

C6636095

MODEL 700TM M24

Model **SWS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.






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

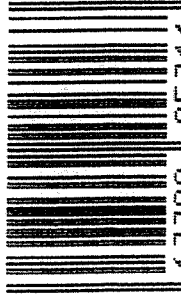
MODEL 700™ M24

SERIAL NO.
C6636095

ORDER NO.
5716

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

UPC



0 47700 25716 7



5716 C6636095

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636095

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		8/2/91	KL
600	Proof		8/2/91	KL
607	Check Headspace		8/2/91	KL
610	Dis-assemble Gun		8/2/91	KL
612	Magnaflux Barrel Action		AUG 7 1991	KR
	Magnaflux Bolt		AUG 7 1991	KR
615	Rollmark Caliber		AUG 7 1991	28
617	Drill and Tap Sight Holes		AUG 7 1991	LB
618	Polish Barrel		AUG 13 1991	W.B
620	Apply Coatings (Barrel Action)		8-27-91	KL
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/29/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/29/91	KL
	C) Inspect Ejector Hole for Chamfer		8/29/91	KL
	D) Oil Firing Pin Ass'y		8/29/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		8/31/91	KL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/2	5	5 3/4			8-31-91	DH
	G) Safety Off Force	2	2	2			8-31-91	DH
	H) Trigger Pull Test & Retainability						8/31/91	JK
	I) Firing Pin Indent	.022	.023	.022			8-31-91	DH
	J) Assemble Stock						9/3/91	JK
	K) Assemble Swivel Studs						9-12-91	DH
	L) Attach Front and Rear Sight Assemblies						9/3/91	JK
	M) Iron Sight Alignment						9/3/91	JK
	N) Detach Front & Rear Sights & place in numbered container						9/3/91	JK
	O) Attach Scope to Rifle						9/3/91	JK
	P) Detach & Attach Scope 20 Times						9/3/91	JK
640	Gallery Target & Test						9-11-91	AC
	A) Time						9-11-91	AC
	B) Malfunctions						9-11-91	AC
	C) Pierced Primers						9-11-91	AC
	D) Optical Clarity of Scope						9-11-91	AC
645	Inspect for Live Ammo						9-11-91	AC
655	Final Inspection							
	A) Headspace						9-12-91	DH
	B) Trigger Pull	2.68	2.66	2.65	2.62	2.66	9/12/91	JK
	C) Function						9-12-91	DH
660	Pack						9-18-91	N

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6636095

DATE 8-31-91

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.45	2.27	2.44	2.68	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.64	2.18	2.64	2.66	
PULL #3	2.24	2.47	2.50	2.65	
PULL #4	2.20	2.57	2.55	2.62	
PULL #5	2.28	2.56	2.55	2.66	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.51	3.64		
PULL #2	3.52	3.53		
PULL #3	3.58	3.64		
PULL #4	3.58	3.61		
PULL #5	3.68	3.53		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.21	4.42		4.63
PULL #2	4.46	4.50		4.54
PULL #3	4.28	4.33		4.64
PULL #4	4.48	4.53		4.60
PULL #5	4.46	4.63		4.49
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636095
11 Sep 1991

CENTROIDAL DISTANCES

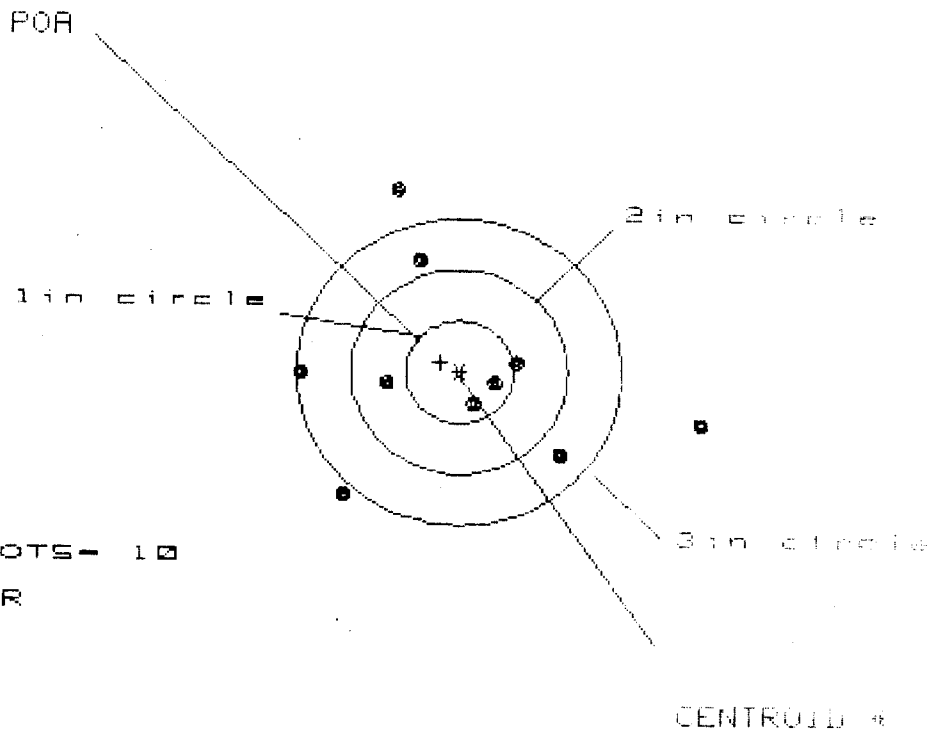
0 TO	1	.197466
1 TO	2	.0842912
1 TO	3	.158902
1 TO	4	.183338
1 TO	5	.215335

3g <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1224
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0772
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .144712
THE RME FOR THIS RIFLE IS: 1.111

FILE:/PATTERNING/CENTERFIRE_PATT/C6836095.1

CENTERFIRE PATTERNS # 1



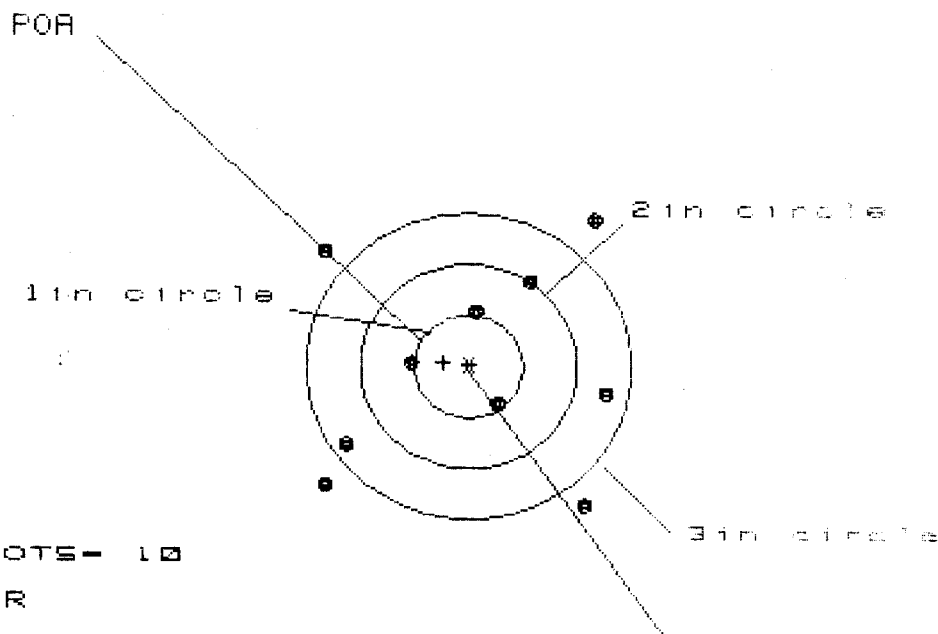
* OF SHOTS- 10
 * IN CIR
 1in = 2
 2in = 4
 3in = 7
 HS= 3.702
 VS= 2.941
 GS= 3.734

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.211	1.197	1.158
MINIMUM X	-1.491	-1.245	-1.284
MAXIMUM Y	1.767	1.713	1.253
MINIMUM Y	-1.174	-1.228	-1.014
CENTROID X	.172	-.074	-.035
CENTROID Y	-.097	-.043	-.257
POA TO CENTROID IN.	.197	.085	.259
MIN RADIUS	.282	.431	.314
MEAN RADIUS	1.140	1.026	.989
MAX RADIUS	2.264	1.740	1.336
HORIZONTAL SPREAD	3.702	2.442	2.442
VERTICAL SPREAD	2.941	2.941	2.267
EXTREME SPREAD	3.734	2.998	2.578
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		7	

11 Sep 1997

FILE:/PATTERNING/CENTERFIRE_PATT/C6636095.1

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 6

HS= 2.663

VS= 2.798

GS= 3.583

CENTROID *

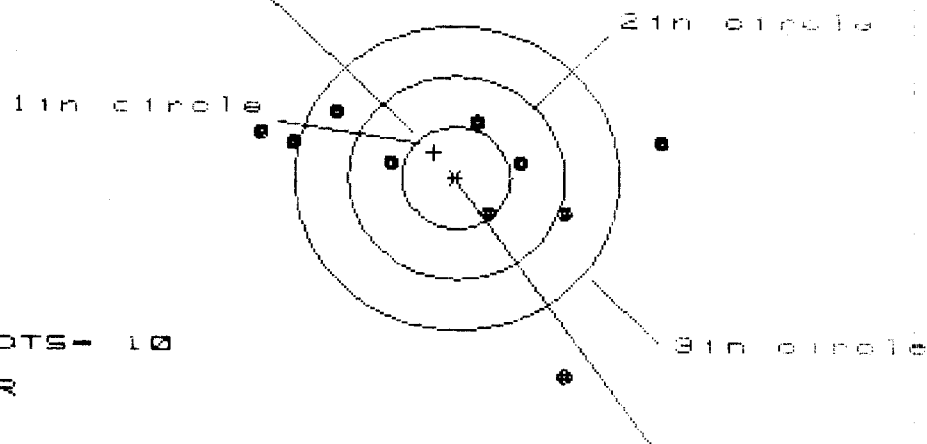
PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.283	1.129	1.250
MINIMUM X	:	-1.380	-1.498	-1.377
MAXIMUM Y	:	1.397	1.268	1.173
MINIMUM Y	:	-1.401	-1.530	-1.372
CENTROID X	:	.235	.389	.268
CENTROID Y	:	-.041	.089	-.069
POA TO CENTROID in.	:	.239	.399	.277
MIN RADIUS	:	.435	.376	.394
MEAN RADIUS	:	1.234	1.152	1.092
MAX RADIUS	:	1.809	1.809	1.809
HORIZONTAL SPREAD	:	2.663	2.627	2.627
VERTICAL SPREAD	:	2.798	2.798	2.545
EXTREME SPREAD	:	3.583	3.534	3.534
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		6	

11 Sep 1981

FILE:/PATTERNING/CENTERFIRE_PATT/C6636095.1

CENTERFIRE PATTERNS # 3

POA



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 5

HS= 3.704

VS= 2.646

QS= 3.709

CENTROID *

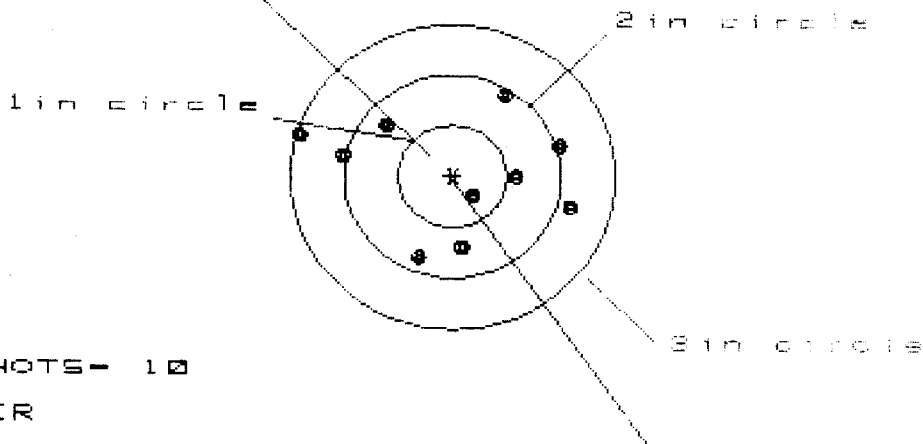
PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.926	2.035	1.334
MINIMUM X	:	-1.778	-1.669	-1.414
MAXIMUM Y	:	.691	.474	.485
MINIMUM Y	:	-1.955	-.595	-.584
CENTROID X	:	.207	.098	-.157
CENTROID Y	:	-.252	-.035	-.046
POA TO CENTROID in.:	:	.326	.104	.163
MIN RADIUS	:	.480	.428	.239
MEAN RADIUS	:	1.210	1.085	.952
MAX RADIUS	:	2.189	2.037	1.456
HORIZONTAL SPREAD	:	3.704	3.704	2.748
VERTICAL SPREAD	:	2.646	1.069	1.069
EXTREME SPREAD	:	3.709	3.709	2.882
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		5	

11 Sep 1981

FILE:/PATTERNING/CENTERFIRE_PATT/C6636095.1

CENTERFIRE PATTERNS # 4

POA



OF SHOTS- 10

IN CIR

1 in - 1

2 in - 7

3 in - 9

HS- 2.510

VS- 1.600

GS- 2.596

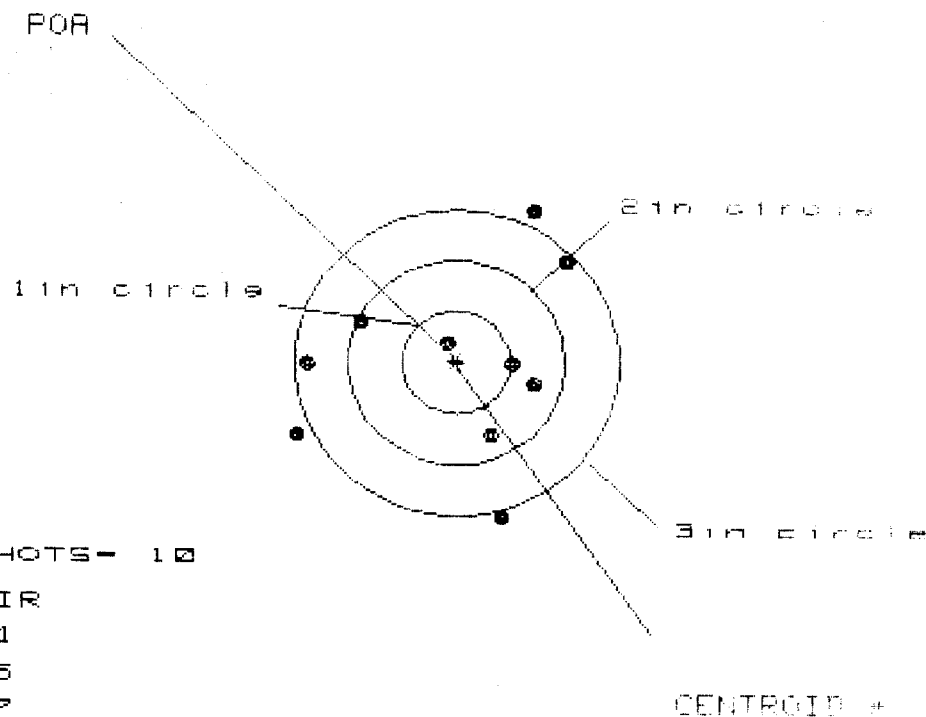
CENTROID *

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.048	.886	.892
MINIMUM X	:	-1.462	-1.156	-1.045
MAXIMUM Y	:	.755	.796	.763
MINIMUM Y	:	-.845	-.804	-.837
CENTROID X	:	.014	.176	.065
CENTROID Y	:	-.004	-.045	-.012
POA TO CENTROID in.	:	.014	.182	.066
MIN RADIUS	:	.304	.202	.268
MEAN RADIUS	:	.883	.781	.772
MAX RADIUS	:	1.506	1.179	1.064
HORIZONTAL SPREAD	:	2.510	2.042	1.937
VERTICAL SPREAD	:	1.600	1.600	1.600
EXTREME SPREAD	:	2.596	2.100	1.942
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	9		

11-27-71

FILE:/PATTERNING/CENTERFIRE_PATT/C6636095.1

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 7

HS= 2.511

VS= 2.996

GS= 3.124

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	0
MAXIMUM X	:	1.035	1.116	.941
MINIMUM X	:	-1.476	-1.395	-1.459
MAXIMUM Y	:	1.525	1.200	1.135
MINIMUM Y	:	-1.471	-1.302	-1.367
CENTROID X	:	-.016	-.097	.078
CENTROID Y	:	.008	-.161	-.096
POA TO CENTROID in.	:	.018	.188	.124
MIN RADIUS	:	.208	.367	.341
MEAN RADIUS	:	1.090	1.028	.936
MAX RADIUS	:	1.690	1.639	1.475
HORIZONTAL SPREAD	:	2.511	2.511	2.400
VERTICAL SPREAD	:	2.996	2.502	2.502
EXTREME SPREAD	:	3.124	3.043	2.608
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	