

C6636343

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.

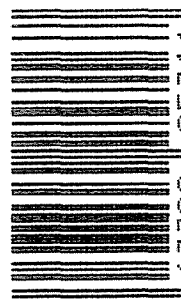
MODEL 700TM H24

SERIAL NO.
C6636343

ORDER NO.
5716

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

LPC



0 47700 25716 7



5716 C6636343

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636343

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 30	91	RW
600	Proof	4 30	91	RW
607	Check Headspace	4 30	91	RW
610	Dis-assemble Gun	4 30	91	RW
612	Magnaflux Barrel Action	5 6	91	RW
	Magnaflux Bolt	5 6	91	RW
615	Rollmark Caliber	5 6	91	RW
617	Drill and Tap Sight Holes	5 10	91	RW
618	Polish Barrel	5 10	91	RW
620	Apply Coatings (Barrel Action)		5-30-91	RW
	Apply Coating (Bolt)		5-30-91	RW
625	Final Assembly A) Clean inside of Bolt Assembly		5/30/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/91	RW
	C) Inspect Ejector Hole for Chamfer		5/30/91	RW
	D) Oil Firing Pin Ass'y		5/30/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		6-10-91	RW

op. #	OP. NAME	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	5 1/2	5 1/2	5 1/2	6/10/91	WLB		
	G) Safety Off Force	3 1/2	3 1/2	3 1/2	6/10/91	WLB		
	H) Trigger Pull Test & Retainability				6-10-91	JU		
	I) Firing Pin Indent	.022	.0225	.022	6/10/91	WLB		
	J) Assemble Stock				6/10/91	RW		
	K) Assemble Swivel Studs				6-13-91	K		
	L) Attach Front and Rear Sight Assemblies				6/10/91	RW		
	M) Iron Sight Alignment				6/10/91	RW		
	N) Detach Front & Rear Sights & place in numbered container				6/10/91	RW		
	O) Attach Scope to Rifle				6/10/91	RW		
	P) Detach & Attach Scope 20 Times				6/10/91	RW		
640	Gallery Target & Test				6-11-91	DH		
	A) Time				6-11-91	DH		
	B) Malfunctions				6-11-91	DH		
	C) Pierced Primers				6-11-91	DH		
	D) Optical Clarity of Scope				6-11-91	DH		
645	Inspect for Live Ammo				6-11-91	DH		
655	Final Inspection							
	A) Headspace				6-13-91	K		
	B) Trigger Pull	2.15	2.17	2.25	2.33	2.48	6-12-91	JU
	C) Function						6-13-91	K
660	Pack						6-20-91	NF

SWS TRIGGER PULL TEST

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

SERIAL NO. C 6636343

DATE 6-10-91

TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.54	2.49	2.59	2.15	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.37	2.64	2.65	2.17	
PULL #3	2.53	2.76	2.60	2.25	
PULL #4	2.53	2.76	2.63	2.33	
PULL #5	2.70	2.63	2.68	2.48	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.43	3.41		
PULL #2	3.18	3.14		
PULL #3	3.30	3.31		
PULL #4	3.25	3.33		
PULL #5	3.22	3.28		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.51	4.26		4.28
PULL #2	4.35	4.74		4.19
PULL #3	4.38	4.67		4.35
PULL #4	4.41	4.78		4.92
PULL #5	4.44	4.28		4.68
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS

FOR RIFLE # C6636343

11 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.240033
1 TO	2	.259656
1 TO	3	.143126
1 TO	4	.255196
1 TO	5	.0901388

4 <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1468
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0916
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .173034

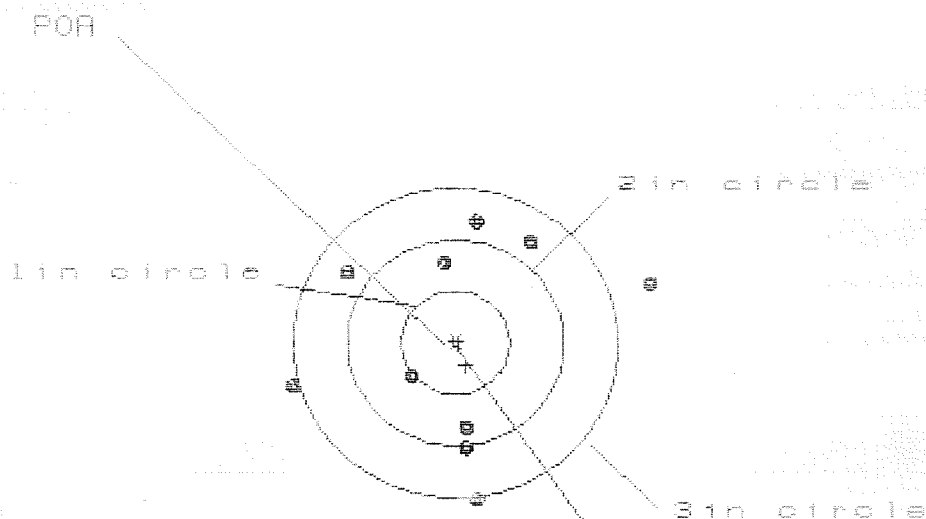
THE AMR FOR THIS RIFLE IS: .9552

(1 Jun 1991)

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CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1in = 0

2in = 3

3in = 7

HS= 3.335

VS= 2.701

GS= 3.483

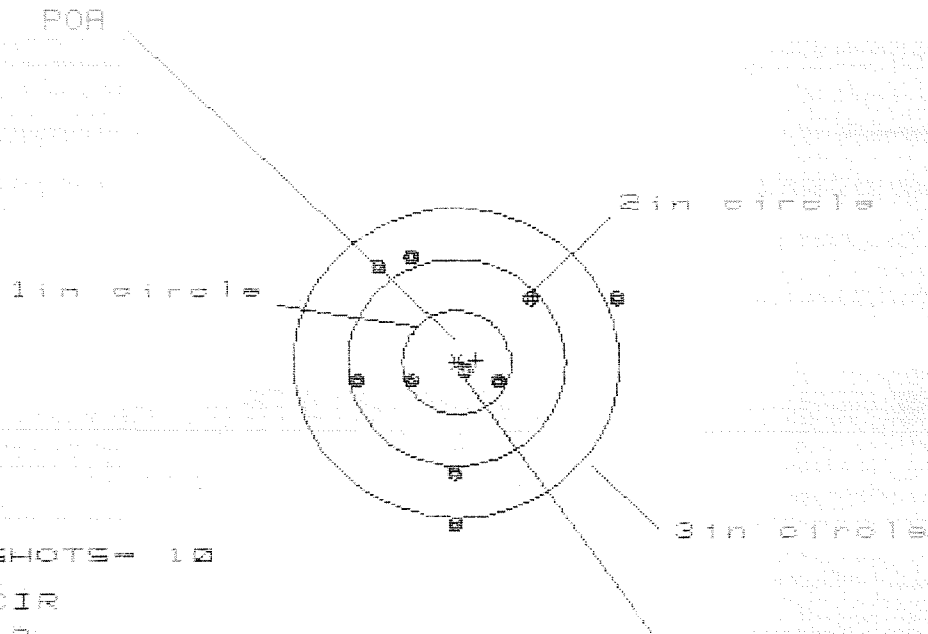
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.794	.933	.766
MINIMUM X	-1.541	-1.342	-.986
MAXIMUM Y	1.185	1.246	1.197
MINIMUM Y	-1.516	-1.455	-1.504
CENTROID X	-.096	-.295	-.128
CENTROID Y	.220	.159	.208
POA TO CENTROID in.	.240	.336	.244
MIN RADIUS	.501	.305	.468
MEAN RADIUS	1.173	1.067	1.027
MAX RADIUS	1.877	1.513	1.525
HORIZONTAL SPREAD	3.335	2.275	1.752
VERTICAL SPREAD	2.701	2.701	2.701
EXTREME SPREAD	3.483	2.701	2.701
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	7		

11 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8685343.1

CENTERFIRE PATTERNS

2



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 5

3 in = 8

HS= 2.483

VS= 2.610

GS= 2.706

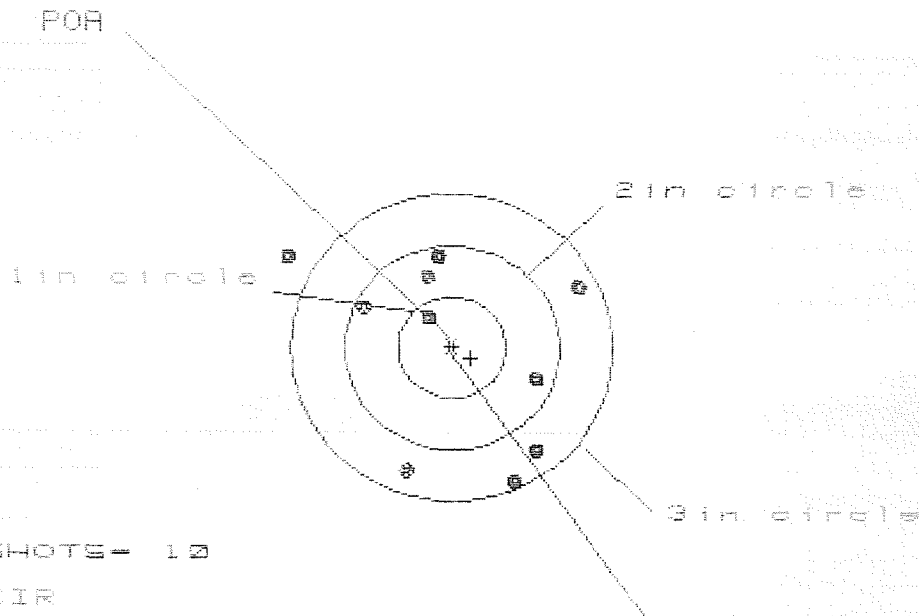
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.526	.815	.830
MINIMUM X	:	-.957	-.788	-.773
MAXIMUM Y	:	1.053	1.125	.939
MINIMUM Y	:	-1.557	-1.485	-1.237
CENTROID X	:	-.182	-.351	-.366
CENTROID Y	:	-.025	-.097	.089
POA TO CENTROID in.	:	.183	.364	.377
MIN RADIUS	:	.166	.285	.368
MEAN RADIUS	:	.964	.878	.802
MAX RADIUS	:	1.656	1.490	1.244
HORIZONTAL SPREAD	:	2.483	1.603	1.603
VERTICAL SPREAD	:	2.610	2.610	2.175
EXTREME SPREAD	:	2.706	2.641	2.213
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

[1 Jun 1991]

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CENTERFIRE PATTERNS

3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS= 2.665

VS= 2.211

GS= 2.961

CENTROID *

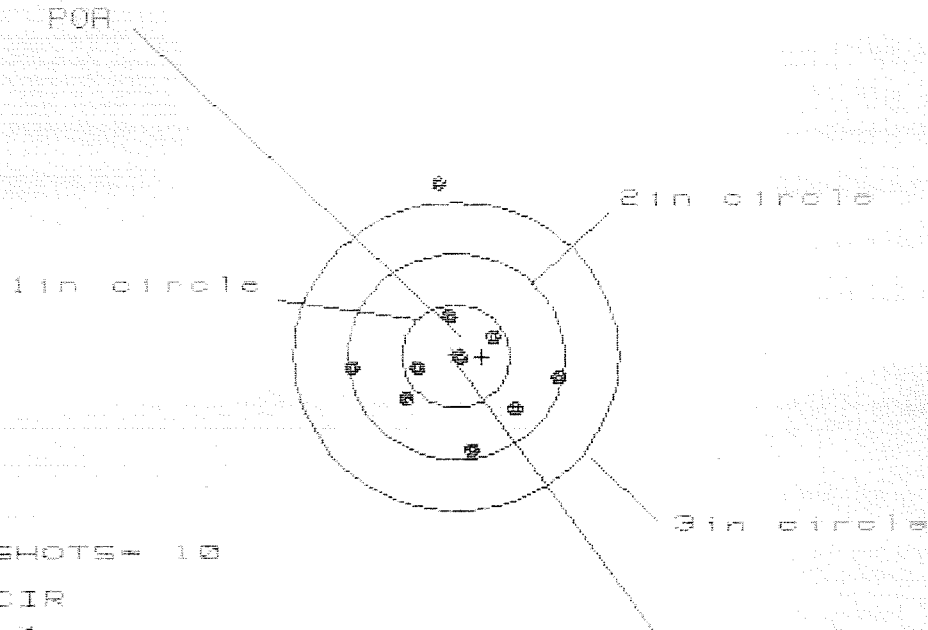
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.188	1.023	1.071
MINIMUM X	:	-1.477	-.954	-.906
MAXIMUM Y	:	.942	1.041	.895
MINIMUM Y	:	-1.269	-1.170	-1.248
CENTROID X	:	-.177	-.012	-.060
CENTROID Y	:	.102	.003	.149
POR TO CENTROID in.	:	.204	.013	.161
MIN RADIUS	:	.329	.515	.387
MEAN RADIUS	:	1.058	.988	.930
MAX RADIUS	:	1.727	1.260	1.370
HORIZONTAL SPREAD	:	2.665	1.977	1.977
VERTICAL SPREAD	:	2.211	2.211	2.143
EXTREME SPREAD	:	2.961	2.421	2.421
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

11 Jun 1991

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CENTERFIRE PATTERNS

4



OF SHOTS= 10

IN CIR

1in = 4

2in = 9

3in = 9

HS= 1.838

VS= 2.607

GS= 2.615

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.928	.915	.926
MINIMUM X	:	-.910	-.923	-.912
MAXIMUM Y	:	1.657	.590	.494
MINIMUM Y	:	-.950	-.766	-.417
CENTROID X	:	-.241	-.228	-.239
CENTROID Y	:	.010	-.174	-.078
POA TO CENTROID in.	:	.241	.287	.251
MIN RADIUS	:	.028	.177	.085
MEAN RADIUS	:	.711	.609	.568
MAX RADIUS	:	1.660	.924	.931
HORIZONTAL SPREAD	:	1.838	1.838	1.838
VERTICAL SPREAD	:	2.607	1.356	.911
EXTREME SPREAD	:	2.615	1.839	1.839
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		9	

(1 JUN 1991)

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in - 4

2in - 6

3in - 9

HS= 2.935

VS= 1.494

GS= 2.941

CENTROID #

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.629	1.288	1.147
MINIMUM X	-1.306	-1.125	-.962
MAXIMUM Y	.670	.724	.634
MINIMUM Y	-.824	-.770	-.679
CENTROID X	-.838	-.219	-.078
CENTROID Y	.151	.097	.086
POA TO CENTROID in.	.155	.239	.078
MIN RADIUS	.371	.359	.447
MEAN RADIUS	.870	.774	.699
MAX RADIUS	1.700	1.342	1.182
HORIZONTAL SPREAD	2.935	2.413	2.109
VERTICAL SPREAD	1.494	1.494	1.313
EXTREME SPREAD	2.941	2.652	2.145
NUMBER IN ONE INCH CIRCLE	=	4	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	9	