

C6611702

MODEL 700™ M24

Model S&S™

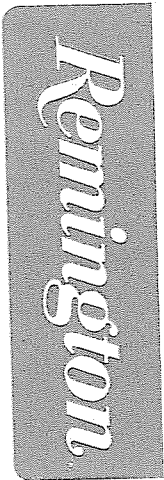
Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.



 		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700TM M24		SERIAL NO. C6611702
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		ORDER NO. 5716



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6611702**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/13/91	K.S.
600	Proof		3/13/91	K.S.
607	Check Headspace		3/13/91	K.S.
610	Dis-assemble Gun		3/13/91	K.S.
612	Magnaflux Barrel Action		3/27/91	KR
	Magnaflux Bolt		11	KR
615	Rollmark Caliber		3/27/91	BS
617	Drill and Tap Sight Holes		APR 3 1991	FB
618	Polish Barrel		APR 3 1991	WB
620	Apply Coatings (Barrel Action)		4-18-91	SH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/18/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/18/91	KS
	C) Inspect Ejector Hole for Chamfer		4/18/91	KS
	D) Oil Firing Pin Ass'y		4/18/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		4/19/91	JP

op. #	BARBER M24 0034526	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7	6 $\frac{1}{4}$	6			4-19-91	DH
	G) Safety Off Force	3	3	3 $\frac{3}{4}$			4-19-91	DH
	H) Trigger Pull Test & Retainability						4/19/91	80/
	I) Firing Pin Indent	.020	.020	.021			4-19-91	DH
	J) Assemble Stock						4/25/91	KS
	K) Assemble Swivel Studs						5-10-91	AC
	L) Attach Front and Rear Sight Assemblies						4/24/91	KS
	M) Iron Sight Alignment						4/24/91	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						4-27-91	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						5-10-91	AC
	B) Trigger Pull	2.55	2.50	2.30	2.43	2.34	5/9/91	80/
	C) Function						5-10-91	AC
660	Pack						6-17-91	AC

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6611.702

DATE 4/19/19

TESTER [Signature]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.21	2.47	2.45	2.53	MIN. SETTING
PULL #2	2.23	2.45	2.48	2.50	NO AVG. OF 5
PULL #3	2.28	2.42	2.42	2.30	READINGS ACCEPT-
PULL #4	2.23	2.42	2.40	2.43	ABLE LESS THAN 2#
PULL #5	2.36	2.41	2.40	2.34	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES			COMMENTS
PULL #1	3.35	3.47			
PULL #2	3.46	3.21			
PULL #3	3.32	3.29			
PULL #4	3.24	3.28			
PULL #5	3.51	3.27			
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	4.40		4.14
PULL #2	4.21	4.30		4.43
PULL #3	4.24	4.31		4.35
PULL #4	4.22	4.28		4.48
PULL #5	4.28	4.22		4.53
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611702
29 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.0988433
1 TO	2	.143126
1 TO	3	.378906
1 TO	4	.212514
1 TO	5	.244182

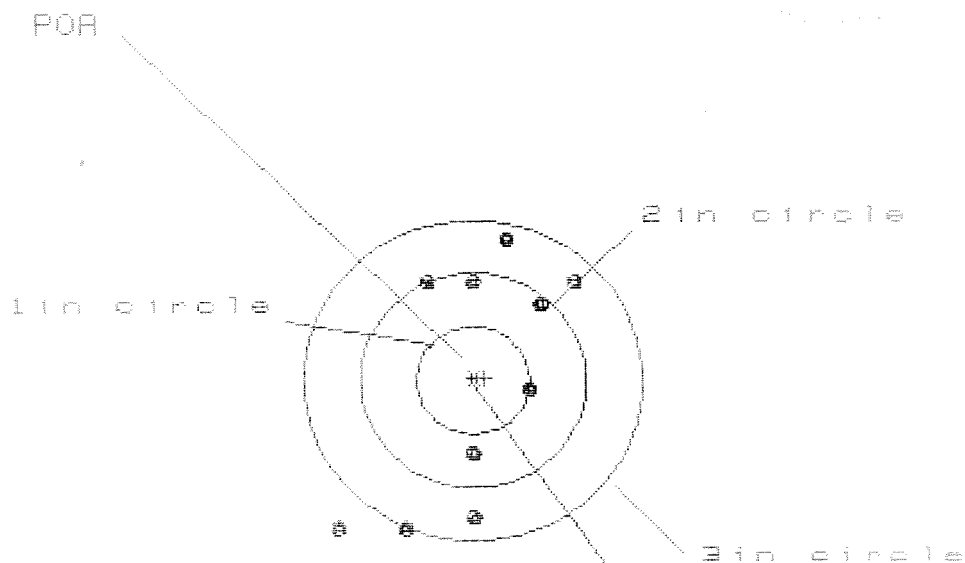
1
23 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0602
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.029
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .066821
THE AMR FOR THIS RIFLE IS: 1.028

29 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06611702

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 8

HS= 2.113

VS= 2.774

GS= 3.118

CENTROID #

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.906	.772	.673
MINIMUM X	:	-1.207	-.786	-.671
MAXIMUM Y	:	1.360	1.206	1.010
MINIMUM Y	:	-1.414	-1.568	-1.614
CENTROID X	:	-.097	.037	.136
CENTROID Y	:	-.019	.135	.331
POR TO CENTROID in.	:	.098	.140	.358
MIN RADIUS	:	.536	.457	.470
MEAN RADIUS	:	1.138	1.022	.882
MAX RADIUS	:	1.835	1.754	1.629
HORIZONTAL SPREAD	:	2.113	1.558	1.344
VERTICAL SPREAD	:	2.774	2.774	2.624
EXTREME SPREAD	:	3.118	2.926	2.638
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	8		

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CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 2

3 in = 7

HS= 3.560

VS= 2.827

GS= 3.560

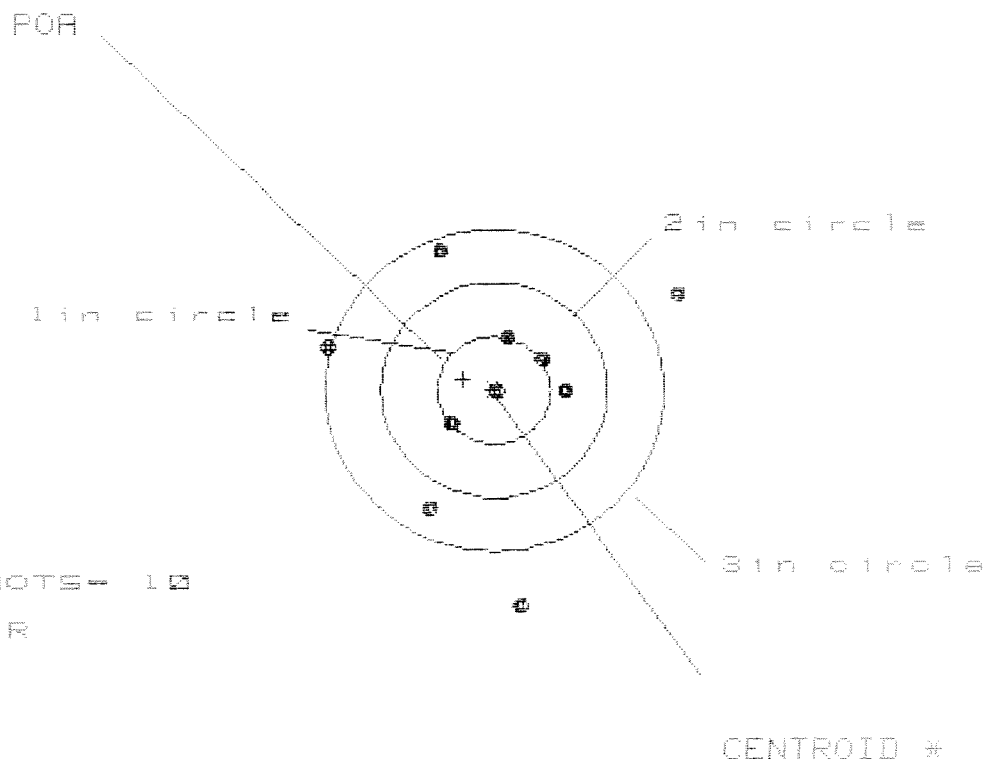
CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.789	1.104	.907
MINIMUM X	-1.771	-1.572	-1.012
MAXIMUM Y	1.661	1.667	1.669
MINIMUM Y	-1.166	-1.160	-1.158
CENTROID X	.030	-.169	.028
CENTROID Y	-.085	-.091	-.093
POA TO CENTROID in.	.090	.191	.097
MIN RADIUS	.402	.292	.395
MEAN RADIUS	1.212	1.138	1.069
MAX RADIUS	1.790	1.692	1.738
HORIZONTAL SPREAD	3.560	2.676	1.919
VERTICAL SPREAD	2.827	2.827	2.827
EXTREME SPREAD	3.560	3.152	3.152
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		2	
NUMBER IN THREE INCH CIRCLE =		7	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 7

HS= 3.097

VS= 3.241

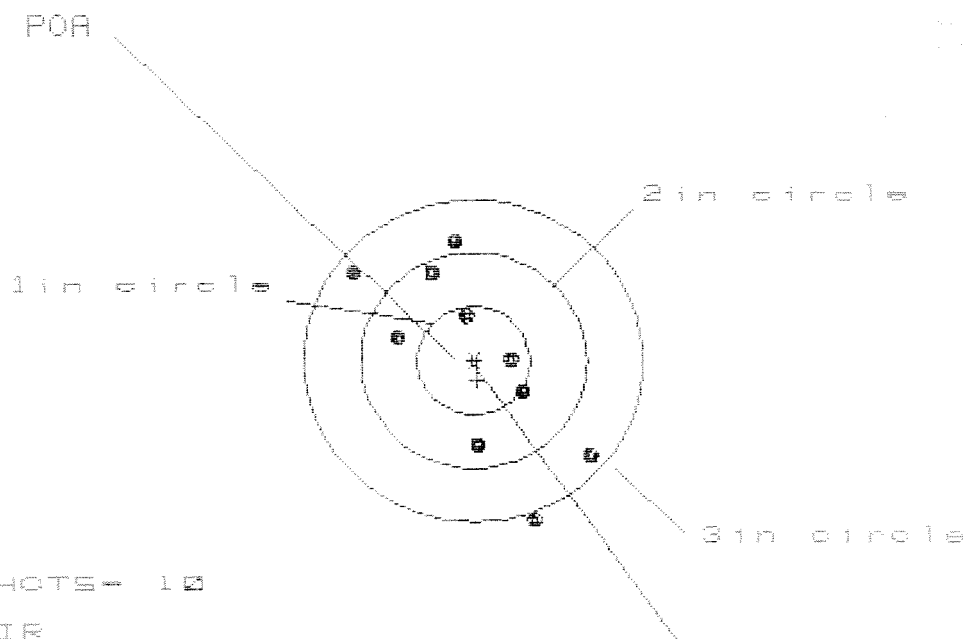
GS= 3.306

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.583	1.603	.894
MINIMUM X	-1.514	-1.494	-1.294
MAXIMUM Y	1.266	1.047	1.132
MINIMUM Y	-1.975	-1.290	-1.205
CENTROID X	.274	.254	.054
CENTROID Y	-.096	.123	.038
POA TO CENTROID in.	.291	.283	.066
MIN RADIUS	.055	.231	.306
MEAN RADIUS	1.024	.910	.825
MAX RADIUS	1.983	1.741	1.318
HORIZONTAL SPREAD	3.097	3.097	2.188
VERTICAL SPREAD	3.241	2.337	2.337
EXTREME SPREAD	3.306	3.139	2.341
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 9

HS= 2.139

VS= 2.563

GS= 2.837

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.018	1.082	.950
MINIMUM X	-1.121	-1.057	-.746
MAXIMUM Y	1.080	.916	.994
MINIMUM Y	-1.483	-1.032	-.954
CENTROID X	-.028	-.092	.040
CENTROID Y	.182	.346	.268
POA TO CENTROID in.	.184	.358	.271
MIN RADIUS	.338	.273	.285
MEAN RADIUS	.905	.809	.749
MAX RADIUS	1.589	1.496	1.346
HORIZONTAL SPREAD	2.139	2.139	1.696
VERTICAL SPREAD	2.563	1.948	1.948
EXTREME SPREAD	2.837	2.708	2.263
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 1.719

VS= 2.357

GS= 2.688

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.155	1.261	1.213
MINIMUM X	:	-.565	-.458	-.506
MAXIMUM Y	:	.716	.533	.355
MINIMUM Y	:	-1.641	-1.428	-.555
CENTROID X	:	.122	.015	.063
CENTROID Y	:	-.127	.056	.234
POA TO CENTROID in.	:	.175	.058	.243
MIN RADIUS	:	.384	.181	.071
MEAN RADIUS	:	.863	.665	.516
MAX RADIUS	:	1.899	1.478	1.229
HORIZONTAL SPREAD	:	1.719	1.719	1.719
VERTICAL SPREAD	:	2.357	1.961	.910
EXTREME SPREAD	:	2.688	2.162	1.756
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	