

C6636120

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.

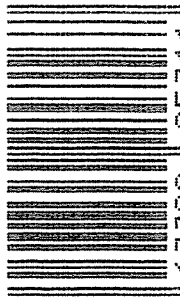
MODEL 700TM M24

SERIAL NO.
C6636120

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 C6636120

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636120

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	11
615	Rollmark Caliber	APR	2 1991	GL
617	Drill and Tap Sight Holes	APR	5 1991	KB
618	Polish Barrel	APR	5 1991	WB
620	Apply Coatings (Barrel Action)		2-10-91	JA
	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		4/16/91	JH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			4-16-91	AC
	G) Safety Off Force	2	3	3			4-16-91	AC
	H) Trigger Pull Test & Retainability						4-16-91	D/H
	I) Firing Pin Indent	.022	.022	.023			4-16-91	AC
	J) Assemble Stock						4/16/91	RW
	K) Assemble Swivel Studs						5-18-91	D/H
	L) Attach Front and Rear Sight Assemblies						4/16/91	RW
	M) Iron Sight Alignment						4/16/91	RW
	N) Detach Front & Rear Sights & place in numbered container						4/16/91	RW
	O) Attach Scope to Rifle						4/16/91	RW
	P) Detach & Attach Scope 20 Times						4/16/91	RW
640	Gallery Target & Test						4/17/91	K2
	A) Time							K2
	B) Malfunctions							K3
	C) Pierced Primers							K4
	D) Optical Clarity of Scope							K5
645	Inspect for Live Ammo						4/17/91	K2
655	Final Inspection							
	A) Headspace						5-18-91	D/H
	B) Trigger Pull	2.46	2.43	2.43	2.41	2.44	4/22/91	D/H
	C) Function						5-18-91	D/H
660	Pack						6-18-91	N

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6636120

DATE 4-16-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.57	2.42	2.55	2.45	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.60	2.45	2.60	2.43	
PULL #3	2.62	2.50	2.67	2.43	
PULL #4	2.59	2.49	2.64	2.41	
PULL #5	2.58	2.54	2.64	2.44	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.23	3.09		
PULL #2	3.41	3.37		
PULL #3	3.40	3.34		
PULL #4	3.38	3.38		
PULL #5	3.42	3.39		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.38	4.56		4.16
PULL #2	4.18	4.47		4.23
PULL #3	4.47	4.46		4.41
PULL #4	4.45	4.50		4.34
PULL #5	4.22	4.47		4.27
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636120
17 Apr 1991

CENTROIDAL DISTANCES

0 TO 1	.0901388
1 TO 2	.264428
1 TO 3	.11967
1 TO 4	.0575847
1 TO 5	.173104

~~SP~~ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0326
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0736
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0804967
THE AMR FOR THIS RIFLE IS: 1.133

17 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8635120

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 7

HS = 3.183

VS = 3.096

GS = 3.914

CENTROID *

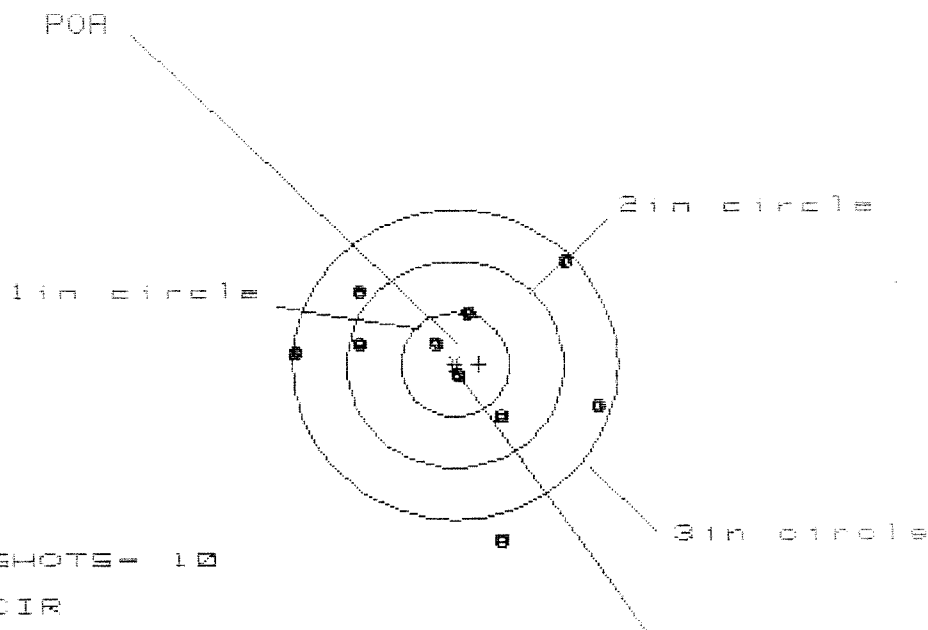
PATTERN #

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.921	1.218	1.190
MINIMUM X	-1.262	-1.049	-1.077
MAXIMUM Y	1.137	.995	.732
MINIMUM Y	-1.959	-2.101	-1.183
CENTROID X	.030	-.183	-.155
CENTROID Y	.085	.227	.490
POA TO CENTROID in.	.090	.292	.514
MIN RADIUS	.311	.242	.476
MEAN RADIUS	1.229	1.060	.922
MAX RADIUS	2.310	2.114	1.216
HORIZONTAL SPREAD	3.183	2.267	2.267
VERTICAL SPREAD	3.096	3.096	1.915
EXTREME SPREAD	3.914	3.311	2.279
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		7	

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS= 2.805

VS= 2.702

GS= 2.849

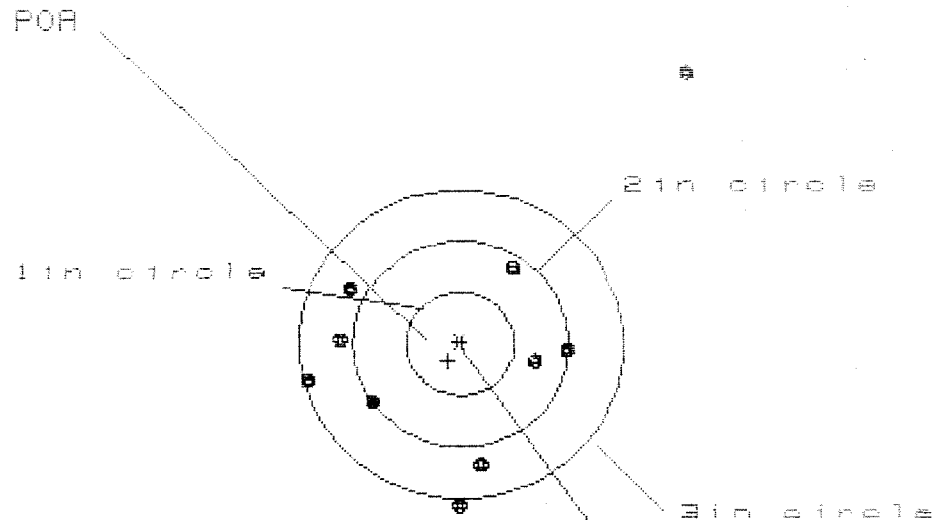
CENTROID *

PATTERN #	2	2	2
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.352	1.396	1.220
MINIMUM X	-1.453	-1.409	-1.045
MAXIMUM Y	1.001	.812	.804
MINIMUM Y	-1.701	-.681	-.689
CENTROID X	-.219	-.263	-.087
CENTROID Y	-.004	.185	.193
POA TO CENTROID in.	.219	.322	.212
MIN RADIUS	.144	.101	.273
MEAN RADIUS	.966	.859	.800
MAX RADIUS	1.746	1.505	1.347
HORIZONTAL SPREAD	2.805	2.805	2.265
VERTICAL SPREAD	2.702	1.493	1.493
EXTREME SPREAD	2.849	2.849	2.497
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 0

2in = 3

3in = 8

HS = 3.484

VS = 4.215

GS = 4.708

CENTROID #

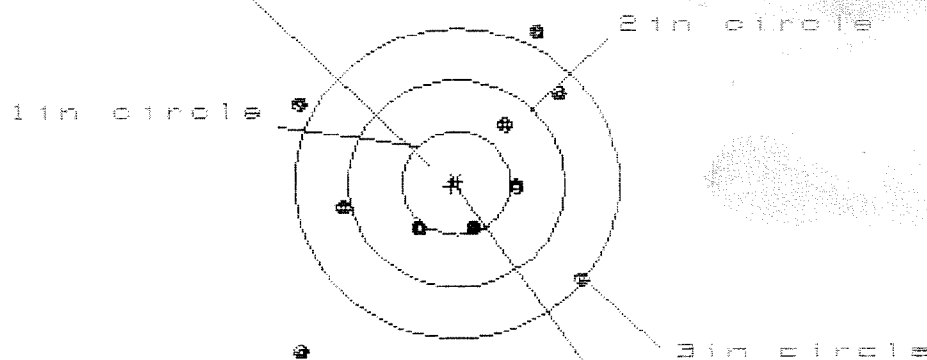
PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	2.054
MINIMUM X	-1.429
MAXIMUM Y	2.602
MINIMUM Y	-1.614
CENTROID X	.119
CENTROID Y	.165
POA TO CENTROID in.	.203
MIN RADIUS	.691
MEAN RADIUS	1.347
MAX RADIUS	3.315
HORIZONTAL SPREAD	3.484
VERTICAL SPREAD	4.215
EXTREME SPREAD	4.708
NUMBER IN ONE INCH CIRCLE =	0
NUMBER IN TWO INCH CIRCLE =	3
NUMBER IN THREE INCH CIRCLE =	8

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CENTERFIRE PATTERNS # 4

POA



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 5

HS= 2.614

VS= 3.043

GS= 3.755

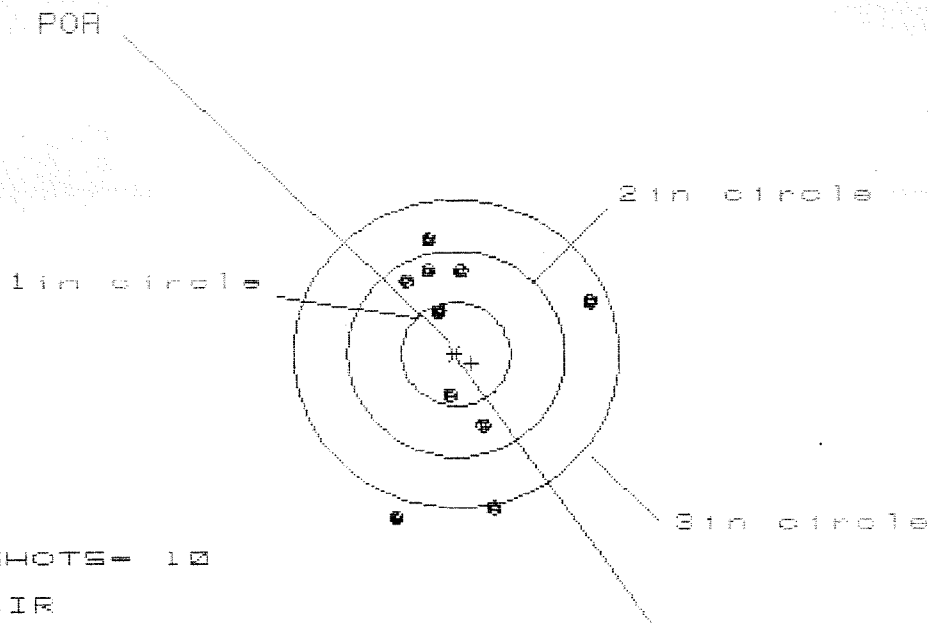
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.197	1.040	1.120
MINIMUM X	:	-1.417	-1.574	-1.494
MAXIMUM Y	:	1.437	1.259	.889
MINIMUM Y	:	-1.606	-1.118	-.961
CENTROID X	:	.050	.207	.127
CENTROID Y	:	.031	.209	.052
POA TO CENTROID in.	:	.059	.294	.138
MIN RADIUS	:	.496	.415	.443
MEAN RADIUS	:	1.163	1.037	.974
MAX RADIUS	:	2.136	1.694	1.688
HORIZONTAL SPREAD	:	2.614	2.614	2.614
VERTICAL SPREAD	:	3.043	2.377	1.850
EXTREME SPREAD	:	3.755	3.143	3.143
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		5	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS= 1.791

VS= 2.712

GS= 2.791

CENTROID *

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.207	1.142	1.173
MINIMUM X	-.584	-.505	-.474
MAXIMUM Y	1.074	.892	.686
MINIMUM Y	-1.638	-1.650	-1.127
CENTROID X	-.143	-.078	-.109
CENTROID Y	.091	.273	.479
POA TO CENTROID in.	.170	.284	.492
MIN RADIUS	.375	.263	.144
MEAN RADIUS	.962	.842	.679
MAX RADIUS	1.739	1.668	1.179
HORIZONTAL SPREAD	1.791	1.647	1.647
VERTICAL SPREAD	2.712	2.542	1.813
EXTREME SPREAD	2.791	2.614	1.880
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	