

C6648923

MODEL 700™ M24

Model S&S™

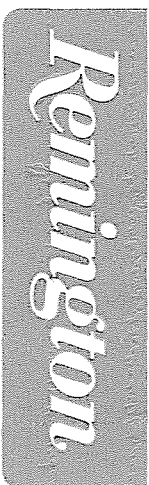
Action _____

Barrel Length _____

Capacity _____

Order No. 5715

*Includes 1 in chamber.






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

MODEL 700TM M24

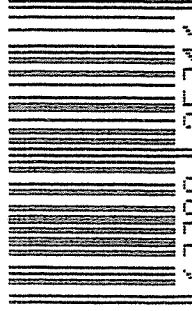
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off. Marca Registrada Marque Deposee.

SERIAL NO.
C6648923

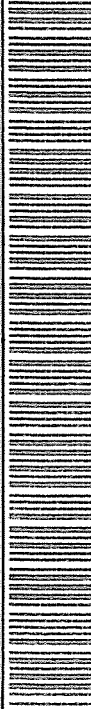
ORDER NO.
5716

20

UPC



0 47700 25716 2



5716 C6648923

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6648923

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	7 2 9 1		RW
610	Dis-assemble Gun	7 2 9 1		RW
612	Magnaflux Barrel Action		JUL 22 1991	28
	Magnaflux Bolt		JUL 22 1991	28
615	Rollmark Caliber		JUL 22 1991	FB
617	Drill and Tap Sight Holes		JUL 22 1991	WB
618	Polish Barrel		7/22/91	WB
620	Apply Coatings (Barrel Action)		8-2-91	WB
	Apply Coating (Bolt)			WB
625	Final Assembly A) Clean inside of Bolt Assembly		8/9/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/9/91	RW
	C) Inspect Ejector Hole for Chamfer		8/9/91	RW
	D) Oil Firing Pin Ass'y		8/9/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8-19-91	JH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8-19-91	JY
	G) Safety Off Force	3	3	3			8-19-91	JY
	H) Trigger Pull Test & Retainability						8-19-91	JY
	I) Firing Pin Indent	.023	.023	.022			8-19-91	JY
	J) Assemble Stock						8/20/91	RW
	K) Assemble Swivel Studs						8-22-91	D/H
	L) Attach Front and Rear Sight Assemblies						8/20/91	RW
	M) Iron Sight Alignment						8/20/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/20/91	RW
	O) Attach Scope to Rifle						8/20/91	RW
	P) Detach & Attach Scope 20 Times						8/20/91	RW
640	Gallery Target & Test						8-21-91	AC
	A) Time						8-21-91	AC
	B) Malfunctions						8-21-91	AC
	C) Pierced Primers						8-21-91	AC
	D) Optical Clarity of Scope						8-21-91	AC
645	Inspect for Live Ammo						8-21-91	AC
655	Final Inspection A) Headspace						8-22-91	D/H
	B) Trigger Pull	220	223	224	225	230	8-21-91	D/H
	C) Function						8-22-91	D/H
660	Pack						9-18-91	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-6648923

DATE 8-19-91

TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.57	2.66	2.55	2.20	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.58	2.63	2.60	2.23	
PULL #3	2.65	2.62	2.65	2.24	
PULL #4	2.67	2.70	2.53	2.25	
PULL #5	2.61	2.67	2.44	2.30	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.40	3.24		
PULL #2	3.29	3.25		
PULL #3	3.52	3.37		
PULL #4	3.27	3.21		
PULL #5	3.24	3.36		
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	4.55		4.58
PULL #2	4.42	4.59		4.58
PULL #3	4.25	4.53		4.49
PULL #4	4.51	4.54		4.50
PULL #5	4.56	4.44		4.54
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6648923
22 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.0537587
1 TO	2	.228215
1 TO	3	.317824
1 TO	4	.16456
1 TO	5	.26414

$\frac{5}{27}$

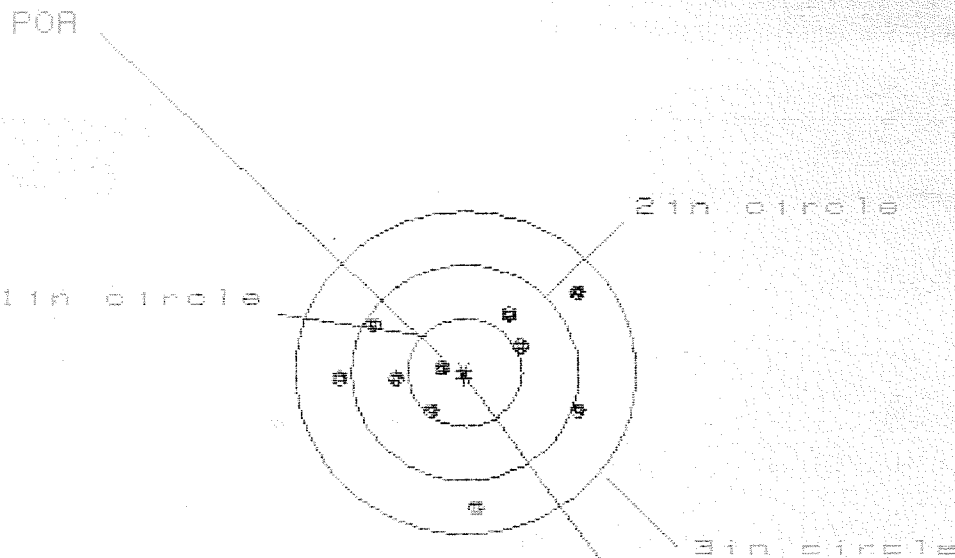
(---POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1342
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0742
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .153347
THE AMP FOR THIS RIFLE IS: .868

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C864B923

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 10

HS= 2.128

VS= 2.069

GS= 2.289

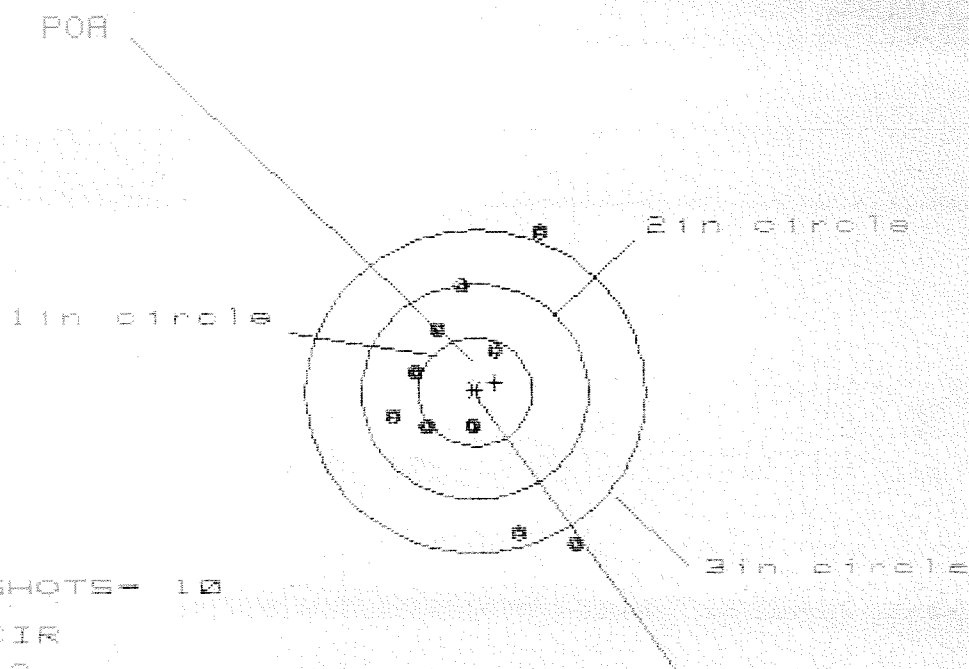
PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.031	1.104	1.129
MINIMUM X	:	-1.097	-.983	-.959
MAXIMUM Y	:	.790	.665	.516
MINIMUM Y	:	-1.279	-1.191	-.405
CENTROID X	:	.009	-.105	-.130
CENTROID Y	:	.053	-.035	.114
POA TO CENTROID in.	:	.054	.111	.172
MIN RADIUS	:	.235	.176	.094
MEAN RADIUS	:	.822	.748	.671
MAX RADIUS	:	1.299	1.207	1.199
HORIZONTAL SPREAD	:	2.128	2.087	2.087
VERTICAL SPREAD	:	2.069	1.856	.921
EXTREME SPREAD	:	2.289	2.107	2.107
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	10		

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CENTERFIRE PATTERNS

2



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 1.571

VS= 2.864

GS= 2.878

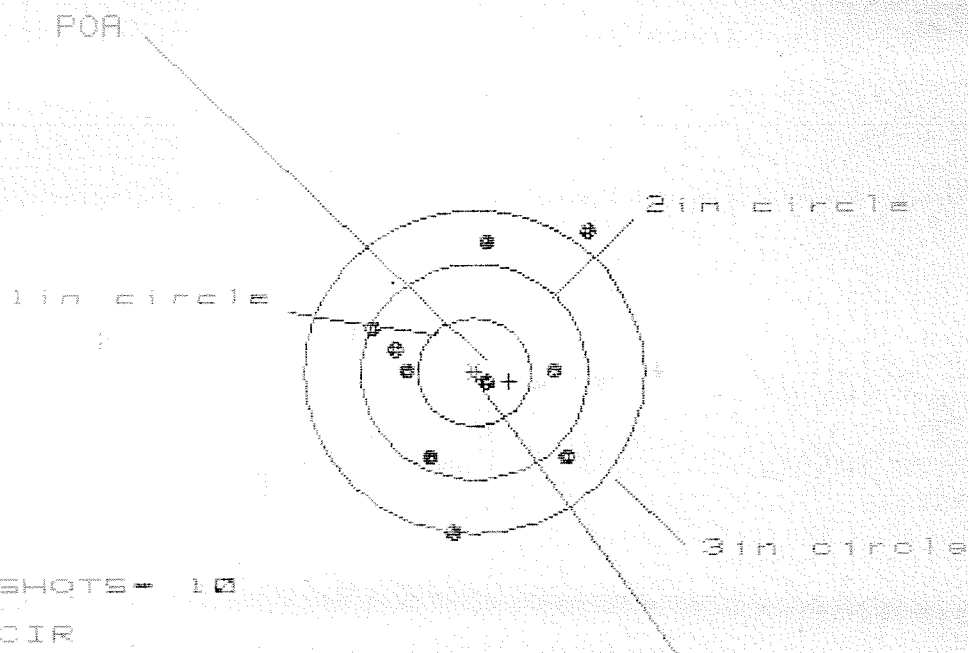
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.902	.715	.574
MINIMUM X	:	-.769	-.669	-.579
MAXIMUM Y	:	1.443	1.285	1.016
MINIMUM Y	:	-1.421	-1.495	-1.334
CENTROID X	:	-.172	-.272	-.362
CENTROID Y	:	-.086	.072	-.089
POA TO CENTROID in.	:	.192	.282	.372
MIN RADIUS	:	.284	.361	.346
MEAN RADIUS	:	.892	.775	.670
MAX RADIUS	:	1.683	1.571	1.452
HORIZONTAL SPREAD	:	1.671	1.384	1.153
VERTICAL SPREAD	:	2.864	2.780	2.350
EXTREME SPREAD	:	2.878	2.790	2.404
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 1

2in = 6

3in = 8

HS= 1.915

VS= 2.800

GS= 3.038

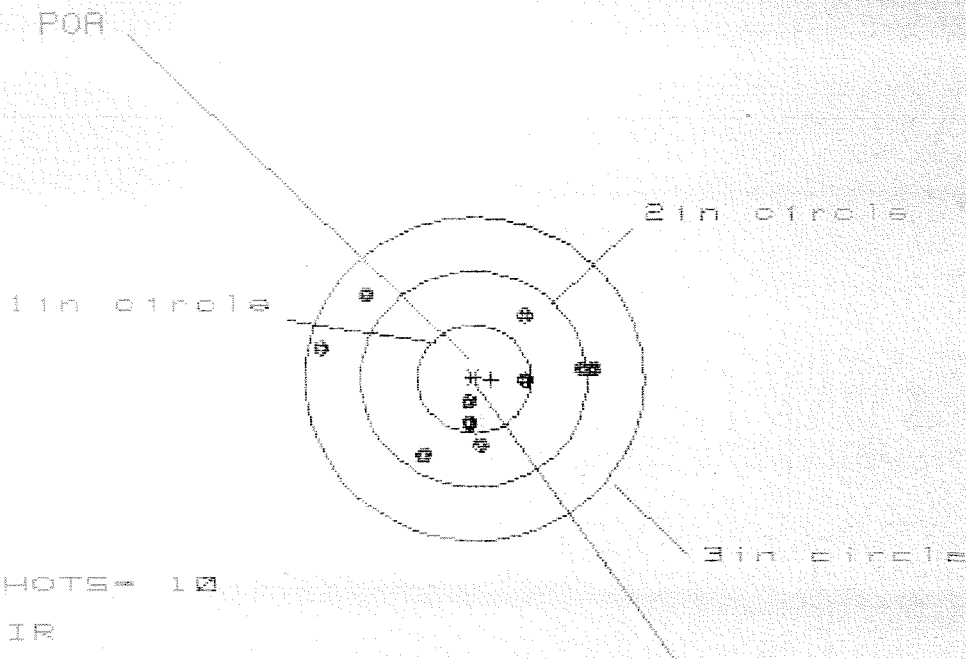
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.017	.902	.895
MINIMUM X	:	-.898	-.785	-.792
MAXIMUM Y	:	1.273	1.374	1.201
MINIMUM Y	:	-1.527	-1.386	-.855
CENTROID X	:	-.307	-.420	-.414
CENTROID Y	:	.087	-.054	.119
POA TO CENTROID in.	:	.319	.423	.430
MIN RADIUS	:	.091	.219	.202
MEAN RADIUS	:	.945	.860	.781
MAX RADIUS	:	1.629	1.392	1.226
HORIZONTAL SPREAD	:	1.915	1.687	1.687
VERTICAL SPREAD	:	2.800	2.760	2.056
EXTREME SPREAD	:	3.038	2.773	2.149
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

22 Aug 1991

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CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

HS= 2.422

VS= 1.497

GS= 2.427

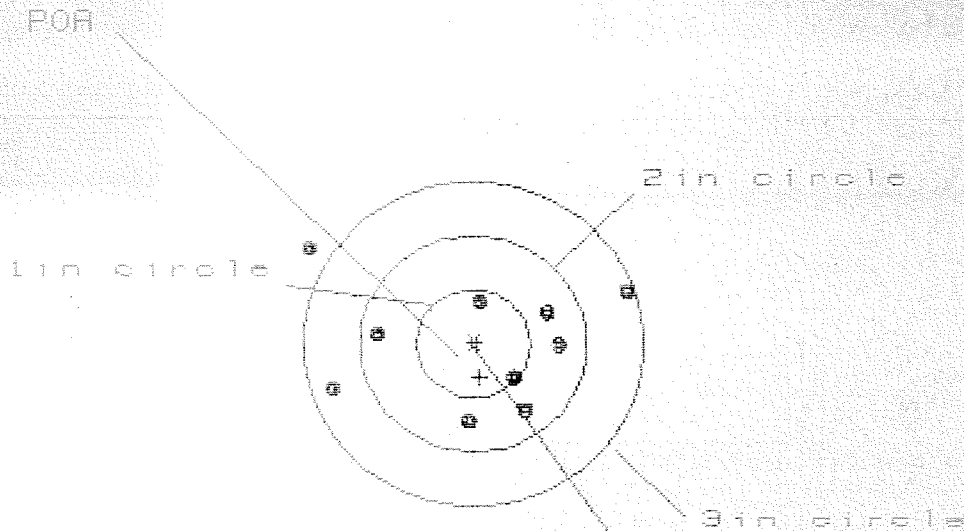
CENTROID *.

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.026	.871	.737
MINIMUM X	-1.396	-1.072	-.736
MAXIMUM Y	.834	.862	.717
MINIMUM Y	-.663	-.635	-.527
CENTROID X	-.149	.006	.140
CENTROID Y	.007	-.021	-.129
POA TO CENTROID in.	.149	.022	.190
MIN RADIUS	.195	.256	.205
MEAN RADIUS	.786	.691	.588
MAX RADIUS	1.419	1.376	.985
HORIZONTAL SPREAD	2.422	1.943	1.473
VERTICAL SPREAD	1.497	1.497	1.244
EXTREME SPREAD	2.427	2.075	1.662
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

22 Aug 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 9

CENTROID #

HS= 2.733

VS= 1.569

GS= 2.758

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.307	1.149	.699
MINIMUM X	-1.426	-1.394	-1.250
MAXIMUM Y	.888	.618	.518
MINIMUM Y	-.681	-.582	-.505
CENTROID X	-.052	.106	-.038
CENTROID Y	.310	.211	.134
POA TO CENTROID in.	.314	.237	.139
MIN RADIUS	.345	.294	.364
MEAN RADIUS	.895	.767	.711
MAX RADIUS	1.679	1.435	1.278
HORIZONTAL SPREAD	2.733	2.543	1.949
VERTICAL SPREAD	1.569	1.200	1.023
EXTREME SPREAD	2.758	2.717	2.036
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		