

C6636197

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™ H24	SERIAL NO. C6636197
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.	ORDER NO. 5716

20



5716 C6636197



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636197

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		4/3/91	K.S.
600	Proof		4/3/91	K.S.
607	Check Headspace		4/3/91	K.S.
610	Dis-assemble Gun		4/3/91	K.S.
612	Magnaflux Barrel Action		4/10/91	KR
	Magnaflux Bolt		4/10/91	"
615	Rollmark Caliber		4/10/91	GL
617	Drill and Tap Sight Holes		APR 10 1991	KB
618	Polish Barrel		APR 19 1991	WB
620	Apply Coatings (Barrel Action)		5-10-91	JA
	Apply Coating (Bolt)		5-10-91	JA
625	Final Assembly A) Clean inside of Bolt Assembly		5/22/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/22/91	KS
	C) Inspect Ejector Hole for Chamfer		5/22/91	KS
	D) Oil Firing Pin Ass'y		5/22/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		5/23/91	JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5-23-91	DH
	G) Safety Off Force	3	3	3			5-23-91	DH
	H) Trigger Pull Test & Retainability						5/23/91	JA
	I) Firing Pin Indent	.020	.021	.020			5-23-91	D/H
	J) Assemble Stock						5/24/91	KS
	K) Assemble Swivel Studs						6-1-91	D/H
	L) Attach Front and Rear Sight Assemblies						5/24/91	KS
	M) Iron Sight Alignment						5/24/91	KS
	N) Detach Front & Rear Sights & place in numbered container						5/24/91	KS
	O) Attach Scope to Rifle						5/24/91	KS
	P) Detach & Attach Scope 20 Times						5/24/91	KS
640	Gallery Target & Test						5-24-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						5-25-91	AF
655	Final Inspection							
	A) Headspace						6-1-91	D/H
	B) Trigger Pull	2.34	2.31	2.29	2.28	2.26	6/1/91	JA
	C) Function						6-1-91	D/H
660	Pack						6-20-91	AF

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

SERIAL NO. C6636197DATE 5/23/91TESTER GM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.66	2.41	2.58	2.34	MIN. SETTING,
PULL #2	2.62	2.62	2.53	2.31	NO AVG. OF 5
PULL #3	2.39	2.60	2.58	2.29	READINGS ACCEPT-
PULL #4	2.42	2.59	2.50	2.28	ABLE LESS THAN 2#
PULL #5	2.33	2.67	2.61	2.26	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.22	3.56		
PULL #2	3.25	3.57		
PULL #3	3.16	3.33		
PULL #4	3.58	3.37		
PULL #5	3.41	3.44		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.53	4.44		4.31
PULL #2	4.24	4.49		4.23
PULL #3	4.31	4.45		4.28
PULL #4	4.26	4.32		4.29
PULL #5	4.39	4.32		4.25
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636197
28 May 1991

CENTROIDAL DISTANCES

0 TO	1	.415549
1 TO	2	.497562
1 TO	3	.374767
1 TO	4	.369899
1 TO	5	.557904

• x----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .044
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0386
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0585317
THE AMR FOR THIS RIFLE IS: 1.019

28 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08636197

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 2

3 in = 6

HS = 4.022

VS = 4.325

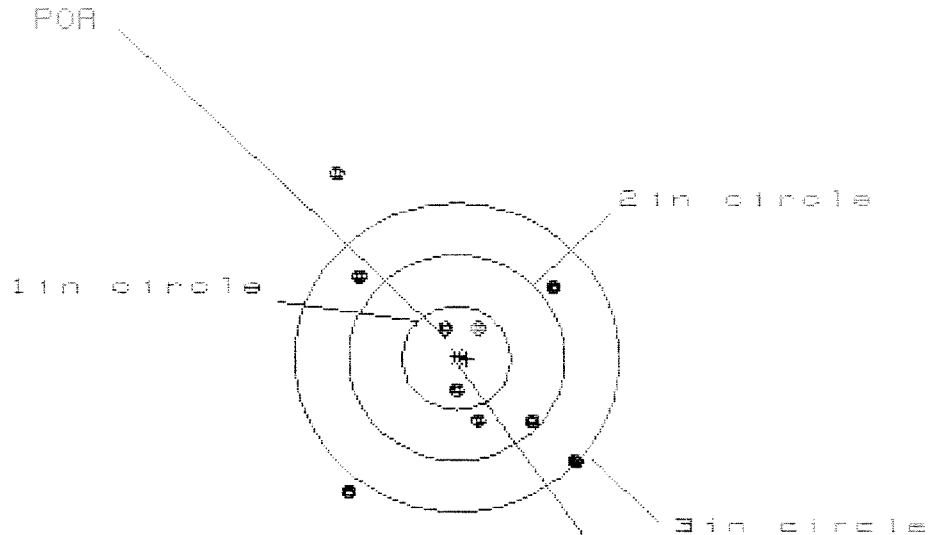
GS = 5.087

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.877	.667	.660
MINIMUM X	:	-1.145	-.825	-.832
MAXIMUM Y	:	1.438	1.552	1.206
MINIMUM Y	:	-2.887	-2.773	-2.014
CENTROID X	:	.355	.035	.042
CENTROID Y	:	.216	.102	.448
POA TO CENTROID in.	:	.415	.108	.450
MIN RADIUS	:	.151	.367	.273
MEAN RADIUS	:	1.496	1.304	1.058
MAX RADIUS	:	3.055	2.773	2.014
HORIZONTAL SPREAD	:	4.022	1.492	1.492
VERTICAL SPREAD	:	4.325	4.325	3.220
EXTREME SPREAD	:	5.087	4.335	3.240
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			2	
NUMBER IN THREE INCH CIRCLE =			6	

28 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06036197

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 8

HS= 2.124

VS= 3.164

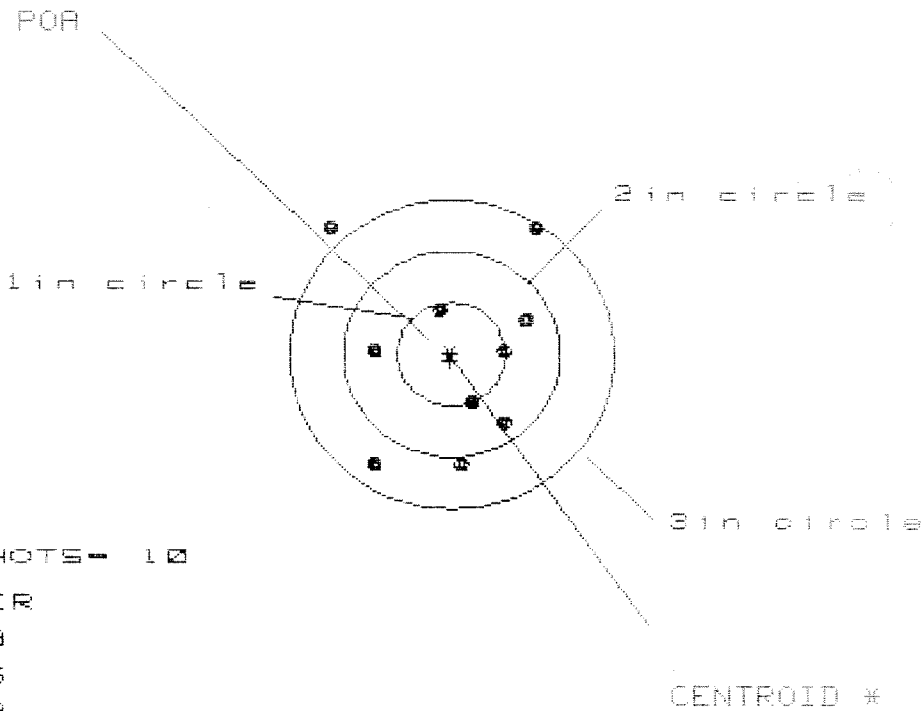
GS= 3.537

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.069	.951	.815
MINIMUM X	:	-1.055	-1.096	-1.160
MAXIMUM Y	:	1.809	1.035	.891
MINIMUM Y	:	-1.355	-1.154	-.962
CENTROID X	:	-.097	.021	.158
CENTROID Y	:	.008	-.193	-.049
POA TO CENTROID in.	:	.097	.194	.165
MIN RADIUS	:	.303	.151	.332
MEAN RADIUS	:	1.003	.854	.757
MAX RADIUS	:	2.094	1.591	1.463
HORIZONTAL SPREAD	:	2.124	2.047	1.975
VERTICAL SPREAD	:	3.164	2.189	1.853
EXTREME SPREAD	:	3.537	2.744	2.708
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 8

HE= 1.813

VS= 2.299

GS= 2.736

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.743	.625	.645
MINIMUM X	:	-1.070	-.866	-.788
MAXIMUM Y	:	1.214	1.344	.709
MINIMUM Y	:	-1.085	-.950	-.782
CENTROID X	:	.012	.130	.052
CENTROID Y	:	.065	-.070	-.238
POA TO CENTROID in.	:	.066	.148	.244
MIN RADIUS	:	.426	.316	.194
MEAN RADIUS	:	.915	.810	.713
MAX RADIUS	:	1.618	1.482	1.111
HORIZONTAL SPREAD	:	1.813	1.491	1.433
VERTICAL SPREAD	:	2.299	2.294	1.491
EXTREME SPREAD	:	2.736	2.736	2.044
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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FILE:/PATTERNING/CENTERFIRE_PATT/06636197

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS - 10

IN CIR

1in = 5

2in = 9

3in = 10

HS= 1.777

VS= 1.398

GS= 1.878

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.162	.667	.647
MINIMUM X	:	-.615	-.486	-.586
MAXIMUM Y	:	.480	.510	.399
MINIMUM Y	:	-.918	-.888	-.392
CENTROID X	:	.071	-.058	-.038
CENTROID Y	:	-.021	-.051	.060
POA TO CENTROID in.	:	.074	.077	.071
MIN RADIUS	:	.149	.159	.048
MEAN RADIUS	:	.548	.451	.374
MAX RADIUS	:	1.194	.902	.780
HORIZONTAL SPREAD	:	1.777	1.153	1.153
VERTICAL SPREAD	:	1.398	1.398	.791
EXTREME SPREAD	:	1.878	1.493	1.245
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS

5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 7

HS = 2.846

VS = 3.232

GS = 3.577

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.434
MINIMUM X	-1.411
MAXIMUM Y	1.170
MINIMUM Y	-2.062
CENTROID X	-.121
CENTROID Y	-.075
POA TO CENTROID in.	.143
MIN RADIUS	.346
MEAN RADIUS	1.132
MAX RADIUS	2.375
HORIZONTAL SPREAD	2.846
VERTICAL SPREAD	3.232
EXTREME SPREAD	3.577
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	7