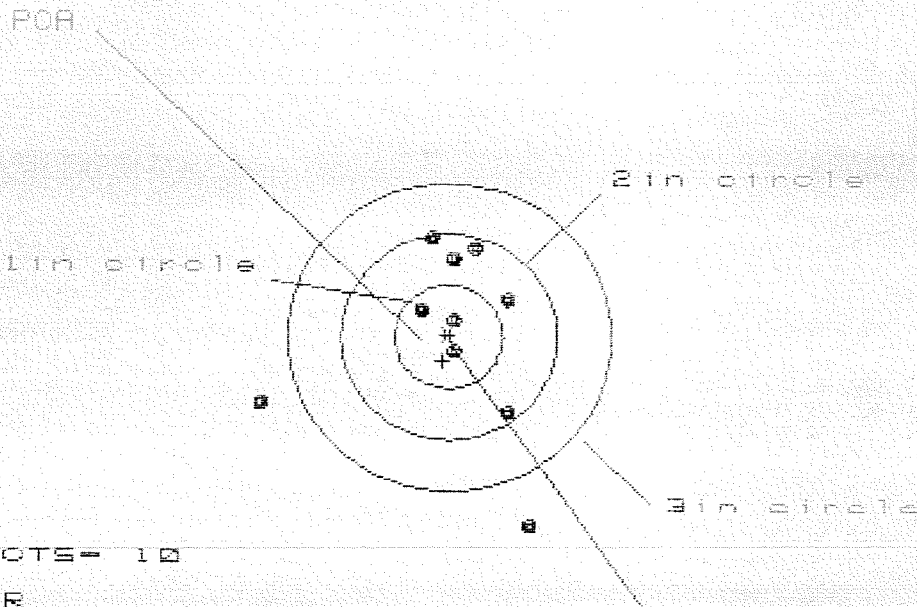
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.353	1.159	1.055
MINIMUM X	:	-1.751	-.825	-.573
MAXIMUM Y	:	1.097	.911	.624
MINIMUM Y	:	-2.109	-2.295	-.665
CENTROID X	:	-.091	.103	.207
CENTROID Y	:	-.109	.077	.364
POA TO CENTROID in.	:	.142	.129	.418
MIN RADIUS	:	.236	.294	.407
MEAN RADIUS	:	1.102	.907	.694
MAX RADIUS	:	2.420	2.439	1.176
HORIZONTAL SPREAD	:	3.104	1.984	1.628
VERTICAL SPREAD	:	3.206	3.206	1.289
EXTREME SPREAD	:	4.088	3.601	1.947
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			7	

20 Aug 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 3

2in = 8

3in = 8

HS= 2.518

VS= 2.802

CS= 2.962

CENTROID *

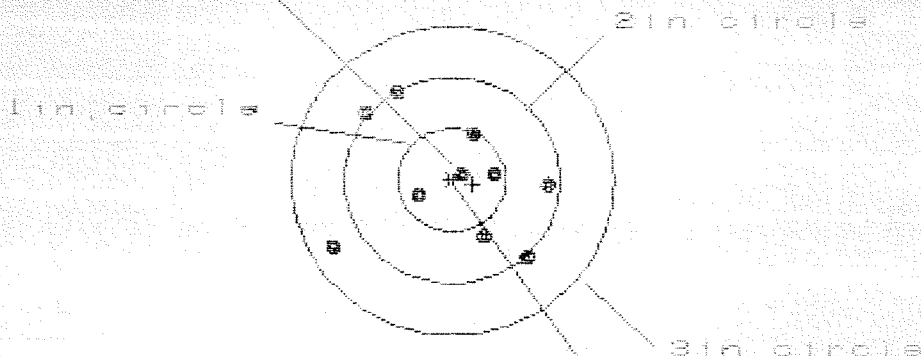
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.783	.657	.451
MINIMUM X	:	-1.735	-1.648	-1.410
MAXIMUM Y	:	.928	.719	.608
MINIMUM Y	:	-1.874	-.939	-1.050
CENTROID X	:	.054	-.033	.173
CENTROID Y	:	.233	.442	.553
POA TO CENTROID in.	:	.240	.443	.579
MIN RADIUS	:	.136	.161	.185
MEAN RADIUS	:	.878	.712	.535
MAX RADIUS	:	2.031	1.873	1.115
HORIZONTAL SPREAD	:	2.518	2.305	.861
VERTICAL SPREAD	:	2.802	1.658	1.658
EXTREME SPREAD	:	2.962	2.541	1.790
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			8	

21 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636250

CENTERFIRE PATTERNS # 5

POA



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

HS= 2.002

VS= 1.555

GS= 2.091

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.907	.785	.666
MINIMUM X	-1.095	-.952	-.711
MAXIMUM Y	.835	.766	.844
MINIMUM Y	-.720	-.789	-.711
CENTROID X	-.193	-.071	.048
CENTROID Y	.045	.114	.036
POA TO CENTROID in.	.198	.134	.060
MIN RADIUS	.141	.046	.108
MEAN RADIUS	.723	.637	.558
MAX RADIUS	1.261	1.138	1.103
HORIZONTAL SPREAD	2.002	1.737	1.377
VERTICAL SPREAD	1.555	1.555	1.555
EXTREME SPREAD	2.091	2.091	1.953
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. CCC36290

DATE 8-5-91

TESTER D/H

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.67	2.47	2.36	2.70	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.65	2.75	2.77	2.77	
PULL #3	2.64	2.70	2.81	2.69	
PULL #4	2.62	2.62	2.91	2.76	
PULL #5	2.74	2.74	2.73	2.64	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.19	3.49		
PULL #2	3.12	3.53		
PULL #3	2.93	3.49		
PULL #4	3.17	3.55		
PULL #5	3.53	3.05		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.20	4.54		4.38
PULL #2	4.10	4.52		4.44
PULL #3	3.98	4.26		4.35
PULL #4	4.10	4.32		4.29
PULL #5	4.20	4.32		4.13
TOTAL				
AVG.				