

C6649120

MODEL 700™ M24

Model S&S™

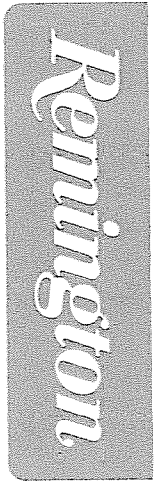
Action

Barrel Length

Capacity

Order No. 5715

*Includes 1 in chamber.






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

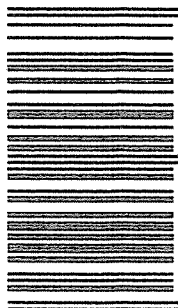
MODEL 700TM M24

SERIAL NO.
C6649120

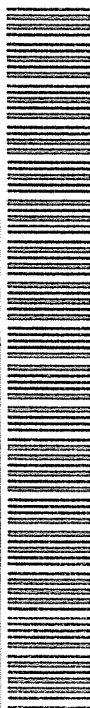
ORDER NO.
5716

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

UPC



0 47700 25716 7



5716 C6649120

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6649120**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/26/91	KA
600	Proof		6/26/91	KA
607	Check Headspace		6/26/91	KA
610	Dis-assemble Gun		6/26/91	KA
612	Magnaflux Barrel Action		JUL 1 8 1991	CS
	Magnaflux Bolt		JUL 1 8 1991	CS
615	Rollmark Caliber		JUL 1 8 1991	CS
617	Drill and Tap Sight Holes		JUL 1 8 1991	FB
618	Polish Barrel		JUL 2 0 1991	WB
620	Apply Coatings (Barrel Action)		7-91	AB
	Apply Coating (Bolt)		8-91	AB
625	Final Assembly A) Clean inside of Bolt Assembly		8/20/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/20/91	KA
	C) Inspect Ejector Hole for Chamfer		8/20/91	KA
	D) Oil Firing Pin Ass'y		8/20/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		8/21/91	KA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	6			8-21-91	DH
	G) Safety Off Force	3	3	3			8-21-91	DH
	H) Trigger Pull Test & Retainability						8/21/91	JH
	I) Firing Pin Indent	.022	.021	.022			8-21-91	DH
	J) Assemble Stock						8/26/91	TK
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies						8/26/91	TK
	M) Iron Sight Alignment						8/26/91	TK
	N) Detach Front & Rear Sights & place in numbered container						8/26/91	TK
	O) Attach Scope to Rifle						8/26/91	TK
	P) Detach & Attach Scope 20 Times						8/26/91	TK
640	Gallery Target & Test						8-27-91	AC
	A) Time						8-27-91	AC
	B) Malfunctions						8-27-91	AC
	C) Pierced Primers						8-27-91	AC
	D) Optical Clarity of Scope						8-27-91	AC
645	Inspect for Live Ammo						8-27-91	AC
655	Final Inspection						8-31-91	DH
	A) Headspace							
	B) Trigger Pull	2-32	2-32	2-37	2-41	2-44	8/29/91	JH
	C) Function						8-31-91	DH
660	Pack						9-18-91	AE

SWS TRIGGER PULL TEST

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

SERIAL NO C-6649120
DATE 8/21/91
TESTER JPL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.28	2.37	2.30	2.32	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.47	2.36	2.36	2.32	
PULL #3	2.40	2.38	2.33	2.37	
PULL #4	2.42	2.23	2.38	2.41	
PULL #5	2.44	2.36	2.38	2.44	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.43	3.49		
PULL #2	3.43	3.51		
PULL #3	3.43	3.29		
PULL #4	3.49	3.52		
PULL #5	3.46	3.51		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.37	4.49		4.46
PULL #2	4.39	4.39		4.20
PULL #3	4.23	4.20		4.52
PULL #4	4.42	4.50		4.49
PULL #5	4.44	4.31		4.48
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649120
28 Aug 1991

CENTROIDAL DISTANCES

0 TO 1	.549586
1 TO 2	.55171
1 TO 3	.548091
1 TO 4	.739982
1 TO 5	.573864

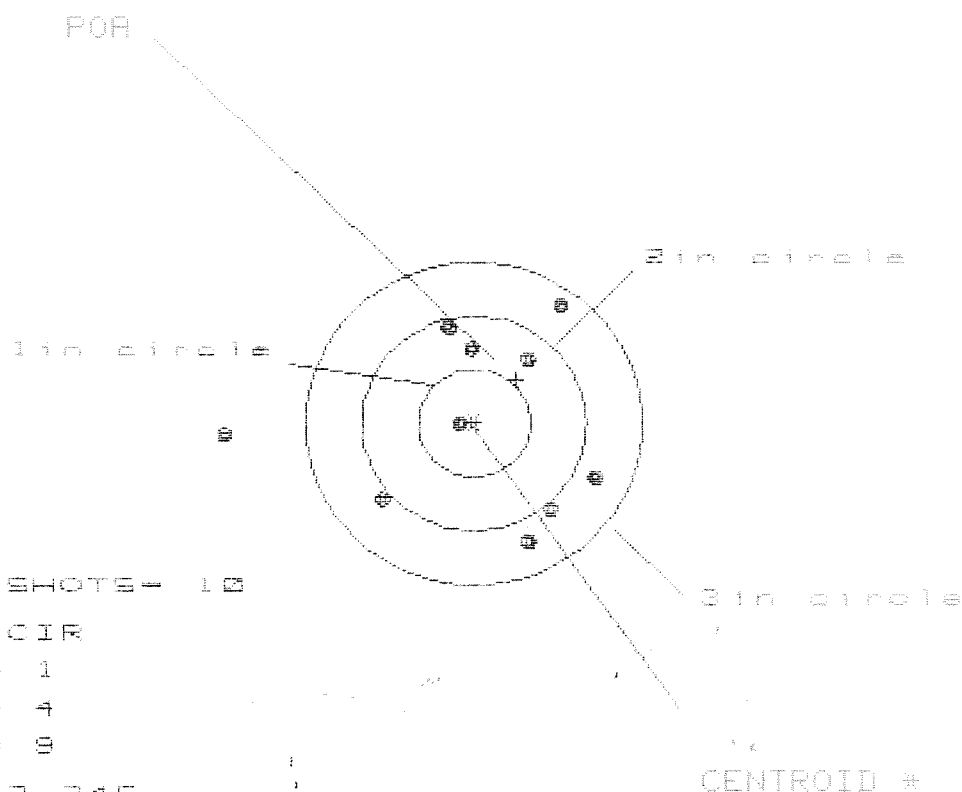
2 1/2" <----POA
1

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1518
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0626
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .164201
THE AMR FOR THIS RIFLE IS: .978

27 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C5649120

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 9

HS= 3.246

VS= 2.213

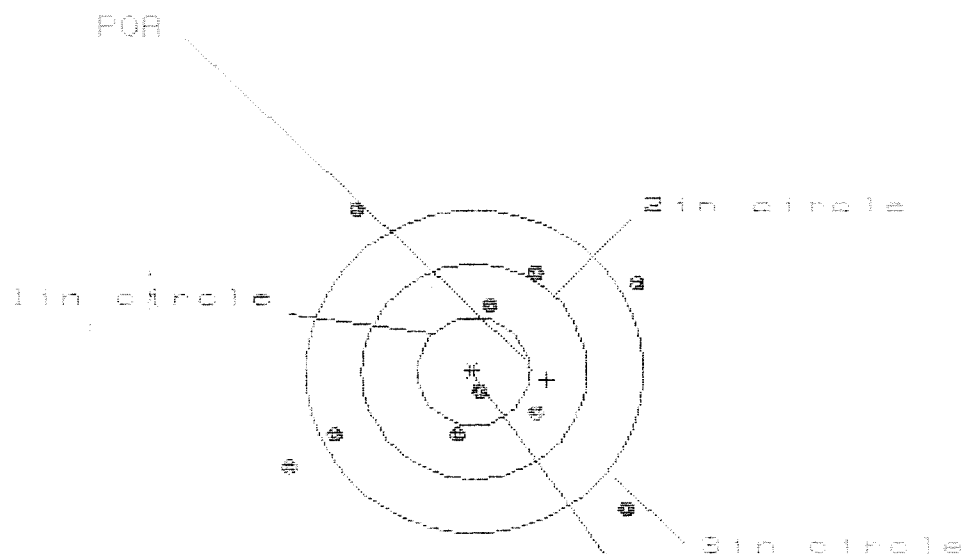
GS= 3.374

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.086	.835	.894
MINIMUM X	:	-2.260	-1.069	-1.010
MAXIMUM Y	:	1.103	1.095	1.009
MINIMUM Y	:	-1.110	-1.118	-.982
CENTROID X	:	-.379	-.128	-.168
CENTROID Y	:	-.398	-.398	-.526
POA TO CENTROID in.	:	.550	.410	.359
MIN RADIUS	:	.117	.368	.327
MEAN RADIUS	:	1.061	.916	.879
MAX RADIUS	:	2.262	1.309	1.184
HORIZONTAL SPREAD	:	3.346	1.904	1.904
VERTICAL SPREAD	:	2.213	2.213	1.991
EXTREME SPREAD	:	3.374	2.412	2.092
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

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FILE:/PATTERNING/CENTERFIRE_PATT/CBE49120

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 6

HS= 3.107

VS= 2.772

GS= 3.688

CENTROID #

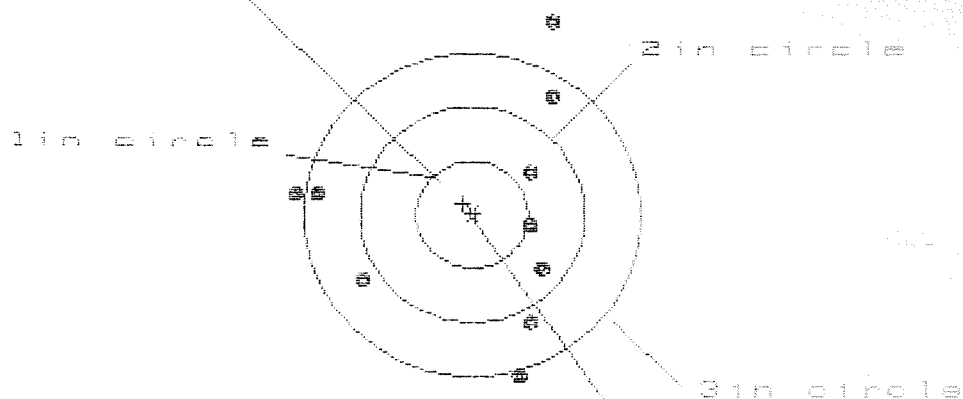
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.443	1.597	1.409
MINIMUM X	:	-1.664	-1.510	-1.317
MAXIMUM Y	:	1.515	1.375	1.252
MINIMUM Y	:	-1.257	-0.983	-0.865
CENTROID X	:	-0.651	-0.805	-0.617
CENTROID Y	:	.082	.222	.345
POR TO CENTROID in.	:	.656	.835	.706
MIN RADIUS	:	.212	.401	.362
MEAN RADIUS	:	1.181	1.122	1.008
MAX RADIUS	:	1.872	1.802	1.646
HORIZONTAL SPREAD	:	3.107	3.107	2.725
VERTICAL SPREAD	:	2.772	2.358	2.117
EXTREME SPREAD	:	3.688	3.515	3.665
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	

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FILE:/PATTERNING/CENTERFIRE_PATT/08849120

CENTERFIRE PATTERNS # 3

POA



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 3

3 in = 7

HS = 3.347

VS = 3.288

GS = 3.303

CENTROID #

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.735	.774	.583
MINIMUM X	-1.611	-1.530	-1.524
MAXIMUM Y	1.805	1.301	1.347
MINIMUM Y	-1.483	-1.282	-1.236
CENTROID X	.081	-.000	.191
CENTROID Y	-.100	-.300	-.346
POA TO CENTROID in.	.129	.300	.395
MIN RADIUS	.569	.654	.480
MEAN RADIUS	1.207	1.114	1.010
MAX RADIUS	1.950	1.573	1.583
HORIZONTAL SPREAD	2.347	2.304	2.107
VERTICAL SPREAD	3.288	2.583	2.583
EXTREME SPREAD	3.303	2.616	2.597
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		7	

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FILE:/PATTERNING/CENTERFIRE_PATT/C6849120

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 3

2in = 8

3in = 10

HS = 1.153

VS = 1.427

GS = 2.417

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.033	.908	.644
MINIMUM X	:	-1.120	-.757	-.643
MAXIMUM Y	:	.783	.835	.763
MINIMUM Y	:	-.643	-.592	-.664
CENTROID X	:	.203	.328	.214
CENTROID Y	:	.059	.007	.079
POA TO CENTROID in.	:	.212	.328	.228
MIN RADIUS	:	.196	.204	.204
MEAN RADIUS	:	.694	.628	.563
MAX RADIUS	:	1.214	1.077	.882
HORIZONTAL SPREAD	:	2.153	1.665	1.287
VERTICAL SPREAD	:	1.427	1.427	1.427
EXTREME SPREAD	:	2.417	1.870	1.476
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			10	

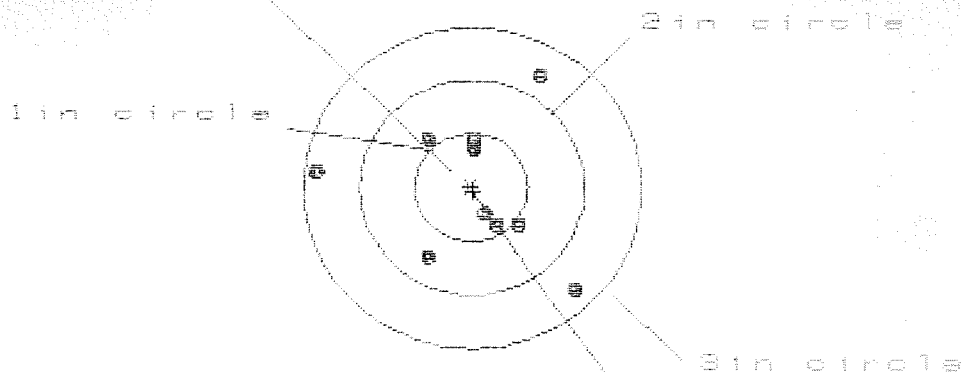
27 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8B49120

CENTERFIRE PATTERNS

5

POA



OF SHOTS = 10

IN CIR

1in = 4

2in = 7

3in = 10

HS = 2.323

VS = 1.964

GS = 2.558

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.893	.734	.510
MINIMUM X	:	-1.430	-.583	-.492
MAXIMUM Y	:	1.051	1.069	.957
MINIMUM Y	:	-.913	-.895	-.773
CENTROID X	:	-.013	.146	.055
CENTROID Y	:	.044	.026	.138
POA TO CENTROID in.	:	.046	.149	.148
MIN RADIUS	:	.305	.260	.389
MEAN RADIUS	:	.747	.656	.588
MAX RADIUS	:	1.439	1.157	1.085
HORIZONTAL SPREAD	:	2.323	1.317	1.002
VERTICAL SPREAD	:	1.964	1.964	1.730
EXTREME SPREAD	:	2.558	1.989	1.979
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	