

C6611778

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 700TM M24

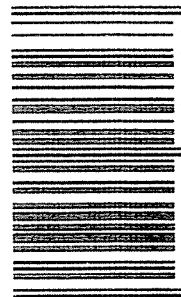
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

48

SERIAL NO.
C6611778

ORDER NO.
5716

LPC



0 47700 25716 7



5716 C6611778

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611778

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 28 91		RW
600	Proof	3 28 91		RW
607	Check Headspace	3 28 91		RW
610	Dis-assemble Gun	3 28 91		RW
612	Magnaflux Barrel Action	APR 2 1991		KR
	Magnaflux Bolt	APR 2 1991		U
615	Rollmark Caliber	APR 2 1991		GL
617	Drill and Tap Sight Holes	APR 5 1991		LB
618	Polish Barrel	APR 5 1991		WB
620	Apply Coatings (Barrel Action)		4-91	PA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/10/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/10/91	RW
	C) Inspect Ejector Hole for Chamfer		4/10/91	RW
	D) Oil Firing Pin Ass'y		4/10/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4/12/91	JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			4/15/91	RL
	G) Safety Off Force	3	3	3			4/15/91	RL
	H) Trigger Pull Test & Retainability						4/12/91	RL
	I) Firing Pin Indent	.0225	.023	.023			4/15/91	RL
	J) Assemble Stock						4/15/91	RW
	K) Assemble Swivel Studs						4-17-91	A
	L) Attach Front and Rear Sight Assemblies						4/15/91	RW
	M) Iron Sight Alignment						4/15/91	RW
	N) Detach Front & Rear Sights & place in numbered container						4/15/91	RW
	O) Attach Scope to Rifle						4/15/91	RW
	P) Detach & Attach Scope 20 Times						4/15/91	RW
640	Gallery Target & Test						4/14/91	KL
	A) Time							KL
	B) Malfunctions							KL
	C) Pierced Primers							KL
	D) Optical Clarity of Scope							KL
645	Inspect for Live Ammo						4/14/91	KL
655	Final Inspection							
	A) Headspace						4-17-91	A
	B) Trigger Pull	2.41	2.34	2.45	2.43	2.50	4/17/91	RL
	C) Function						4-17-91	R
660	Pack						4-17-91	N

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6611778

DATE 4/12/81

TESTER Jef

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.26	2.38	2.33	2.41	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.23	2.26	2.41	2.34	
PULL #3	2.34	2.12	2.35	2.45	
PULL #4	2.35	2.15	2.40	2.43	
PULL #5	2.23	2.14	2.41	2.50	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.55	3.41		
PULL #2	3.54	3.51		
PULL #3	3.47	3.53		
PULL #4	3.54	3.48		
PULL #5	3.51	3.49		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.32	4.20		4.32
PULL #2	4.36	4.29		4.32
PULL #3	4.24	4.32		4.22
PULL #4	4.15	4.36		4.21
PULL #5	4.23	4.39		4.26
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611778
16 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.0725672
1 TO	2	.112294
1 TO	3	.192627
1 TO	4	.161385
1 TO	5	.187489

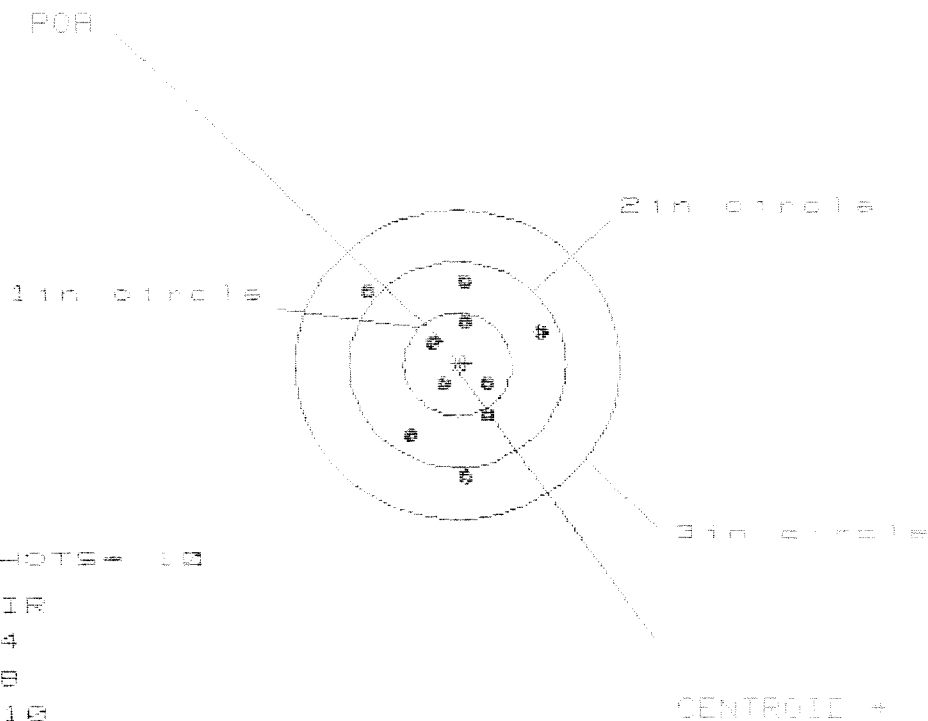
←----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0068
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0292
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .029981
THE AMR FOR THIS RIFLE IS: .748

16 Apr 1991

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CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 4

2in = 8

3in = 10

HE= 1.676

VS= 1.892

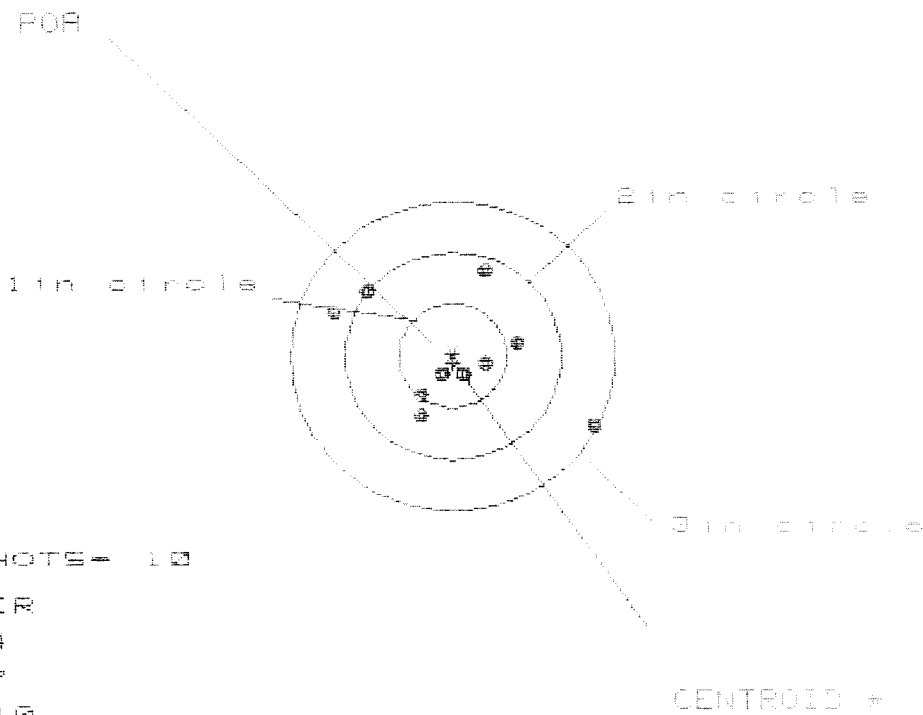
GS= 2.069

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.815	.719	.719
MINIMUM X	-.861	-.555	-.555
MAXIMUM Y	.817	.902	.778
MINIMUM Y	-1.075	-.990	-.732
CENTROID X	-.071	.025	.025
CENTROID Y	-.015	-.100	.024
POA TO CENTROID in.	.073	.103	.055
MIN RADIUS	.233	.235	.200
MEAN RADIUS	.663	.602	.546
MAX RADIUS	1.150	.990	.919
HORIZONTAL SPREAD	1.676	1.274	1.274
VERTICAL SPREAD	1.892	1.892	1.510
EXTREME SPREAD	2.069	1.892	1.618
NUMBER IN ONE INCH CIRCLE	= 4		
NUMBER IN TWO INCH CIRCLE	= 8		
NUMBER IN THREE INCH CIRCLE	= 10		

18 Apr 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 4

2 in = 7

3 in = 10

HS = 3.420

VS = 1.440

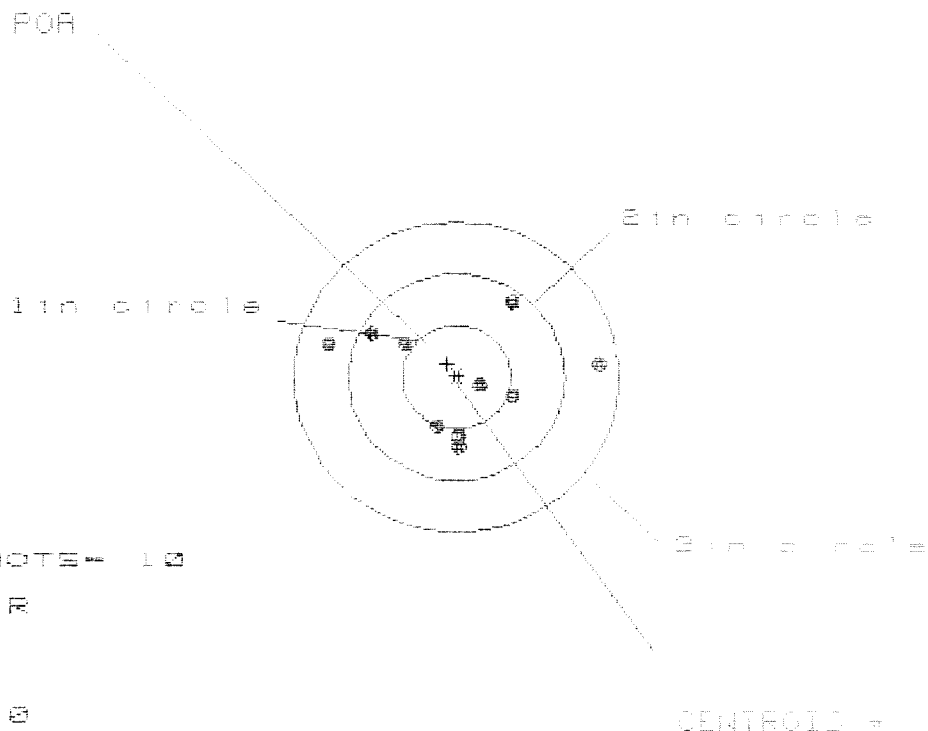
GS = 2.632

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.327	.721	.682
MINIMUM X	:	-1.093	-.945	-.792
MAXIMUM Y	:	.813	.743	.785
MINIMUM Y	:	-.627	-.689	-.647
CENTROID X	:	-.000	-.148	-.025
CENTROID Y	:	.072	.142	.100
POA TO CENTROID in.	:	.072	.205	.184
MIN RADIUS	:	.174	.217	.184
MEAN RADIUS	:	.701	.635	.556
MAX RADIUS	:	1.468	1.004	.990
HORIZONTAL SPREAD	:	2.420	1.666	1.394
VERTICAL SPREAD	:	1.440	1.432	1.432
EXTREME SPREAD	:	2.632	1.683	1.580
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

18 Apr 1993

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10
 # IN CIR
 1in = 2
 2in = 8
 3in = 10
 HS = 2.460
 VS = 1.382
 GS = 2.475

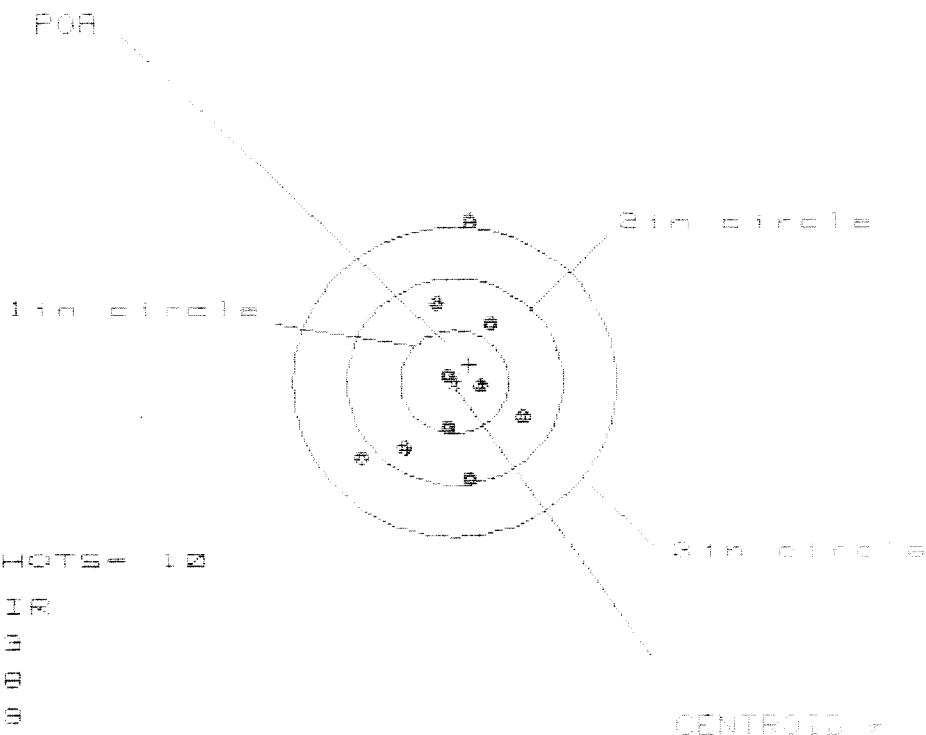
PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.322	.691	.567
MINIMUM X	-1.138	-.991	-.743
MAXIMUM Y	.729	.741	.789
MINIMUM Y	-.653	-.641	-.593
CENTROID X	.085	-.062	.062
CENTROID Y	-.128	-.140	-.189
POA TO CENTROID in.	.153	.153	.138
MIN RADIUS	.177	.320	.195
MEAN RADIUS	.735	.669	.595
MAX RADIUS	1.327	1.064	.935
HORIZONTAL SPREAD	2.460	1.682	1.310
VERTICAL SPREAD	1.382	1.382	1.382
EXTREME SPREAD	2.475	1.781	1.466
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	

16 Apr 1991

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CENTERFIRE PATTERNS

4



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 8

3 in = 9

HS = 1.487

VS = 2.514

CS = 2.519

CENTROID +

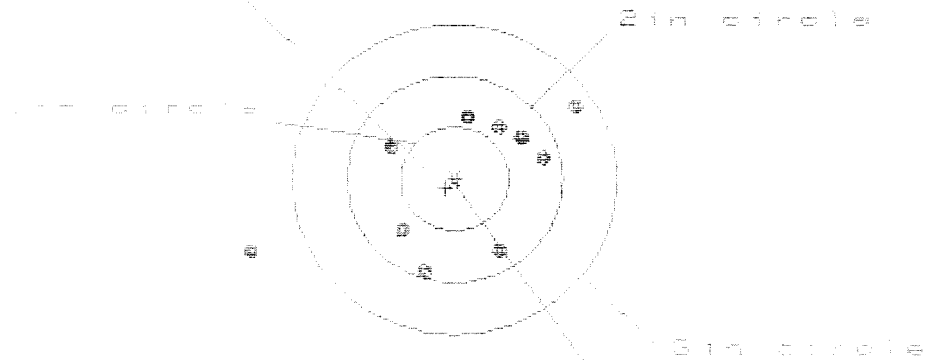
PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.621	.609	.590
MINIMUM X	-.366	-.848	-.543
MAXIMUM Y	1.590	.895	.828
MINIMUM Y	-.924	-.748	-.815
CENTROID X	-.133	-.151	-.044
CENTROID Y	-.164	-.341	-.274
POA TO CENTROID in.	.211	.373	.278
MIN RADIUS	.096	.229	.189
MEAN RADIUS	.730	.622	.561
MAX RADIUS	1.598	1.002	.856
HORIZONTAL SPREAD	1.487	1.487	1.076
VERTICAL SPREAD	2.514	1.643	1.643
EXTREME SPREAD	2.519	1.786	1.571
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		9	

18 Apr 1991

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CENTERFIRE PATTERNS # 5

POF



OF SHOTS = 10

IN CIR

1 in = 8

2 in = 8

3 in = 9

IS = 2.557

VS = 1.629

CS = 3.300

CENTROID =

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.077	.867	.677
MINIMUM X	:	-1.890	-.731	-.682
MAXIMUM Y	:	.759	.682	.612
MINIMUM Y	:	-.670	-.947	-.861
CENTROID X	:	.885	.295	.186
CENTROID Y	:	.085	.166	.080
POA TO CENTROID in.	:	.100	.333	.203
MIN RADIUS	:	.7	.412	.548
MEAN RADIUS	:	.7	.748	.713
MAX RADIUS	:	2.011	1.104	.858
HORIZONTAL SPREAD	:	2.96	1.658	1.359
VERTICAL SPREAD	:	1.629	1.639	1.473
EXTREME SPREAD	:	3.300	2.145	1.553
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	