

C6611760

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 700™ M24

REG. U.S. PAT. & TM. OFF.

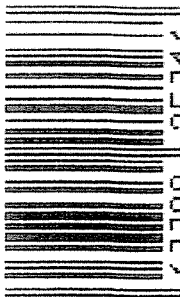
SERIAL NO.
C6611760

ORDER NO.
5716

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

20

UPC



0 47700 25716 7



5716 C6611760

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6611760

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		1/10/91	KA
600	Proof		1/10/91	KA
607	Check Headspace		1/10/91	KA
610	Dis-assemble Gun		1/10/91	KA
612	Magnaflux Barrel Action		1/16/91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	SS
617	Drill and Tap Sight Holes	1 18 91		FB
618	Polish Barrel	1 18 91		WB
620	Apply Coatings (Barrel Action)		2-13-91	KA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/22/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/22/91	KA
	C) Inspect Ejector Hole for Chamfer		2/22/91	KA
	D) Oil Firing Pin Ass'y		2/22/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake			

Op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	5	5			2-26-91	DH
	G) Safety Off Force	.0203	3	3			2-26-91	DH
	H) Trigger Pull Test & Retainability						2-26-91	
	I) Firing Pin Indent	.0205	.0205	.022			2-26-91	DH
	J) Assemble Stock						2-26-91	DH
	K) Assemble Swivel Studs						2-28-91	A
	L) Attach Front and Rear Sight Assemblies						2/26/91	KV
	M) Iron Sight Alignment						2/26/91	FF
	N) Detach Front & Rear Sights & place in numbered container						2/26/91	KV
	O) Attach Scope to Rifle						2/26/91	FF
	P) Detach & Attach Scope 20 Times						2/26/91	FF
640	Gallery Target & Test						2-26-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						2-26-91	AF
655	Final Inspection							
	A) Headspace						2-28-91	A
	B) Trigger Pull	2.21	2.64	2.60	2.51	2.55	2/27/91	SP
	C) Function						2-28-91	AC
660	Pack						2-18-91	AF

MOD. _____ GA. CAL. _____ GUN # 1760

#	TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
		1st		
		2/26	Safe Bind	K5
		2nd		
		2/27/91	Rep'd	K5
		3rd		
		4th		
			FUNCTION	

RD 6654

Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6611760DATE 7-26-91TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.34	2.90	2.72	2.21	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.40	2.83	2.90	2.54	
PULL #3	2.30	2.85	3.03	2.50	
PULL #4	2.34	2.98	2.96	2.51	
PULL #5	2.31	2.96	3.00	2.55	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.00	3.06		
PULL #2	3.05	3.13		
PULL #3	2.99	2.89		
PULL #4	3.01	3.07		
PULL #5	2.96	3.02		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.43	4.50		4.26
PULL #2	4.37	4.48		4.37
PULL #3	4.26	4.44		4.23
PULL #4	4.45	4.37		4.52
PULL #5	4.47	4.55		4.30
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06611760
27 Feb 1991

CENTROIDAL DISTANCES

0 TO 1	.250689
1 TO 2	.162789
1 TO 3	.58376
1 TO 4	.171164
1 TO 5	.537134

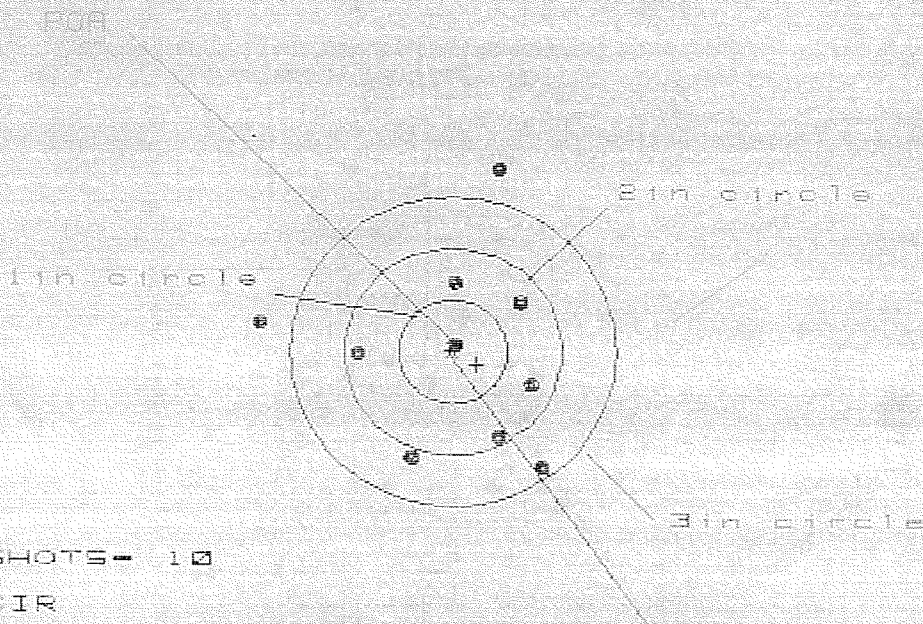
49 <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0246
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1332
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .135453
THE AMP FOR THIS RIFLE IS: .9848

22 Feb 1991

FILE: PATTERNING/CENTERFIRE_PATT/C8611750

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 8

HS= 2.552

VS= 2.907

GS= 2.949

CENTROID #

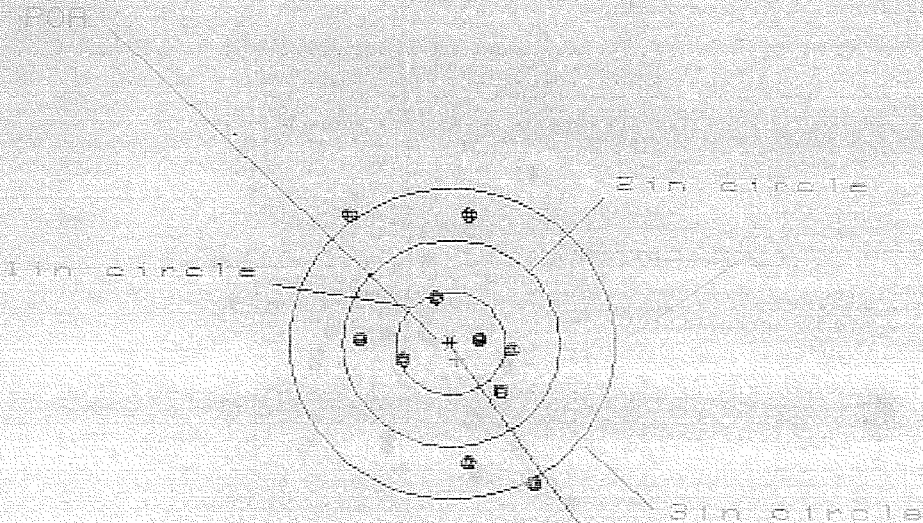
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.793	.598	.621
MINIMUM X	-1.759	-1.031	-1.008
MAXIMUM Y	1.741	1.776	.918
MINIMUM Y	-1.166	-1.131	-.909
CENTROID X	-.219	-.024	-.047
CENTROID Y	.122	.087	-.135
POB TO CENTROID in.	.251	.099	.143
MIN RADIUS	.107	.256	.409
MEAN RADIUS	1.012	.914	.800
MAX RADIUS	1.786	1.786	1.101
HORIZONTAL SPREAD	2.552	1.629	1.629
VERTICAL SPREAD	2.907	2.907	1.827
EXTREME SPREAD	2.949	2.936	2.014
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

22 MAR 1993

FILE: PATTERNING CENTERFIRE_PATT/CS611760

CENTERFIRE PATTERNS

2



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 6

3 in = 8

HS = 1.666

VS = 2.561

GS = 3.055

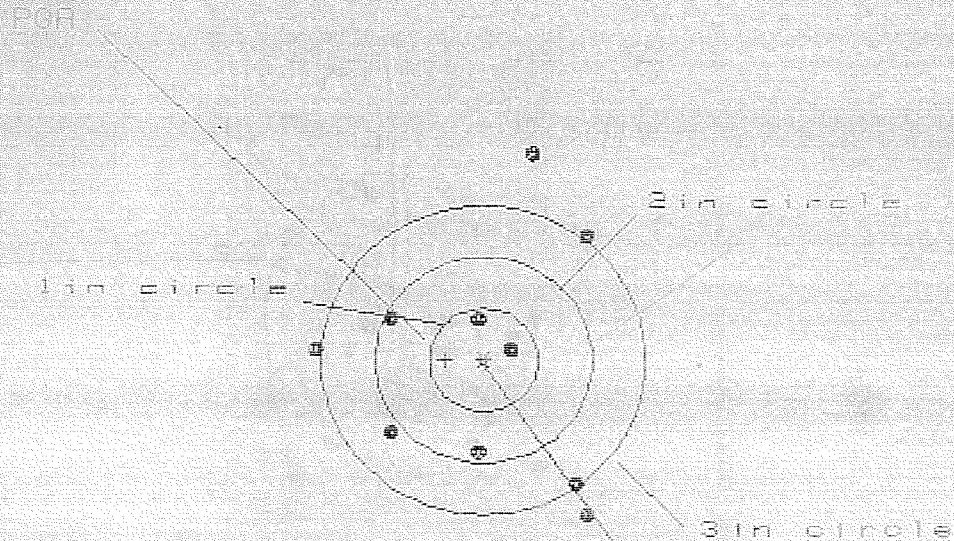
CENTROID +

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.728	.623	.576
MINIMUM X	:	-.938	-.916	-.838
MAXIMUM Y	:	1.249	1.362	1.215
MINIMUM Y	:	-1.312	-1.173	-1.146
CENTROID X	:	-.059	.046	-.032
CENTROID Y	:	.152	.013	.160
FOR TO CENTROID IN.	:	.163	.048	.163
MIN RADIUS	:	.258	.234	.231
MEAN RADIUS	:	.865	.778	.696
MAX RADIUS	:	1.562	1.362	1.220
HORIZONTAL SPREAD	:	1.666	1.539	1.414
VERTICAL SPREAD	:	2.561	2.535	2.361
EXTREME SPREAD	:	3.055	2.604	2.361
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			8	

22 Feb 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6611760

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 4

3 in = 6

HS = 2.479

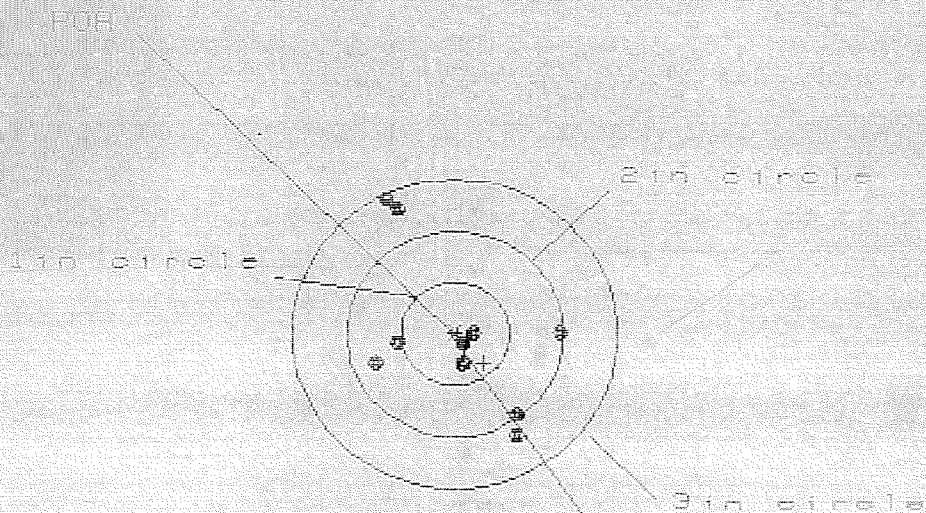
VS = 3.486

GS = 3.529

CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.961	1.007	1.083
MINIMUM X	:	-1.518	-1.472	-1.347
MAXIMUM Y	:	1.957	1.460	1.296
MINIMUM Y	:	-1.529	-1.312	-1.107
CENTROID X	:	.351	.305	.179
CENTROID Y	:	-.004	-.221	-.057
POB TO CENTROID in.	:	.351	.377	.188
MIN RADIUS	:	.262	.424	.442
MEAN RADIUS	:	1.190	1.098	1.004
MAX RADIUS	:	1.993	1.746	1.689
HORIZONTAL SPREAD	:	2.479	2.479	2.429
VERTICAL SPREAD	:	3.486	2.772	2.403
EXTREME SPREAD	:	3.529	2.969	2.706
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			4	
NUMBER IN THREE INCH CIRCLE =			6	

CENTERFIRE PATTERNS # 4



* OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 1.667

VS= 2.313

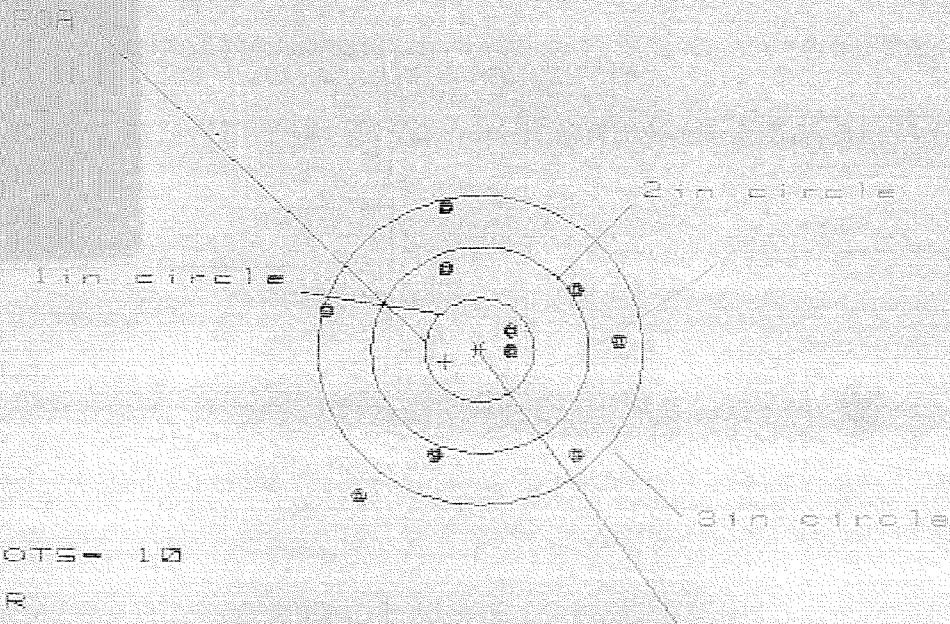
GS= 2.610

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.927	.861	.798
MINIMUM X	:	-.748	-.806	-.877
MAXIMUM Y	:	1.320	1.349	.330
MINIMUM Y	:	-.993	-.846	-.677
CENTROID X	:	-.268	-.202	-.131
CENTROID Y	:	.286	.139	-.038
POR TO CENTROID in.	:	.392	.245	.134
MIN RADIUS	:	.158	.058	.107
MEAN RADIUS	:	.776	.662	.571
MAX RADIUS	:	1.449	1.465	.877
HORIZONTAL SPREAD	:	1.667	1.667	1.667
VERTICAL SPREAD	:	2.313	2.195	1.887
EXTREME SPREAD	:	2.610	2.463	1.700
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			10	

FILE:/PATTERNING/CENTERFIRE_PATT/C6611260

CENTERFIRE PATTERNS # 5



OF SHOTS= 10
 # IN CIR
 1in = 2
 2in = 3
 3in = 9
 HS= 2.709
 VS= 2.734
 GS= 2.838

PATTERN #	1	5	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.316	1.192	1.003
MINIMUM X	-1.398	-1.517	-1.726
MAXIMUM Y	1.371	1.219	1.251
MINIMUM Y	-1.368	-1.204	-1.172
CENTROID X	.318	.441	.630
CENTROID Y	.110	.262	.230
FOR TO CENTROID in.	.336	.513	.671
MIN RADIUS	.285	.147	.091
MEAN RADIUS	1.081	.956	.851
MAX RADIUS	1.758	1.538	1.415
HORIZONTAL SPREAD	2.709	2.709	1.729
VERTICAL SPREAD	2.734	2.423	2.423
EXTREME SPREAD	2.838	2.729	2.697
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		9	