

C6636106

MODEL 720™ M24

Model **SAS**™

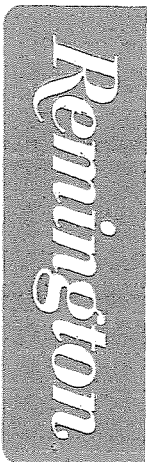
Action

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

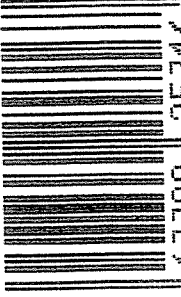
SERIAL NO.
C6636106

ORDER NO.
5716

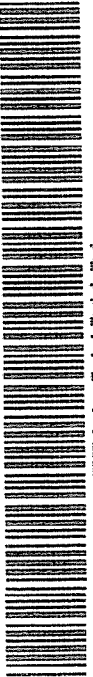
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada. Marque Deposee.

46

LPC



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5716 C6636106

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636106

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 28	9 1	RW
600	Proof	3 28	9 1	RW
607	Check Headspace	3 28	9 1	RW
610	Dis-assemble Gun	3 28	9 1	RW
612	Magnaflux Barrel Action	APR	2 1991	KR
	Magnaflux Bolt	APR	2 1991	LL
615	Rollmark Caliber	APR	2 1991	LL
617	Drill and Tap Sight Holes	APR	5 1991	LB
618	Polish Barrel	APR	5 1991	WB
620	Apply Coatings (Barrel Action)		4-10-91	LB
	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		4/10/91	PL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			4-16-91	DH
	G) Safety Off Force	2	2	2			4-16-91	DH
	H) Trigger Pull Test & Retainability						4/16/91	RP
	I) Firing Pin Indent	021	021	020			4-16-91	DH
	J) Assemble Stock						4/16/91	RW
	K) Assemble Swivel Studs						4-17-91	A
	L) Attach Front and Rear Sight Assemblies						4/16/91	RW
	M) Iron Sight Alignment						4/16/91	RW
	N) Detach Front & Rear Sights & place in numbered container						4/16/91	RW
	O) Attach Scope to Rifle						4/16/91	RW
	P) Detach & Attach Scope 20 Times						4/16/91	RW
640	Gallery Target & Test						4/16/91	RS
	A) Time							RS
	B) Malfunctions							RS
	C) Pierced Primers							RS
	D) Optical Clarity of Scope							RS
645	Inspect for Live Ammo						4/16/91	RS
655	Final Inspection							
	A) Headspace						4-17-91	A
	B) Trigger Pull	2.34	2.32	2.29	2.29	2.30	4/17/91	RP
	C) Function						4-17-91	A
660	Pack						6-17-91	RS

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO C6636106

DATE 4/18/91

TESTER JM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.21	2.32	2.35	2.34	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.23	2.26	2.40	2.32	
PULL #3	2.21	2.33	2.38	2.29	
PULL #4	2.42	2.35	2.36	2.29	
PULL #5	2.46	2.37	2.36	2.30	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.44	3.46		
PULL #2	3.47	3.48		
PULL #3	3.46	3.46		
PULL #4	3.46	3.41		
PULL #5	3.44	3.40		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.33	4.46		4.30
PULL #2	4.33	4.51		4.36
PULL #3	4.20	4.38		4.31
PULL #4	4.30	4.35		4.20
PULL #5	4.31	4.33		4.26
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636106
16 Apr 1991

CENTROIDAL DISTANCES

0 TO 1	.364335
1 TO 2	.469038
1 TO 3	.0878009
1 TO 4	.294272
1 TO 5	.313268



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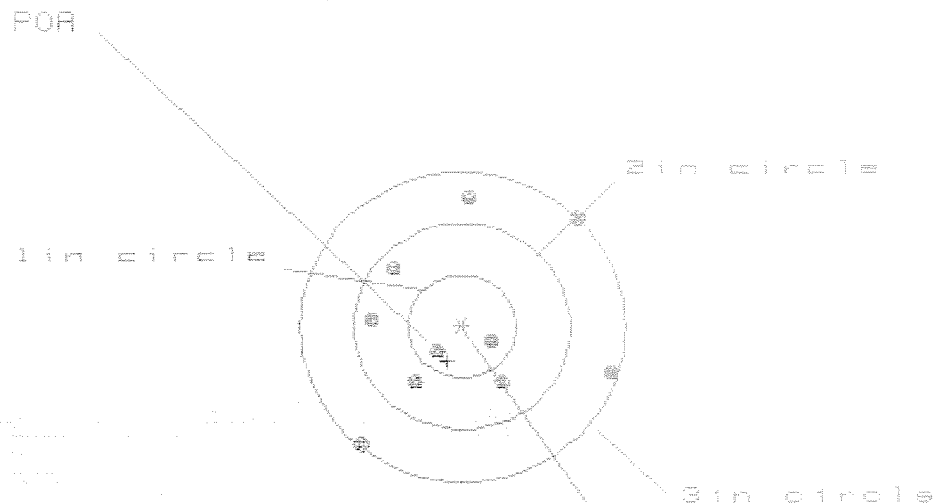
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0442
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1644
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .170238

THE AMR FOR THIS RIFLE IS: .664

18 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6836106

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.352

VS= 2.350

GS= 2.993

CENTROID *

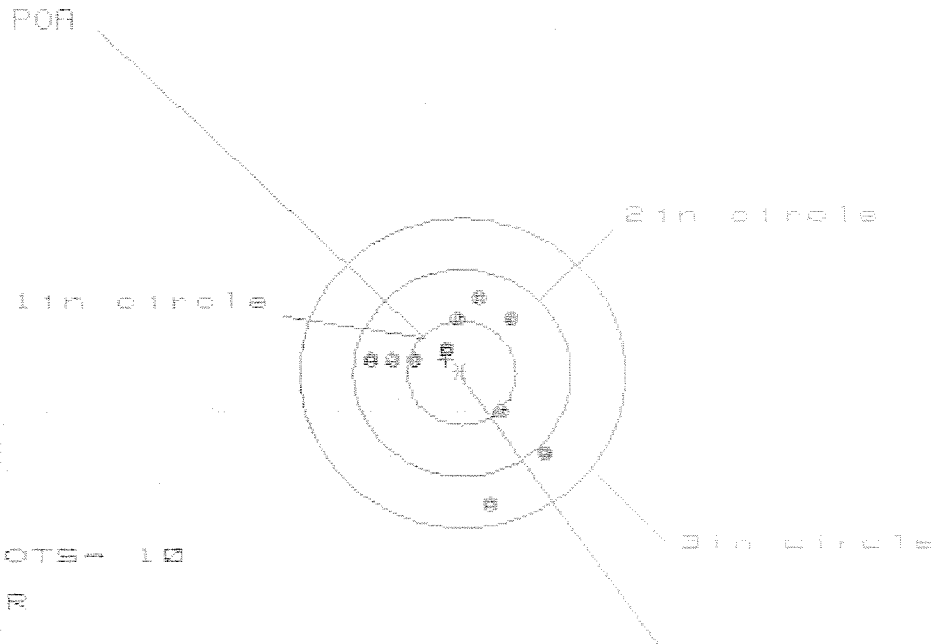
PATTERN

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.380	1.501	1.395
MINIMUM X	-.972	-.851	-.807
MAXIMUM Y	1.253	1.373	1.251
MINIMUM Y	-1.097	-.977	-.588
CENTROID X	.136	.015	.121
CENTROID Y	.338	.218	.340
POA TO CENTROID in.	.364	.219	.361
MIN RADIUS	.286	.150	.300
MEAN RADIUS	.936	.837	.795
MAX RADIUS	1.529	1.538	1.468
HORIZONTAL SPREAD	2.352	2.352	2.202
VERTICAL SPREAD	2.350	2.350	1.839
EXTREME SPREAD	2.993	2.557	2.389
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

16 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636186

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 8

3in = 10

HS= 1.579

VS= 2.012

GS= 2.014

CENTROID *

PATTERN #

2

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.756

.787

.568

MINIMUM X

-.823

-.792

-.694

MAXIMUM Y

.760

.621

.584

MINIMUM Y

-1.252

-.934

-.674

CENTROID X

.142

.111

.013

CENTROID Y

-.131

.008

.125

POA TO CENTROID in.

.193

.111

.126

MIN RADIUS

.231

.117

.072

MEAN RADIUS

.787

.684

.491

MAX RADIUS

1.284

1.222

.820

HORIZONTAL SPREAD

1.579

1.579

1.262

VERTICAL SPREAD

2.012

1.555

1.178

EXTREME SPREAD

2.014

1.836

1.333

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

8

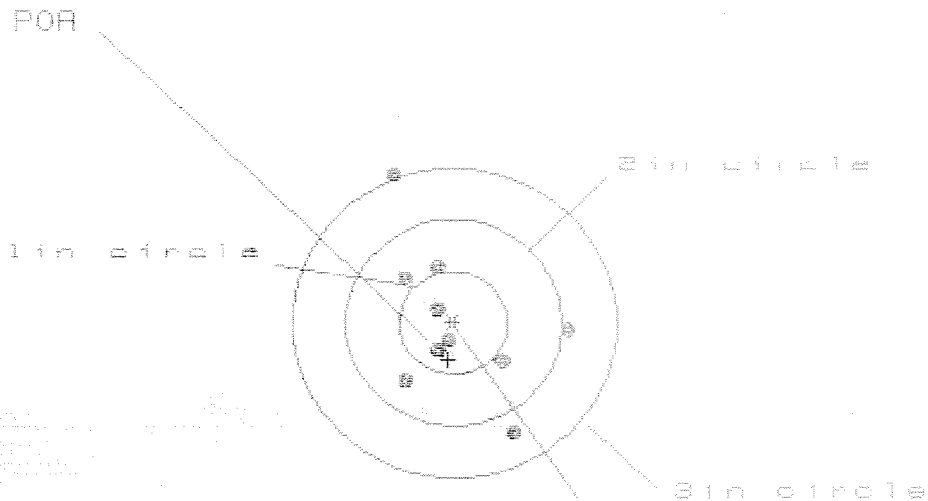
NUMBER IN THREE INCH CIRCLE =

10

16 Apr 1981

FILE:/PATTERNING/CENTERFIRE_PATT/C6635106

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 1.500

VS= 2.568

GS= 2.787

CENTROID *

PATTERN #

3

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.051

.990

1.050

MINIMUM X

-.549

-.537

-.478

MAXIMUM Y

1.476

.703

.587

MINIMUM Y

-1.092

-.928

-.489

CENTROID X

.051

.112

.053

CENTROID Y

.360

.196

.312

POR TO CENTROID in.

.363

.225

.316

MIN RADIUS

.196

.084

.149

MEAN RADIUS

.711

.600

.534

MAX RADIUS

1.575

1.041

1.050

HORIZONTAL SPREAD

1.600

1.527

1.527

VERTICAL SPREAD

2.568

1.631

1.076

EXTREME SPREAD

2.787

1.045

1.619

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

7

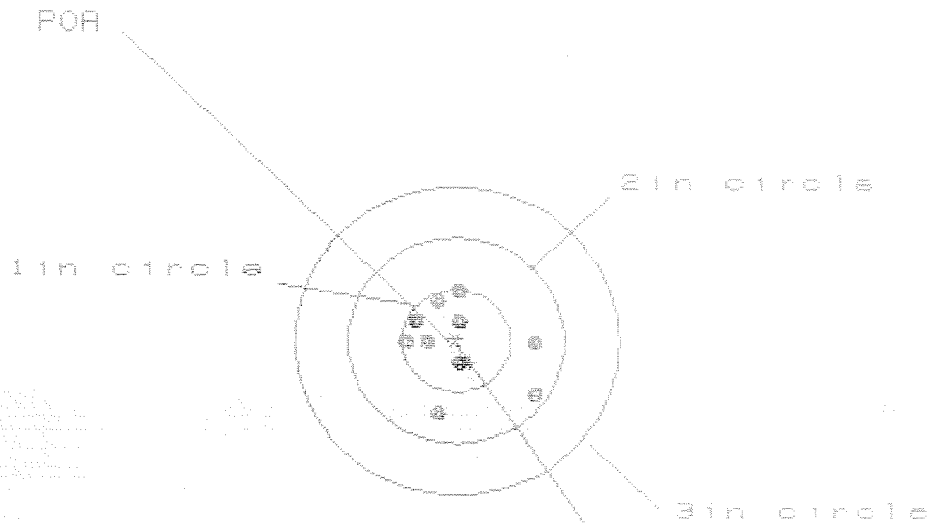
NUMBER IN THREE INCH CIRCLE =

9

16 Apr 1991

FILE:/PATTERNING/CENTERFIRE PATT/C6636106

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 5

2in = 10

3in = 10

HS= 1.235

VS= 1.228

GS= 1.311

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.726

.803

.217

MINIMUM X

-.509

-.432

-.331

MAXIMUM Y

.537

.485

.474

MINIMUM Y

-.691

-.743

-.754

CENTROID X

-.128

-.205

-.306

CENTROID Y

.208

.261

.272

POA TO CENTROID in.

.244

.332

.410

MIN RADIUS

.199

.172

.107

MEAN RADIUS

.486

.424

.355

MAX RADIUS

.842

.809

.755

HORIZONTAL SPREAD

1.235

1.235

.548

VERTICAL SPREAD

1.228

1.228

1.228

EXTREME SPREAD

1.311

1.238

1.238

NUMBER IN ONE INCH CIRCLE =

5

NUMBER IN TWO INCH CIRCLE =

10

NUMBER IN THREE INCH CIRCLE =

10

16 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B36106

CENTERFIRE PATTERNS

5

POB

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in - 7

2in - 9

3in - 10

HS= 1.149

VS= 1.715

GS= 1.732

CENTROID *

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X .483

.514

.494

MINIMUM X -.566

-.639

-.575

MAXIMUM Y .633

.513

.424

MINIMUM Y -1.082

-.371

-.007

CENTROID X .020

-.067

-.071

CENTROID Y .047

.167

.103

POB TO CENTROID in. .051

.167

.125

MIN RADIUS .154

.251

.174

MEAN RADIUS .480

.417

.360

MAX RADIUS 1.109

.723

.608

HORIZONTAL SPREAD 1.149

1.149

1.069

VERTICAL SPREAD 1.715

.884

.731

EXTREME SPREAD 1.732

1.210

1.122

NUMBER IN ONE INCH CIRCLE =

7

NUMBER IN TWO INCH CIRCLE =

9

NUMBER IN THREE INCH CIRCLE =

10