

C6636329

MODEL 760™ N24

Model S&S™

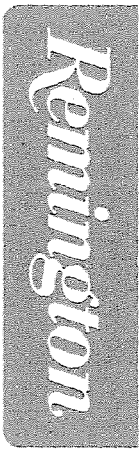
Action

Barrel Length

Capacity

Order No. 5715

*Includes 1 in chamber.





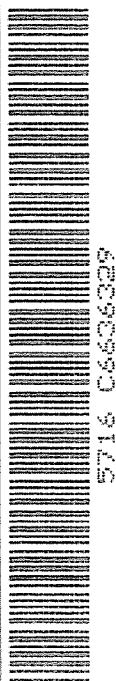

VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700TH H24

SERIAL NO.
C6606329

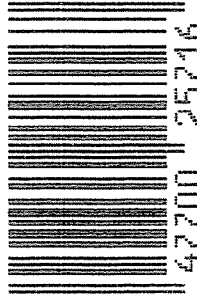
ORDER NO.
5716

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



5716 C6606329

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6636329**

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

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 $\frac{3}{4}$	5 $\frac{3}{4}$	6			8-6-91	DH
	G) Safety Off Force	2 $\frac{1}{2}$	2 $\frac{1}{2}$	2 $\frac{1}{2}$			8-6-91	DH
	H) Trigger Pull Test & Retainability						8-6-91	DL
	I) Firing Pin Indent	.022	.021	.020			8-6-91	DH
	J) Assemble Stock						8/9/91	Yd
	K) Assemble Swivel Studs						8-15-91	DH
	L) Attach Front and Rear Sight Assemblies						8/9/91	Yd
	M) Iron Sight Alignment						8/9/91	Yd
	N) Detach Front & Rear Sights & place in numbered container						8/9/91	Yd
	O) Attach Scope to Rifle						8/9/91	Yd
	P) Detach & Attach Scope 20 Times						8/9/91	Yd
640	Gallery Target & Test						8/14/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						8/14/91	KT
655	Final Inspection							
	A) Headspace						8-15-91	DH
	B) Trigger Pull	2.52	2.20	2.15	2.20	2.25	8-15-91	DL
	C) Function						8-15-91	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 C6636329
DATE 8-6-81
TESTER JP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.31	2.44	2.44	2.52	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.33	2.41	2.50	2.20	
PULL #3	2.39	2.51	2.40	2.15	
PULL #4	2.31	2.30	2.44	2.20	
PULL #5	2.29	2.43	2.43	2.25	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.43	3.37		
PULL #2	3.25	3.44		
PULL #3	3.20	3.50		
PULL #4	3.31	3.20		
PULL #5	3.39	3.38		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.63	4.51		4.34
PULL #2	4.50	4.54		4.42
PULL #3	4.45	4.33		4.35
PULL #4	4.50	4.43		4.20
PULL #5	4.44	4.42		4.52
TOTAL				
AVG.				

TABLE CALCULATIONS

06636239

TIDAL DISTANCES

1	.14384
2	.0880738
3	.192844
4	.206903
5	.247358

←----POA

DATE FOR THIS RIFLE IS: -.1102

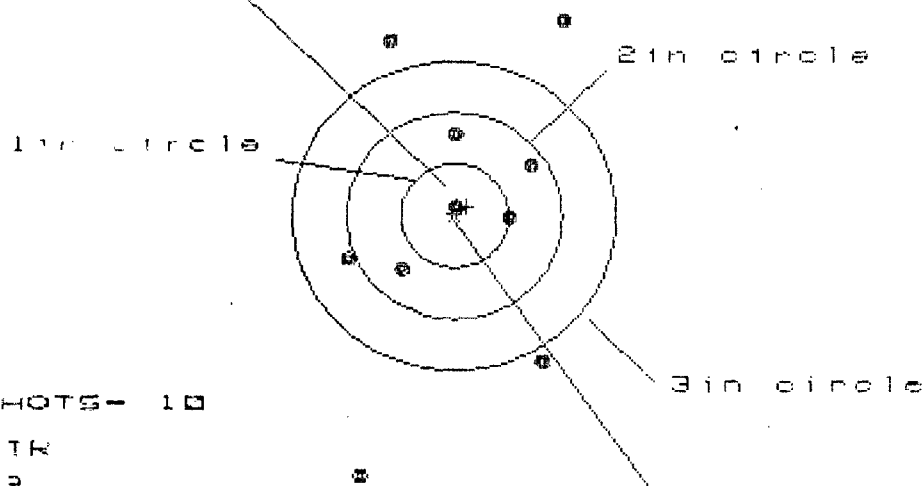
DATE FOR THIS RIFLE IS: .0444

RADIUS FOR THIS RIFLE IS: .118806

RIFLE : .9336

1: PATTERNING/CENTERFIRE_PATT/C6636239.1

CENTERFIRE PATTERNS # 1



SHOTS- 10

1 IN CIR

2

5

6

2.035

4.386

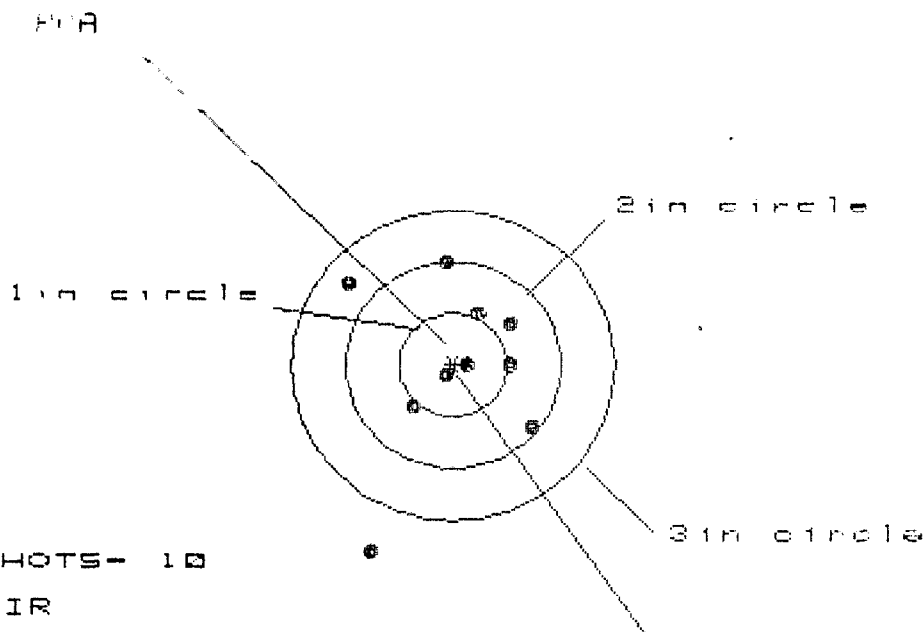
4.795

CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.002	.899	.825
MINIMUM X	-1.032	-1.136	-1.024
MAXIMUM Y	1.853	1.571	1.617
MINIMUM Y	-2.533	-1.722	-1.525
CENTROID X	-.113	-.010	-.122
CENTROID Y	-.089	.193	-.004
POB TO CENTROID in.	.144	.193	.122
MIN RADIUS	.087	.213	.037
MEAN RADIUS	1.226	1.046	.924
MAX RADIUS	2.700	1.863	1.734
HORIZONTAL SPREAD	2.035	2.035	1.849
VERTICAL SPREAD	4.386	3.293	3.142
EXTREME SPREAD	4.795	3.438	3.438
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	5	
NUMBER IN THREE INCH CIRCLE	=	6	

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS= 1.661

VS= 2.852

GS= 2.955

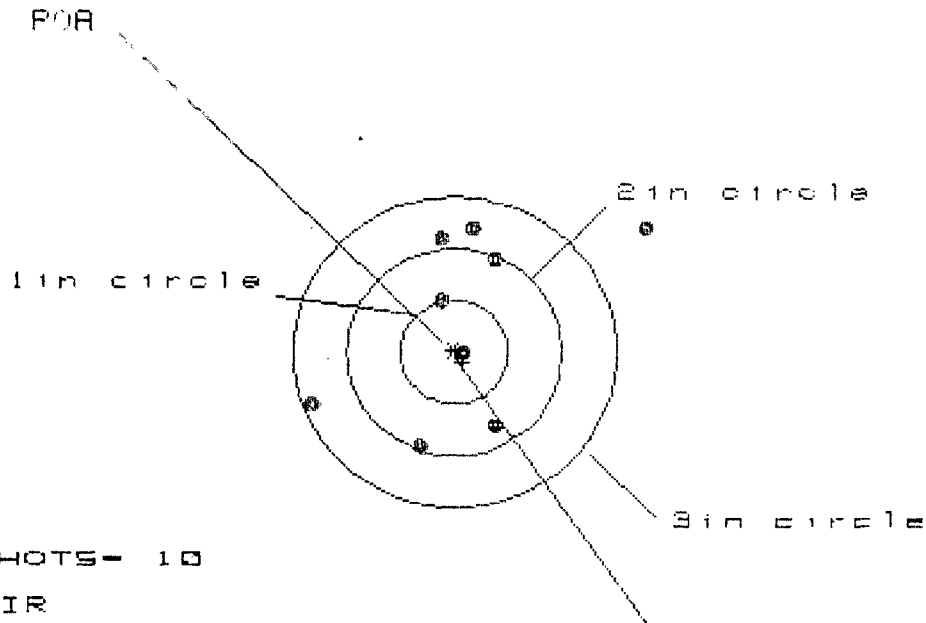
CENTROID #

PATTERN #	:	02		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.725	.636	.588
MINIMUM X	:	-.936	-1.025	-.588
MAXIMUM Y	:	1.036	.834	.915
MINIMUM Y	:	-1.816	-.807	-.726
CENTROID X	:	-.132	-.043	.085
CENTROID Y	:	-.003	.199	.118
POA TO CENTROID in.	:	.132	.204	.145
MIN RADIUS	:	.119	.207	.121
MEAN RADIUS	:	.786	.635	.537
MAX RADIUS	:	1.983	1.213	.946
HORIZONTAL SPREAD	:	1.661	1.661	1.096
VERTICAL SPREAD	:	2.852	1.641	1.641
EXTREME SPREAD	:	2.955	2.209	1.803
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

Aug 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 3.124

VS= 3.997

GS= 4.791

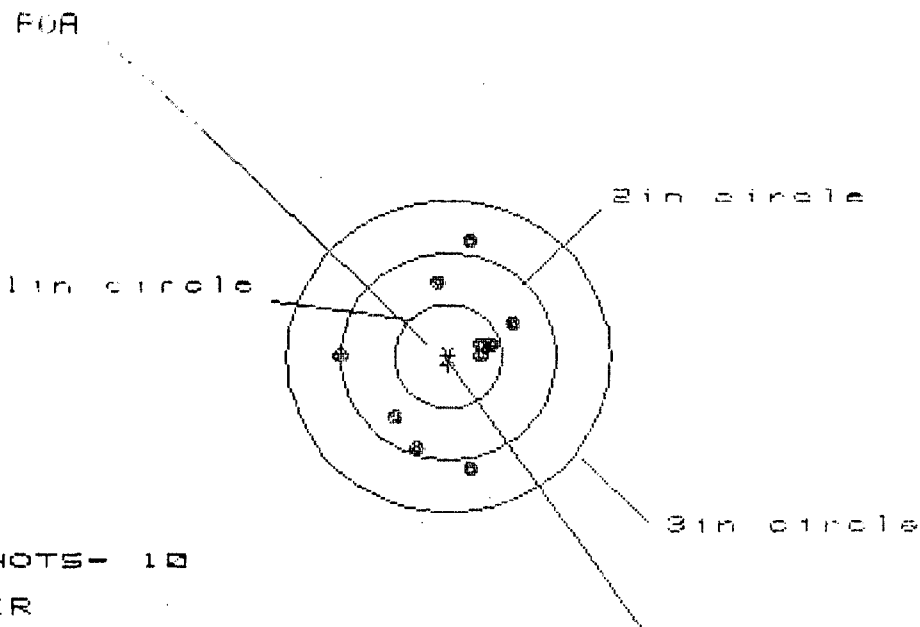
CENTROID #

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.790	1.696	.501
MINIMUM X	:	-1.334	-1.428	-1.216
MAXIMUM Y	:	1.245	.940	.972
MINIMUM Y	:	-2.752	-1.203	-1.086
CENTROID X	:	-.080	.014	-.197
CENTROID Y	:	.101	.406	.289
POA TO CENTROID in.	:	.129	.407	.350
MIN RADIUS	:	.086	.283	.268
MEAN RADIUS	:	1.203	.983	.856
MAX RADIUS	:	2.881	1.938	1.387
HORIZONTAL SPREAD	:	3.124	3.124	1.718
VERTICAL SPREAD	:	3.997	2.143	2.058
EXTREME SPREAD	:	4.791	3.568	2.233
NUMBER IN ONE INCH CIRCLE	=	2		
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 = 3

2in = 8

3in = 10

HS= 1.597

VS= 2.122

GS= 2.122

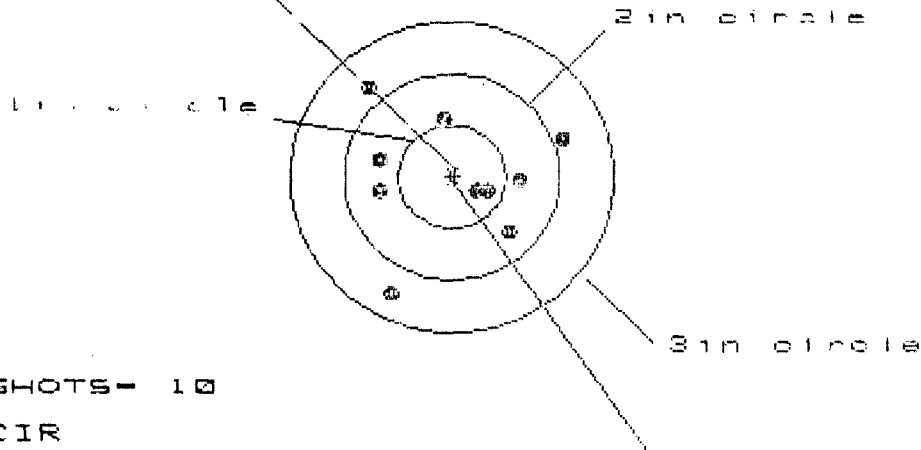
CENTROID #

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.609	.626	.653
MINIMUM X	:	-.988	-.971	-.944
MAXIMUM Y	:	1.089	.871	.757
MINIMUM Y	:	-1.033	-.912	-.880
CENTROID X	:	.002	-.015	-.042
CENTROID Y	:	.083	-.038	.075
POA TO CENTROID in.	:	.083	.041	.086
MIN RADIUS	:	.279	.316	.323
MEAN RADIUS	:	.736	.700	.660
MAX RADIUS	:	1.100	.982	.945
HORIZONTAL SPREAD	:	1.597	1.597	1.597
VERTICAL SPREAD	:	2.122	1.783	1.637
EXTREME SPREAD	:	2.122	1.807	1.652
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3

FOR



OF SHOTS- 10
IN CIR
1 in = 2
2 in = 7
3 in = 10
HS= 1.843
VS= 2.090
GS= 2.222

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.060	.999	.893
MINIMUM X	-.783	-.844	-.854
MAXIMUM Y	.014	.784	.506
MINIMUM Y	-1.176	-.659	-.561
CENTROID X	-.228	-.167	-.061
CENTROID Y	.130	.260	.163
POA TO CENTROID in.	.262	.309	.174
MIN RADIUS	.206	.256	.129
MEAN RADIUS	.742	.673	.578
MAX RADIUS	1.297	1.152	.952
HORIZONTAL SPREAD	1.843	1.843	1.747
VERTICAL SPREAD	2.090	1.443	1.067
EXTREME SPREAD	2.222	1.934	1.811
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	7	
NUMBER IN THREE INCH CIRCLE	=	10	