

06649121

MODEL 700™ M24

Model S&S™

Action _____

Barrel Length _____

Capacity _____

Order No. 5716

*Includes 1 in chamber.





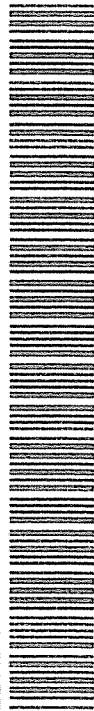

VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700TM H24

SERIAL NO.
C6649121

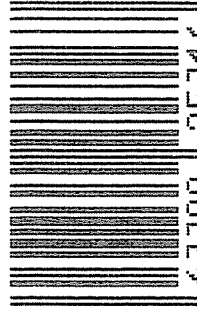
ORDER NO.
5716

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



5716 C6649121

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6649121

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		4/26/91	KA
600	Proof		4/26/91	KA
607	Check Headspace		4/26/91	KA
610	Dis-assemble Gun		4/26/91	KA
612	Magnaflux Barrel Action		JUL 1 6 1991 JUL 1 0 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)		8-7-91	KA
	Apply Coating (Bolt)			KA
625	Final Assembly A) Clean inside of Bolt Assembly		8/8/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/8/91	KA
	C) Inspect Ejector Hole for Chamfer		8/8/91	KA
	D) Oil Firing Pin Ass'y		8/8/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		8-9-91	KA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8-9-91	JK
	G) Safety Off Force	4	4	4			8-9-91	JK
	H) Trigger Pull Test & Retainability						8-9-91	JK
	I) Firing Pin Indent	.022	.0225	.0225			8-9-91	JK
	J) Assemble Stock						8/12/91	JK
	K) Assemble Swivel Studs						8-15-91	D/H
	L) Attach Front and Rear Sight Assemblies						8/12/91	JK
	M) Iron Sight Alignment						8/12/91	JK
	N) Detach Front & Rear Sights & place in numbered container						8/12/91	JK
	O) Attach Scope to Rifle						8/12/91	JK
	P) Detach & Attach Scope 20 Times						8/12/91	JK
640	Gallery Target & Test						8-13-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						8-13-91	JK
655	Final Inspection						8-15-91	D/H
	A) Headspace						8-15-91	D/H
	B) Trigger Pull	2.56	2.67	2.65	2.67	2.70	8-14-91	JK
	C) Function						8-15-91	D/H
660	Pack						7-17-91	D/H

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # RUNC6649121
23 Aug 1991

CENTROIDAL DISTANCES

0	TO	1	.0286531
1	TO	2	.263828
1	TO	3	.0900222
1	TO	4	.142042
1	TO	5	.156186

-----POA

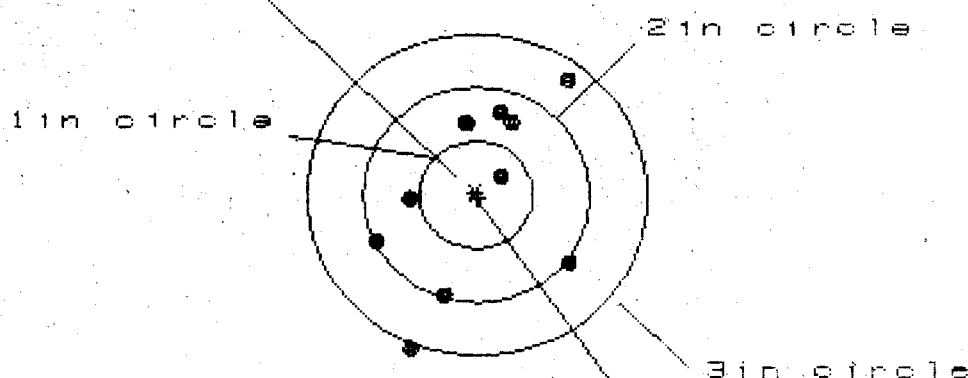
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0068
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.068
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0683392
THE AMR FOR THIS RIFLE IS: .8112

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649121

CENTERFIRE PATTERNS # 1

FOR



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 9

HS= 1.714

VS= 2.425

GS= 2.768

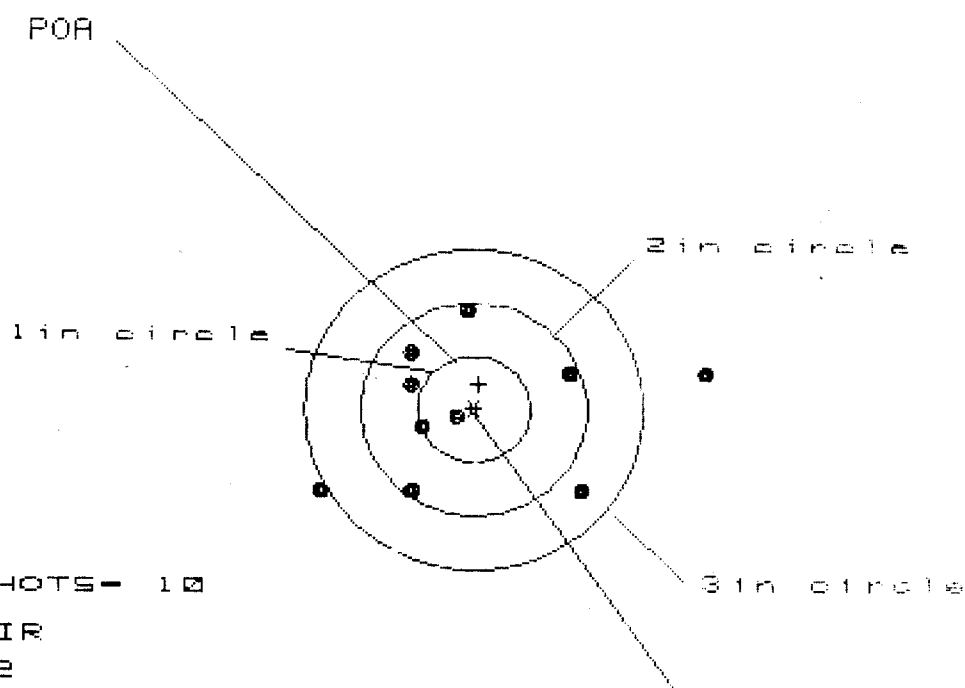
CENTROID #

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.842	.779	.867
MINIMUM X	:	-.872	-.935	-.847
MAXIMUM Y	:	1.032	.877	.747
MINIMUM Y	:	-1.393	-1.038	-.928
CENTROID X	:	-.014	.049	-.039
CENTROID Y	:	.025	.180	.070
POA TO CENTROID in.	:	.029	.187	.080
MIN RADIUS	:	.260	.152	.260
MEAN RADIUS	:	.882	.780	.747
MAX RADIUS	:	1.504	1.124	1.085
HORIZONTAL SPREAD	:	1.714	1.714	1.714
VERTICAL SPREAD	:	2.425	1.915	1.675
EXTREME SPREAD	:	2.768	2.181	1.745
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			9	

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 8

HS= 3.448

VS= 1.794

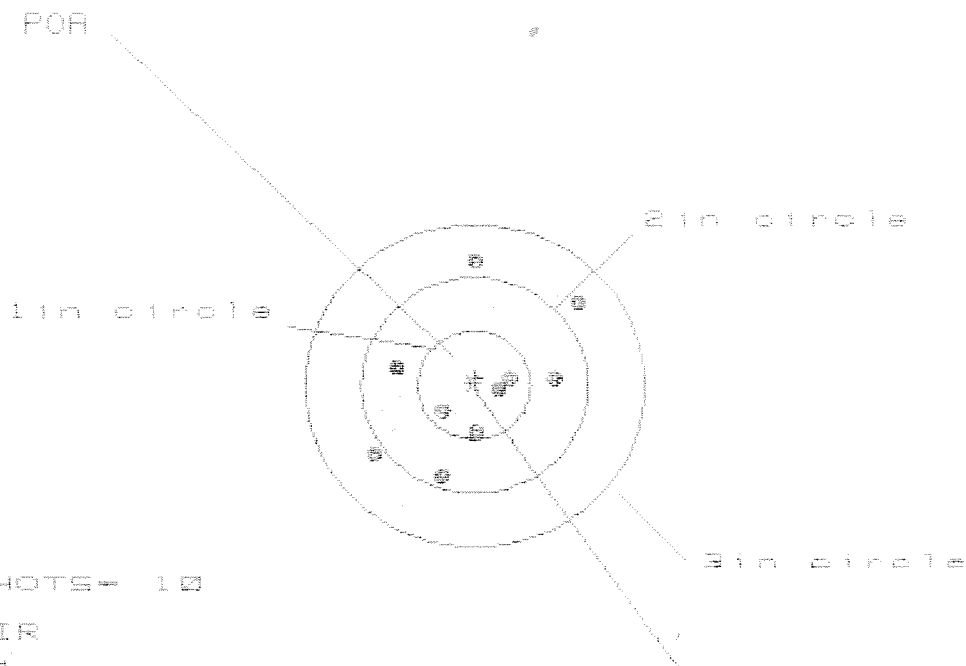
GS= 3.645

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.044	1.152	1.005
MINIMUM X	:	-1.404	-1.177	-.502
MAXIMUM Y	:	.983	1.025	.928
MINIMUM Y	:	-.811	-.769	-.839
CENTROID X	:	-.045	-.272	-.125
CENTROID Y	:	-.237	-.279	-.182
POA TO CENTROID in.	:	.242	.390	.221
MIN RADIUS	:	.159	.072	.110
MEAN RADIUS	:	.971	.788	.726
MAX RADIUS	:	2.078	1.406	1.309
HORIZONTAL SPREAD	:	3.448	2.329	1.507
VERTICAL SPREAD	:	1.794	1.794	1.767
EXTREME SPREAD	:	3.645	2.504	2.027
NUMBER IN ONE INCH CIRCLE	:	2		
NUMBER IN TWO INCH CIRCLE	:	7		
NUMBER IN THREE INCH CIRCLE	:	8		

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 4

2in = 7

3in = 10

HS= 1.791

VS= 1.985

GS= 2.274

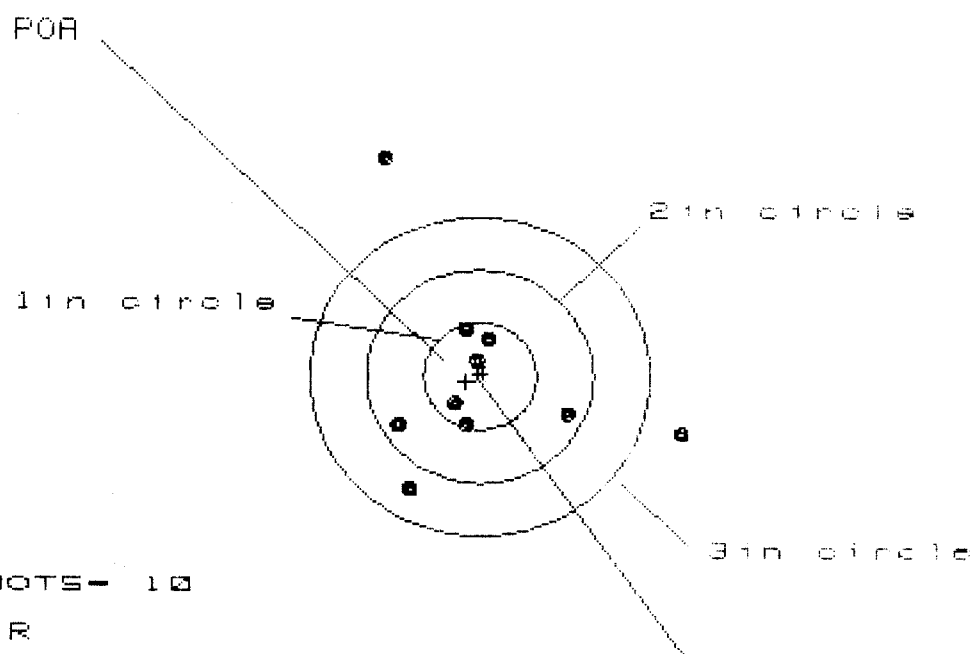
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.988	.786	.794
MINIMUM X	:	-.983	-.782	-.774
MAXIMUM Y	:	1.164	1.247	.410
MINIMUM Y	:	-.821	-.738	-.582
CENTROID X	:	-.012	-.113	-.121
CENTROID Y	:	-.065	-.148	-.384
POA TO CENTROID in.	:	.066	.186	.327
MIN RADIUS	:	.254	.242	.185
MEAN RADIUS	:	.714	.653	.555
MAX RADIUS	:	1.175	1.249	.879
HORIZONTAL SPREAD	:	1.791	1.568	1.568
VERTICAL SPREAD	:	1.985	1.985	.992
EXTREME SPREAD	:	2.274	2.006	1.715
NUMBER IN ONE INCH CIRCLE =			4	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			10	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in - 5

2in - 7

3in = 8

HS= 2.570

VS= 3.155

GS= 3.671

CENTROID #

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.779	1.691	.850
MINIMUM X	:	-.791	-.854	-.643
MAXIMUM Y	:	2.088	.708	.671
MINIMUM Y	:	-1.067	-.835	-.872
CENTROID X	:	.126	.214	.002
CENTROID Y	:	.049	-.183	-.146
POA TO CENTROID in.	:	.136	.282	.146
MIN RADIUS	:	.106	.255	.027
MEAN RADIUS	:	.862	.722	.546
MAX RADIUS	:	2.233	1.717	.992
HORIZONTAL SPREAD	:	2.570	2.545	1.493
VERTICAL SPREAD	:	3.155	1.543	1.543
EXTREME SPREAD	:	3.671	2.546	1.619
NUMBER IN ONE INCH CIRCLE =	:	5		
NUMBER IN TWO INCH CIRCLE =	:	7		
NUMBER IN THREE INCH CIRCLE =	:	8		

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CENTERFIRE PATTERNS # 5

POR

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 3

2in = 9

3in = 10

HS= 1.927

VS= 1.255

GS= 2.232

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.761	.631	.607
MINIMUM X	-1.166	-.607	-.538
MAXIMUM Y	.700	.719	.675
MINIMUM Y	-.555	-.477	-.501
CENTROID X	-.089	.041	-.038
CENTROID Y	-.112	-.190	-.146
POR TO CENTROID in.	.143	.194	.161
MIN RADIUS	.212	.082	.157
MEAN RADIUS	.627	.520	.497
MAX RADIUS	1.360	.729	.692
HORIZONTAL SPREAD	1.927	1.238	1.235
VERTICAL SPREAD	1.255	1.196	1.196
EXTREME SPREAD	2.232	1.299	1.299
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6649121

DATE 8-9-91

TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.53	2.41	2.29	2.56	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.36	2.36	2.23	2.67	
PULL #3	2.33	2.30	2.33	2.65	
PULL #4	2.29	2.34	2.44	2.67	
PULL #5	2.37	2.38	2.35	2.70	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.55	3.41		
PULL #2	3.43	3.44		
PULL #3	3.37	3.40		
PULL #4	3.44	3.33		
PULL #5	3.47	3.26		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.60	4.53		4.60
PULL #2	4.54	4.54		4.44
PULL #3	4.27	4.62		4.49
PULL #4	4.43	4.52		4.58
PULL #5	4.59	4.63		4.54
TOTAL				
AVG.				