

C6587727

MODEL 700™ M24

Model S&S™

Action _____

Barrel Length _____

Capacity _____

Order No. 5716

*Includes 1 in chamber.





MODEL 700™ M24

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

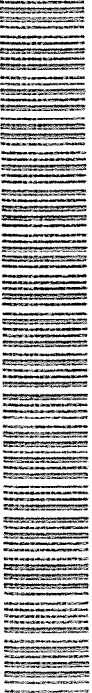


REG. U.S. PAT. & T.M. OFF.

VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.

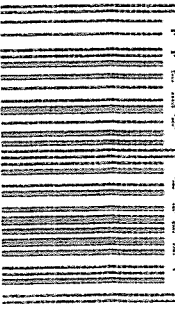
SERIAL NO.
C6587727

ORDER NO.
5716



5716 C6587727

UPC



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CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587727

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1228	90	RW
600	Proof	1228	90	RW
607	Check Headspace	1228	90	RW
610	Dis-assemble Gun	1228	90	RW
612	Magnaflux Barrel Action		1-7-91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	GL
617	Drill and Tap Sight Holes	1 10 91		FB
618	Polish Barrel	1 10 91		WB
620	Apply Coatings (Barrel Action)		1-26-91	TA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		1/28/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/28/91	RW
	C) Inspect Ejector Hole for Chamfer		1/28/91	RW
	D) Oil Firing Pin Ass'y		1/28/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2-4-91	GL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	2 1/4	4 1/4	4 1/4			2/4/91	WB
	G) Safety Off Force	2 1/4	2 1/4	2 1/4			2/4/91	WB
	H) Trigger Pull Test & Retainability						2/4/91	WB
	I) Firing Pin Indent	.021	.021	.021			2/4/91	WB
	J) Assemble Stock						2/5/91	RW
	K) Assemble Swivel Studs						2-19-91	A
	L) Attach Front and Rear Sight Assemblies						2/5/91	RW
	M) Iron Sight Alignment						2/5/91	RW
	N) Detach Front & Rear Sights & place in numbered container						2/5/91	RW
	O) Attach Scope to Rifle						2/5/91	RW
	P) Detach & Attach Scope 20 Times						2/5/91	RW
640	Gallery Target & Test						2/6/91	K2
	A) Time						"	K2
	B) Malfunctions						"	K2
	C) Pierced Primers						"	K2
	D) Optical Clarity of Scope						"	K2
645	Inspect for Live Ammo						2/6/91	K2
655	Final Inspection							
	A) Headspace						2-19-91	A
	B) Trigger Pull	2.59	2.63	2.67	2.66	2.69	2/18/91	WB
	C) Function						2-19-91	A
660	Pack						3-19-91	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO C6587727

DATE 2-4-91

TESTER JUL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.25	2.31	2.15	2.59	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.21	2.40	2.33	2.63	
PULL #3	2.20	2.44	2.32	2.67	
PULL #4	2.19	2.41	2.33	2.66	
PULL #5	2.34	2.36	2.29	2.69	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.22		
PULL #2	3.33	3.21		
PULL #3	3.42	3.29		
PULL #4	3.41	3.28		
PULL #5	3.47	3.32		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.37	4.32		4.25
PULL #2	4.30	4.30		4.48
PULL #3	4.35	4.28		4.47
PULL #4	4.26	4.31		4.49
PULL #5	4.28	4.26		4.36
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587727
7 Feb 1991

CENTROIDAL DISTANCES

Ø TO	1	.418814
1 TO	2	.384832
1 TO	3	.216086
1 TO	4	.330905
1 TO	5	.219112

✱ ←---POB

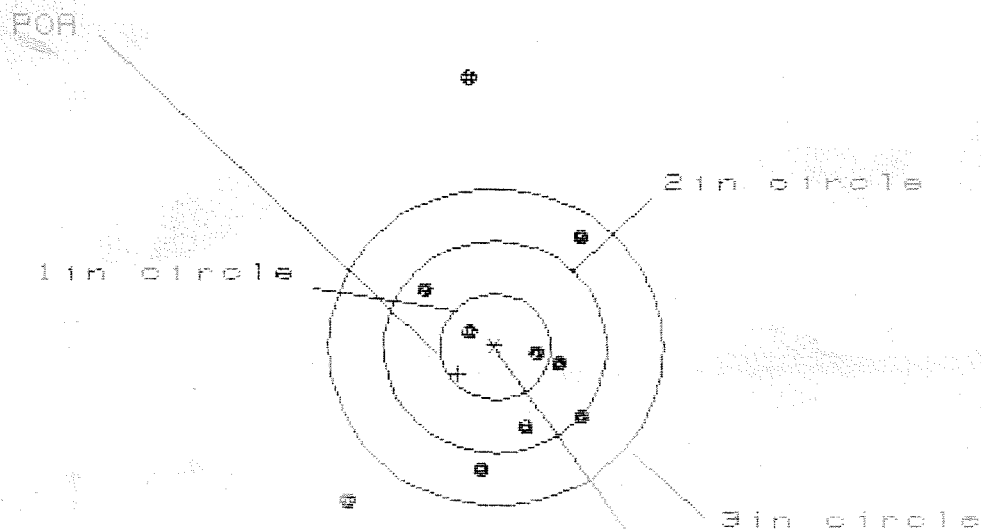
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1708
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .197921

THE AMR FOR THIS RIFLE IS: 1.001

7 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8587727

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.166

VS= 3.988

GS= 4.140

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.786	.756	.579
MINIMUM X	:	-1.380	-1.410	-.866
MAXIMUM Y	:	2.506	1.320	1.170
MINIMUM Y	:	-1.482	-1.204	-1.055
CENTROID X	:	.333	.363	.540
CENTROID Y	:	.254	-.024	.126
POA TO CENTROID in.	:	.419	.364	.554
MIN RADIUS	:	.268	.420	.188
MEAN RADIUS	:	1.089	.909	.745
MAX RADIUS	:	2.520	1.854	1.277
HORIZONTAL SPREAD	:	2.166	2.166	1.445
VERTICAL SPREAD	:	3.988	2.524	2.225
EXTREME SPREAD	:	4.140	3.283	2.372
NUMBER IN ONE INCH CIRCLE	:	2		

NUMBER IN TWO INCH CIRCLE = 5
 NUMBER IN THREE INCH CIRCLE = 8

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FILE:/PATTERNING/CENTERFIRE_PATT/06507727

CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 4

2in = 7

3in = 9

HS= 2.210

VS= 1.852

GS= 2.828

CENTROID #

PATTERN #

:

2

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

.822

.667

.599

MINIMUM X

:

-1.388

-.552

-.620

MAXIMUM Y

:

.709

.592

.434

MINIMUM Y

:

-1.143

-1.260

-.575

CENTROID X

:

.053

.208

.276

CENTROID Y

:

-.010

.107

.265

POA TO CENTROID in.:

.054

.234

.383

MIN RADIUS

:

.071

.247

.209

MEAN RADIUS

:

.724

.607

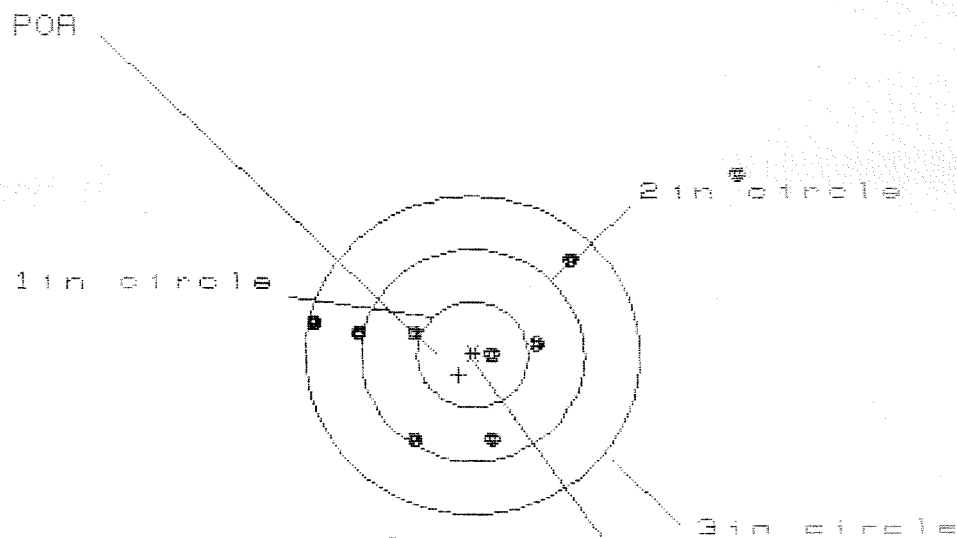
.506

MAX RADIUS	:	1.744	1.374	.740
HORIZONTAL SPREAD	:	2.210	1.219	1.219
VERTICAL SPREAD	:	1.852	1.852	1.009
EXTREME SPREAD	:	2.828	2.214	1.288
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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FILE:/PATTERNING/CENTERFIRE_PATT/C6587727

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 8

HS= 3.824

VS= 3.448

GS= 4.668

CENTROID #

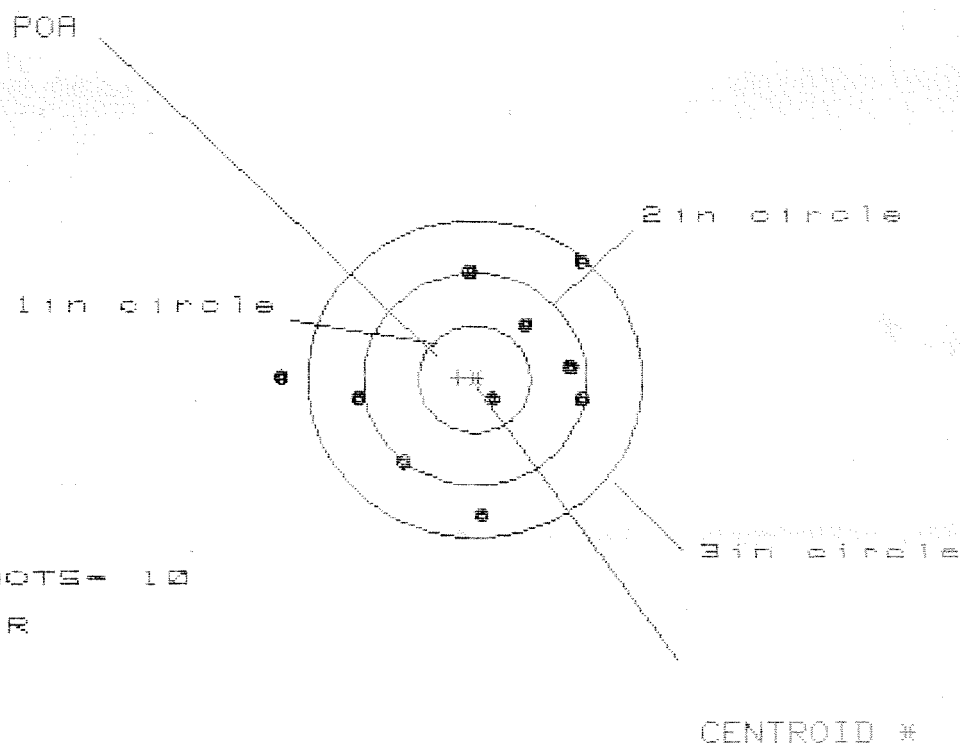
PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.407	1.181	1.122
MINIMUM X	:	-1.417	-1.150	-1.209
MAXIMUM Y	:	1.700	1.095	.900
MINIMUM Y	:	-1.748	-1.559	-.841
CENTROID X	:	.126	-.141	-.082
CENTROID Y	:	.192	.003	.198
POA TO CENTROID in.	:	.230	.141	.214
MIN RADIUS	:	.126	.440	.334
MEAN RADIUS	:	1.163	.947	.842
MAX RADIUS	:	2.946	1.629	1.438
HORIZONTAL SPREAD	:	3.824	2.331	2.331
VERTICAL SPREAD	:	3.448	2.654	1.741
EXTREME SPREAD	:	4.668	3.127	2.415
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	8		

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CENTERFIRE PATTERNS

4



OF SHOTS= 10

IN CIR

1in = 1

2in = 3

3in = 8

HS= 2.726

VS= 2.386

GS= 2.897

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.993	.800	.896
MINIMUM X	:	-1.733	-1.234	-1.139
MAXIMUM Y	:	1.082	1.081	1.173
MINIMUM Y	:	-1.384	-1.385	-1.170
CENTROID X	:	.146	.339	.243
CENTROID Y	:	-.019	-.018	-.153
POA TO CENTROID in.	:	.147	.339	.288
MIN RADIUS	:	.256	.220	.090
MEAN RADIUS	:	1.036	.926	.868
MAX RADIUS	:	1.733	1.322	1.184
HORIZONTAL SPREAD	:	2.726	2.034	2.034
VERTICAL SPREAD	:	2.386	2.386	2.343
EXTREME SPREAD	:	2.897	2.533	2.349
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		9	

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FILE:/PATTERNING/CENTERFIRE_PATT/08587727

CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 1

2in = 7

3in = 9

HS= 3.019

VS= 3.264

GS= 3.656

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.521	.448	.454
MINIMUM X	:	-.498	-.329	-.323
MAXIMUM Y	:	1.928	1.195	1.054
MINIMUM Y	:	-1.336	-1.121	-.837
CENTROID X	:	.196	.027	.021
CENTROID Y	:	.083	-.132	.009
POA TO CENTROID in.	:	.212	.134	.023
MIN RADIUS	:	.464	.330	.343
MEAN RADIUS	:	.995	.770	.734
MAX RADIUS	:	2.456	1.213	1.076
HORIZONTAL SPREAD	:	2.019	.777	.777
VERTICAL SPREAD	:	3.264	2.316	1.891
EXTREME SPREAD	:	3.656	2.320	1.994
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	