

C6636273

MODEL 700™ M24

Model **S&S**™

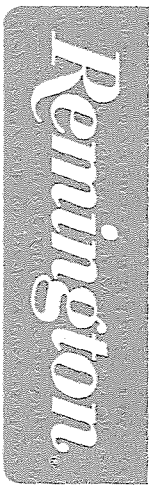
Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.






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

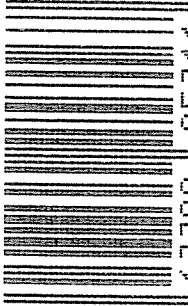
MODEL 700™
H24

SERIAL NO.
06636273

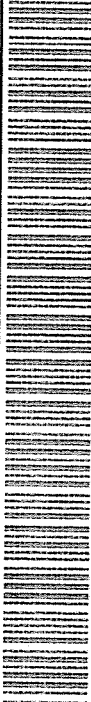
ORDER NO.
5716

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

UPC



0 4700 25716 7



5716 06636273

GUN SERIAL # **C6636273**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/24/91	KL
600	Proof		6/24/91	KL
607	Check Headspace		6/24/91	KL
610	Dis-assemble Gun		6/24/91	KL
612	Magnaflux Barrel Action	JUL 1 1991		KR
	Magnaflux Bolt	JUL 1 1991		KR
615	Rollmark Caliber	JUL 1 1991		DS.
617	Drill and Tap Sight Holes	JUL 1 1991		LB
618	Polish Barrel	JUL 2 1991		WB
620	Apply Coatings (Barrel Action)		7-23-91	TS
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		8/5/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/5/91	KL
	C) Inspect Ejector Hole for Chamfer		8/5/91	KL
	D) Oil Firing Pin Ass'y		8/5/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		8-6-91	KL

Op. #	Op. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	4½			8-6-91	DH
	G) Safety Off Force	3	3	3			8-6-91	DH
	H) Trigger Pull Test & Retainability						8-6-91	RU
	I) Firing Pin Indent	.020	.021	.021			8-6-91	DH
	J) Assemble Stock						8/7/91	KS
	K) Assemble Swivel Studs						8-8-91	DH
	L) Attach Front and Rear Sight Assemblies						8/7/91	KS
	M) Iron Sight Alignment						8/7/91	KS
	N) Detach Front & Rear Sights & place in numbered container						8/7/91	KS
	O) Attach Scope to Rifle						8/7/91	KS
	P) Detach & Attach Scope 20 Times						8/7/91	KS
640	Gallery Target & Test						8/8/91	KF
	A) Time						✓	KF
	B) Malfunctions						✓	KF
	C) Pierced Primers						✓	KF
	D) Optical Clarity of Scope						✓	KF
645	Inspect for Live Ammo						8/8/91	KF
655	Final Inspection							
	A) Headspace						8-8-91	DH
	B) Trigger Pull	2.20	2.25	2.35	2.31	2.39	8-9-91	RP
	C) Function						8-8-91	DH
660	Pack						9-9-91	✓

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF	<i>stop</i> <i>test</i> <i>8-9-91</i>	<i>AC</i>
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

MOD. _____ GA. CAL. _____ GUN # 6273

#	DATE	MALFUNCTION/DEFECT	ASSEM. #
KT	1st	Trig. Creep Shave Brass	KS
	2nd		
	3rd		
	4th		
		FUNCTION	RD 6654 Rev 1

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C6636273

DATE 8-6-91

TESTER D/H

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.63	2.52	2.50	2.20	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.64	2.48	2.53	2.25	
PULL #3	2.72	2.52	2.56	2.35	
PULL #4	2.80	2.56	2.50	2.31	
PULL #5	2.63	2.44	2.55	2.39	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.59	3.44		
PULL #2	3.48	3.52		
PULL #3	3.56	3.40		
PULL #4	3.41	3.53		
PULL #5	3.41	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	4.34	4.49		4.37
PULL #2	4.30	4.61		4.62
PULL #3	4.36	4.49		4.54
PULL #4	4.38	4.41		4.50
PULL #5	4.39	4.44		4.36
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636273
8 Aug 1991

CENTROIDAL DISTANCES

0 TO 1	.355224
1 TO 2	.271221
1 TO 3	.216689
1 TO 4	.028178
1 TO 5	.590715

←---POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0884
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1182
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .1476
THE AVE FOR THIS RIFLE IS: .7824

1 Aug 1981

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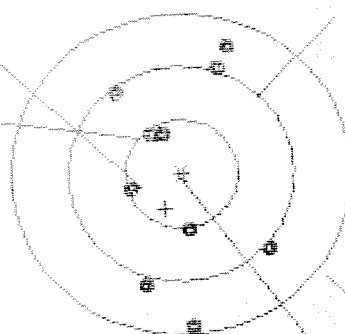
CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 10

HS= 1.263

VS= 2.562

GS= 2.591

CENTROID *

PATTERN #

SHOTS (BEST OF)

MAXIMUM X

MINIMUM X

MAXIMUM Y

MINIMUM Y

CENTROID X

CENTROID Y

POA TO CENTROID in.

MIN RADIUS

MEAN RADIUS

MAX RADIUS

HORIZONTAL SPREAD

VERTICAL SPREAD

EXTREME SPREAD

NUMBER IN ONE INCH CIRCLE =

NUMBER IN TWO INCH CIRCLE =

NUMBER IN THREE INCH CIRCLE =

10

9

8

.725

.735

.796

-.538

-.528

-.467

1.170

1.015

.905

-1.392

-1.136

-1.009

.150

.140

.079

.322

.477

.350

.355

.497

.358

.375

.229

.331

.846

.761

.711

1.395

1.180

1.102

1.263

1.263

1.263

2.562

2.151

1.914

2.591

2.297

2.018

3

6

10

8 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636273

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 2

2in = 8

3in = 10

HS= 1.610

VS= 1.879

GS= 1.969

CENTROID *

PATTERN #

2

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.734

.668

.675

MINIMUM X

-.876

-.942

-.935

MAXIMUM Y

1.093

1.197

.567

MINIMUM Y

-.786

-.682

-.532

CENTROID X

-.010

.056

.049

CENTROID Y

.103

-.001

-.151

POA TO CENTROID in.

.103

.056

.159

MIN RADIUS

.074

.178

.254

MEAN RADIUS

.710

.662

.587

MAX RADIUS

1.109

1.198

1.094

HORIZONTAL SPREAD

1.610

1.610

1.610

VERTICAL SPREAD

1.879

1.879

1.099

EXTREME SPREAD

1.969

1.954

1.761

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

8

NUMBER IN THREE INCH CIRCLE =

10

8 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8536273

CENTERFIRE PATTERNS

5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in - 2

2 in - 8

3 in - 10

HS= 1.813

VS= 2.373

GS= 2.422

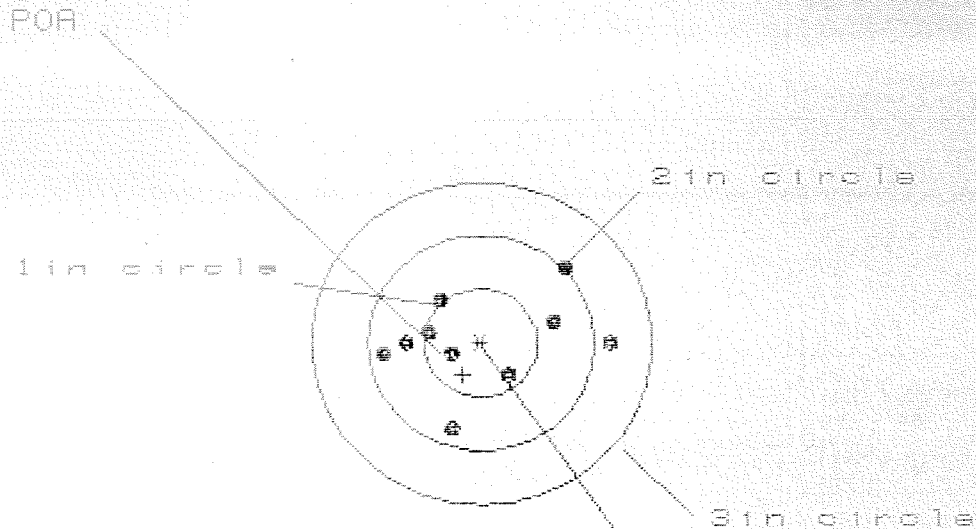
CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.912	.878	.761
MINIMUM X	:	-.981	-.935	-.681
MAXIMUM Y	:	.980	.825	.889
MINIMUM Y	:	-1.393	-.986	-.922
CENTROID X	:	-.038	-.004	.113
CENTROID Y	:	-.238	-.083	-.147
POA TO CENTROID in.	:	.241	.083	.135
MIN RADIUS	:	.032	.117	.187
MEAN RADIUS	:	.776	.685	.644
MAX RADIUS	:	1.427	1.065	.928
HORIZONTAL SPREAD	:	1.813	1.813	1.442
VERTICAL SPREAD	:	2.373	1.811	1.811
EXTREME SPREAD	:	2.422	2.076	1.815
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

6 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636273

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 4

2in = 9

3in = 10

HS= 1.975

VS= 1.464

GS= 1.976

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.104	.812	.882
MINIMUM X	:	-.871	-.748	-.646
MAXIMUM Y	:	.667	.669	.450
MINIMUM Y	:	-.797	-.795	-.712
CENTROID X	:	.163	.040	-.062
CENTROID Y	:	.297	.295	.211
POA TO CENTROID in.	:	.339	.298	.220
MIN RADIUS	:	.276	.181	.058
MEAN RADIUS	:	.667	.591	.501
MAX RADIUS	:	1.104	1.052	.917
HORIZONTAL SPREAD	:	1.975	1.560	1.529
VERTICAL SPREAD	:	1.464	1.464	1.161
EXTREME SPREAD	:	1.976	1.727	1.545
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

8 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636273

CENTERFIRE PATTERNS

3

POB

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in - 2

2 in - 6

3 in - 8

HS- 3.114

VS- 2.398

GS- 3.155

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.698	.816	.507
MINIMUM X	-1.416	-1.227	-1.126
MAXIMUM Y	1.505	1.405	.777
MINIMUM Y	-.893	-.949	-.773
CENTROID X	.177	-.012	-.114
CENTROID Y	.107	.207	.031
POB TO CENTROID in.	.207	.207	.118
MIN RADIUS	.151	.223	.330
MEAN RADIUS	.913	.790	.696
MAX RADIUS	1.919	1.625	1.168
HORIZONTAL SPREAD	3.114	2.043	1.632
VERTICAL SPREAD	2.398	2.354	1.550
EXTREME SPREAD	3.155	2.786	1.854
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	8	