

C6611515

MODEL 700<sup>TM</sup> M24

Model **SWS** <sup>TM</sup>

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 700<sup>TM</sup> M24

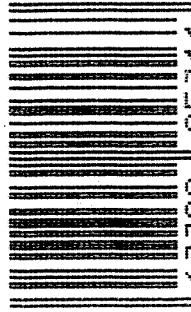
20

SERIAL NO.  
C6611515

ORDER NO.  
5716

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

UPC



0 47700 25716 7



5716 C6611515

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6611515

| OP. #        | OP. NAME                                                       | READINGS | DATE    | INIT |
|--------------|----------------------------------------------------------------|----------|---------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   |          | 3/12/91 | K.S. |
| 600          | Proof                                                          |          | 3/12/91 | K.S. |
| 607          | Check Headspace                                                |          | 3/12/91 | K.S. |
| 610          | Dis-assemble Gun                                               |          | 3/12/91 | K.S. |
| 612          | Magnaflux Barrel<br>Action                                     |          | 3/27/91 | KR   |
|              | Magnaflux Bolt                                                 |          | 11      | KR   |
| 615          | Rollmark Caliber                                               |          | 3/27/91 | GLS  |
| 617          | Drill and Tap Sight Holes                                      | APR      | 3 1991  | EB   |
| 618          | Polish Barrel                                                  | APR      | 3 1991  | WB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 3/12/91 | JS   |
|              | Apply Coating (Bolt)                                           |          |         |      |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 5/2/91  | KS   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 5/2/91  | KS   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 5/2/91  | KS   |
|              | D) Oil Firing Pin Ass'y                                        |          | 5/2/91  | KS   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 5-9-91  | D/H  |

| op. #        | OP. NAME                                                    | READINGS |      |      |      |      | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|------|------|------|------|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 6        | 6    | 6    |      |      | 5-9-91  | K    |
|              | G) Safety Off Force                                         | 4        | 4    | 4    |      |      | 5-9-91  | K    |
|              | H) Trigger Pull Test & Retainability                        |          |      |      |      |      | 5-9-91  | DH   |
|              | I) Firing Pin Indent                                        | .022     | .023 | .023 |      |      | 5-9-91  | AC   |
|              | J) Assemble Stock                                           |          |      |      |      |      | 5/9/91  | ICS  |
|              | K) Assemble Swivel Studs                                    |          |      |      |      |      | 5-21-91 | DH   |
|              | L) Attach Front and Rear Sight Assemblies                   |          |      |      |      |      | 5/9/91  | ICS  |
|              | M) Iron Sight Alignment                                     |          |      |      |      |      | 5/9/91  | KS   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |      |      |      |      | 5/9/91  | KS   |
|              | O) Attach Scope to Rifle                                    |          |      |      |      |      | 5/9/91  | KS   |
|              | P) Detach & Attach Scope 20 Times                           |          |      |      |      |      | 5/9/91  | KS   |
| 640          | Gallery Target & Test                                       |          |      |      |      |      | 5/13/91 | KT   |
|              | A) Time                                                     |          |      |      |      |      |         | KT   |
|              | B) Malfunctions                                             |          |      |      |      |      |         | KT   |
|              | C) Pierced Primers                                          |          |      |      |      |      |         | KT   |
|              | D) Optical Clarity of Scope                                 |          |      |      |      |      |         | KT   |
| 645          | Inspect for Live Ammo                                       |          |      |      |      |      | 5/13/91 | KT   |
| 655          | Final Inspection                                            |          |      |      |      |      |         |      |
|              | A) Headspace                                                |          |      |      |      |      | 5-21-91 | DH   |
|              | B) Trigger Pull                                             | 2.26     | 2.20 | 2.26 | 2.24 | 2.19 | 5/20/91 | JJ   |
|              | C) Function                                                 |          |      |      |      |      | 5-21-91 | DH   |
| 660          | Pack                                                        |          |      |      |      |      | 6-10-91 | VF   |

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS  
2.50# ± .50#  
3.00# ± .75#  
4.00# ± 1.00#

SERIAL NO. C00611515

DATE 5-9-91

TESTER P/H

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS          |
|---------|------------------|--------------------------|--------------------------------|------|-------------------|
| PULL #1 | 2.69             | 2.68                     | 2.77                           | 2.26 | MIN. SETTING,     |
| PULL #2 | 2.67             | 2.59                     | 2.77                           | 2.20 | NO AVG. OF 5      |
| PULL #3 | 2.57             | 3.02                     | 2.86                           | 2.26 | READINGS ACCEPT-  |
| PULL #4 | 2.77             | 2.83                     | 2.86                           | 2.24 | ABLE LESS THAN 2# |
| PULL #5 | 2.70             | 3.00                     | 2.88                           | 2.19 |                   |
| TOTAL   |                  |                          |                                |      |                   |
| AVG.    |                  |                          |                                |      |                   |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.33             | 3.06                     |  |          |
| PULL #2 | 3.32             | 3.07                     |  |          |
| PULL #3 | 3.19             | 3.22                     |  |          |
| PULL #4 | 3.03             | 3.05                     |  |          |
| PULL #5 | 3.31             | 3.24                     |  |          |
| TOTAL   |                  |                          |  |          |
| AVG.    |                  |                          |  |          |

|         | 4.00#<br>INITIAL | 4.00# AFTER<br>20 CYCLES | MAX SETTING<br>GREATER THAN 4# | RESET TO 4# FOR<br>TARGET & ACCURACY |
|---------|------------------|--------------------------|--------------------------------|--------------------------------------|
| PULL #1 | 4.22             | 4.00                     |                                | 4.58                                 |
| PULL #2 | 3.99             | 4.03                     |                                | 4.60                                 |
| PULL #3 | 3.96             | 4.22                     |                                | 4.60                                 |
| PULL #4 | 4.33             | 4.40                     |                                | 4.61                                 |
| PULL #5 | 4.24             | 4.01                     |                                | 4.53                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6611515  
13 May 1991

CENTROIDAL DISTANCES

|        |         |
|--------|---------|
| 0 TO 1 | .112894 |
| 1 TO 2 | .221508 |
| 1 TO 3 | .344397 |
| 1 TO 4 | 1.3041  |
| 1 TO 5 | .353362 |

$\bar{V}_5$   $\leftarrow$  POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2448  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .141  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: 1.000  
THE AMR FOR THIS RIFLE IS: 1.127

13 May 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6611515

# CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

# OF SHOTS- 10

# IN CIR

1in = 3

2in = 8

3in = 10

HS= 2.352

VS= 1.089

GS= 2.416

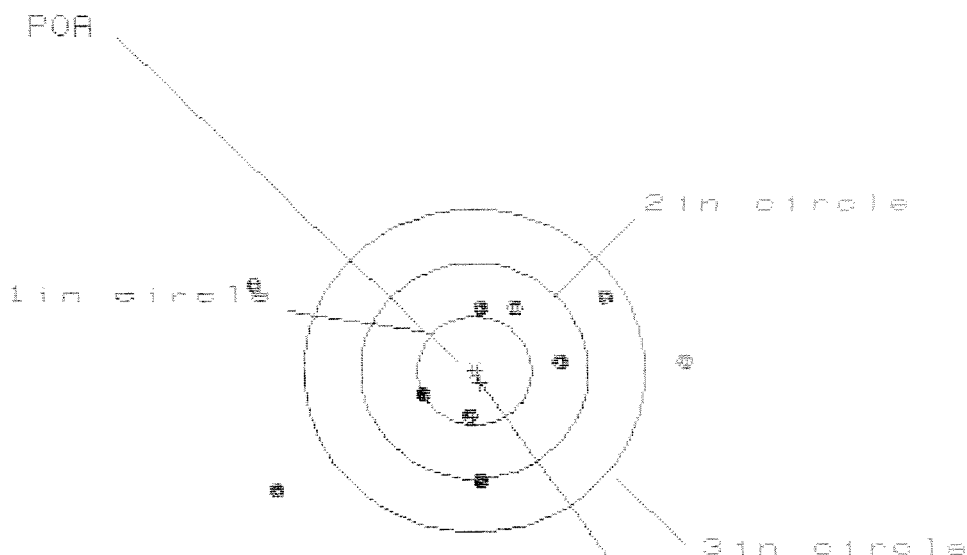
CENTROID #

|                             |   |        |       |       |
|-----------------------------|---|--------|-------|-------|
| PATTERN #                   | : | 1      |       |       |
| SHOTS (BEST OF)             | : | 10     | 9     | 8     |
| MAXIMUM X                   | : | 1.342  | 1.126 | 1.017 |
| MINIMUM X                   | : | -1.020 | -.871 | -.909 |
| MAXIMUM Y                   | : | .688   | .722  | .700  |
| MINIMUM Y                   | : | -.401  | -.367 | -.389 |
| CENTROID X                  | : | -.036  | -.185 | -.076 |
| CENTROID Y                  | : | -.107  | -.141 | -.119 |
| POA TO CENTROID in.         | : | .113   | .232  | .141  |
| MIN RADIUS                  | : | .205   | .102  | .171  |
| MEAN RADIUS                 | : | .729   | .640  | .605  |
| MAX RADIUS                  | : | 1.375  | 1.133 | 1.028 |
| HORIZONTAL SPREAD           | : | 2.362  | 1.997 | 1.926 |
| VERTICAL SPREAD             | : | 1.089  | 1.089 | 1.089 |
| EXTREME SPREAD              | : | 2.416  | 1.997 | 1.931 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 3     |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 8     |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 10    |       |

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# CENTERFIRE PATTERNS # 2



# OF SHOTS= 10

# IN CIR

1in = 1

2in = 5

3in = 7

HS= 3.815

VS= 1.818

GS= 3.873

CENTROID \*

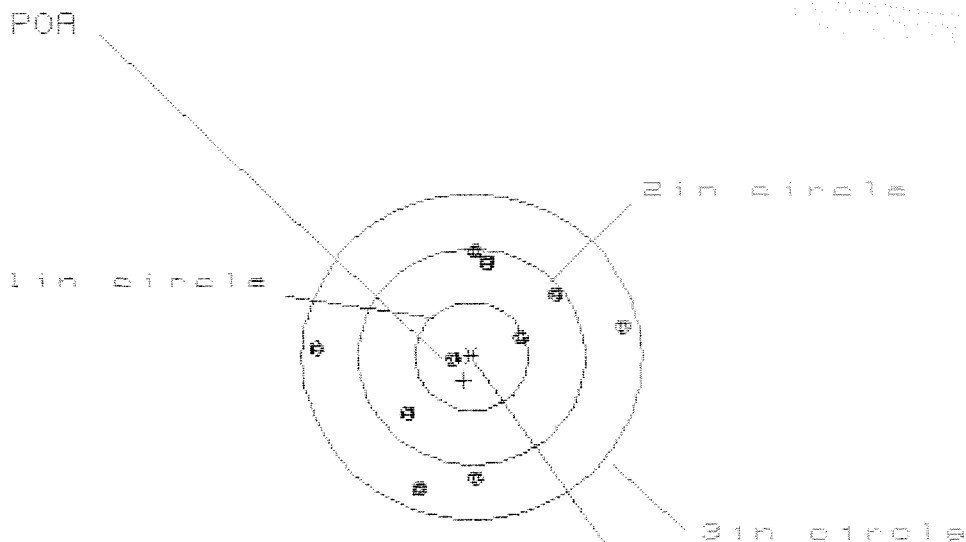
| PATTERN #                     | 2      | 3      | 8      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.829  | 1.609  | 1.366  |
| MINIMUM X                     | -1.986 | -1.943 | -.951  |
| MAXIMUM Y                     | .743   | .727   | .603   |
| MINIMUM Y                     | -1.075 | -.993  | -1.049 |
| CENTROID X                    | -.051  | .169   | .412   |
| CENTROID Y                    | .114   | .032   | .156   |
| POA TO CENTROID in.           | .125   | .172   | .441   |
| MIN RADIUS                    | .409   | .425   | .316   |
| MEAN RADIUS                   | 1.134  | 1.005  | .833   |
| MAX RADIUS                    | 2.120  | 2.182  | 1.366  |
| HORIZONTAL SPREAD             | 3.815  | 3.552  | 2.317  |
| VERTICAL SPREAD               | 1.818  | 1.720  | 1.652  |
| EXTREME SPREAD                | 3.873  | 3.733  | 2.337  |
| NUMBER IN ONE INCH CIRCLE =   | 1      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 5      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 7      |        |        |



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# CENTERFIRE PATTERNS # 3



# OF SHOTS = 10

# IN CIR

1 in = 2

2 in = 6

3 in = 10

HS = 2.706

VS = 2.201

GS = 2.715

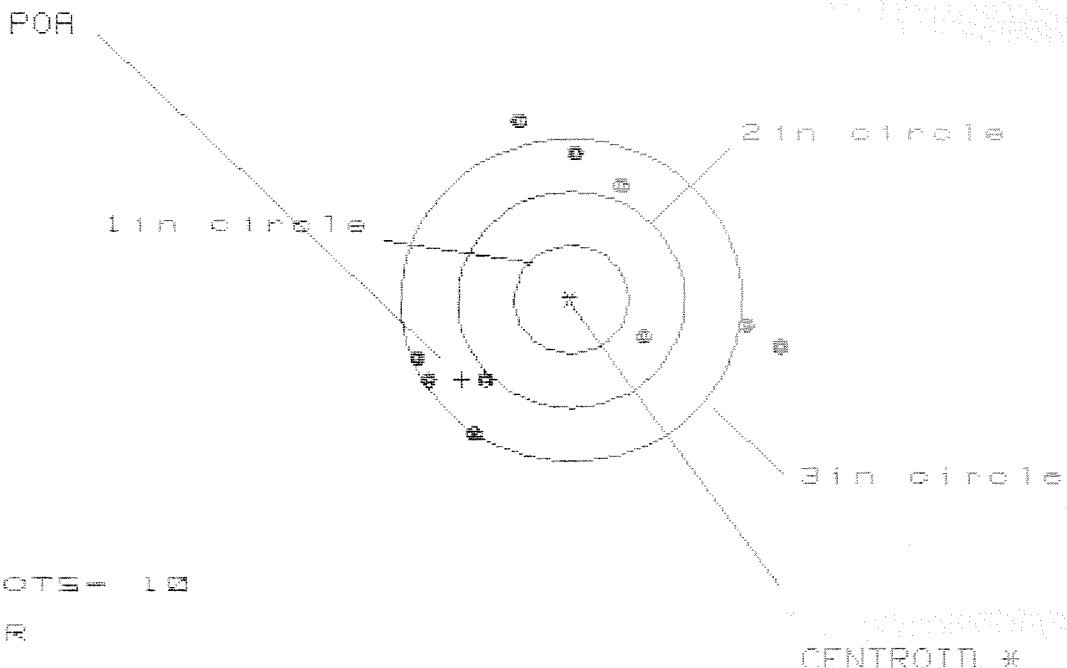
CENTROID \*

|                             |   |        |        |        |
|-----------------------------|---|--------|--------|--------|
| PATTERN #                   | : | 3      |        |        |
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.298  | 1.142  | .698   |
| MINIMUM X                   | : | -1.408 | -.766  | -.623  |
| MAXIMUM Y                   | : | .999   | 1.008  | 1.046  |
| MINIMUM Y                   | : | -1.202 | -1.193 | -1.155 |
| CENTROID X                  | : | .069   | .225   | .082   |
| CENTROID Y                  | : | .221   | .212   | .174   |
| POA TO CENTROID in.         | : | .231   | .309   | .192   |
| MIN RADIUS                  | : | .149   | .297   | .151   |
| MEAN RADIUS                 | : | .940   | .881   | .834   |
| MAX RADIUS                  | : | 1.410  | 1.352  | 1.256  |
| HORIZONTAL SPREAD           | : | 2.706  | 1.908  | 1.321  |
| VERTICAL SPREAD             | : | 2.201  | 2.201  | 2.201  |
| EXTREME SPREAD              | : | 2.715  | 2.324  | 2.257  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 6      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 10     |        |

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# CENTERFIRE PATTERNS # 4



# OF SHOTS = 10

# IN CIR

1in = 0

2in = 1

3in = 7

HS = 3.193

VS = 2.905

GS = 3.194

|                             |   |        |        |        |
|-----------------------------|---|--------|--------|--------|
| PATTERN #                   | : | 4      |        |        |
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.874  | 1.728  | 1.700  |
| MINIMUM X                   | : | -1.319 | -1.111 | -1.139 |
| MAXIMUM Y                   | : | 1.695  | 1.649  | 1.513  |
| MINIMUM Y                   | : | -1.210 | -1.256 | -1.050 |
| CENTROID X                  | : | .959   | .751   | .780   |
| CENTROID Y                  | : | .736   | .782   | .576   |
| POA TO CENTROID in.         | : | 1.209  | 1.084  | .969   |
| MIN RADIUS                  | : | .721   | .901   | .763   |
| MEAN RADIUS                 | : | 1.376  | 1.303  | 1.230  |
| MAX RADIUS                  | : | 1.919  | 1.750  | 1.701  |
| HORIZONTAL SPREAD           | : | 3.193  | 2.839  | 2.839  |
| VERTICAL SPREAD             | : | 2.905  | 2.905  | 2.563  |
| EXTREME SPREAD              | : | 3.194  | 2.934  | 2.853  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 0      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 1      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 7      |        |

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# CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID \*

# OF SHOTS- 10

# IN CIR

1 in = 1

2 in = 5

3 in = 5

HS= 3.334

VS= 5.260

GS= 5.296

| PATTERN #                     | 5      | 5      | 5      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.049  | 1.044  | .758   |
| MINIMUM X                     | -2.285 | -2.290 | -.971  |
| MAXIMUM Y                     | 1.729  | 1.337  | 1.196  |
| MINIMUM Y                     | -3.531 | -1.128 | -1.069 |
| CENTROID X                    | .283   | .288   | .574   |
| CENTROID Y                    | -.259  | .133   | .274   |
| POA TO CENTROID in.           | .384   | .317   | .636   |
| MIN RADIUS                    | .328   | .344   | .396   |
| MEAN RADIUS                   | 1.456  | 1.175  | .986   |
| MAX RADIUS                    | 3.531  | 2.553  | 1.445  |
| HORIZONTAL SPREAD             | 3.334  | 3.334  | 1.729  |
| VERTICAL SPREAD               | 5.260  | 2.465  | 2.265  |
| EXTREME SPREAD                | 5.296  | 4.024  | 2.684  |
| NUMBER IN ONE INCH CIRCLE =   | 1      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 5      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 5      |        |        |