

C6649012

MODEL 700™ M24

Model **S&S**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.





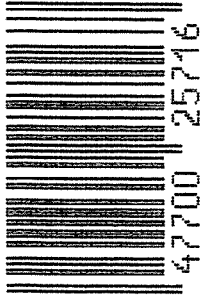

VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

REG. U.S. PAT. & TM. OFF.

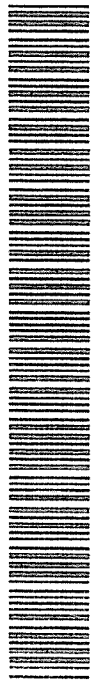
MODEL 700 TM	H24	SERIAL NO. C6649012	ORDER NO. 5716
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MADE IN ILION, N.Y., U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

UPC



0 47700 25716 7



5716 C6649012

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649012

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	8	9 1	Rw
610	Dis-assemble Gun	7 2		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		7/28/91	WB
620	Apply Coatings (Barrel Action)		7-23-91	AB
	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		8/29/91	AM

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	5 1/2	5 3/4			8-29-91	DH
	G) Safety Off Force	3	3	3			8-29-91	DH
	H) Trigger Pull Test & Retainability						8/29/91	RL
	I) Firing Pin Indent	.022	.023	.021			8-29-91	DH
	J) Assemble Stock						8/31/91	RW
	K) Assemble Swivel Studs						8-4-91	DH
	L) Attach Front and Rear Sight Assemblies						8/31/91	RW
	M) Iron Sight Alignment						8/31/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/31/91	RW
	O) Attach Scope to Rifle						8/31/91	RW
	P) Detach & Attach Scope 20 Times						8/31/91	RW
640	Gallery Target & Test						9-3-91	DH
	A) Time						9-3-91	DH
	B) Malfunctions						9-3-91	DH
	C) Pierced Primers						9-3-91	DH
	D) Optical Clarity of Scope						9-3-91	DH
645	Inspect for Live Ammo						9-3-91	DH
655	Final Inspection							
	A) Headspace						9-4-91	DH
	B) Trigger Pull	2.24	2.28	2.19	2.23	2.19	9-3-91	DH
	C) Function						9-4-91	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. C6649012

DATE 8/29/91

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.25	2.29	2.24	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.50	2.17	2.44	2.28	
PULL #3	2.25	2.34	2.51	2.19	
PULL #4	2.44	2.27	2.49	2.23	
PULL #5	2.29	2.31	2.38	2.19	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.42	3.36		
PULL #2	3.33	3.34		
PULL #3	3.35	3.38		
PULL #4	3.32	3.44		
PULL #5	3.32	3.43		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.34		4.36
PULL #2	4.49	4.35		4.35
PULL #3	4.48	4.33		4.37
PULL #4	4.40	4.33		4.28
PULL #5	4.41	4.38		4.27
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06649012
3 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.298739
1 TO	2	.022561
1 TO	3	.381369
1 TO	4	.682528
1 TO	5	.614921

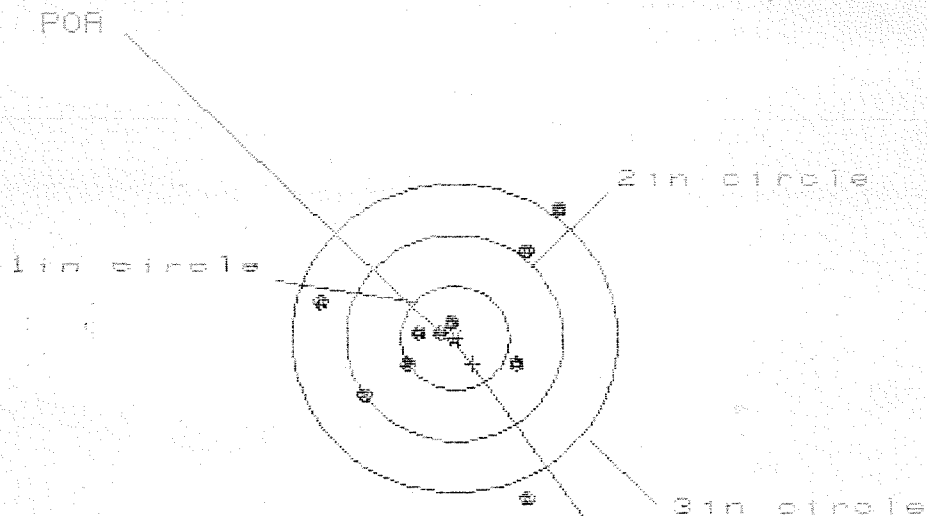
4.0 5 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0586
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0488
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0762589
THE AMR FOR THIS RIFLE IS: .0686

3 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08645012

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 4

2in = 5

3in = 8

HS= 2.188

VS= 2.812

GS= 2.821

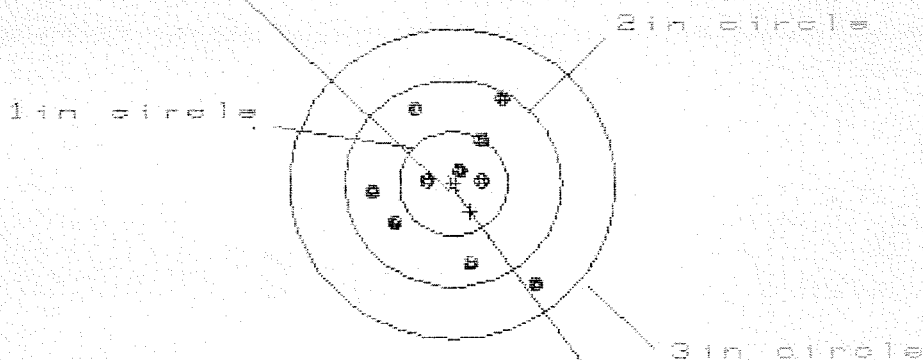
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.941	1.019	.915
MINIMUM X	-1.248	-1.169	-1.041
MAXIMUM Y	1.239	1.064	.763
MINIMUM Y	-1.574	-.761	-.628
CENTROID X	-.162	-.240	-.368
CENTROID Y	.251	.426	.293
POA TO CENTROID in.	.299	.489	.471
MIN RADIUS	.154	.092	.032
MEAN RADIUS	.845	.733	.595
MAX RADIUS	1.726	1.473	1.191
HORIZONTAL SPREAD	2.188	2.188	1.956
VERTICAL SPREAD	2.812	1.825	1.391
EXTREME SPREAD	2.821	2.514	2.043
NUMBER IN ONE INCH CIRCLE =	4	4	4
NUMBER IN TWO INCH CIRCLE =	5	5	5
NUMBER IN THREE INCH CIRCLE =	8	8	8

3 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649012

CENTERFIRE PATTERNS # 2

POA



OF SHOTS- 10

IN CIR

1in = 3

2in = 9

3in = 10

HS= 1.521

VS= 1.873

GS= 2.030

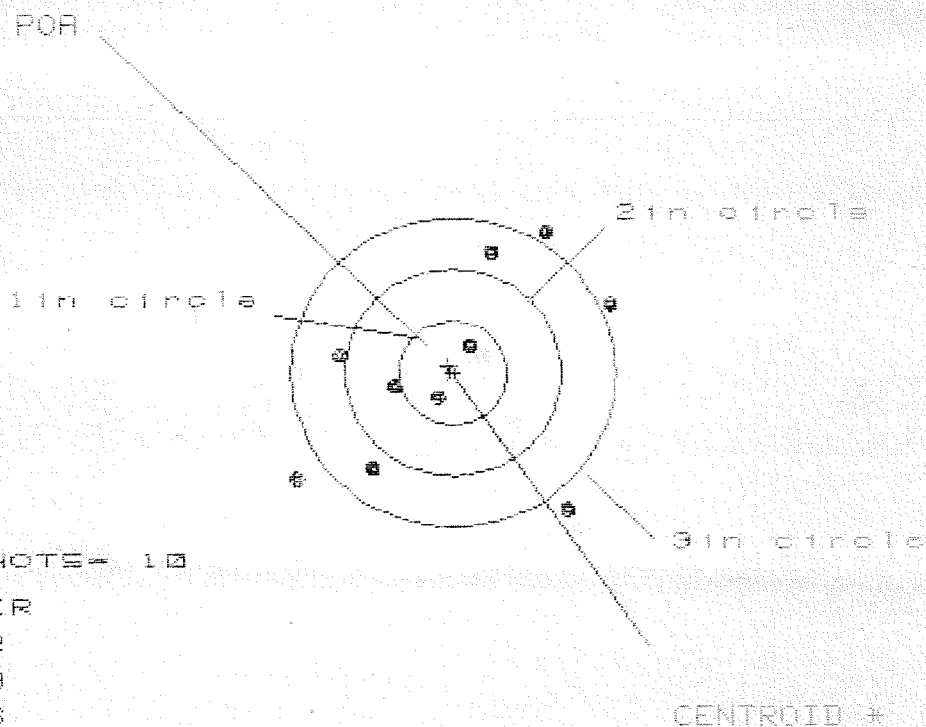
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.752	.534	.396
MINIMUM X	:	-.769	-.685	-.619
MAXIMUM Y	:	.864	.752	.703
MINIMUM Y	:	-1.009	-.896	-.802
CENTROID X	:	-.157	-.241	-.307
CENTROID Y	:	.273	.385	.291
POA TO CENTROID in.	:	.315	.454	.424
MIN RADIUS	:	.174	.144	.084
MEAN RADIUS	:	.646	.562	.517
MAX RADIUS	:	1.259	.922	.843
HORIZONTAL SPREAD	:	1.521	1.219	1.015
VERTICAL SPREAD	:	1.873	1.648	1.505
EXTREME SPREAD	:	2.030	1.683	1.562
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

3 Sep 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 3

3 in = 5

HS= 2.836

VS= 2.661

GS= 3.317

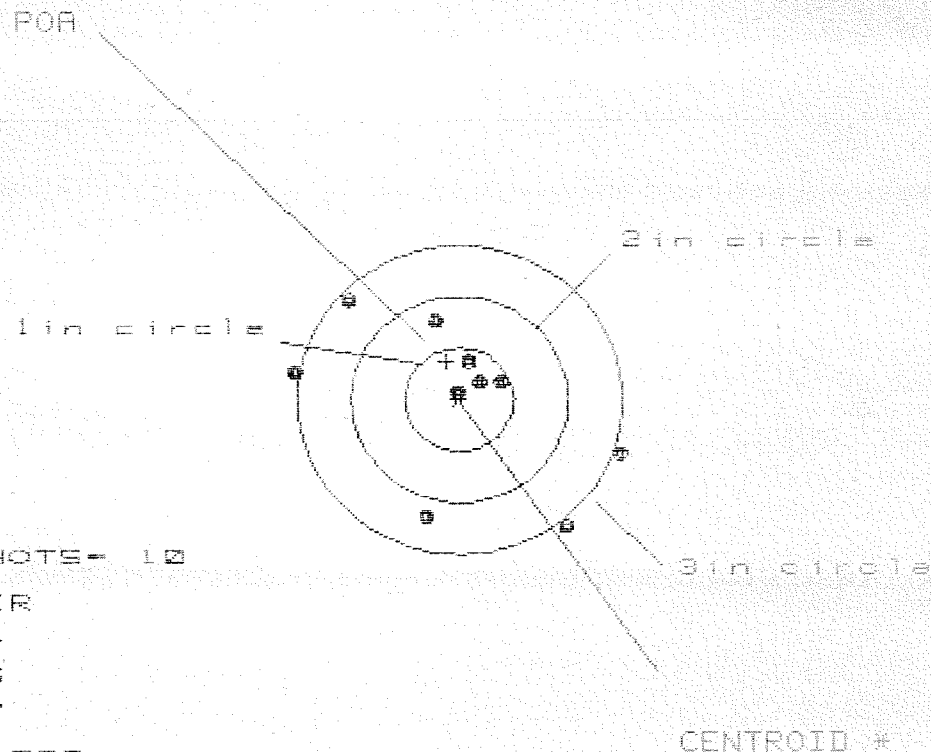
CENTROID *

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.413	1.254	1.368
MINIMUM X	-1.423	-1.213	-1.099
MAXIMUM Y	1.344	1.228	1.049
MINIMUM Y	-1.317	-1.433	-1.186
CENTROID X	.047	.205	.091
CENTROID Y	-.068	.048	.227
POR TO CENTROID in.	.083	.210	.245
MIN RADIUS	.250	.188	.141
MEAN RADIUS	1.115	1.044	.941
MAX RADIUS	1.769	1.695	1.418
HORIZONTAL SPREAD	2.836	2.467	2.467
VERTICAL SPREAD	2.661	2.661	2.235
EXTREME SPREAD	3.317	2.714	2.714
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		6	

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 4

2in = 5

3in = 7

HS= 3.027

VS= 2.174

GS= 3.140

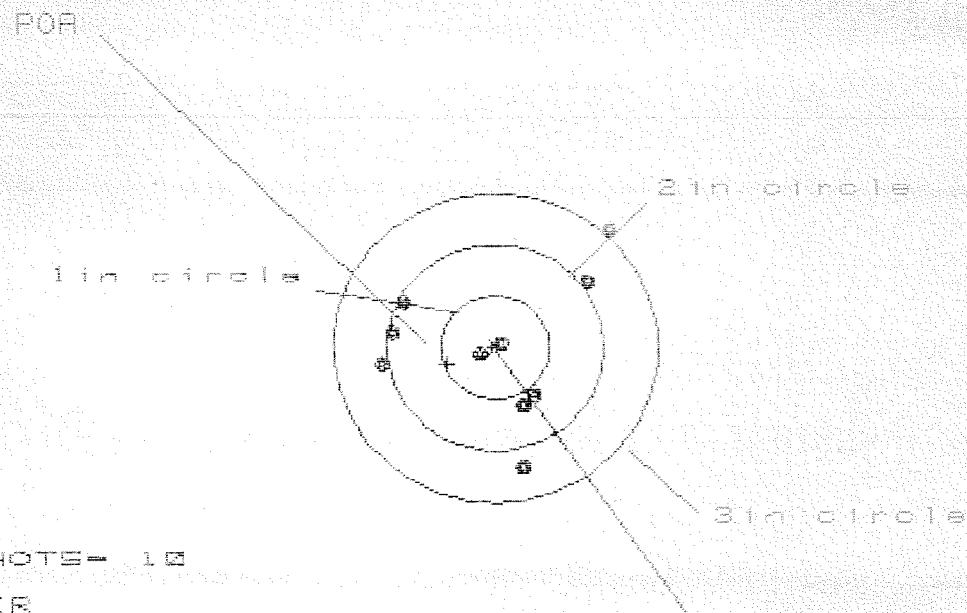
CENTROID #

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.489	1.144	.973
MINIMUM X	:	-1.538	-1.373	-.998
MAXIMUM Y	:	.953	.893	.923
MINIMUM Y	:	-1.221	-1.281	-1.251
CENTROID X	:	.119	-.046	.125
CENTROID Y	:	-.371	-.311	-.341
POA TO CENTROID in.	:	.390	.315	.363
MIN RADIUS	:	.025	.176	.006
MEAN RADIUS	:	.911	.851	.734
MAX RADIUS	:	1.582	1.717	1.585
HORIZONTAL SPREAD	:	3.027	2.517	1.971
VERTICAL SPREAD	:	2.174	2.174	2.174
EXTREME SPREAD	:	3.140	2.940	2.934
NUMBER IN ONE INCH CIRCLE	=	4		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	7		

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HE= 2.057

VS= 2.292

GS= 2.484

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.050	1.019	1.062
MINIMUM X	-1.017	-.901	-.858
MAXIMUM Y	1.171	.723	.599
MINIMUM Y	-1.121	-.991	-.578
CENTROID X	.446	.330	.287
CENTROID Y	.159	.029	.153
POB TO CENTROID in.	.474	.331	.326
MIN RADIUS	.121	.071	.060
MEAN RADIUS	.826	.729	.695
MAX RADIUS	1.572	1.249	1.219
HORIZONTAL SPREAD	2.067	1.920	1.920
VERTICAL SPREAD	2.292	1.714	1.177
EXTREME SPREAD	2.484	2.080	2.080
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	9	