

C6649005

MODEL 700™ M24

Model **S&S**™

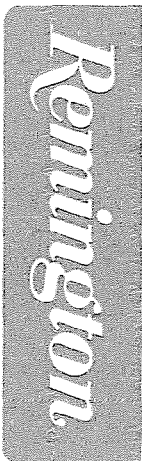
Action

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

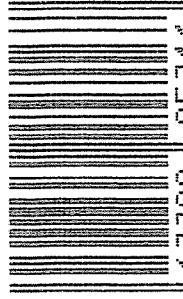
SERIAL NO. 06649005

ORDER NO. 5716

20

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

UPC



0 47700 25716 7



5716 06649005

CONTRACT # DAAA21-87-C-0086

GFM

GUN SERIAL # C6649005

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 2	9 1	RW
600	Proof	7 2	9 1	RW
607	Check Headspace	7 2	9 1	RW
610	Dis-assemble Gun	7 2	9 1	RW
612	Magnaflux Barrel Action		JUL 22 1991	GS
	Magnaflux Bolt		JUL 22 1991	GS
615	Rollmark Caliber		JUL 22 1991	GS
617	Drill and Tap Sight Holes		JUL 22 1991	LB
618	Polish Barrel		7/22/91	WB
620	Apply Coatings (Barrel Action)		7-22-91	LB
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/28/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/28/91	RW
	C) Inspect Ejector Hole for Chamfer		8/28/91	RW
	D) Oil Firing Pin Ass'y		8/28/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9-7-91	D/H

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6 1/2	7 3/4	7 1/2			9-7-91	DH
	G) Safety Off Force	3	3 1/4	3			9-7-91	DH
	H) Trigger Pull Test & Retainability						9-7-91	DH
	I) Firing Pin Indent	.0021	.020	.022			9-7-91	DH
	J) Assemble Stock						9/7/91	RW
	K) Assemble Swivel Studs						9-10-91	DH
	L) Attach Front and Rear Sight Assemblies						9/7/91	RW
	M) Iron Sight Alignment						9/7/91	RW
	N) Detach Front & Rear Sights & place in numbered container						9/7/91	RW
	O) Attach Scope to Rifle						9/7/91	RW
	P) Detach & Attach Scope 20 Times						9/7/91	RW
640	Gallery Target & Test						9-9-91	DH
	A) Time						9-9-91	DH
	B) Malfunctions						9-9-91	DH
	C) Pierced Primers						9-9-91	DH
	D) Optical Clarity of Scope						9-9-91	DH
645	Inspect for Live Ammo						9-9-91	DH
655	Final Inspection							
	A) Headspace						9-10-91	DH
	B) Trigger Pull	210	211	211	210	210	9-9-91	DH
	C) Function						9-10-91	DH
660	Pack						9-17-91	DH

SWS TRIGGER PULL TEST

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

SERIAL NO. C6649005
DATE 9-7-91
TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.23	2.23	2.10	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.30	2.21	2.44	2.11	
PULL #3	2.34	2.18	2.30	2.11	
PULL #4	2.34	2.19	2.25	2.10	
PULL #5	2.35	2.00	2.33	2.10	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.22	3.00		
PULL #2	3.14	3.01		
PULL #3	3.25	3.10		
PULL #4	3.21	3.02		
PULL #5	3.15	3.03		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.09	4.11		4.30
PULL #2	4.01	4.20		4.21
PULL #3	4.14	4.12		4.26
PULL #4	4.18	4.16		4.05
PULL #5	4.07	4.20		4.08
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649085
9 Sep 1991

CENTROIDAL DISTANCES

0 TO 1	.218673
1 TO 2	.0425206
1 TO 3	.0547814
1 TO 4	.221948
1 TO 5	.145774

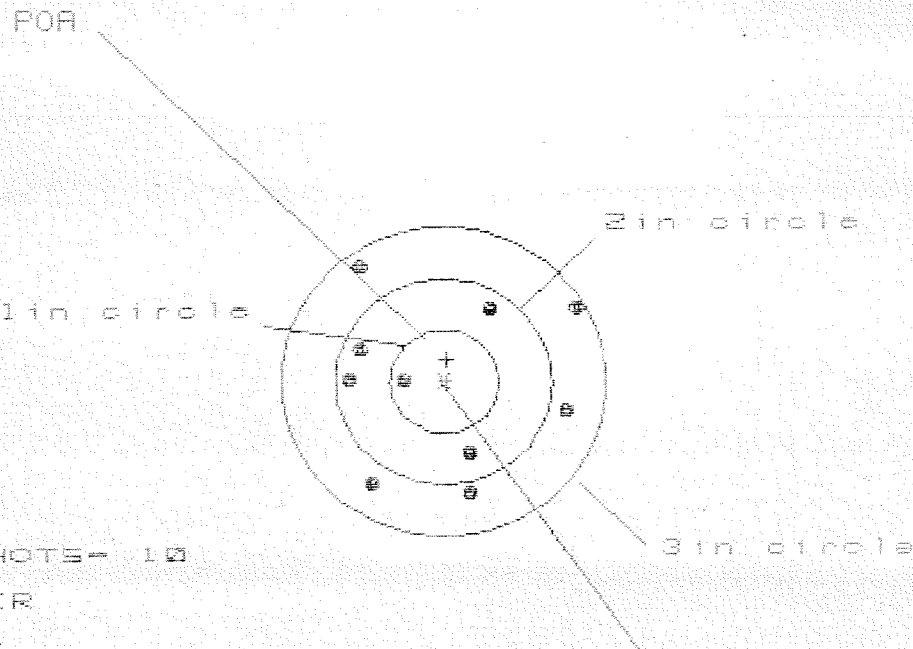
←----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.039
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1402
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .145523
THE AMR FOR THIS RIFLE IS: .9428

9 Sep 1981

FILE:/PATTERNING/CENTERFIRE_PATT/C8649005

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 2.124

VS= 2.219

GS= 2.572

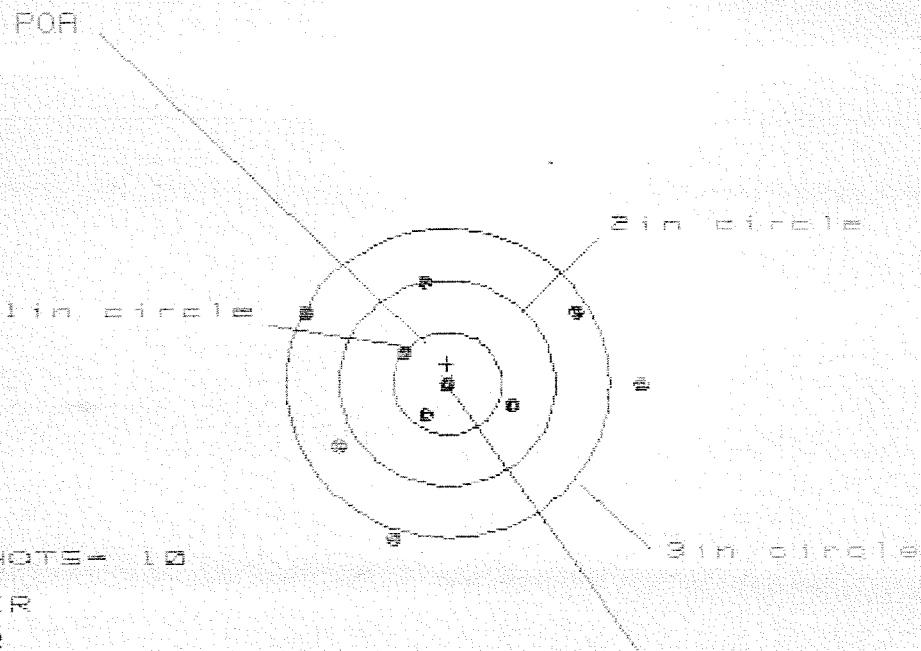
CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.273	1.294	1.213
MINIMUM X	-.851	-.710	-.790
MAXIMUM Y	1.130	1.206	.980
MINIMUM Y	-1.089	-1.013	-.862
CENTROID X	-.027	-.168	-.088
CENTROID Y	-.217	-.293	-.444
POR TO CENTROID in.	.219	.338	.453
MIN RADIUS	.335	.221	.377
MEAN RADIUS	.995	.918	.862
MAX RADIUS	1.446	1.369	1.214
HORIZONTAL SPREAD	2.124	2.004	2.004
VERTICAL SPREAD	2.219	2.219	1.842
EXTREME SPREAD	2.572	2.454	2.077
NUMBER IN ONE INCH CIRCLE =	1	1	1
NUMBER IN TWO INCH CIRCLE =	5	5	5
NUMBER IN THREE INCH CIRCLE =	10	10	10

9 Sep 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

HS = 3.053

VS = 2.472

GS = 3.157

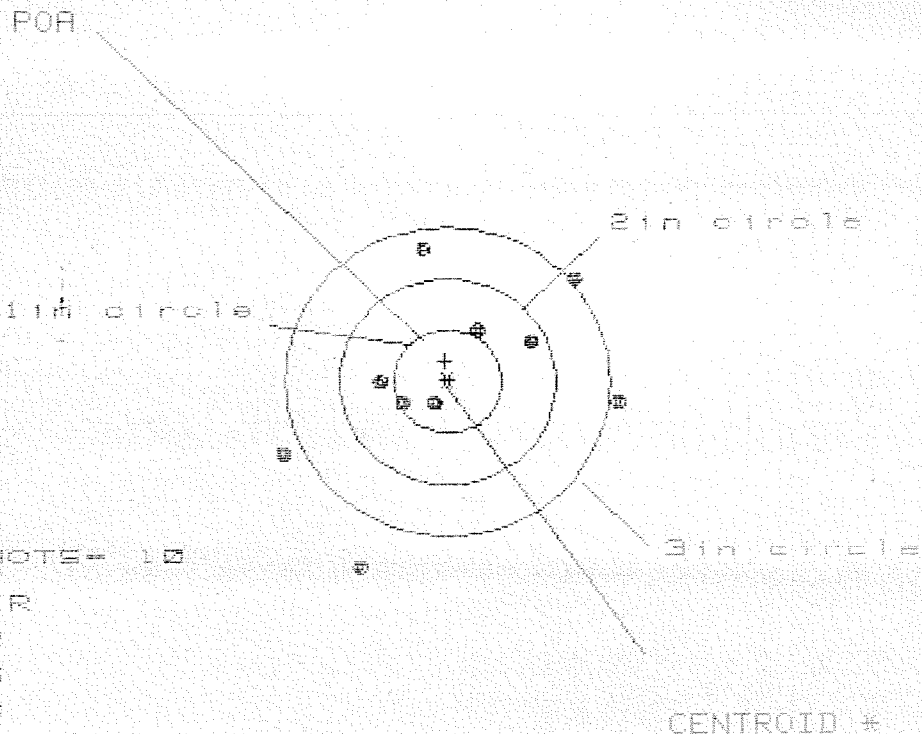
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.805	1.432	1.395
MINIMUM X	:	-1.258	-1.058	-1.095
MAXIMUM Y	:	1.003	.997	.813
MINIMUM Y	:	-1.469	-1.475	-1.753
CENTROID X	:	.005	-.195	-.158
CENTROID Y	:	-.189	-.183	.001
POA TO CENTROID in.	:	.189	.268	.158
MIN RADIUS	:	.051	.192	.281
MEAN RADIUS	:	.996	.895	.821
MAX RADIUS	:	1.806	1.574	1.472
HORIZONTAL SPREAD	:	3.053	2.490	2.490
VERTICAL SPREAD	:	2.472	2.472	1.566
EXTREME SPREAD	:	3.157	2.742	2.587
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

9 Sep 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 6

HS= 3.076

VS= 3.185

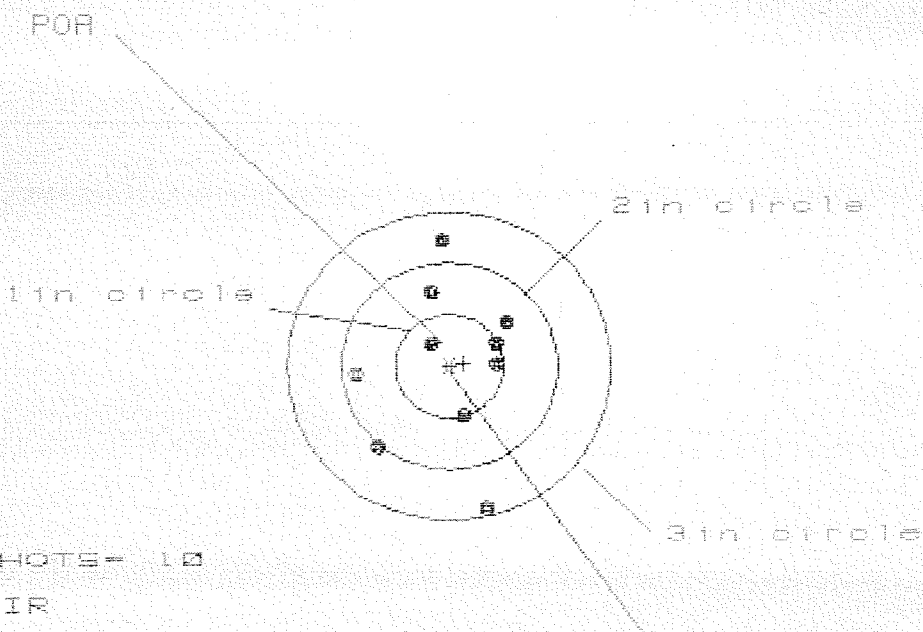
GS= 3.451

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.526	1.437	1.232
MINIMUM X	-1.550	-1.639	-1.953
MAXIMUM Y	1.336	1.130	1.017
MINIMUM Y	-1.849	-1.902	-1.570
CENTROID X	.024	.113	.318
CENTROID Y	-.197	.009	.122
FOR TO CENTROID in.	.198	.113	.340
MIN RADIUS	.241	.306	.164
MEAN RADIUS	1.091	.977	.849
MAX RADIUS	2.016	1.871	1.330
HORIZONTAL SPREAD	3.076	3.076	2.185
VERTICAL SPREAD	3.185	2.032	1.587
EXTREME SPREAD	3.451	3.201	2.335
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		6	

9 Sep 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 1.443

VS= 2.632

GS= 2.673

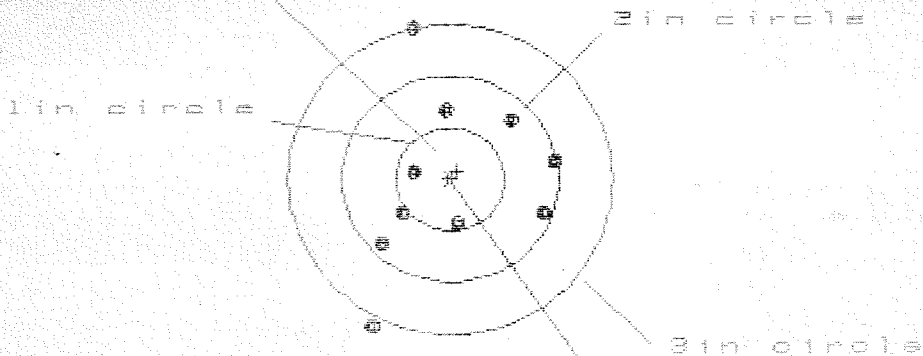
PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.568	.609	.602
MINIMUM X	-.875	-.834	-.841
MAXIMUM Y	1.213	1.055	.783
MINIMUM Y	-1.419	-.900	-.768
CENTROID X	-.133	-.174	-.167
CENTROID Y	-.022	.136	.004
POA TO CENTROID in.	.134	.220	.167
MIN RADIUS	.244	.106	.204
MEAN RADIUS	.767	.669	.623
MAX RADIUS	1.466	1.102	1.002
HORIZONTAL SPREAD	1.443	1.443	1.443
VERTICAL SPREAD	2.632	1.955	1.471
EXTREME SPREAD	2.673	2.040	1.679
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

9 Sep 1993

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CENTERFIRE PATTERNS # 5

POA



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS= 1.695

VS= 2.921

GS= 2.954

PATTERN #

5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.954	.871	.824
MINIMUM X	-.741	-.709	-.756
MAXIMUM Y	1.495	1.336	.722
MINIMUM Y	-1.426	-.745	-.578
CENTROID X	-.064	.019	.066
CENTROID Y	-.076	.083	-.084
POA TO CENTROID in.	.099	.085	.107
MIN RADIUS	.335	.397	.405
MEAN RADIUS	.865	.782	.692
MAX RADIUS	1.607	1.396	.952
HORIZONTAL SPREAD	1.695	1.580	1.580
VERTICAL SPREAD	2.921	2.081	1.299
EXTREME SPREAD	2.954	2.106	1.747
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	8	
NUMBER IN THREE INCH CIRCLE	=	8	