

C6636183

MODEL 700™ M24

Model S&S™

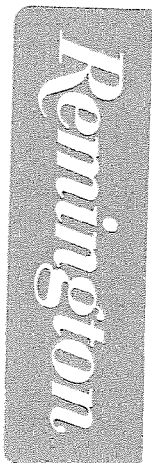
Action _____

Barrel Length _____

Capacity _____

Order No. 5715

*Includes 1 in chamber.






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

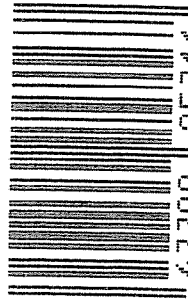
MODEL 700™ M24

SERIAL NO.
C6636183

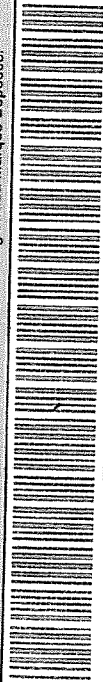
ORDER NO.
5716

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

UPC



0 47700 25716 7



5716 C6636183

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636183

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	5/3/91	KS
600	Proof		5/3/91	KS
607	Check Headspace		5/3/91	KS
610	Dis-assemble Gun		5/3/91	KS
612	Magnaflux Barrel Action		JUL 2 1991	KR
	Magnaflux Bolt		JUL 2 1991	KR
615	Rollmark Caliber		JUL 2 1991	KR
617	Drill and Tap Sight Holes		JUL 2 1991	KB
618	Polish Barrel		JUL 17 1991	WB
620	Apply Coatings (Barrel Action)		8-6-91	KB
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/15/91	KB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/15/91	KB
	C) Inspect Ejector Hole for Chamfer		8/15/91	KB
	D) Oil Firing Pin Ass'y		8/15/91	KB
	E) Adjust Trigger Pull to Min Setting and Stake		8/16/91	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			8/16/91	WB
	G) Safety Off Force	2	2	2			8/16/91	WB
	H) Trigger Pull Test & Retainability						8/16/91	WB
	I) Firing Pin Indent	.0205	.021	.021			8/16/91	WB
	J) Assemble Stock						8/16/91	KL
	K) Assemble Swivel Studs						8/22/91	KL
	L) Attach Front and Rear Sight Assemblies						8/16/91	KL
	M) Iron Sight Alignment						8/16/91	KL
	N) Detach Front & Rear Sights & place in numbered container						8/16/91	KL
	O) Attach Scope to Rifle						8/16/91	KL
	P) Detach & Attach Scope 20 Times						8/16/91	KL
640	Gallery Target & Test						8/19/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						8/19/91	KT
655	Final Inspection							
	A) Headspace						8/22/91	KL
	B) Trigger Pull	2.31	2.42	2.40	2.39	2.35	8-20-91	PH
	C) Function						8/22/91	KL
660	Pack						9-17-91	PH

SWS TRIGGER PULL TEST

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

SERIAL NO. C6636183
DATE 8/16/91
TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.35	2.25	2.43	231	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.42	2.35	2.36	242	
PULL #3	2.31	2.36	2.43	240	
PULL #4	2.37	2.45	2.43	239	
PULL #5	2.42	2.26	2.46	235	
TOTAL	11.87	11.67	12.11		
AVG.	2.37	2.33	2.42		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.17	3.34		
PULL #2	3.15	3.48		
PULL #3	3.13	3.40		
PULL #4	3.09	3.11		
PULL #5	3.10	3.37		
TOTAL	15.64	16.70		
AVG.	3.13	3.34		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.04	4.01		4.37
PULL #2	4.06	4.01		4.15
PULL #3	4.08	3.95		4.05
PULL #4	4.11	4.00		4.18
PULL #5	4.13	4.00		4.17
TOTAL	20.42	19.97		20.92
AVG.	4.08	4.00		4.18

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636183
23 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.0714493
1 TO	2	.0400125
1 TO	3	.20854
1 TO	4	.270535
1 TO	5	.190515

←----PDR

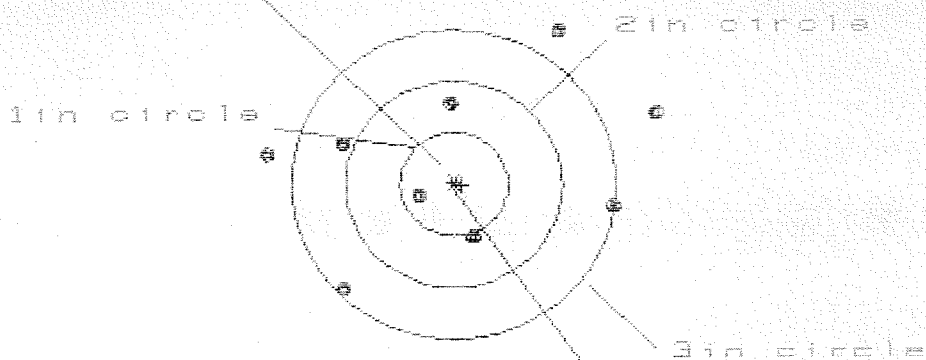
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0416
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0336
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0531745
THE AMR FOR THIS RIFLE IS: .9924

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66361B3

CENTERFIRE PATTERNS # 1

FOR



OF SHOTS - 10

IN CIR

1in = 1

2in = 3

3in = 6

HS= 3.656

VS= 3.375

GS= 3.683

CENTROID #

PATTERN #

1

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.894	1.661	1.656
MINIMUM X	:	-1.762	-1.551	-1.556
MAXIMUM Y	:	1.487	1.569	1.343
MINIMUM Y	:	-1.888	-1.806	-1.133
CENTROID X	:	-.071	-.292	-.277
CENTROID Y	:	.008	-.074	.152
POA TO CENTROID in.	:	.072	.291	.316
MIN RADIUS	:	.320	.095	.260
MEAN RADIUS	:	1.311	1.190	1.118
MAX RADIUS	:	2.034	1.973	1.796
HORIZONTAL SPREAD	:	3.656	3.212	3.212
VERTICAL SPREAD	:	3.375	3.375	2.476
EXTREME SPREAD	:	3.683	3.593	3.247
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		6	

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66361B3

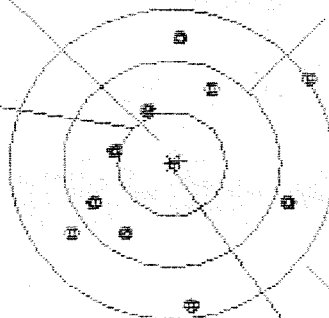
CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle



OF SHOTS = 10

IN CIR

1in = 0

2in = 5

3in = 10

HS= 2.137

VS= 2.521

GS= 2.633

CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.242	1.187	1.224
MINIMUM X	:	-.895	-.757	-.720
MAXIMUM Y	:	1.202	1.294	1.141
MINIMUM Y	:	-1.319	-1.227	-.768
CENTROID X	:	-.072	-.210	-.247
CENTROID Y	:	-.032	-.124	.029
POA TO CENTROID in.	:	.079	.244	.249
MIN RADIUS	:	.548	.444	.366
MEAN RADIUS	:	.979	.894	.828
MAX RADIUS	:	1.495	1.306	1.282
HORIZONTAL SPREAD	:	2.137	1.944	1.944
VERTICAL SPREAD	:	2.521	2.521	1.909
EXTREME SPREAD	:	2.633	2.524	2.128
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

25 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06836103

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS= 10

IN CIR

1 in = 4

2 in = 9

3 in = 10

HS= 2.168

VS= 1.645

GS= 2.211

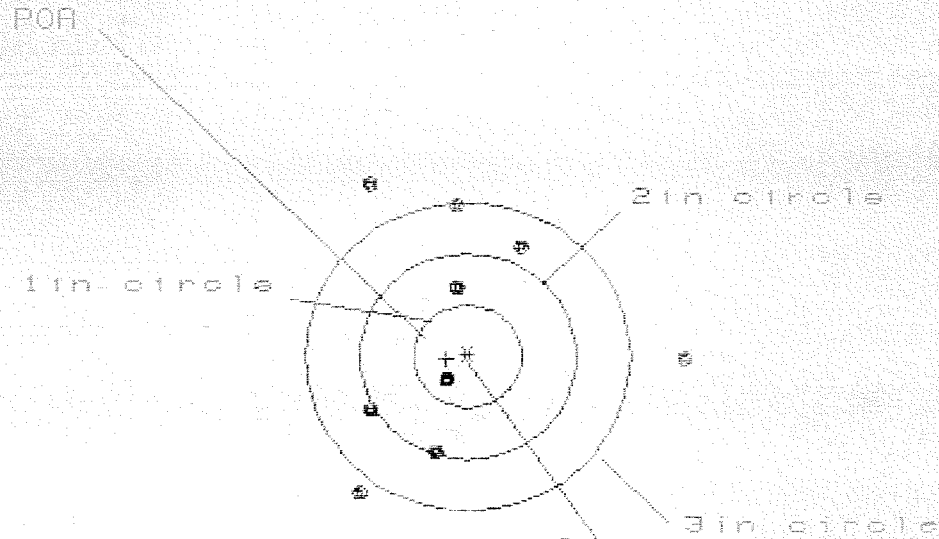
PATTERN # : 3

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.207	.631	.356
MINIMUM X	-.961	-.827	-.748
MAXIMUM Y	.802	.767	.657
MINIMUM Y	-.843	-.878	-.532
CENTROID X	.137	.003	-.076
CENTROID Y	-.007	.028	.138
POA TO CENTROID in.	.137	.028	.158
MIN RADIUS	.067	.078	.097
MEAN RADIUS	.605	.520	.448
MAX RADIUS	1.249	1.082	.748
HORIZONTAL SPREAD	2.168	1.458	1.104
VERTICAL SPREAD	1.645	1.645	1.189
EXTREME SPREAD	2.211	1.838	1.241
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636183

CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1in = 1

2in = 3

3in = 6

HS = 2.984

VS = 3.538

GS = 3.964

CENTROID #

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.026	2.128	1.883
MINIMUM X	-0.958	-0.856	-0.590
MAXIMUM Y	1.665	1.457	1.433
MINIMUM Y	-1.873	-1.530	-1.554
CENTROID X	.199	.097	-.169
CENTROID Y	.025	.233	.257
POA TO CENTROID in.	.201	.252	.307
MIN RADIUS	.271	.411	.462
MEAN RADIUS	1.319	1.212	1.082
MAX RADIUS	2.085	2.136	1.662
HORIZONTAL SPREAD	2.984	2.984	1.473
VERTICAL SPREAD	3.538	2.987	2.987
EXTREME SPREAD	3.964	3.333	2.988
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	6		

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636163

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= .823

VS= 2.151

GS= 2.210

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.446

.398

.368

MINIMUM X

-.377

-.328

-.358

MAXIMUM Y

1.174

1.205

1.133

MINIMUM Y

-.977

-.847

-.696

CENTROID X

.015

-.034

-.084

CENTROID Y

-.162

-.292

-.443

POA TO CENTROID in.

.163

.294

.443

MIN RADIUS

.377

.332

.302

MEAN RADIUS

.748

.664

.556

MAX RADIUS

1.256

1.230

1.145

HORIZONTAL SPREAD

.823

.726

.726

VERTICAL SPREAD

2.151

2.052

1.835

EXTREME SPREAD

2.210

2.065

1.842

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

8

NUMBER IN THREE INCH CIRCLE =

10