

C6611503

MODEL 700™ M24

Model S&S™

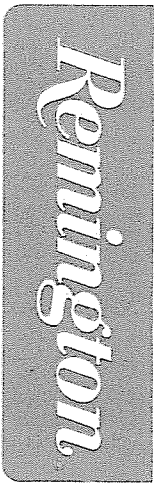
Action

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		SERIAL NO. C6611503
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		ORDER NO. 5716



5716 C6611503

UPC



0 47700 25716 7

Repaired
Stock

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6611503**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/12/91	K.S.
600	Proof		3/12/91	K.S.
607	Check Headspace		3/12/91	K.S.
610	Dis-assemble Gun		3/12/91	K.S.
612	Magnaflux Barrel Action		3/27/91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		3/27/91	L.S.
617	Drill and Tap Sight Holes		APR 3 1991	EB
618	Polish Barrel		APR 3 1991	WB
620	Apply Coatings (Barrel Action)		4-18-91	JS
	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	JS

op. #	BARBER M24 0077921	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6 $\frac{1}{2}$			4-19-91	DH
	G) Safety Off Force	3	3	3			4-19-91	DH
	H) Trigger Pull Test & Retainability						4/19/91	gfi
	I) Firing Pin Indent	.022	.022	.023			4-19-91	DH
	J) Assemble Stock						4/22/91	KS
	K) Assemble Swivel Studs						5-2-91	DH
	L) Attach Front and Rear Sight Assemblies						4/22/91	KS
	M) Iron Sight Alignment						4/22/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/22/91	KS
	O) Attach Scope to Rifle						4/22/91	KS
	P) Detach & Attach Scope 20 Times						4/22/91	KS
640	Gallery Target & Test						4/23/91	KT
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	KT
645	Inspect for Live Ammo						4/23/91	KT
655	Final Inspection							
	A) Headspace						5-2-91	DH
	B) Trigger Pull	2.60	2.60	2.63	2.65	2.64	4/26/91	gfi
	C) Function						5-2-91	DH
660	Pack						6-19-91	N

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6611503

DATE 4/19/91

TESTER [Signature]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.48	2.40	2.60	MIN. SETTING,
PULL #2	2.42	2.48	2.52	2.60	NO AVG. OF 5
PULL #3	2.57	2.23	2.49	2.63	READINGS ACCEPT-
PULL #4	2.55	2.51	2.50	2.65	ABLE LESS THAN 2#
PULL #5	2.53	2.41	2.50	2.64	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES			COMMENTS
PULL #1	3.39	3.41			
PULL #2	3.17	3.14			
PULL #3	3.35	3.51			
PULL #4	3.41	3.42			
PULL #5	3.41	3.48			
TOTAL					
AVG.					

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.21	4.21		4.24
PULL #2	4.27	4.19		4.24
PULL #3	4.32	4.21		4.29
PULL #4	4.39	4.23		4.25
PULL #5	4.50	4.22		4.25
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611503
23 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.0241661
1 TO	2	.593266
1 TO	3	.27013
1 TO	4	.129418
1 TO	5	.323396

$\bar{x} =$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .165
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0834
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .197

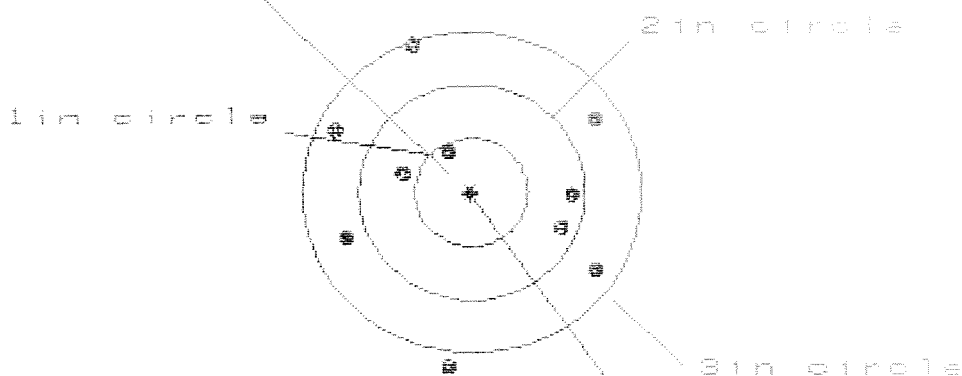
THE AMR FOR THIS RIFLE IS: 1.077

23 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611503

CENTERFIRE PATTERNS

POA



OF SHOTS - 10

IN CIR

1in = 1

2in = 4

3in = 9

HS= 2.242

VS= 2.972

GS= 2.992

CENTROID *

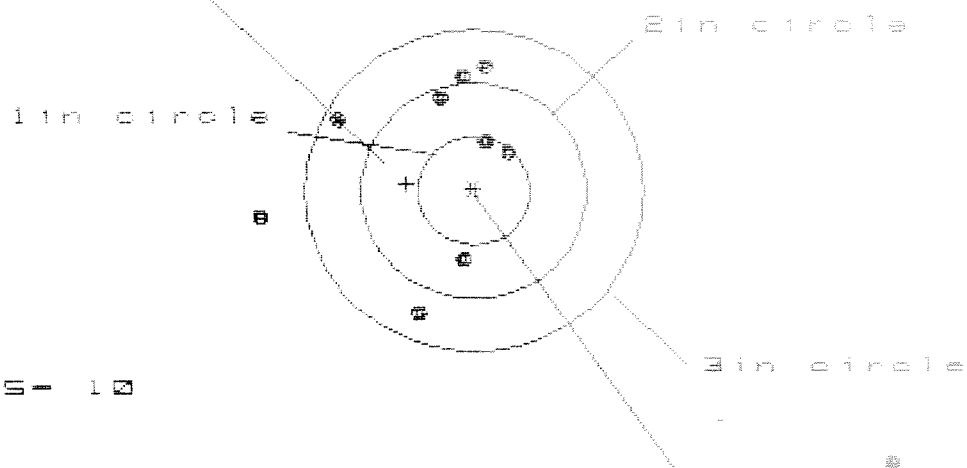
PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.070	1.052	.986
MINIMUM X	-1.172	-1.190	-1.256
MAXIMUM Y	1.387	1.211	.648
MINIMUM Y	-1.585	-.910	-.759
CENTROID X	.010	.028	.094
CENTROID Y	.022	.198	.047
POA TO CENTROID in.	.025	.200	.105
MIN RADIUS	.410	.295	.443
MEAN RADIUS	1.097	1.023	.985
MAX RADIUS	1.593	1.381	1.352
HORIZONTAL SPREAD	2.242	2.242	2.242
VERTICAL SPREAD	2.972	2.121	1.407
EXTREME SPREAD	2.992	2.634	2.561
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	9		

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FILE:/PATTERNING/CENTERFIRE_PATT/C6611503

CENTERFIRE PATTERNS # 2

POA



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

HS = 5.544

VS = 3.675

GS = 6.012

CENTROID #

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	3.657	.705	.520
MINIMUM X	:	-1.887	-1.481	-.982
MAXIMUM Y	:	1.153	.873	.813
MINIMUM Y	:	-2.522	-1.444	-1.504
CENTROID X	:	.597	.191	.376
CENTROID Y	:	-.864	.216	.276
POA TO CENTROID in.	:	.601	.289	.466
MIN RADIUS	:	.435	.567	.374
MEAN RADIUS	:	1.377	.961	.834
MAX RADIUS	:	4.442	1.556	1.537
HORIZONTAL SPREAD	:	5.544	2.186	1.502
VERTICAL SPREAD	:	3.675	2.317	2.317
EXTREME SPREAD	:	6.012	2.400	2.400
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	8		

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CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 4

3 in = 8

HS = 2.333

VS = 3.304

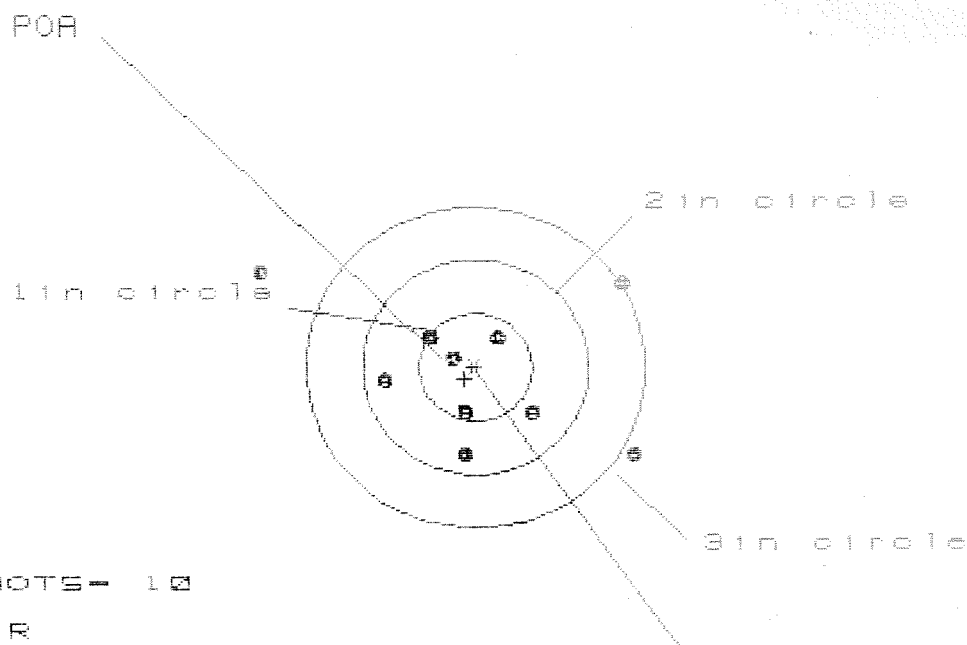
GS = 3.341

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.399	1.445	.915
MINIMUM X	:	-.934	-.888	-.707
MAXIMUM Y	:	1.911	1.045	1.078
MINIMUM Y	:	-1.393	-1.181	-1.148
CENTROID X	:	-.031	-.077	-.258
CENTROID Y	:	-.245	-.457	-.490
POA TO CENTROID in.	:	.247	.463	.554
MIN RADIUS	:	.068	.183	.149
MEAN RADIUS	:	.994	.856	.771
MAX RADIUS	:	1.956	1.470	1.414
HORIZONTAL SPREAD	:	2.333	2.333	1.622
VERTICAL SPREAD	:	3.304	2.226	2.226
EXTREME SPREAD	:	3.341	2.403	2.352
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 7

3 in = 7

HS = 3.367

VS = 1.665

GS = 3.753

CENTROID *

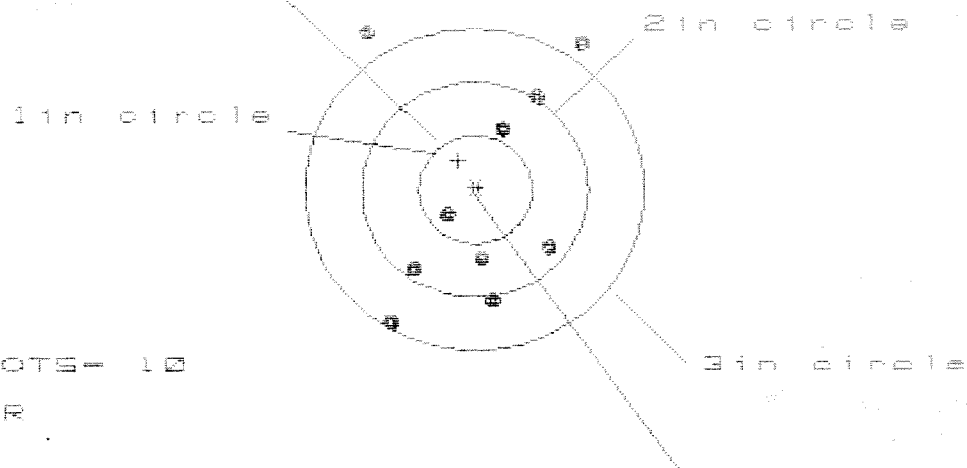
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.430	1.215	1.283
MINIMUM X	:	-1.937	-0.967	-0.815
MAXIMUM Y	:	.884	.918	.834
MINIMUM Y	:	-.781	-.682	-.767
CENTROID X	:	.100	.315	.163
CENTROID Y	:	.115	.016	.100
POA TO CENTROID in.	:	.152	.316	.192
MIN RADIUS	:	.222	.398	.283
MEAN RADIUS	:	.899	.776	.662
MAX RADIUS	:	2.129	1.456	1.530
HORIZONTAL SPREAD	:	3.367	2.182	2.098
VERTICAL SPREAD	:	1.665	1.600	1.600
EXTREME SPREAD	:	3.753	2.295	2.295
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 5

POA



OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 3

HS= 1.912

VS= 2.685

GS= 3.069

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.938	.830	.605
MINIMUM X	-.974	-.851	-.748
MAXIMUM Y	1.500	1.550	1.195
MINIMUM Y	-1.185	-1.018	-.825
CENTROID X	.149	.257	.154
CENTROID Y	-.270	-.437	-.630
POA TO CENTROID in.	.308	.507	.649
MIN RADIUS	.349	.366	.253
MEAN RADIUS	1.016	.895	.733
MAX RADIUS	1.789	1.758	1.324
HORIZONTAL SPREAD	1.912	1.681	1.353
VERTICAL SPREAD	2.685	2.568	2.020
EXTREME SPREAD	3.069	3.069	2.411
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		