

C6611617

MODEL 700™ M24

Model **515**™

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		SERIAL NO. C6611617
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 # C6611617

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 28	9 1	RW
600	Proof	3 28	9 1	RW
607	Check Headspace	3 28	9 1	RW
610	Dis-assemble Gun	3 28	9 1	RW
612	Magnaflux Barrel Action	APR	2 1991	KR
	Magnaflux Bolt	APR	2 1991	CR
615	Rollmark Caliber	APR	2 1991	LS
617	Drill and Tap Sight Holes	APR	5 1991	LB
618	Polish Barrel	APR	5 1991	WB
620	Apply Coatings (Barrel Action)		4/10/91	TH
	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		4-17-91	D/H

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			4/18/91	JH
	G) Safety Off Force	3	3	3			4/18/91	JH
	H) Trigger Pull Test & Retainability						4-17-91	DH
	I) Firing Pin Indent	.0215	.0215	.0215			4/18/91	JH
	J) Assemble Stock						4/18/91	RW
	K) Assemble Swivel Studs						4-22-91	DH
	L) Attach Front and Rear Sight Assemblies						4/18/91	RW
	M) Iron Sight Alignment						4/18/91	RW
	N) Detach Front & Rear Sights & place in numbered container						4/18/91	RW
	O) Attach Scope to Rifle						4/18/91	RW
	P) Detach & Attach Scope 20 Times						4/18/91	RW
640	Gallery Target & Test						4/18/91	KJ
	A) Time							KJ
	B) Malfunctions							KJ
	C) Pierced Primers							KJ
	D) Optical Clarity of Scope							KJ
645	Inspect for Live Ammo						4/18/91	KJ
655	Final Inspection							
	A) Headspace						4-22-91	DH
	B) Trigger Pull	2.52	2.58	2.47	2.38	2.45	4/22/91	JH
	C) Function						4-22-91	DH
660	Pack						6-18-91	AF

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

SERIAL NO. C6611617
DATE 4-17-91
TESTER D/H

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.55	2.58	2.55	2.52	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.62	2.46	2.69	2.58	
PULL #3	2.65	2.54	2.60	2.47	
PULL #4	2.60	2.54	2.63	2.38	
PULL #5	2.65	2.46	2.71	2.45	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.01	2.98		
PULL #2	2.98	3.12		
PULL #3	2.98	3.08		
PULL #4	3.11	3.09		
PULL #5	2.98	2.97		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.18	4.00		4.16
PULL #2	4.06	4.17		4.20
PULL #3	4.20	4.11		4.19
PULL #4	4.18	3.96		4.13
PULL #5	4.08	4.20		4.08
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
 FOR RIFLE # C661
 18 Apr 1991

1617

CENTROIDAL DISTANCES

0 TO	1	.245801
1 TO	2	.208598
1 TO	3	.244755
1 TO	4	.388624
1 TO	5	.59198

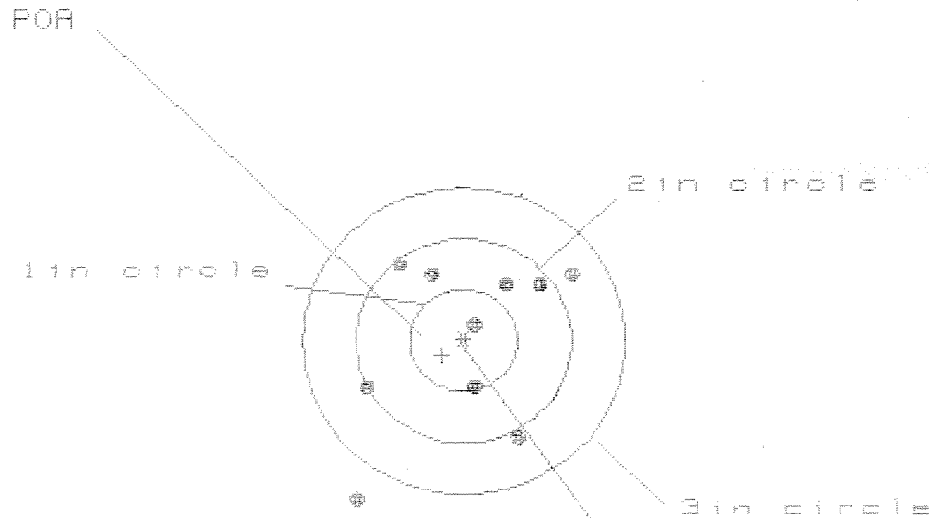
4
3 $\frac{1}{2}$ <---- POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0264
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0334
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0425737
 THE AMR FOR THIS RIFLE IS: .7944

18 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611617

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.031

VS= 2.319

GS= 3.014

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.011	.898	.706
MINIMUM X	-1.020	-1.003	-.891
MAXIMUM Y	.783	.612	.677
MINIMUM Y	-1.536	-1.124	-1.059
CENTROID X	.197	.310	.198
CENTROID Y	.147	.318	.253
POA TO CENTROID in.	.246	.445	.322
MIN RADIUS	.190	.030	.105
MEAN RADIUS	.900	.748	.723
MAX RADIUS	1.844	1.185	1.157
HORIZONTAL SPREAD	2.031	1.901	1.597
VERTICAL SPREAD	2.319	1.736	1.736
EXTREME SPREAD	3.014	2.222	2.032
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

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FILE:/PATTERNING/CENTERFIRE_PATT/06611617

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.699

VS= 2.104

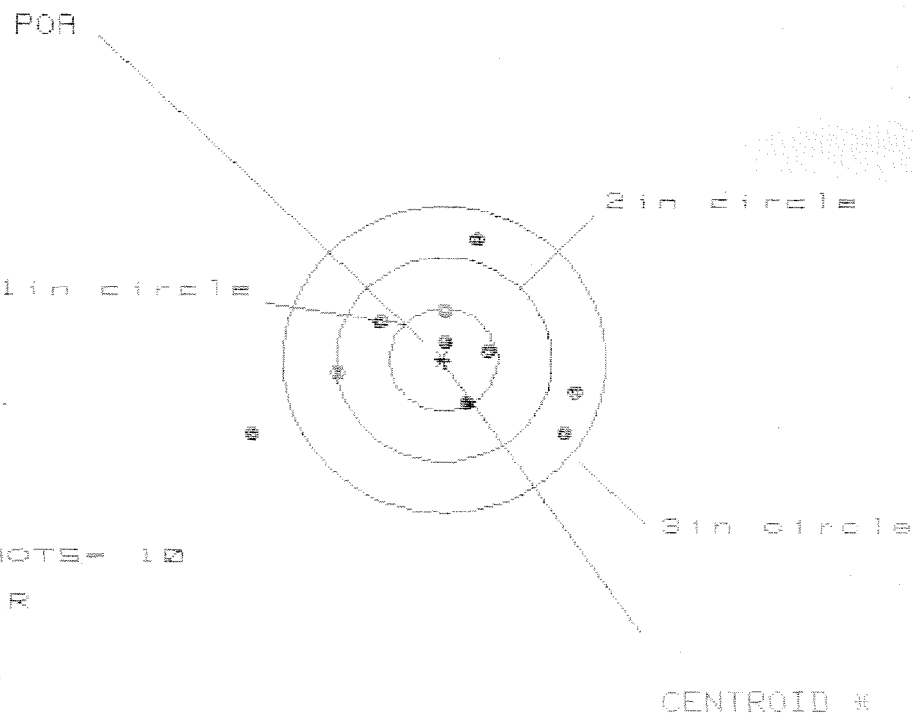
GS= 2.699

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.018	.832	.985
MINIMUM X	:	-1.681	-.868	-.815
MAXIMUM Y	:	1.122	1.113	.683
MINIMUM Y	:	-.982	-.991	-.852
CENTROID X	:	.149	.335	.282
CENTROID Y	:	-.056	-.047	-.186
POA TO CENTROID in.	:	.159	.339	.337
MIN RADIUS	:	.221	.168	.097
MEAN RADIUS	:	.864	.744	.680
MAX RADIUS	:	1.683	1.318	1.179
HORIZONTAL SPREAD	:	2.699	1.700	1.700
VERTICAL SPREAD	:	2.104	2.104	1.535
EXTREME SPREAD	:	2.699	2.472	1.993
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 4

2 in = 5

3 in = 9

HS= 3.068

VS= 1.868

GS= 3.086

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.250	1.048	1.160
MINIMUM X	-1.010	-1.163	-1.051
MAXIMUM Y	1.164	1.089	.992
MINIMUM Y	-.704	-.779	-.576
CENTROID X	-.011	.191	.079
CENTROID Y	.010	.093	.190
POA TO CENTROID in.	.021	.213	.206
MIN RADIUS	.155	.184	.068
MEAN RADIUS	.883	.741	.663
MAX RADIUS	1.938	1.186	1.266
HORIZONTAL SPREAD	3.068	2.211	2.211
VERTICAL SPREAD	1.868	1.868	1.568
EXTREME SPREAD	3.086	2.227	2.227
NUMBER IN ONE INCH CIRCLE	= 4		
NUMBER IN TWO INCH CIRCLE	= 6		
NUMBER IN THREE INCH CIRCLE	= 9		

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FILE:/PATTERNING/CENTERFIRE_PATT/C6611617

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 5

2 in = 9

3 in = 10

HS = 1.817

VS = 1.369

GS = 1.981

CENTROID *

PATTERN #

4

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.022	.459	.373
MINIMUM X	:	-.795	-.681	-.573
MAXIMUM Y	:	.765	.698	.713
MINIMUM Y	:	-.604	-.395	-.380
CENTROID X	:	-.178	-.292	-.206
CENTROID Y	:	.249	.316	.301
POA TO CENTROID in.	:	.306	.430	.365
MIN RADIUS	:	.164	.232	.156
MEAN RADIUS	:	.575	.506	.471
MAX RADIUS	:	1.187	.738	.730
HORIZONTAL SPREAD	:	1.817	1.140	.946
VERTICAL SPREAD	:	1.369	1.093	1.093
EXTREME SPREAD	:	1.981	1.251	1.224
NUMBER IN ONE INCH CIRCLE =		5		
NUMBER IN TWO INCH CIRCLE =		9		
NUMBER IN THREE INCH CIRCLE =		10		

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FILE:/PATTERNING/CENTERFIRE_PATT/C8811617

CENTERFIRE PATTERNS

5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS = 2.302

VS = 1.369

GS = 2.372

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.270	.964	.997
MINIMUM X	-1.032	-.891	-.771
MAXIMUM Y	.805	.760	.339
MINIMUM Y	-.564	-.609	-.514
CENTROID X	-.289	-.430	-.550
CENTROID Y	-.191	-.146	-.241
POA TO CENTROID in.	.346	.454	.601
MIN RADIUS	.329	.184	.199
MEAN RADIUS	.750	.653	.552
MAX RADIUS	1.334	1.227	1.016
HORIZONTAL SPREAD	2.302	1.855	1.768
VERTICAL SPREAD	1.369	1.369	.853
EXTREME SPREAD	2.372	1.964	1.814
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		