

C6611819

MODEL 700TM M24

Model S&STM

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 H24

SERIAL NO.
C6611819

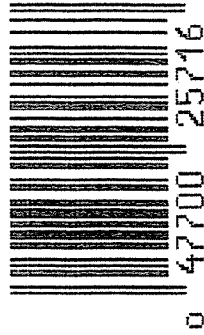
ORDER NO.
5716

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

46



UPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611819

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 28	91	RW
600	Proof	3 28	91	RW
607	Check Headspace	3 28	91	RW
610	Dis-assemble Gun	3 28	91	RW
612	Magnaflux Barrel Action	APR	2 1991	K.R
	Magnaflux Bolt	APR	2 1991	U
615	Rollmark Caliber	APR	2 1991	GL
617	Drill and Tap Sight Holes	APR	5 1991	FB
618	Polish Barrel	APR	5 1991	WB
620	Apply Coatings (Barrel Action)		4-9-91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/10/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/10/91	RW
	C) Inspect Ejector Hole for Chamfer		4/10/91	RW
	D) Oil Firing Pin Ass'y		4/10/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4-16-91	DH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			4-16-91	AC
	G) Safety Off Force	3	4	3			4-16-91	AC
	H) Trigger Pull Test & Retainability						4-16-91	D/H
	I) Firing Pin Indent	.024	.023	.022			4-16-91	AC
	J) Assemble Stock						4/17/91	RW
	K) Assemble Swivel Studs						4-22-91	D/H
	L) Attach Front and Rear Sight Assemblies						4/17/91	RW
	M) Iron Sight Alignment						4/17/91	RW
	N) Detach Front & Rear Sights & place in numbered container						4/17/91	RW
	O) Attach Scope to Rifle						4/17/91	RW
	P) Detach & Attach Scope 20 Times						4/17/91	RW
640	Gallery Target & Test						4/17/91	KJ
	A) Time						"	KJ
	B) Malfunctions						"	KJ
	C) Pierced Primers						"	KJ
	D) Optical Clarity of Scope						"	KJ
645	Inspect for Live Ammo						4/17/91	KJ
655	Final Inspection							
	A) Headspace						4-22-91	D/H
	B) Trigger Pull	2.37	2.40	2.38	2.37	2.43	4/22/91	RW
	C) Function						4-22-91	D/H
660	Pack						6-18-91	D/H

SWS TRIGGER PULL TEST

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

SERIAL NO. CCG11819
DATE 4-16-91
TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.48	2.49	2.37	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.54	2.42	2.74	2.40	
PULL #3	2.38	2.40	2.62	2.38	
PULL #4	2.45	2.38	2.68	2.37	
PULL #5	2.48	2.52	2.71	2.43	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.17	3.05		
PULL #2	3.07	3.18		
PULL #3	3.02	3.08		
PULL #4	3.13	3.00		
PULL #5	3.02	3.06		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4#, FOR TARGET & ACCURACY
PULL #1	4.20	4.55		4.22
PULL #2	4.10	3.91		4.15
PULL #3	4.02	4.46		4.27
PULL #4	4.21	4.48		4.28
PULL #5	4.05	3.83		4.00
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611819
17 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.224617
1 TO	2	.240853
1 TO	3	.104019
1 TO	4	.223806
1 TO	5	.229924

←----POA

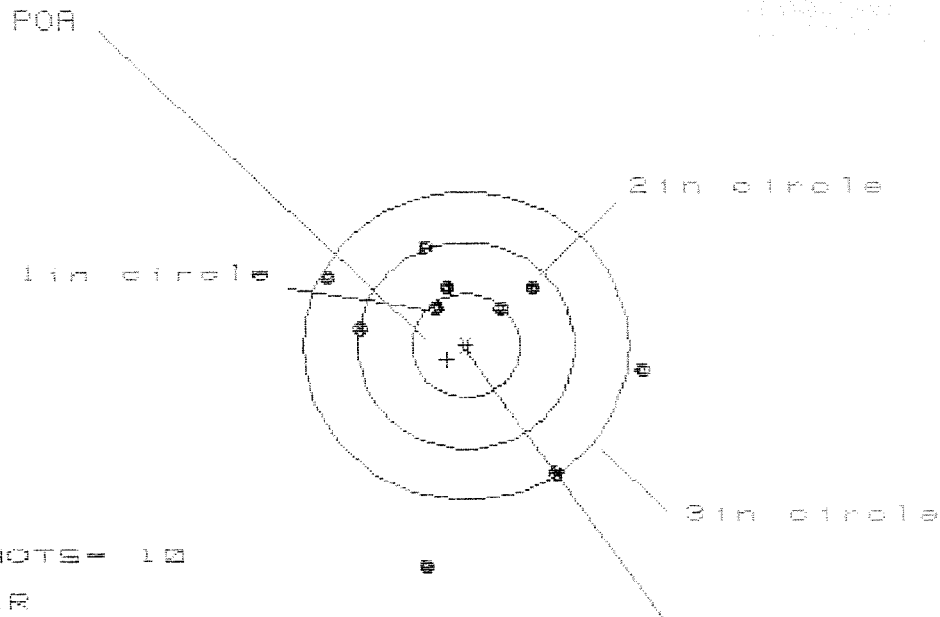
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1494
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1312
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .198831

THE AMR FOR THIS RIFLE IS: .9824

17 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611019

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 8

HS = 2.851

VS = 3.105

GS = 3.106

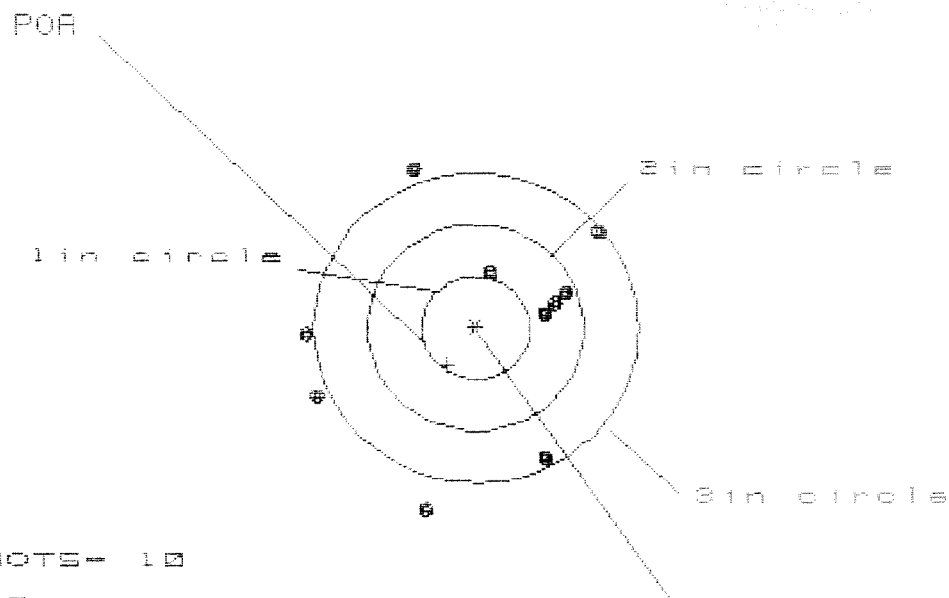
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.584	1.545	.989
MINIMUM X	-1.267	-1.306	-1.113
MAXIMUM Y	.942	.702	.643
MINIMUM Y	-2.163	-1.480	-1.539
CENTROID X	.178	.217	.024
CENTROID Y	.137	.377	.436
POA TO CENTROID in.	.225	.436	.437
MIN RADIUS	.419	.274	.092
MEAN RADIUS	1.107	.907	.774
MAX RADIUS	2.192	1.691	1.829
HORIZONTAL SPREAD	2.851	2.851	2.102
VERTICAL SPREAD	3.105	2.182	2.102
EXTREME SPREAD	3.106	2.999	2.962
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

17 Apr 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 4

3 in = 6

HS= 3.633

VS= 3.278

GS= 3.283

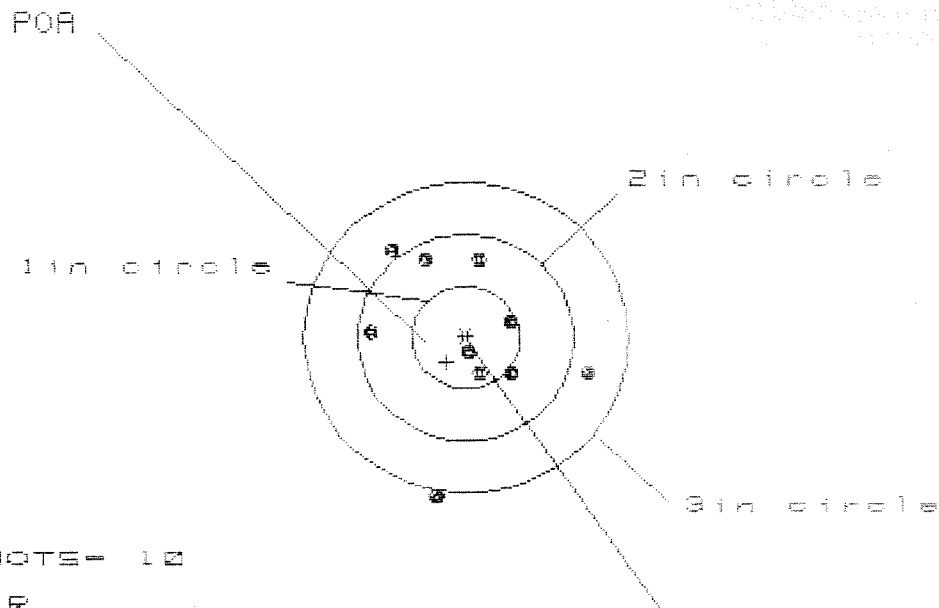
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.101	1.055	.974
MINIMUM X	:	-1.528	-1.574	-1.655
MAXIMUM Y	:	1.551	1.360	.869
MINIMUM Y	:	-1.727	-1.478	-1.308
CENTROID X	:	.269	.315	.396
CENTROID Y	:	.360	.552	.382
POA TO CENTROID in.	:	.450	.636	.551
MIN RADIUS	:	.562	.364	.513
MEAN RADIUS	:	1.234	1.129	1.074
MAX RADIUS	:	1.777	1.774	1.769
HORIZONTAL SPREAD	:	2.629	2.629	2.629
VERTICAL SPREAD	:	3.278	2.838	2.177
EXTREME SPREAD	:	3.283	3.036	3.038
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 1.962

VS= 2.379

GS= 2.418

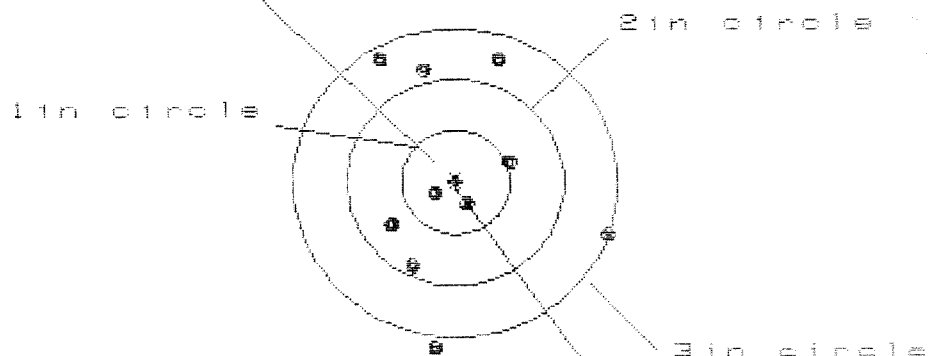
PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.083	1.055	.549
MINIMUM X	-.879	-.907	-.775
MAXIMUM Y	.861	.692	.630
MINIMUM Y	-1.518	-.526	-.588
CENTROID X	.180	.208	.076
CENTROID Y	.241	.410	.472
POA TO CENTROID in.	.301	.459	.478
MIN RADIUS	.125	.295	.371
MEAN RADIUS	.776	.694	.639
MAX RADIUS	1.538	1.168	.858
HORIZONTAL SPREAD	1.962	1.962	1.324
VERTICAL SPREAD	2.379	1.218	1.218
EXTREME SPREAD	2.418	2.125	1.655
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS # 4

POA



OF SHOTS - 10

IN CIR

1in = 2

2in = 5

3in = 8

HS = 2.128

VS = 2.776

GS = 2.849

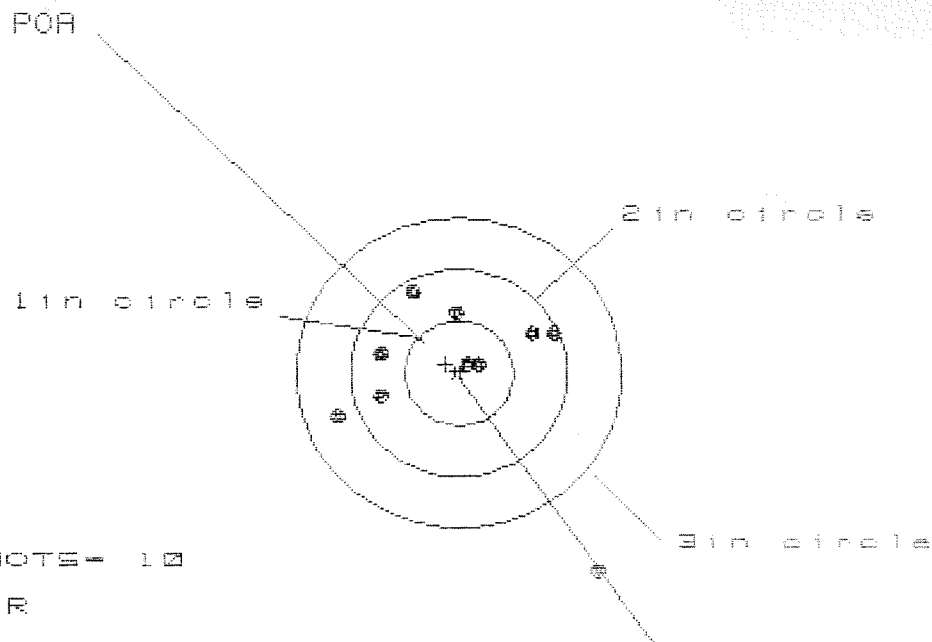
CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.418	1.394	.643
MINIMUM X	-.710	-.734	-.560
MAXIMUM Y	1.221	1.048	.962
MINIMUM Y	-1.555	-.975	-1.061
CENTROID X	-.002	.022	-.152
CENTROID Y	.004	.177	.263
POA TO CENTROID in.	.005	.179	.304
MIN RADIUS	.233	.395	.400
MEAN RADIUS	.950	.895	.813
MAX RADIUS	1.571	1.555	1.121
HORIZONTAL SPREAD	2.128	2.128	1.203
VERTICAL SPREAD	2.776	2.023	2.023
EXTREME SPREAD	2.849	2.721	2.174
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 8

3in = 9

HS= 2.464

VS= 2.647

GS= 3.161

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.303	1.046	.919
MINIMUM X	:	-1.161	-1.016	-.670
MAXIMUM Y	:	.777	.570	.489
MINIMUM Y	:	-1.869	-.642	-.548
CENTROID X	:	.122	-.023	.104
CENTROID Y	:	-.086	.121	.201
POA TO CENTROID in.	:	.150	.123	.227
MIN RADIUS	:	.051	.239	.235
MEAN RADIUS	:	.845	.656	.570
MAX RADIUS	:	2.279	1.202	.926
HORIZONTAL SPREAD	:	2.464	2.062	1.589
VERTICAL SPREAD	:	2.647	1.212	1.038
EXTREME SPREAD	:	3.161	2.227	1.724
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	