

C6611794

MODEL 700TM N24

Model **SAS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.






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

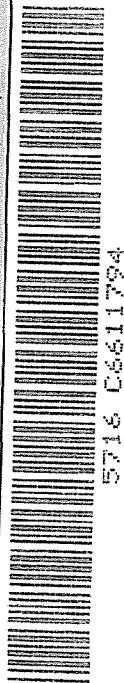
REG. U.S. PAT. & TM. OFF.

MODEL 700™ M24

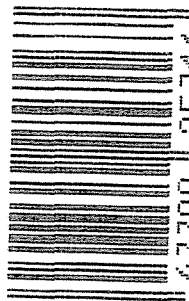
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

SERIAL NO.
C6611794

ORDER NO.
5716



LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611794

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		1/24/91	KS
600	Proof		1/24/91	KS
607	Check Headspace		1/24/91	KS
610	Dis-assemble Gun		1/24/91	KS
612	Magnaflux Barrel Action		1/29/91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	GS
617	Drill and Tap Sight Holes	2 2	91	FB
618	Polish Barrel <i>RBB</i>	2 2	91	WB
620	Apply Coatings (Barrel Action)		2-11-91	<i>HA</i>
	Apply Coating (Bolt)			<i>K</i>
625	Final Assembly A) Clean inside of Bolt Assembly		2/28/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/28/91	KS
	C) Inspect Ejector Hole for Chamfer		2/28/91	KS
	D) Oil Firing Pin Ass'y		2/28/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		2/27/91	DH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			3/1/91	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			3/1/91	WB
	H) Trigger Pull Test & Retainability						2/27/91	DH
	I) Firing Pin Indent	.022	.022	.022			3/1/91	WB
	J) Assemble Stock						3/5/91	Ad
	K) Assemble Swivel Studs						3-11-91	DH
	L) Attach Front and Rear Sight Assemblies						3/5/91	Ad
	M) Iron Sight Alignment						3/5/91	Ad
	N) Detach Front & Rear Sights & place in numbered container						3/5/91	Ad
	O) Attach Scope to Rifle						3/5/91	Ad
	P) Detach & Attach Scope 20 Times						3/5/91	Ad
640	Gallery Target & Test						3-6-91	AC
	A) Time						3-6-91	AC
	B) Malfunctions						3-6-91	AC
	C) Pierced Primers						3-6-91	AC
	D) Optical Clarity of Scope						3-6-91	AC
645	Inspect for Live Ammo						3-6-91	AC
655	Final Inspection							
	A) Headspace						3-11-91	DH
	B) Trigger Pull	2.43	2.20	2.26	2.30	2.30	3/9/91	Ad
	C) Function						3-11-91	DH
660	Pack						3-18-91	Ad

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 794 C6611

DATE 2-27-91

TESTER D/H

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.52	2.68	2.51	2.43	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.52	2.50	2.51	2.20	
PULL #3	2.49	2.66	2.51	2.26	
PULL #4	2.48	2.70	2.45	2.30	
PULL #5	2.54	2.75	2.53	2.30	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.34	3.54		
PULL #2	3.21	3.53		
PULL #3	3.19	3.61		
PULL #4	3.39	3.42		
PULL #5	3.45	3.61		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.24	4.56		4.04
PULL #2	4.40	4.52		4.21
PULL #3	4.26	4.63		4.20
PULL #4	4.44	4.53		4.23
PULL #5	3.95	4.51		4.17
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611794
6 Mar 1991

CENTROIDAL DISTANCES

0 TO 1	.402782
1 TO 2	.525921
1 TO 3	.546717
1 TO 4	.648093
1 TO 5	.398321

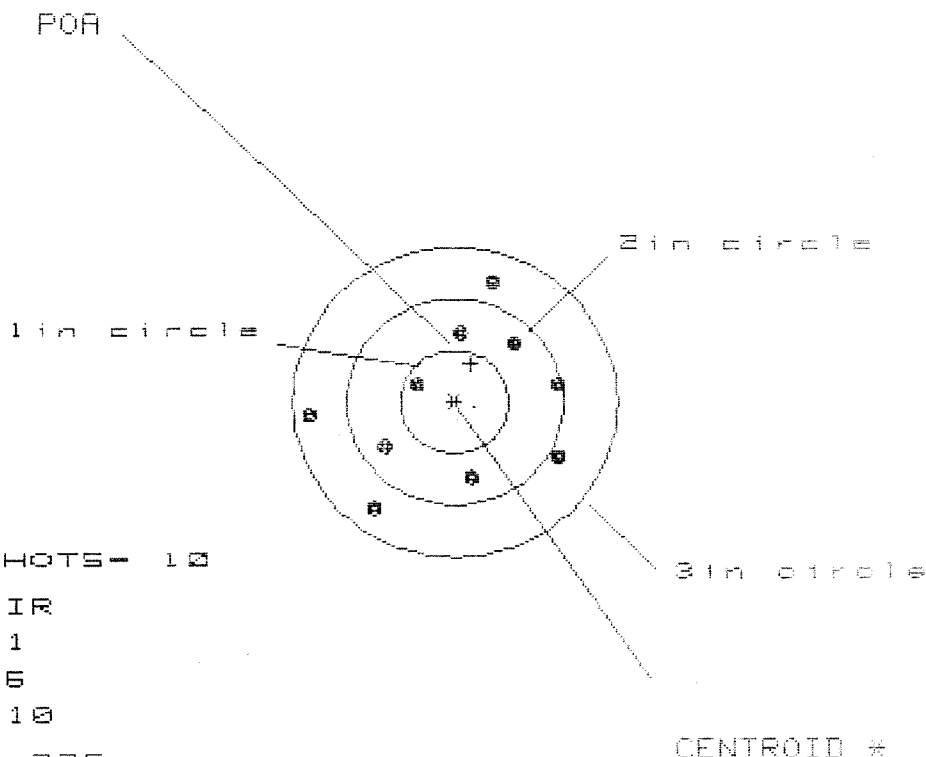
 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0374
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.018
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0415061
THE AMR FOR THIS RIFLE IS: .9998

8 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611794

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 6

3 in = 10

HS= 2.326

VS= 2.158

GS= 2.394

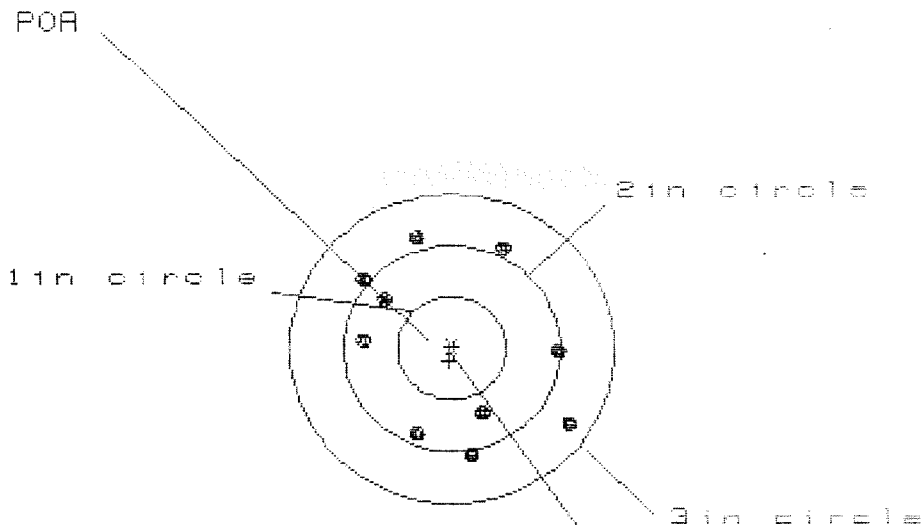
CENTROID *

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.981	.832	.723
MINIMUM X	:	-1.345	-.865	-.903
MAXIMUM Y	:	1.169	1.150	1.024
MINIMUM Y	:	-.989	-1.008	-.848
CENTROID X	:	-.152	-.003	.106
CENTROID Y	:	-.373	-.354	-.228
POA TO CENTROID in.	:	.403	.354	.251
MIN RADIUS	:	.400	.524	.525
MEAN RADIUS	:	.926	.871	.793
MAX RADIUS	:	1.355	1.328	1.063
HORIZONTAL SPREAD	:	2.326	1.697	1.626
VERTICAL SPREAD	:	2.158	2.158	1.872
EXTREME SPREAD	:	2.394	2.394	1.884
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	10		

6 Mar 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in - 0

2 in - 4

3 in - 10

HS - 1.897

VS - 2.047

GS - 2.335

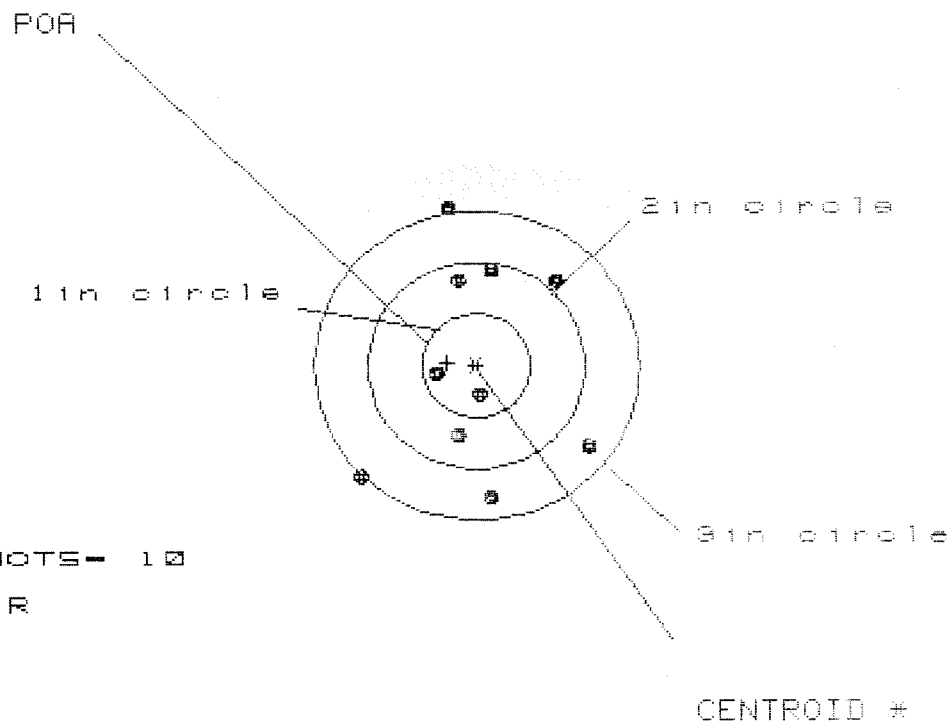
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.037	1.133	1.210
MINIMUM X	:	-0.860	-0.745	-0.668
MAXIMUM Y	:	1.026	.948	1.064
MINIMUM Y	:	-1.021	-1.099	-0.983
CENTROID X	:	.020	-.095	-.172
CENTROID Y	:	.124	.202	.086
POA TO CENTROID in.	:	.126	.223	.193
MIN RADIUS	:	.728	.655	.637
MEAN RADIUS	:	.988	.944	.907
MAX RADIUS	:	1.249	1.136	1.212
HORIZONTAL SPREAD	:	1.897	1.878	1.878
VERTICAL SPREAD	:	2.047	2.047	2.047
EXTREME SPREAD	:	2.335	2.118	2.118
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

6 Mar 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 2.106

VS= 2.785

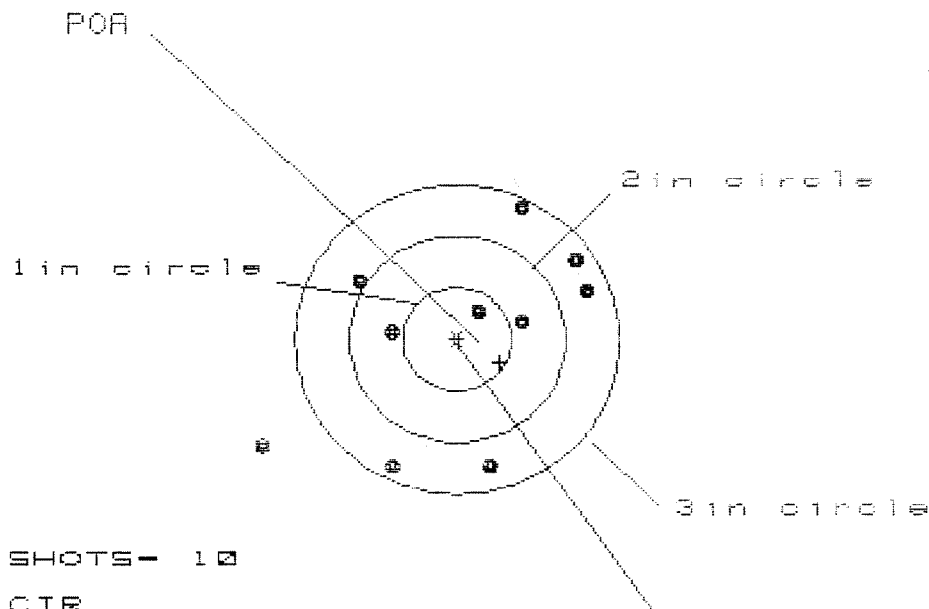
GS= 2.817

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.050	1.018	.882
MINIMUM X	:	-1.056	-1.088	-.537
MAXIMUM Y	:	1.483	1.085	.974
MINIMUM Y	:	-1.302	-1.137	-1.248
CENTROID X	:	.268	.300	.436
CENTROID Y	:	-.023	-.188	-.076
POA TO CENTROID in.	:	.269	.354	.442
MIN RADIUS	:	.248	.082	.238
MEAN RADIUS	:	.987	.906	.862
MAX RADIUS	:	1.510	1.407	1.249
HORIZONTAL SPREAD	:	2.106	2.106	1.419
VERTICAL SPREAD	:	2.785	2.222	2.222
EXTREME SPREAD	:	2.817	2.654	2.254
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

8 Mar 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in - 1

2 in - 3

3 in - 6

HS- 3.001

VS= 2.504

GS= 3.412

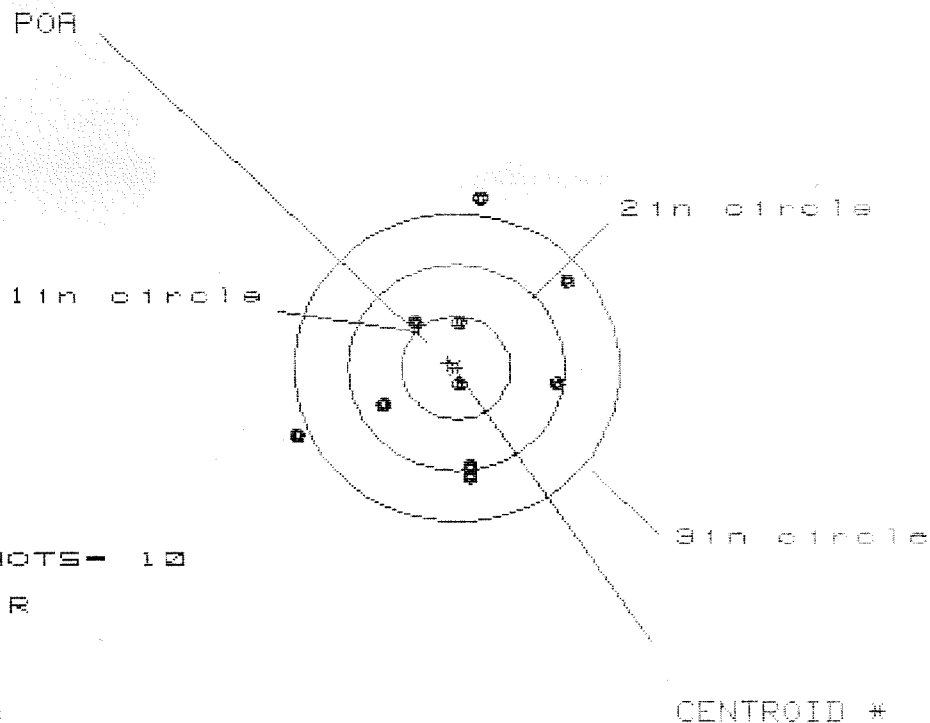
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.185	.983	.883
MINIMUM X	:	-1.816	-1.128	-1.228
MAXIMUM Y	:	1.255	1.138	.967
MINIMUM Y	:	-1.249	-1.366	-1.537
CENTROID X	:	-.397	-.195	-.095
CENTROID Y	:	.227	.344	.515
POA TO CENTROID in.	:	.457	.395	.523
MIN RADIUS	:	.347	.144	.076
MEAN RADIUS	:	1.147	.990	.875
MAX RADIUS	:	2.098	1.582	1.537
HORIZONTAL SPREAD	:	3.001	2.111	2.111
VERTICAL SPREAD	:	2.504	2.504	2.504
EXTREME SPREAD	:	3.412	2.756	2.513
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		9	

5 Mar 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.488

VS= 2.699

GS= 2.926

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.994
MINIMUM X	-1.494
MAXIMUM Y	1.641
MINIMUM Y	-1.058
CENTROID X	.074
CENTROID Y	-.045
POA TO CENTROID in.	.087
MIN RADIUS	.117
MEAN RADIUS	.951
MAX RADIUS	1.663
HORIZONTAL SPREAD	2.488
VERTICAL SPREAD	2.699
EXTREME SPREAD	2.926
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	8