

06594613

MODEL 700™ M24

Model 515™

Action

Barrel Length

Capacity

Order No. 5715

*Includes 1 in chamber.






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

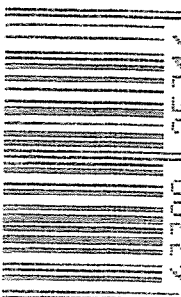
MODEL 700™ H24

SERIAL NO.
C6594613

ORDER NO.
5716

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

LPC



0 47700 25716 7



5716 C6594613

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6594613

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		12/27/90	K.S.
600	Proof		12/27/90	K.S.
607	Check Headspace		12/27/90	K.S.
610	Dis-assemble Gun		12/27/90	K.S.
612	Magnaflux Barrel Action		1-7-91	KR
	Magnaflux Bolt		1-7-91	KR
615	Rollmark Caliber		1-7-91	G.B.
617	Drill and Tap Sight Holes	1	10 91	K.B.
618	Polish Barrel	1	10 91	W.B.
620	Apply Coatings (Barrel Action)		1-26-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/4/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/4/91	KA
	C) Inspect Ejector Hole for Chamfer		2/4/91	KA
	D) Oil Firing Pin Ass'y		2/4/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		2/5/91	JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			2/5/91	WB
	G) Safety Off Force	2 1/4	2 1/4	2 1/4			2/5/91	WB
	H) Trigger Pull Test & Retainability						2/5/91	gll
	I) Firing Pin Indent	.0205	.021	.0205			2/5/91	WB
	J) Assemble Stock						2/6/91	KA
	K) Assemble Swivel Studs						2-19-91	AC
	L) Attach Front and Rear Sight Assemblies						2/6/91	KA
	M) Iron Sight Alignment						2/6/91	KA
	N) Detach Front & Rear Sights & place in numbered container						2/6/91	KA
	O) Attach Scope to Rifle						2/6/91	KA
	P) Detach & Attach Scope 20 Times						2/6/91	KA
640	Gallery Target & Test						2-7-91	DH
	A) Time						2-7-91	DH
	B) Malfunctions						2-7-91	DH
	C) Pierced Primers						2-7-91	DH
	D) Optical Clarity of Scope						2-7-91	DH
645	Inspect for Live Ammo						2-7-91	DH
655	Final Inspection						2-19-91	AC
	A) Headspace							
	B) Trigger Pull	2.32	2.24	2.14	2.13	2.15	2/18/91	WB
	C) Function						2-19-91	AC
660	Pack						3-19-91	AC

SWS TRIGGER PULL TEST

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

SERIAL NO. C6594613

DATE 2/5/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.26	2.37	2.32	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.37	2.28	2.34	2.24	
PULL #3	2.47	2.29	2.19	2.14	
PULL #4	2.50	2.19	2.33	2.13	
PULL #5	2.40	2.22	2.29	2.15	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.40	3.73		
PULL #2	3.44	3.33		
PULL #3	3.35	3.32		
PULL #4	3.25	3.34		
PULL #5	3.34	3.19		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.45	4.46		4.38
PULL #2	4.36	4.14		4.38
PULL #3	4.49	4.36		4.47
PULL #4	4.44	4.20		4.31
PULL #5	4.46	4.23		4.18
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594613
8 Feb 1991

CENTROIDAL DISTANCES

0 TO	1	.29625
1 TO	2	.489813
1 TO	3	.528289
1 TO	4	.440256
1 TO	5	.19451

 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0672
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.003
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0672669
THE AMR FOR THIS RIFLE IS: .856

8 Feb 1991

FILE://PATTERNING/CENTERFIRE_PATT/C6534613

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS = 1.742

VS = 2.869

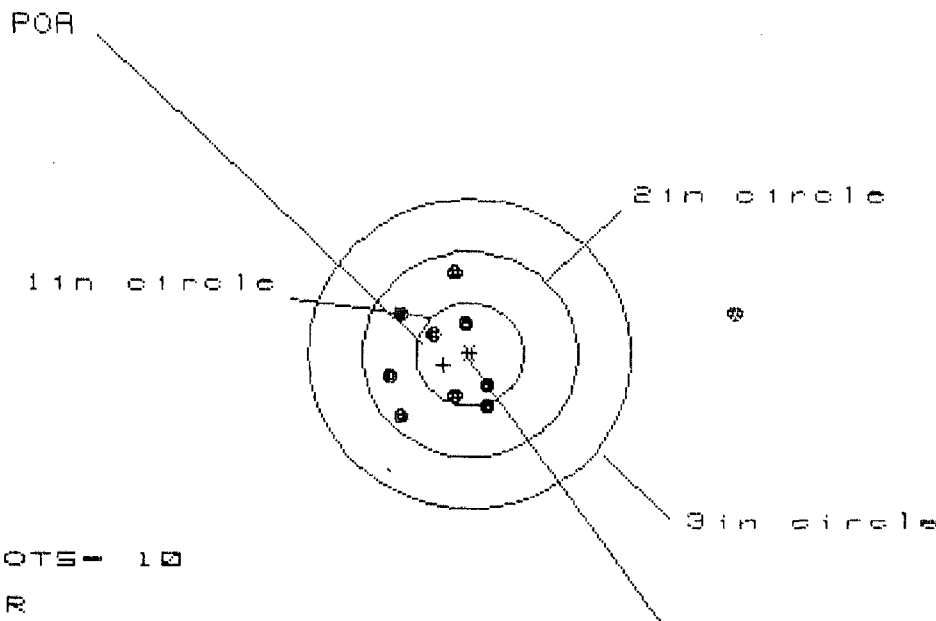
GS = 2.884

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.932	.909	.759
MINIMUM X	:	-.810	-.833	-.719
MAXIMUM Y	:	1.070	.871	.952
MINIMUM Y	:	-1.799	-.907	-.826
CENTROID X	:	-.050	-.027	-.141
CENTROID Y	:	-.292	-.093	-.174
POA TO CENTROID in.	:	.297	.097	.224
MIN RADIUS	:	.356	.393	.299
MEAN RADIUS	:	.870	.741	.678
MAX RADIUS	:	1.810	1.119	.956
HORIZONTAL SPREAD	:	1.742	1.742	1.478
VERTICAL SPREAD	:	2.869	1.778	1.778
EXTREME SPREAD	:	2.884	2.115	1.783
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 4

2in = 8

3in = 9

HS= 3.188

VS= 1.377

GS= 3.255

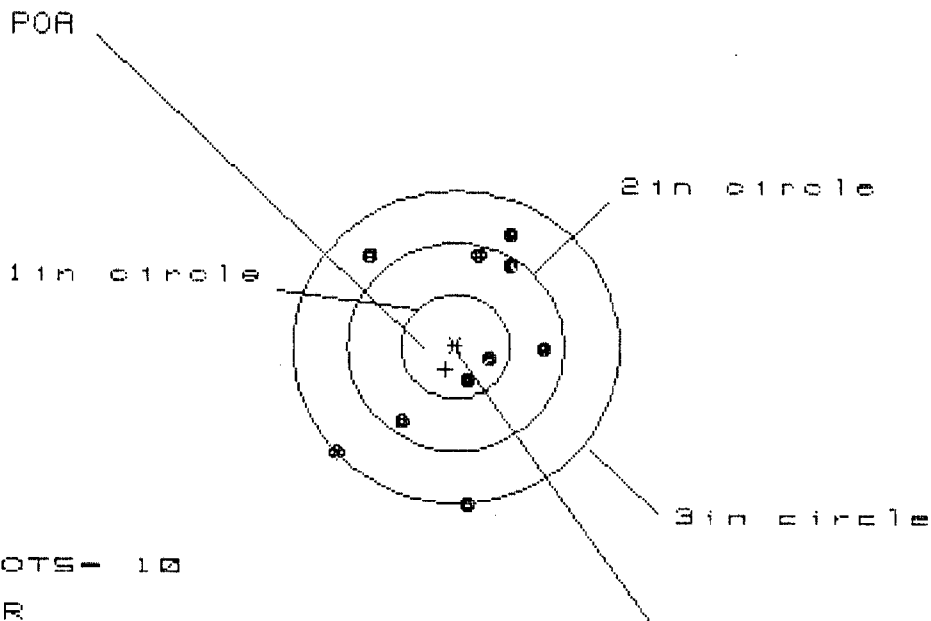
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.433	.453	.411
MINIMUM X	:	-.755	-.485	-.526
MAXIMUM Y	:	.772	.818	.748
MINIMUM Y	:	-.605	-.559	-.573
CENTROID X	:	.241	-.029	.013
CENTROID Y	:	.102	.056	.126
POR TO CENTROID in.	:	.262	.063	.127
MIN RADIUS	:	.298	.244	.211
MEAN RADIUS	:	.768	.529	.508
MAX RADIUS	:	2.467	.822	.749
HORIZONTAL SPREAD	:	3.188	.938	.938
VERTICAL SPREAD	:	1.377	1.377	1.321
EXTREME SPREAD	:	3.255	1.438	1.372
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 1.923

VS= 2.555

GS= 2.670

CENTROID #

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.781	.654	.656
MINIMUM X	:	-1.142	-.959	-.957
MAXIMUM Y	:	1.074	.961	.761
MINIMUM Y	:	-1.481	-1.594	-1.012
CENTROID X	:	.095	.222	.220
CENTROID Y	:	.216	.329	.529
POA TO CENTROID in.	:	.236	.397	.572
MIN RADIUS	:	.284	.254	.435
MEAN RADIUS	:	.956	.870	.773
MAX RADIUS	:	1.533	1.594	1.191
HORIZONTAL SPREAD	:	1.923	1.613	1.613
VERTICAL SPREAD	:	2.555	2.555	1.773
EXTREME SPREAD	:	2.670	2.581	2.043
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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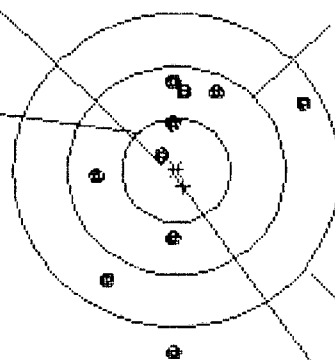
CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 1.818

VS= 2.573

GS= 2.623

CENTROID *

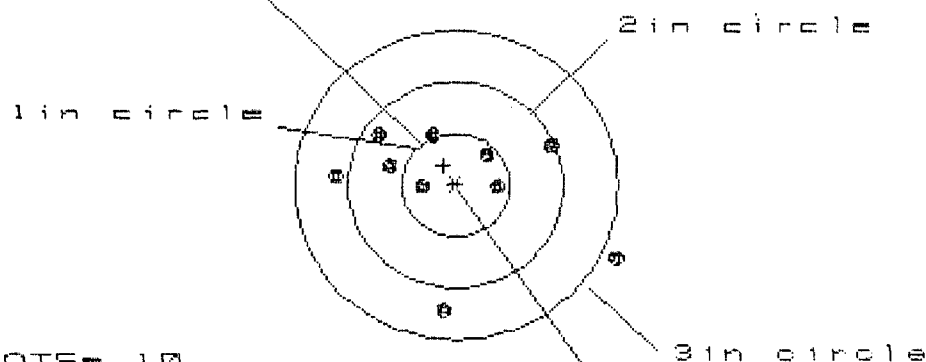
PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.128	1.125	.484
MINIMUM X	:	-.690	-.693	-.552
MAXIMUM Y	:	.838	.645	.699
MINIMUM Y	:	-1.735	-1.271	-1.218
CENTROID X	:	-.065	-.062	-.202
CENTROID Y	:	.148	.341	.287
POA TO CENTROID in.	:	.162	.346	.352
MIN RADIUS	:	.209	.091	.071
MEAN RADIUS	:	.873	.718	.659
MAX RADIUS	:	1.735	1.440	1.330
HORIZONTAL SPREAD	:	1.818	1.818	1.037
VERTICAL SPREAD	:	2.573	1.916	1.916
EXTREME SPREAD	:	2.623	2.475	2.060
NUMBER IN ONE INCH CIRCLE	=	2		
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

1in = 4

2in = 7

3in = 9

HS= 2.577

VS= 1.706

GS= 2.694

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.467	1.060	1.063
MINIMUM X	-1.110	-.947	-.945
MAXIMUM Y	.492	.414	.252
MINIMUM Y	-1.214	-1.292	-.236
CENTROID X	.115	-.048	-.050
CENTROID Y	-.189	-.111	.051
POA TO CENTROID in.	.221	.121	.071
MIN RADIUS	.330	.170	.218
MEAN RADIUS	.813	.685	.587
MAX RADIUS	1.625	1.292	1.072
HORIZONTAL SPREAD	2.577	2.007	2.007
VERTICAL SPREAD	1.706	1.706	.488
EXTREME SPREAD	2.694	2.028	2.028
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	