

C6611683

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™ H24

46

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

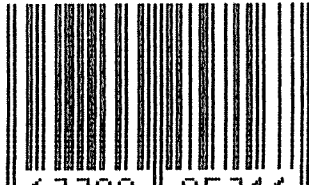
SERIAL NO.
C6611683

ORDER NO.
5716



5716 C6611683

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611683

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	3 28 91	RW
600	Proof		3 28 91	RW
607	Check Headspace		3 28 91	RW
610	Dis-assemble Gun		3 28 91	RW
612	Magnaflux Barrel Action		APR 2 1991	KR
	Magnaflux Bolt		APR 2 1991	W
615	Rollmark Caliber		APR 2 1991	JS
617	Drill and Tap Sight Holes		APR 5 1991	WB
618	Polish Barrel		APR 5 1991	WB
620	Apply Coatings (Barrel Action)		4-9-91	JA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		4/10/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/10/91	RW
	C) Inspect Ejector Hole for Chamfer		4/10/91	RW
	D) Oil Firing Pin Ass'y		4/10/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4/18/91	JL

op. #	BARBER - M24 0034276	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			4/18/91	JU
	G) Safety Off Force	4	4	4			4/18/91	JU
	H) Trigger Pull Test & Retainability						4/18/91	JU
	I) Firing Pin Indent	0.023	0.023	0.023			4/18/91	JU
	J) Assemble Stock						4/19/91	RW
	K) Assemble Swivel Studs						4-24-91	D/H
	L) Attach Front and Rear Sight Assemblies						4/19/91	RW
	M) Iron Sight Alignment						4/19/91	RW
	N) Detach Front & Rear Sights & place in numbered container						4/19/91	RW
	O) Attach Scope to Rifle						4/19/91	RW
	P) Detach & Attach Scope 20 Times						4/19/91	RW
640	Gallery Target & Test						4/19/91	KJ
	A) Time							KJ
	B) Malfunctions							KJ
	C) Pierced Primers							KJ
	D) Optical Clarity of Scope							KJ
645	Inspect for Live Ammo						4/19/91	KJ
655	Final Inspection							
	A) Headspace						4-24-91	D/H
	B) Trigger Pull	2.64	2.60	2.58	2.45	2.46	4/23/91	JU
	C) Function						4-24-91	D/H
660	Pack						6-19-91	W

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6611683

DATE 4/18/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.59	2.40	2.64	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.44	2.49	2.42	2.60	
PULL #3	2.40	2.52	2.40	2.58	
PULL #4	2.29	2.53	2.53	2.45	
PULL #5	2.44	2.46	2.50	2.46	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.25	3.29		
PULL #2	3.20	3.31		
PULL #3	3.26	3.26		
PULL #4	3.28	3.28		
PULL #5	3.28	3.23		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.51	4.36		4.36
PULL #2	4.43	4.32		4.31
PULL #3	4.47	4.32		4.38
PULL #4	4.44	4.25		4.19
PULL #5	4.47	4.37		4.32
TOTAL				
AVG.				

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611683
23 May 1991

CENTROIDAL DISTANCES

0 TO 1	.616774
1 TO 2	.683825
1 TO 3	.248032
1 TO 4	.783733
1 TO 5	.390397

13
8
4

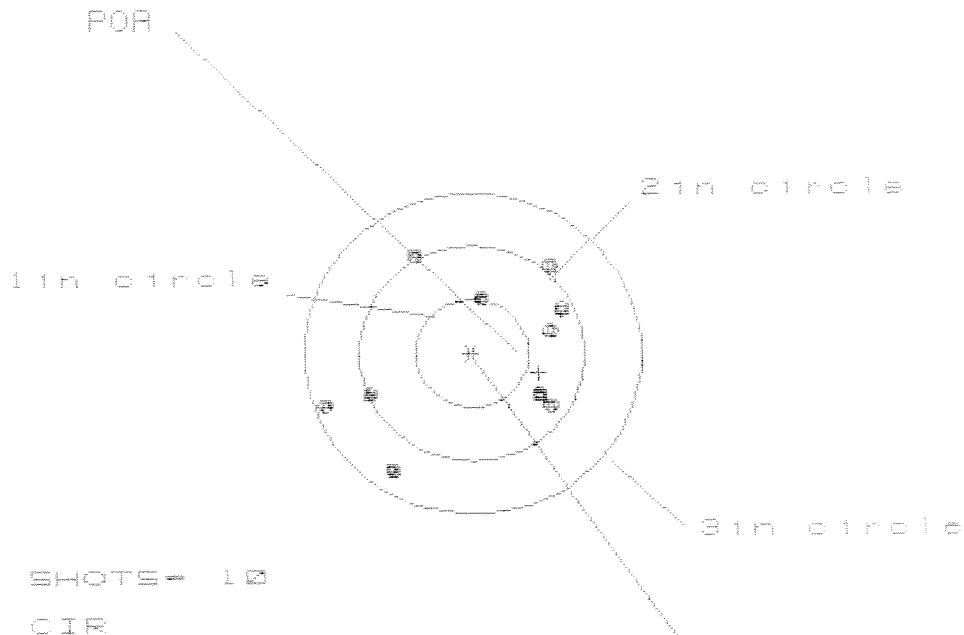
←----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2498
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0442
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .25366
THE AMR FOR THIS RIFLE IS: .9268

23 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611663.1

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 0

2in = 6

3in = 10

HS= 2.165

VS= 1.959

GS= 2.367

CENTROID *

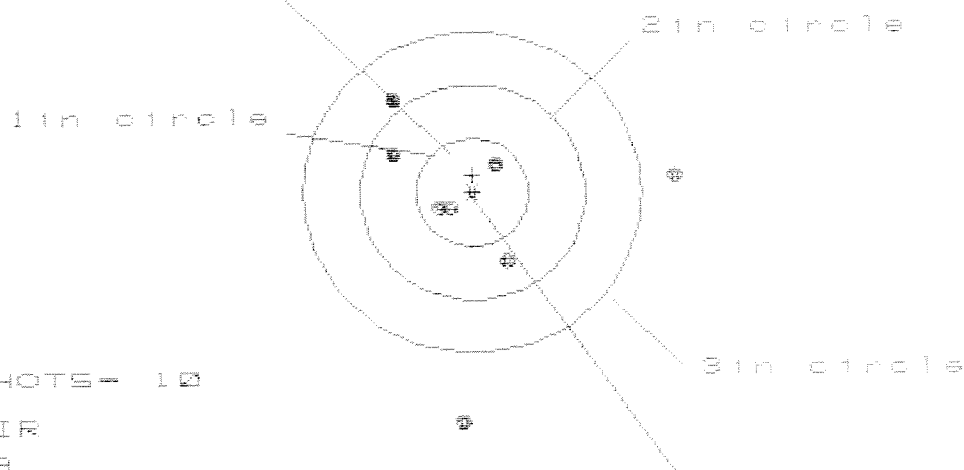
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.824	.675	.566
MINIMUM X	-1.341	-1.033	-1.142
MAXIMUM Y	.879	.829	.688
MINIMUM Y	-1.079	-1.130	-.724
CENTROID X	-.589	-.440	-.331
CENTROID Y	.183	.234	.375
POA TO CENTROID in.	.617	.498	.501
MIN RADIUS	.541	.489	.385
MEAN RADIUS	.954	.867	.756
MAX RADIUS	1.416	1.424	1.294
HORIZONTAL SPREAD	2.165	1.708	1.708
VERTICAL SPREAD	1.959	1.959	1.412
EXTREME SPREAD	2.367	2.349	1.977
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

23 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611683.1

CENTERFIRE PATTERNS # 2

POA



OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 7

HS= 2.510

VS= 4.232

GS= 4.278

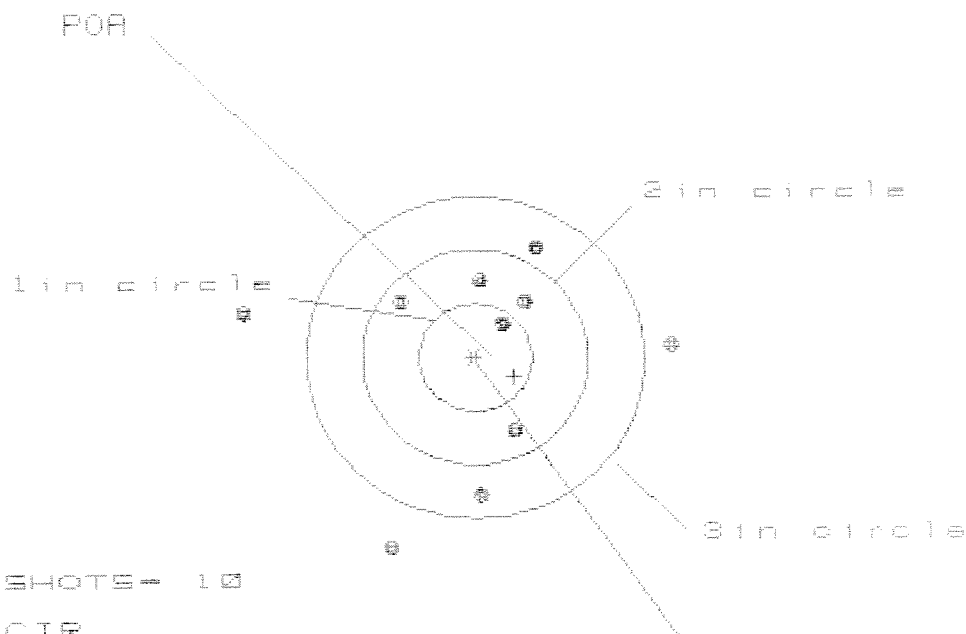
CENTROID #

PATTERN #	2	3	4
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.790	1.715	1.698
MINIMUM X	-.720	-.795	-.812
MAXIMUM Y	2.091	1.072	.834
MINIMUM Y	-2.141	-1.909	-.642
CENTROID X	.002	.077	.094
CENTROID Y	-.161	-.393	-.155
POA TO CENTROID in.	.161	.401	.181
MIN RADIUS	.250	.336	.259
MEAN RADIUS	1.028	.894	.755
MAX RADIUS	2.198	1.913	1.704
HORIZONTAL SPREAD	2.510	2.510	2.510
VERTICAL SPREAD	4.232	2.981	1.476
EXTREME SPREAD	4.278	3.040	2.541
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		7	

23 May 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 7

HS = 3.792

VS = 2.837

GS = 3.805

CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.759	1.533	1.415
MINIMUM X	-2.033	-.942	-1.026
MAXIMUM Y	1.055	1.105	.889
MINIMUM Y	-1.782	-1.732	-1.476
CENTROID X	-.341	-.115	.003
CENTROID Y	.179	.129	.345
POA TO CENTROID in.	.385	.172	.345
MIN RADIUS	.393	.332	.129
MEAN RADIUS	1.169	1.043	.860
MAX RADIUS	2.084	1.971	1.500
HORIZONTAL SPREAD	3.792	2.475	2.441
VERTICAL SPREAD	2.837	2.837	2.365
EXTREME SPREAD	3.805	3.134	2.476
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

23 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6811683.1

CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 4

2 in = 9

3 in = 10

HS = 1.345

VS = 2.133

GS = 2.254

CENTROID #

PATTERN #

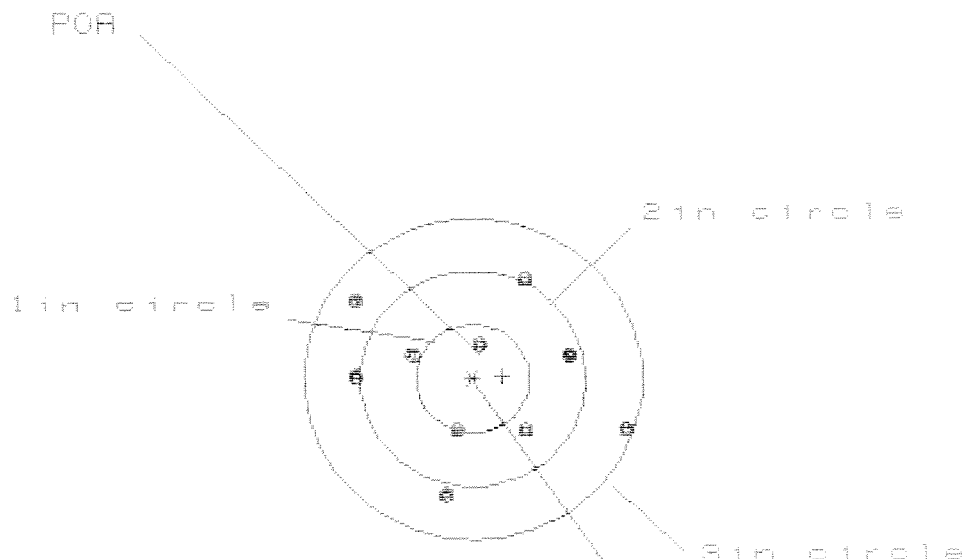
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SHOTS (BEST OF)	10	9	8
MAXIMUM X	.722	.715	.796
MINIMUM X	-.623	-.630	-.549
MAXIMUM Y	.650	.486	.344
MINIMUM Y	-1.482	-.489	-.428
CENTROID X	-.063	-.056	-.137
CENTROID Y	-.398	-.234	-.294
POA TO CENTROID in.	.404	.240	.325
MIN RADIUS	.040	.125	.078
MEAN RADIUS	.594	.498	.443
MAX RADIUS	1.484	.814	.824
HORIZONTAL SPREAD	1.345	1.345	1.345
VERTICAL SPREAD	2.133	.975	.773
EXTREME SPREAD	2.254	1.453	1.389
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	

23 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611683.1

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 10

HS= 2.395

VS= 2.079

GS= 2.697

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.327	.965	.850
MINIMUM X	-1.068	-.928	-.963
MAXIMUM Y	.958	.900	.983
MINIMUM Y	-1.121	-1.179	-1.096
CENTROID X	-.258	-.406	-.291
CENTROID Y	-.024	.034	-.049
POA TO CENTROID in.	.259	.407	.295
MIN RADIUS	.373	.355	.401
MEAN RADIUS	.889	.817	.771
MAX RADIUS	1.426	1.186	1.122
HORIZONTAL SPREAD	2.395	1.885	1.813
VERTICAL SPREAD	2.079	2.079	2.079
EXTREME SPREAD	2.697	2.207	2.207
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611683
19 Apr 1991

CENTROIDAL DISTANCES

0 TO 1	.266852
1 TO 2	.387883
1 TO 3	.272617
1 TO 4	.429942
1 TO 5	.0230217

3x
4x

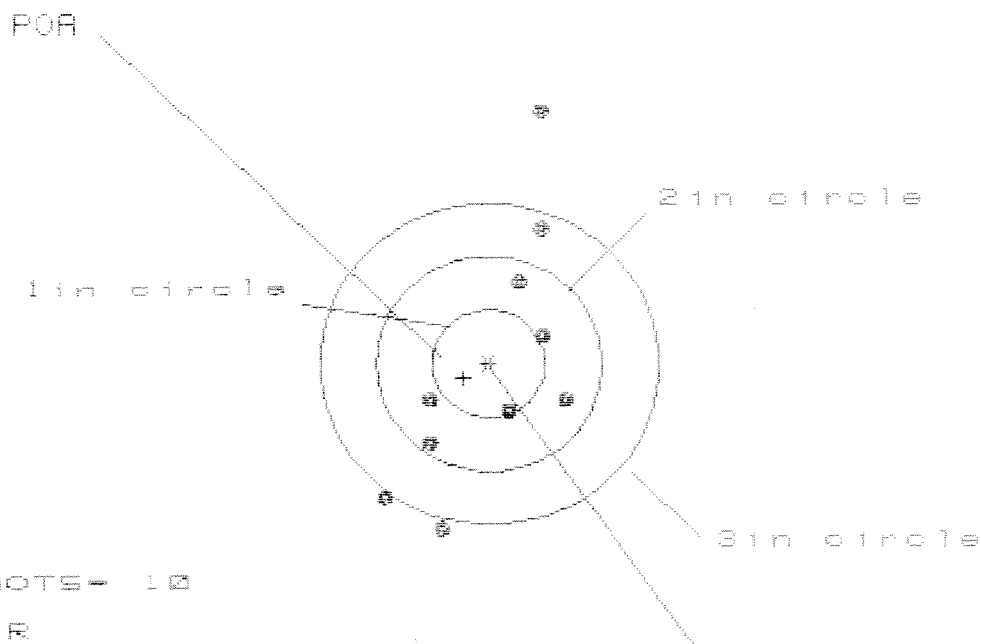
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0592
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0418
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0724699
THE AMR FOR THIS RIFLE IS: .9406

19 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C68116B3

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 7

HS = 1.591

VS = 3.935

GS = 4.044

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.637	.688	.635
MINIMUM X	-.954	-.903	-.956
MAXIMUM Y	2.401	1.513	1.355
MINIMUM Y	-1.534	-1.267	-1.161
CENTROID X	.229	.178	.231
CENTROID Y	.137	-.130	.028
POA TO CENTROID in.	.267	.220	.232
MIN RADIUS	.468	.299	.372
MEAN RADIUS	1.111	.925	.870
MAX RADIUS	2.445	1.603	1.504
HORIZONTAL SPREAD	1.591	1.591	1.591
VERTICAL SPREAD	3.935	2.780	2.516
EXTREME SPREAD	4.044	2.939	2.895
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

19 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06611683

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 1.803

VS= 3.571

GS= 3.751

PATTERN #

2

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.005	.976	1.083
MINIMUM X	-.798	-.827	-.720
MAXIMUM Y	1.031	.748	.585
MINIMUM Y	-2.540	-.841	-.747
CENTROID X	.046	.075	-.032
CENTROID Y	-.205	.078	-.016
POA TO CENTROID in.	.210	.108	.036
MIN RADIUS	.492	.212	.342
MEAN RADIUS	1.014	.780	.744
MAX RADIUS	2.554	1.138	1.090
HORIZONTAL SPREAD	1.803	1.803	1.803
VERTICAL SPREAD	3.571	1.589	1.332
EXTREME SPREAD	3.751	2.161	1.876
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

19 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611683

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS= 1.925

VS= 3.252

GS= 3.267

CENTROID #

PATTERN #

SHOTS (BEST OF)

MAXIMUM X

MINIMUM X

MAXIMUM Y

MINIMUM Y

CENTROID X

CENTROID Y

POA TO CENTROID in.

MIN RADIUS

MEAN RADIUS

MAX RADIUS

HORIZONTAL SPREAD

VERTICAL SPREAD

EXTREME SPREAD

NUMBER IN ONE INCH CIRCLE =

NUMBER IN TWO INCH CIRCLE =

NUMBER IN THREE INCH CIRCLE =

10

9

8

.994

.966

.970

-.931

-.959

-.955

1.287

1.069

1.003

-1.965

-1.277

-1.144

-.035

-.007

-.011

.205

.423

.290

.208

.423

.290

.293

.509

.376

1.031

.909

.881

1.981

1.279

1.146

1.925

1.925

1.925

3.252

2.346

2.147

3.267

2.348

2.148

1

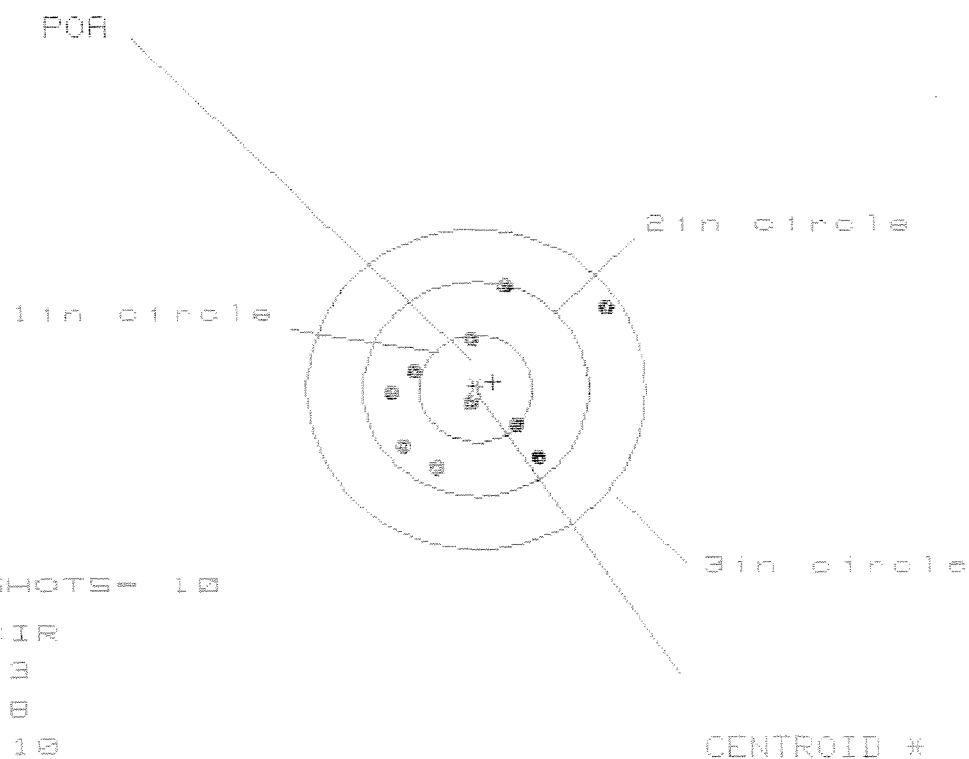
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9

19 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66116B3

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.836

VS= 1.757

GS= 2.252

PATTERN

	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.113	.705	.757
MINIMUM X	-.723	-.599	-.547
MAXIMUM Y	1.003	1.090	.714
MINIMUM Y	-.754	-.667	-.530
CENTROID X	-.150	-.274	-.326
CENTROID Y	-.066	-.153	-.290
POA TO CENTROID in.	.164	.314	.436
MIN RADIUS	.163	.138	.173
MEAN RADIUS	.735	.642	.565
MAX RADIUS	1.365	1.166	.850
HORIZONTAL SPREAD	1.836	1.304	1.304
VERTICAL SPREAD	1.757	1.757	1.244
EXTREME SPREAD	2.252	1.855	1.442
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	

19 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CG611683

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 4

2in = 6

3in = 9

HS= 3.097

VS= 2.184

GS= 3.232

CENTROID *

PATTERN #	:	5	6	7
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.903	.929	.480
MINIMUM X	:	-1.195	-.983	-.867
MAXIMUM Y	:	1.029	.766	.636
MINIMUM Y	:	-1.155	-1.040	-.809
CENTROID X	:	.206	-.006	-.122
CENTROID Y	:	.138	.023	.153
POA TO CENTROID in.	:	.247	.024	.196
MIN RADIUS	:	.108	.172	.273
MEAN RADIUS	:	.812	.667	.580
MAX RADIUS	:	2.163	1.395	.964
HORIZONTAL SPREAD	:	3.097	1.912	1.347
VERTICAL SPREAD	:	2.184	1.806	1.445
EXTREME SPREAD	:	3.232	2.529	1.842
NUMBER IN ONE INCH CIRCLE	=	4		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	9		