

05522349

MODEL 700™ M24

Model **S&S**™

Action

Barrel Length

Capacity

Order No. **5716**

* Includes 1 in chamber.





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

MODEL 700™ M24

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

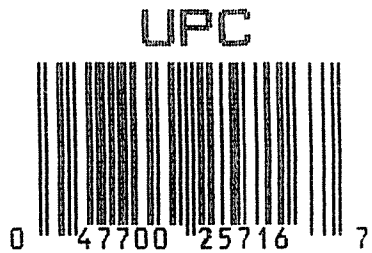
01

SERIAL NO.
C6522349

ORDER NO.
5716



5716 C6522349



CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522349
18 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.153056
1 TO	2	.0616847
1 TO	3	.358013
1 TO	4	.0818841
1 TO	5	.114726

35 <----POA

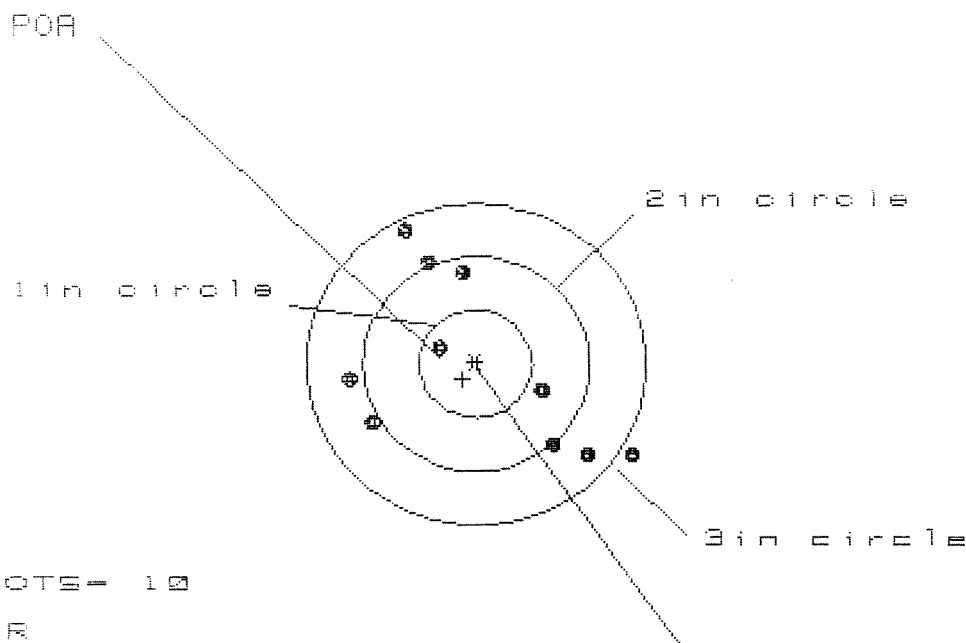
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0518
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0436
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0677057

THE AMP FOR THIS RIFLE IS: .7596

18 Sep 1990

FILE:/PATTERNING/CENTERFIRE_PATT/08522343

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 9

MS= 2.476

VS= 2.112

ES= 2.884

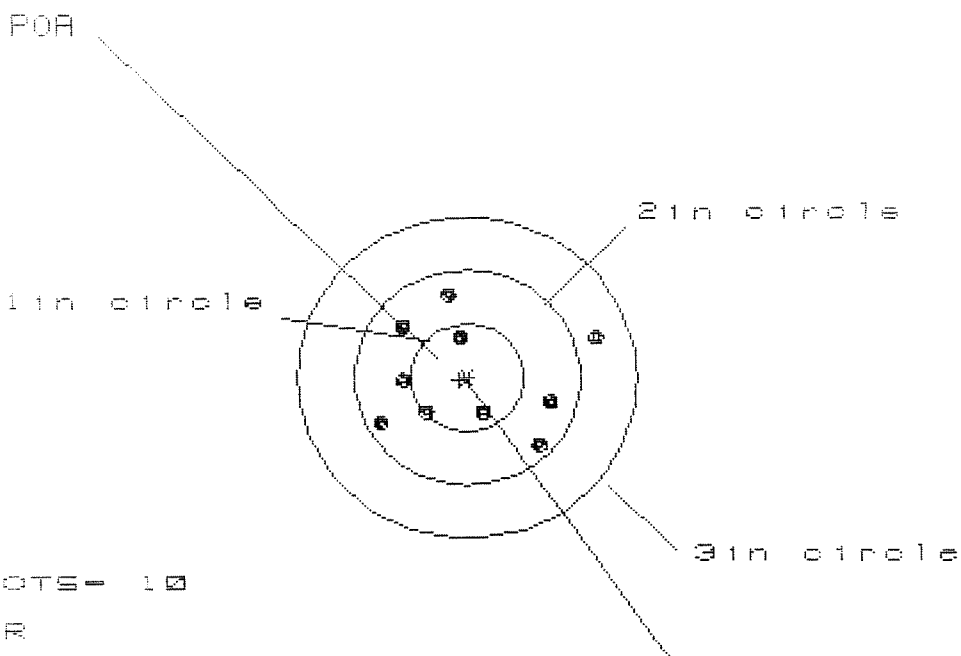
CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.346	1.165	1.185
MINIMUM X	-1.130	-0.980	-1.040
MAXIMUM Y	1.291	1.201	1.051
MINIMUM Y	-0.821	-0.911	-0.761
CENTROID X	.120	-0.030	.030
CENTROID Y	.146	.236	.086
POA TO CENTROID in.	.189	.238	.091
MIN RADIUS	.313	.141	.273
MEAN RADIUS	1.033	.945	.909
MAX RADIUS	1.572	1.479	1.342
HORIZONTAL SPREAD	2.476	2.145	2.145
VERTICAL SPREAD	2.112	2.112	1.812
EXTREME SPREAD	2.884	2.675	2.333
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	9		

18 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522343

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 9

3 in = 10

XS = 1.054

YS = 1.388

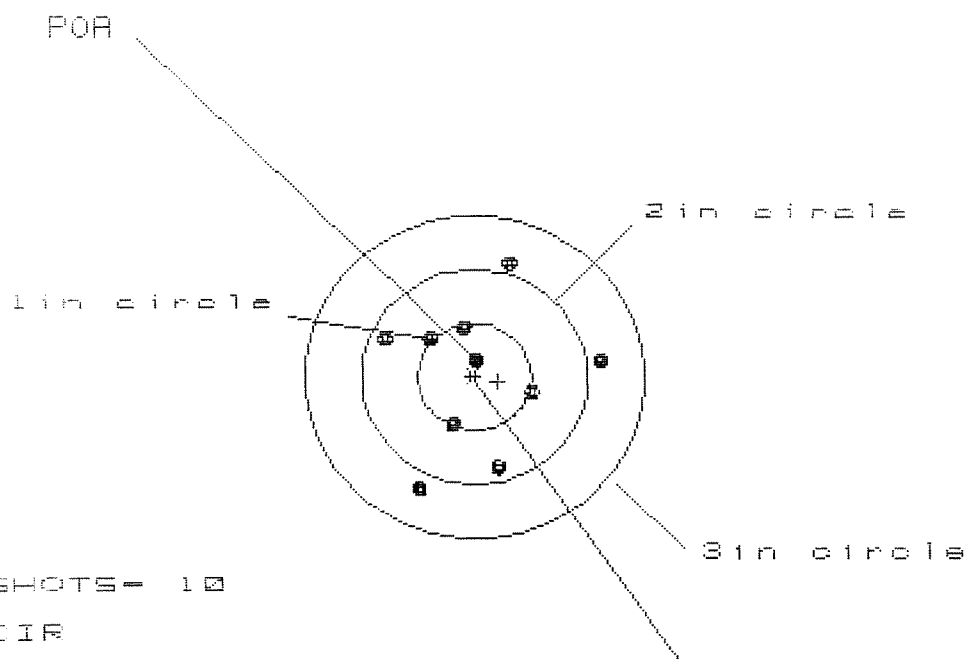
GS = 2.004

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.106	.852	.945
MINIMUM X	-.748	-.625	-.532
MAXIMUM Y	.747	.788	.713
MINIMUM Y	-.641	-.600	-.422
CENTROID X	.068	-.055	-.148
CENTROID Y	.023	-.018	.057
POA TO CENTROID in.	.072	.058	.158
MIN RADIUS	.295	.322	.319
MEAN RADIUS	.688	.615	.557
MAX RADIUS	1.167	.953	.975
HORIZONTAL SPREAD	1.854	1.477	1.477
VERTICAL SPREAD	1.388	1.388	1.135
EXTREME SPREAD	2.004	1.603	1.488
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	9	
NUMBER IN THREE INCH CIRCLE	=	10	

[illegible]

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CENTERFIRE PATTERNS # 3



* OF SHOTS = 10

INCIR

117 = 3

210 *Journal of Health Politics, Policy and Law*

$$e_1 n = 10$$

DECLASSIFICATION AUTHORITY

2013年12月13日

CENTROID #

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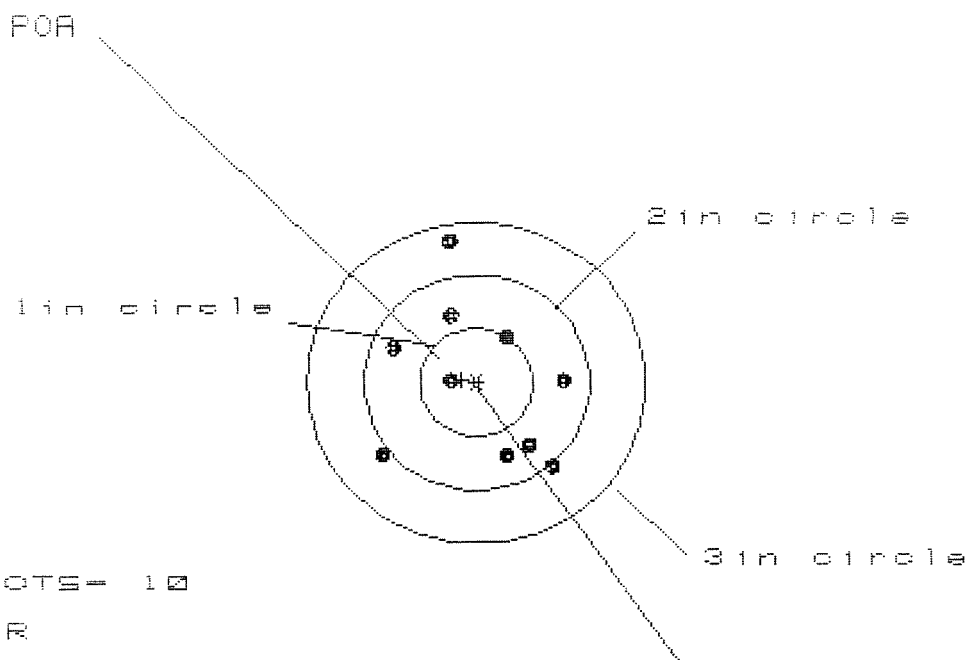
PATTERN #           :           3
SHOTS (BEST OF)    :           10           9           8
MAXIMUM X           :           1.077       1.020       1.046
MINIMUM X           :           -.794       -.851       -.824
MAXIMUM Y           :           1.065       .946        .483
MINIMUM Y           :           -1.068      -.938       -1.819
CENTROID X          :           -.209       -.152       -.178
CENTROID Y          :           .038        .157        .038
POA TO CENTROID in.:           .213       .218       .183
MIN RADIUS          :           .135       .086       .144
MEAN RADIUS         :           .726       .663       .624
MAX RADIUS          :           1.185       1.020       1.053
HORIZONTAL SPREAD   :           1.871       1.871       1.871
VERTICAL SPREAD     :           2.133       1.884       1.302
EXTREME SPREAD      :           2.271       1.886       1.884
NUMBER IN ONE INCH CIRCLE =           3
NUMBER IN TWO INCH CIRCLE =           7
NUMBER IN THREE INCH CIRCLE =          10

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18 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06522349

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 1

2in = 7

3in = 10

SE= 1.626

CS= 2.049

GS= 2.240

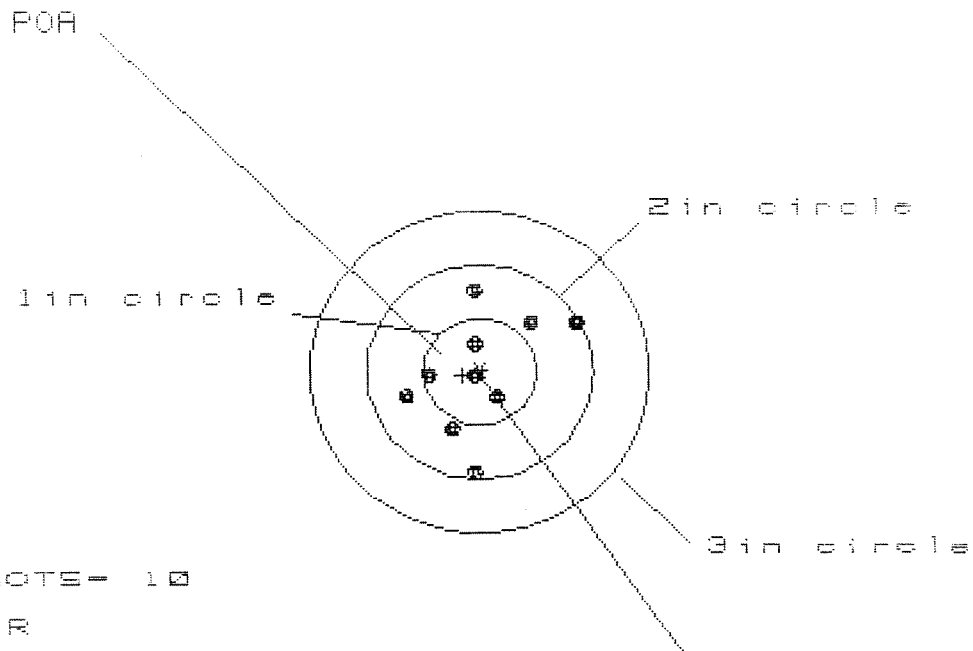
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.753	.726	.613
MINIMUM X	:	-.873	-.900	-.868
MAXIMUM Y	:	1.282	.736	.667
MINIMUM Y	:	-.767	-.625	-.694
CENTROID X	:	.131	.158	.271
CENTROID Y	:	-.024	-.166	-.097
POA TO CENTROID in.	:	.133	.229	.287
KIN RADIUS	:	.255	.320	.403
MEAN RADIUS	:	.778	.714	.659
MAX RADIUS	:	1.305	1.058	.953
HORIZONTAL SPREAD	:	1.626	1.626	1.481
VERTICAL SPREAD	:	2.049	1.361	1.361
EXTREME SPREAD	:	2.240	1.766	1.765
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	10		

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FILE:/PATTERNING/CENTERFIRE_PATT/08522349

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 4

2in = 9

3in = 10

MS= 1.581

VS= 1.705

GS= 1.744

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.894	.534	.546
MINIMUM X	-.687	-.588	-.576
MAXIMUM Y	.793	.846	.738
MINIMUM Y	-.912	-.859	-.550
CENTROID X	.149	.050	.038
CENTROID Y	.035	-.018	.090
POA TO CENTROID in.	.153	.053	.097
MIN RADIUS	.055	.080	.141
MEAN RADIUS	.573	.516	.473
MAX RADIUS	1.011	.865	.739
HORIZONTAL SPREAD	1.581	1.122	1.122
VERTICAL SPREAD	1.705	1.705	1.288
EXTREME SPREAD	1.744	1.707	1.330
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	9		
NUMBER IN THREE INCH CIRCLE =	10		

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

SERIAL NO. C6522349
DATE 9/15/90
TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.39	2.50	2.46	2.37	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.52	2.39	2.20	2.53	
PULL #3	2.58	2.33	2.22	2.53	
PULL #4	2.31	2.44	2.20	2.64	
PULL #5	2.57	2.50	2.20	2.74	
TOTAL	12.37	12.16	12.28	12.81	
AVG.	2.47	2.43	2.25	2.56	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.04	3.00		
PULL #2	3.07	3.00		
PULL #3	3.01	2.95		
PULL #4	3.08	3.03		
PULL #5	3.00	3.08		
TOTAL	15.20	15.06		
AVG.	3.04	3.01		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.20	4.30		4.18
PULL #2	4.18	4.11		4.10
PULL #3	4.30	4.29		4.06
PULL #4	4.31	4.08		4.11
PULL #5	4.08	4.08		4.16
TOTAL	21.07	20.86		20.61
AVG.	4.21	4.17		4.12

MOD. _____		GA. CAL. _____	GUN # _____
# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st	Floor plate pops open when firing	
	2nd	and Don't eject at times	
	3rd		
	4th		
		FUNCTION	RD 6654 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF	New Floor Plate + <u>OK</u> EXTRACTOR	9/18/90 RW
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6522349

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/24/90	KA
600	Proof		6/24/90	KA
607	Check Headspace		6/24/90	KA
610	Dis-assemble Gun		6/24/90	KA
612	Magnaflux Barrel Action		7/10/90	RR
	Magnaflux Bolt		7/10/90	KB
615	Rollmark Caliber		7/10/90	L.S.
617	Drill and Tap Sight Holes		7/11/90	LB
618	Polish Barrel RB		7/13/90	WB
620	Apply Coatings (Barrel Action)		7-23-90	TA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		7/26/90	XS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/26/90	XS
	C) Inspect Ejector Hole for Chamfer		7/26/90	XS
	D) Oil Firing Pin Ass'y		7/26/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		9/15/90	WB

BARBER - M24 0005579

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			8/8/90	JK
	G) Safety Off Force	2	2	2			8/8/90	JK
	H) Trigger Pull Test & Retainability						9/15/90	WB
	I) Firing Pin Indent	.022	.0225	.0225			8/8/90	JK
	J) Assemble Stock						9/15/90	JK
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies						9/15/90	JK
	M) Iron Sight Alignment						9/15/90	JK
	N) Detach Front & Rear Sights & place in numbered container						9/15/90	JK
	O) Attach Scope to Rifle						9/15/90	JK
	P) Detach & Attach Scope 20 Times						9/15/90	JK
640	Gallery Target & Test						9-18-90	JK
	A) Time						"	JK
	B) Malfunctions						"	JK
	C) Pierced Primers						"	JK
	D) Optical Clarity of Scope						"	JK
645	Inspect for Live Ammo						9-18-90	JK
655	Final Inspection							
	A) Headspace						9/18/90	RW
	B) Trigger Pull	2.37	2.53	2.53	2.64	2.74	9/18/90	RW
	C) Function						9/18/90	RW
660	Pack						9/20/90	NE