

C6611532

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

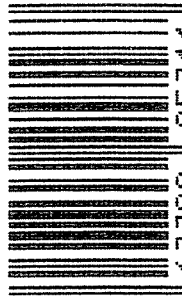
SERIAL NO.
C6611532

ORDER NO.
5716

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

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LPC



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5716 C6611532

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6611532

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/18/91	K.S.
600	Proof		3/18/91	K.S.
607	Check Headspace		3/18/91	K.S.
610	Dis-assemble Gun		3/18/91	K.S.
612	Magnaflux Barrel Action		3/28/91	KR
	Magnaflux Bolt		"	"
615	Rollmark Caliber		"	GB
617	Drill and Tap Sight Holes	APR	3 1991	FB
618	Polish Barrel	APR	3 1991	WB
620	Apply Coatings (Barrel Action)		4-19-91	DA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/23/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/24/91	KS
	C) Inspect Ejector Hole for Chamfer		4/24/91	KS
	D) Oil Firing Pin Ass'y		4/24/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		4/25/91	JK

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			4/25/91	JP
	G) Safety Off Force	2	2	2			4/25/91	JP
	H) Trigger Pull Test & Retainability						4/25/91	JP
	I) Firing Pin Indent	.0225	.023	.023			4/25/91	JP
	J) Assemble Stock						4/26/91	KS
	K) Assemble Swivel Studs						5-18-91	D/H
	L) Attach Front and Rear Sight Assemblies						4/26/91	KS
	M) Iron Sight Alignment						4/26/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/26/91	KS
	O) Attach Scope to Rifle						4/26/91	KS
	P) Detach & Attach Scope 20 Times						4/26/91	KS
640	Gallery Target & Test						4-29-91	AC
	A) Time						4-29-91	AC
	B) Malfunctions						4-29-91	AC
	C) Pierced Primers						4-29-91	AC
	D) Optical Clarity of Scope						4-29-91	AC
645	Inspect for Live Ammo						4-29-91	AC
655	Final Inspection							
	A) Headspace						5-18-91	D/H
	B) Trigger Pull	2.32	2.38	2.38	2.32	2.41	5/10/91	JP
	C) Function						5-18-91	D/H
660	Pack						6-18-91	NF

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6611532

DATE 4/23/97

TESTER JRP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.31	2.49	2.40	2.32	MIN. SETTING.
PULL #2	2.25	2.30	2.38	2.38	NO AVG. OF 5.
PULL #3	2.28	2.43	2.36	2.38	READINGS ACCEPT-
PULL #4	2.33	2.28	2.22	2.32	ABLE LESS THAN 2#
PULL #5	2.28	2.36	2.33	2.41	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.30	3.55		
PULL #2	3.34	3.45		
PULL #3	3.57	3.55		
PULL #4	3.50	3.56		
PULL #5	3.59	3.58		
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	4.36		4.31
PULL #2	4.35	4.47		4.40
PULL #3	4.34	4.53		4.42
PULL #4	4.39	4.49		4.55
PULL #5	4.39	4.20		4.30
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06611532
29 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.536079
1 TO	2	.287606
1 TO	3	.861734
1 TO	4	.524061
1 TO	5	.335722

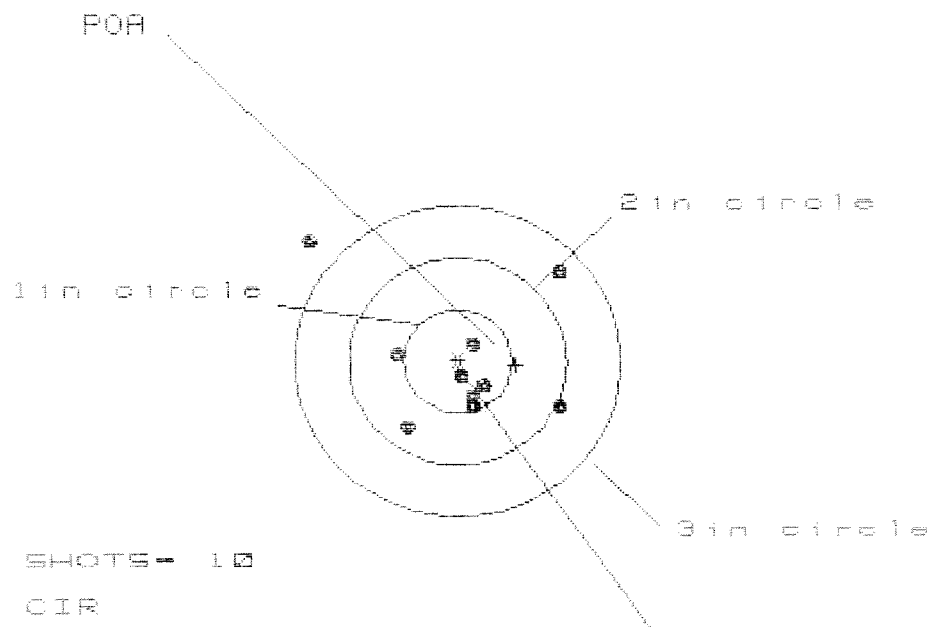
$\frac{1}{2}t_3$ <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1562
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.037
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .160027
THE AME FOR THIS RIFLE IS: .7972

29 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CBB11532

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 5

2in = 5

3in = 0

HS = 2.254

VS = 1.839

GS = 2.779

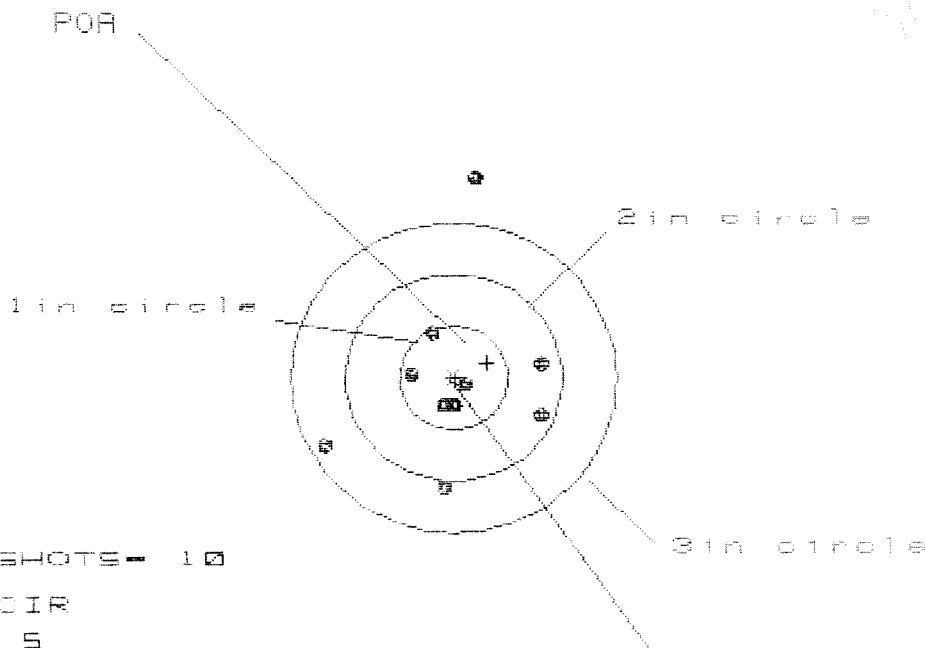
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.911	.762	.844
MINIMUM X	-1.343	-.734	-.639
MAXIMUM Y	1.211	.988	.448
MINIMUM Y	-.628	-.493	-.370
CENTROID X	-.535	-.386	-.481
CENTROID Y	.034	-.101	-.224
POA TO CENTROID in.	.536	.398	.530
MIN RADIUS	.177	.157	.103
MEAN RADIUS	.707	.533	.413
MAX RADIUS	1.809	1.247	.862
HORIZONTAL SPREAD	2.254	1.496	1.483
VERTICAL SPREAD	1.839	1.481	.818
EXTREME SPREAD	2.779	2.055	1.558
NUMBER IN ONE INCH CIRCLE =	5		
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		9	

29 Apr 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 5

2in = 7

3in = 9

HS = 2.011

VS = 2.959

GS = 2.971

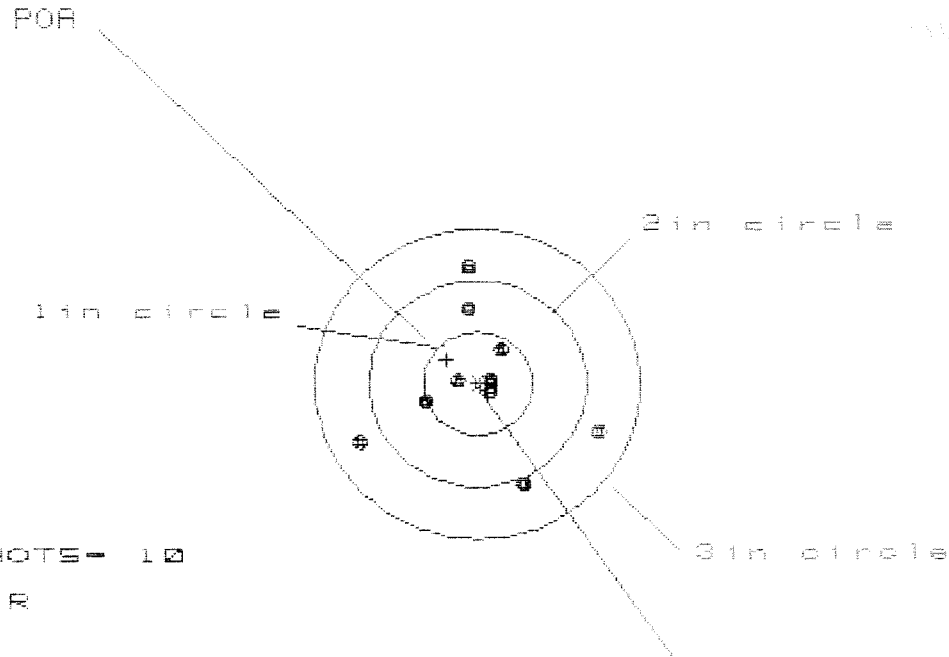
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.898	.826	.678
MINIMUM X	:	-1.203	-1.185	-.485
MAXIMUM Y	:	1.926	.677	.623
MINIMUM Y	:	-1.033	-.819	-.873
CENTROID X	:	-.306	-.324	-.176
CENTROID Y	:	-.140	-.354	-.300
POA TO CENTROID in.	:	.337	.480	.348
MIN RADIUS	:	.174	.007	.089
MEAN RADIUS	:	.751	.578	.502
MAX RADIUS	:	1.932	1.259	.904
HORIZONTAL SPREAD	:	2.011	2.011	1.163
VERTICAL SPREAD	:	2.959	1.496	1.496
EXTREME SPREAD	:	2.971	2.153	1.498
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 5

2in = 6

3in = 10

HS= 2.206

VS= 2.151

GS= 2.224

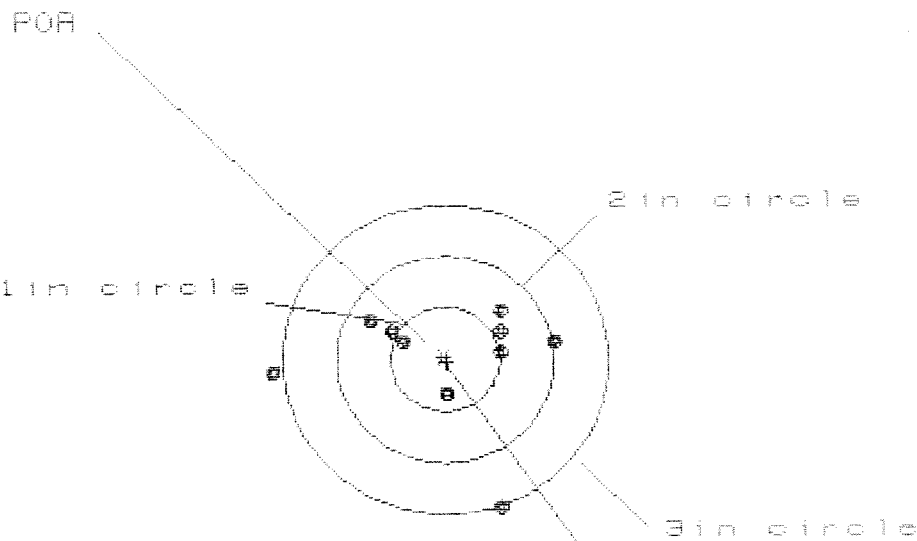
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.130	.561	.442
MINIMUM X	:	-1.076	-.951	-.448
MAXIMUM Y	:	1.167	1.112	1.030
MINIMUM Y	:	-.984	-1.039	-1.121
CENTROID X	:	.284	.159	.278
CENTROID Y	:	-.234	-.179	-.097
POA TO CENTROID in.	:	.368	.239	.294
MIN RADIUS	:	.112	.048	.098
MEAN RADIUS	:	.668	.600	.513
MAX RADIUS	:	1.234	1.181	1.205
HORIZONTAL SPREAD	:	2.206	1.512	.690
VERTICAL SPREAD	:	2.151	2.151	2.151
EXTREME SPREAD	:	2.224	2.224	2.224
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

29 Apr 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 2.601

VS= 1.807

GS= 2.614

CENTROID #

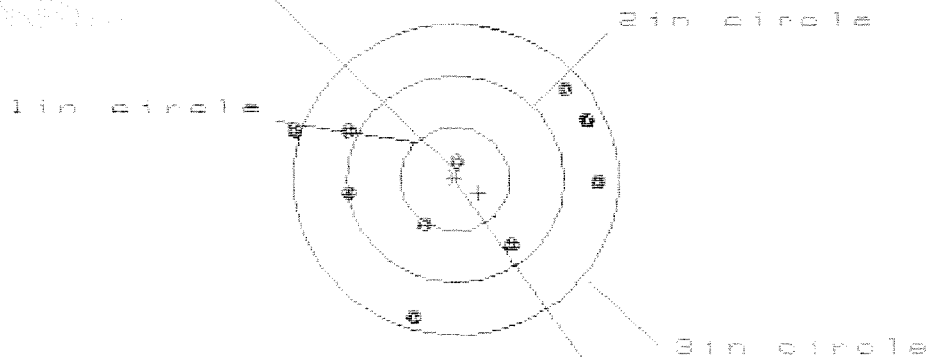
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.006	.829	.666
MINIMUM X	:	-1.595	-.853	-.816
MAXIMUM Y	:	.427	.413	.239
MINIMUM Y	:	-1.380	-1.394	-.489
CENTROID X	:	-.011	.166	.129
CENTROID Y	:	.026	.040	.214
POA TO CENTROID in.	:	.029	.171	.250
MIN RADIUS	:	.302	.307	.338
MEAN RADIUS	:	.784	.675	.562
MAX RADIUS	:	1.599	1.426	.868
HORIZONTAL SPREAD	:	2.601	1.682	1.682
VERTICAL SPREAD	:	1.807	1.807	.728
EXTREME SPREAD	:	2.614	2.121	1.702
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5

POA



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 6

HS= 2.801

VS= 2.275

GS= 2.842

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.341	1.179	1.113
MINIMUM X	:	-1.460	-1.190	-1.256
MAXIMUM Y	:	.903	.953	.788
MINIMUM Y	:	-1.372	-1.322	-1.764
CENTROID X	:	-.213	-.051	.015
CENTROID Y	:	.129	.079	.244
POA TO CENTROID in.	:	.249	.094	.245
MIN RADIUS	:	.204	.288	.222
MEAN RADIUS	:	1.076	1.023	.966
MAX RADIUS	:	1.528	1.421	1.296
HORIZONTAL SPREAD	:	2.801	2.369	2.369
VERTICAL SPREAD	:	2.275	2.275	1.552
EXTREME SPREAD	:	2.842	2.677	2.408
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		9	