

C6636323

MODEL 700™ M24

Model S&S™

Action

Barrel Length

Capacity

Order No. 5716

* Includes 1 in chamber.





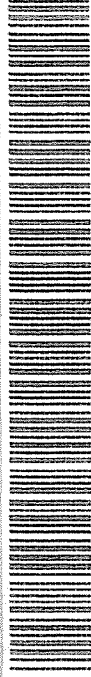

VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

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

MODEL 700™ H24

20

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



5716 C6636323

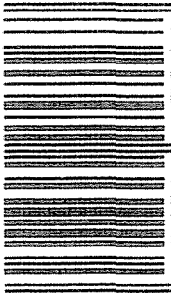
SERIAL NO.

C6636323

ORDER NO.

5716

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636323

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 25	9 1	RW
600	Proof	6 25	9 1	RW
607	Check Headspace	6 25	9 1	RW
610	Dis-assemble Gun	6 25	9 1	RW
612	Magnaflux Barrel Action	JUL	1 1991	KR
	Magnaflux Bolt	JUL	1 1991	KR
615	Rollmark Caliber	JUL	1 1991	JS
617	Drill and Tap Sight Holes	JUL	1 1991	LB
618	Polish Barrel	JUL	2 1991	WB
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/28/91	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/28/91	WB
	C) Inspect Ejector Hole for Chamfer		8/28/91	WB
	D) Oil Firing Pin Ass'y		8/28/91	WB
	E) Adjust Trigger Pull to Min Setting and Stake		8/28/91	JU.

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			8/26/91	DH
	G) Safety Off Force	3	3	3			8/26/91	DH
	H) Trigger Pull Test & Retainability						8/26/91	JU
	I) Firing Pin Indent	.021	.021	.021			8/26/91	DH
	J) Assemble Stock							
	K) Assemble Swivel Studs						8-31-91	DH
	L) Attach Front and Rear Sight Assemblies							
	M) Iron Sight Alignment							
	N) Detach Front & Rear Sights & place in numbered container							
	O) Attach Scope to Rifle							
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test						8-31-91	AC
	A) Time						8-31-91	AC
	B) Malfunctions						8-31-91	AC
	C) Pierced Primers						8-31-91	AC
	D) Optical Clarity of Scope						8-31-91	AC
645	Inspect for Live Ammo						8-31-91	AC
655	Final Inspection						8-31-91	DH
	A) Headspace							
	B) Trigger Pull	2.31	2.28	2.16	2.32	2.40	8/29/91	JU
	C) Function						8-31-91	DH
660	Pack						9-18-91	VF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 06636323

DATE 8-26-91

TESTER JM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.36	2.29	2.31	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.30	2.30	2.40	2.28	
PULL #3	2.25	2.52	2.53	2.16	
PULL #4	2.34	2.31	2.50	2.32	
PULL #5	2.33	2.40	2.48	2.40	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.39	3.55		
PULL #2	3.69	3.44		
PULL #3	3.64	3.48		
PULL #4	3.45	3.46		
PULL #5	3.48	3.56		
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	4.36		4.24
PULL #2	4.43	4.48		4.66
PULL #3	4.52	4.41		4.42
PULL #4	4.40	4.44		4.51
PULL #5	4.42	4.53		4.49
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636323
27 Aug. 1991

CENTROIDAL DISTANCES

0 TO 1	.12596
1 TO 2	.0296142
1 TO 3	.233848
1 TO 4	.279807
1 TO 5	.925467

5 <----POA
5

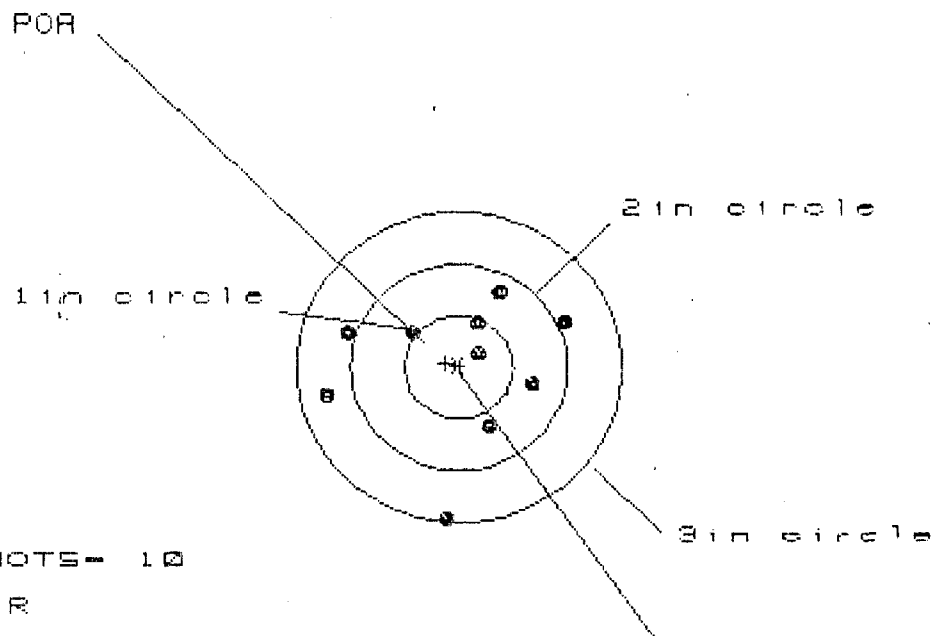
1. AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1926
2. AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.099
3. AVERAGE POI RADIUS FOR THIS RIFLE IS: .112554.
4. AVERAGE POI RADIUS FOR THIS RIFLE IS: .8312

27 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636323

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 10

HS= 2.223

VS= 2.190

GS= 2.337

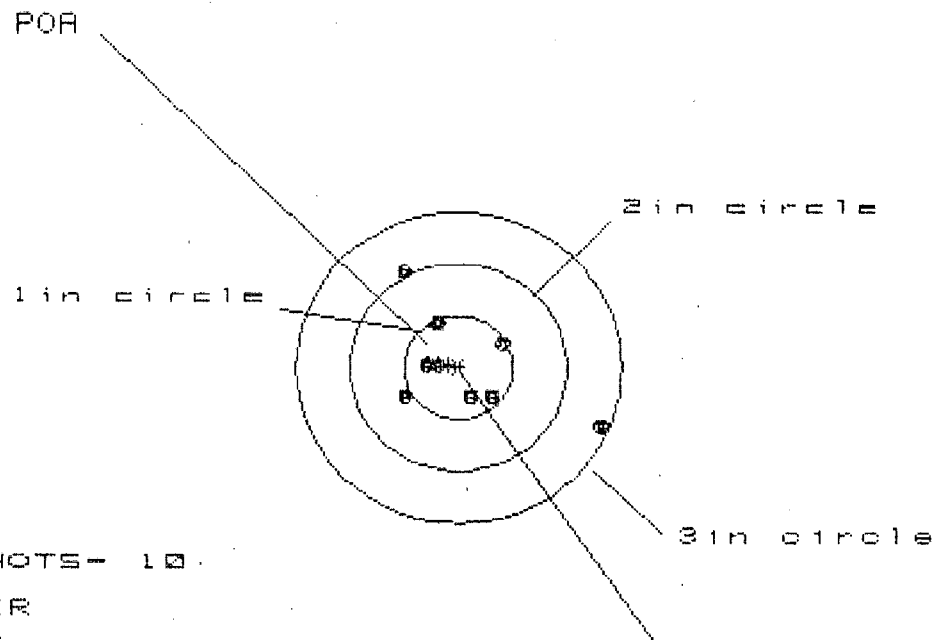
CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.991	.978	.823
MINIMUM X	:	-1.232	-1.245	-1.201
MAXIMUM Y	:	.705	.539	.487
MINIMUM Y	:	-1.486	-.728	-.780
CENTROID X	:	.121	.134	.289
CENTROID Y	:	-.035	.130	.182
AVG TO CENTROID in.	:	.126	.186	.342
1IN RADIUS	:	.278	.198	.055
2IN RADIUS	:	.828	.720	.601
3IN RADIUS	:	1.490	1.314	1.207
1 INCH SPREAD	:	2.223	2.223	2.024
2 INCH SPREAD	:	2.190	1.267	1.267
3 INCH SPREAD	:	2.337	2.337	2.028
CIRCS IN ONE INCH CIRCLE	=	3		
CIRCS IN TWO INCH CIRCLE	=	6		
CIRCS IN THREE INCH CIRCLE	=	10		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 6

2in = 8

3in = 10

HS= 1.852

VS= 1.521

GS= 2.360

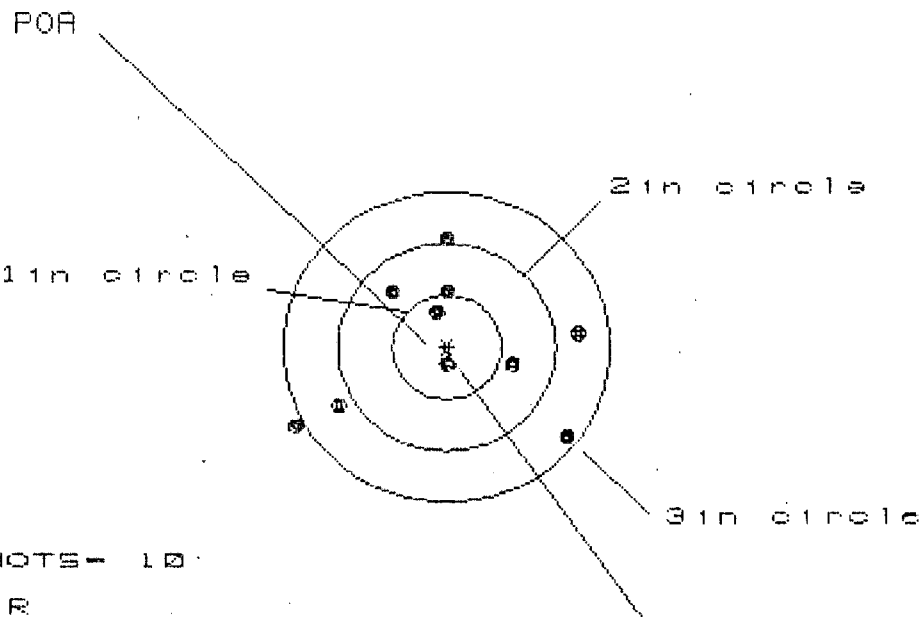
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.328	.577	.536
MINIMUM X	:	-.524	-.377	-.418
MAXIMUM Y	:	.926	.860	.424
MINIMUM Y	:	-.595	-.384	-.276
CENTROID X	:	.092	-.055	-.014
CENTROID Y	:	-.029	.037	-.071
POA TO CENTROID in.	:	.097	.066	.072
MIN RADIUS	:	.197	.054	.117
MEAN RADIUS	:	.573	.441	.379
MAX RADIUS	:	1.455	.921	.598
HORIZONTAL SPREAD	:	1.852	.954	.954
VERTICAL SPREAD	:	1.521	1.244	.700
EXTREME SPREAD	:	2.360	1.403	1.055
NUMBER IN ONE INCH CIRCLE =			6	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			10	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.615

VS= 1.872

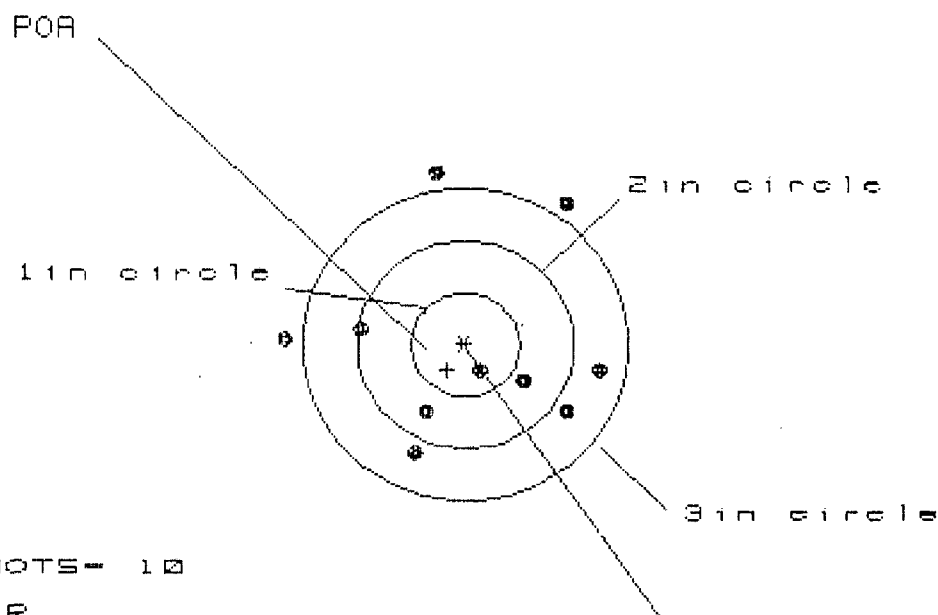
GS= 2.758

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.172	1.012	1.134
MINIMUM X	-1.443	-1.121	-.999
MAXIMUM Y	1.044	.960	.846
MINIMUM Y	-.828	-.912	-.774
CENTROID X	-.005	.155	.033
CENTROID Y	.162	.246	.360
POA TO CENTROID in.	.162	.291	.362
MIN RADIUS	.175	.288	.123
MEAN RADIUS	.876	.779	.677
MAX RADIUS	1.631	1.340	1.264
HORIZONTAL SPREAD	2.615	2.133	2.133
VERTICAL SPREAD	1.872	1.872	1.620
EXTREME SPREAD	2.758	2.242	2.242
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 4



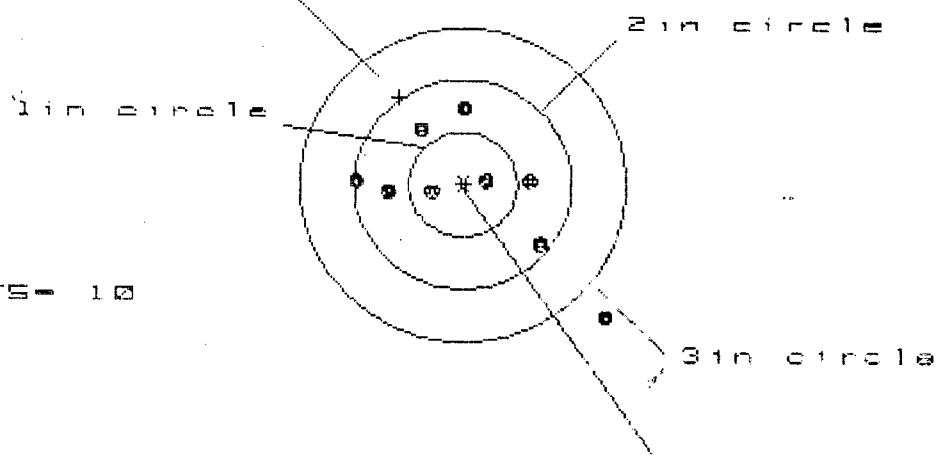
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.192	1.004	.945
MINIMUM X	:	-1.692	-1.114	-1.173
MAXIMUM Y	:	1.627	1.636	1.545
MINIMUM Y	:	-.997	-.989	-.784
CENTROID X	:	.167	.355	.414
CENTROID Y	:	.241	.233	.028
POA TO CENTROID in.	:	.294	.425	.415
MIN RADIUS	:	.315	.266	.107
MEAN RADIUS	:	1.110	1.022	.870
MAX. RADIUS	:	1.694	1.703	1.679
HORIZONTAL SPREAD	:	2.884	2.118	2.118
VERTICAL SPREAD	:	2.625	2.625	2.329
EXTREME SPREAD	:	2.902	2.715	2.715
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 5

POA



OF SHOTS - 10

IN CIR

1in = 2

2in = 8

3in = 9

HS = 2.337

VS = 2.052

GS = 2.713

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.333	.825	.718
MINIMUM X	-1.004	-.855	-.642
MAXIMUM Y	.752	.607	.599
MINIMUM Y	-1.300	-.746	-.754
CENTROID X	.588	.439	.541
CENTROID Y	-.834	-.689	-.691
POA TO CENTROID in.	1.020	.917	.871
MIN RADIUS	.228	.253	.261
MEAN RADIUS	.769	.606	.571
MAX RADIUS	1.863	1.117	1.041
HORIZONTAL SPREAD	2.337	1.617	1.369
VERTICAL SPREAD	2.052	1.333	1.351
EXTREME SPREAD	2.713	1.413	1.503
NUMBER IN ONE INCH CIRCLE =	2	2	2
NUMBER IN TWO INCH CIRCLE =	8	8	8
NUMBER IN THREE INCH CIRCLE =	9	9	9