

C6649135

MODEL 700™ M24

Model S4S™

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.

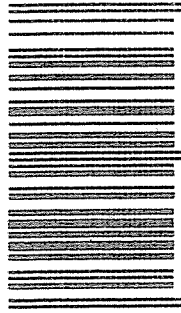
MODEL 700™ M24

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

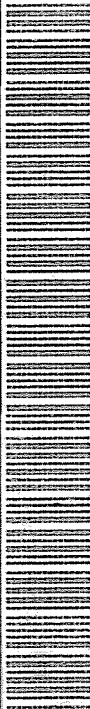
SERIAL NO.
C6649135

ORDER NO.
5716

UPC



0 47700 25716 7



5716 C6649135

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6649135**

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	EB
618	Polish Barrel		JUL 2 0 1991	WB
620	Apply Coatings (Barrel Action)		8-7-91	DA
	Apply Coating (Bolt)			
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	JH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8-21-91	DH
	G) Safety Off Force	2 3/4	2 3/4	3			8-21-91	DH
	H) Trigger Pull Test & Retainability						8/21/91	KA
	I) Firing Pin Indent	.022	.022	.022			8-21-91	DH
	J) Assemble Stock						8/21/91	KA
	K) Assemble Swivel Studs						8-23-91	DH
	L) Attach Front and Rear Sight Assemblies						8/21/91	KA
	M) Iron Sight Alignment						8/21/91	KA
	N) Detach Front & Rear Sights & place in numbered container						8/21/91	KA
	O) Attach Scope to Rifle						8/21/91	KA
	P) Detach & Attach Scope 20 Times						8/21/91	KA
640	Gallery Target & Test						8/22/91	KJ
	A) Time							KJ
	B) Malfunctions							KJ
	C) Pierced Primers							KJ
	D) Optical Clarity of Scope							KJ
645	Inspect for Live Ammo						8/22/91	KJ
655	Final Inspection							
	A) Headspace						8-23-91	DH
	B) Trigger Pull	2.48	2.52	2.57	2.63	2.60	8-23-91	KA
	C) Function						8-23-91	DH
660	Pack						8-19-91	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. 06649135

DATE 8/21/91

TESTER JN

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.50	2.49	2.50	2.48	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.54	2.46	2.48	2.52	
PULL #3	2.54	2.45	2.40	2.57	
PULL #4	2.52	2.46	2.44	2.63	
PULL #5	2.48	2.43	2.40	2.60	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.49	3.31		
PULL #2	3.18	3.45		
PULL #3	3.33	3.43		
PULL #4	3.34	3.43		
PULL #5	3.39	3.46		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.45	4.26		4.41
PULL #2	4.417	4.55		4.64
PULL #3	4.39	4.59		4.62
PULL #4	4.40	4.58		4.65
PULL #5	4.30	4.61		4.69
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649135
22 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.281432
1 TO	2	.390969
1 TO	3	.357095
1 TO	4	.2222
1 TO	5	.270485

✱ <----POA

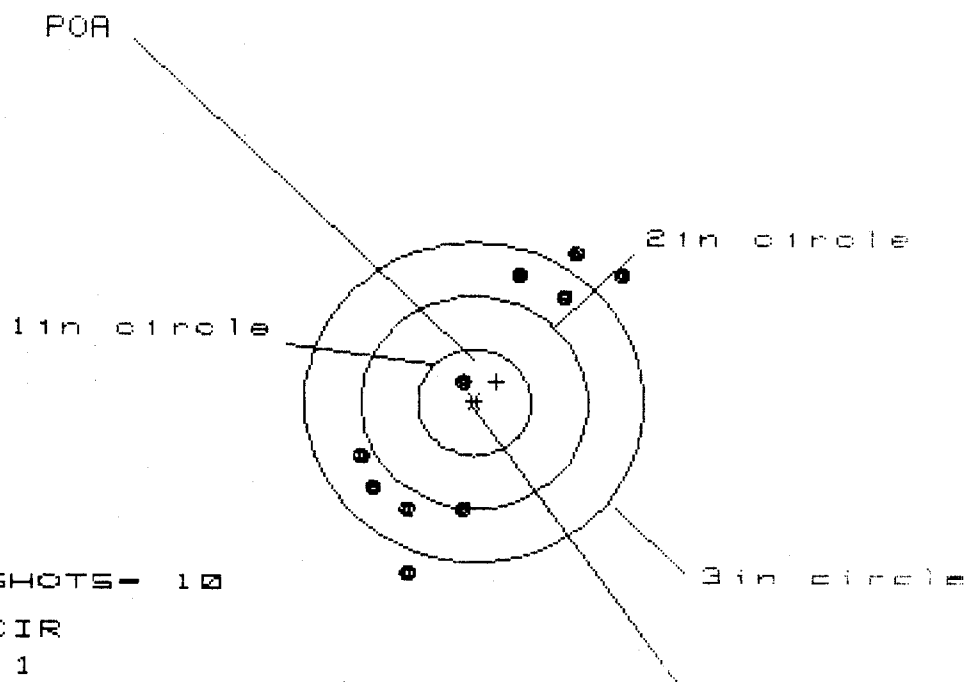
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0238
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.126
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .129221
THE AMR FOR THIS RIFLE IS: 1.159

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649135

CENTERFIRE PATTERNS

1



OF SHOTS - 10

IN CIR

1in = 1

2in = 2

3in = 7

HS= 2.293

VS= 3.029

GS= 3.418

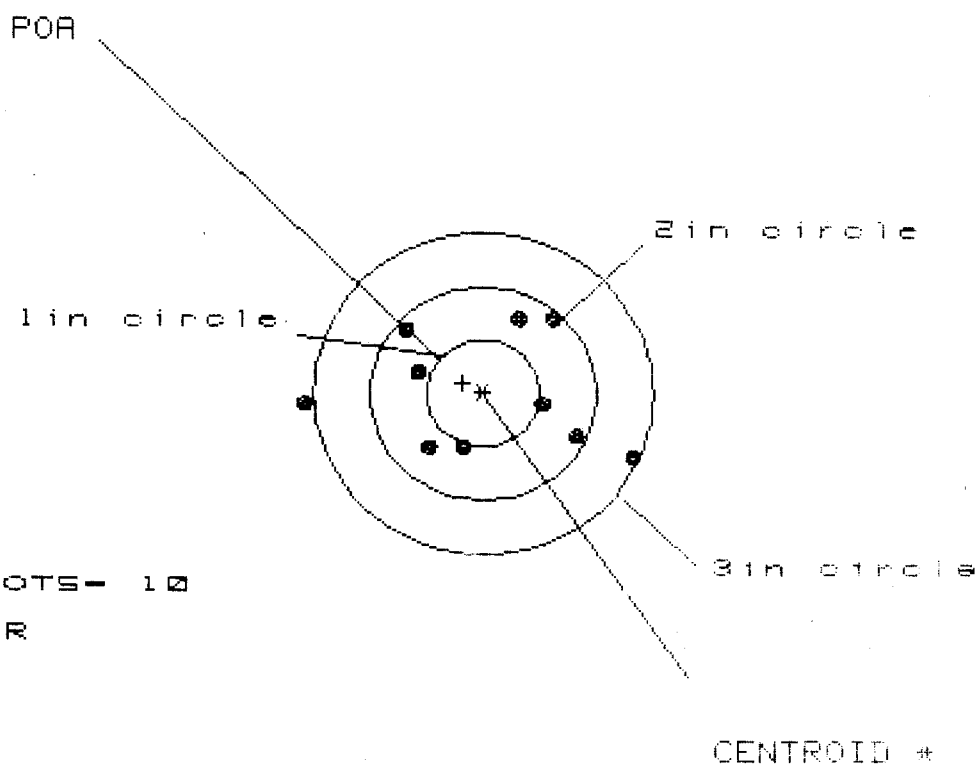
CENTROID *

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.279	1.029	.970
MINIMUM X	:	-1.014	-.872	-.931
MAXIMUM Y	:	1.395	1.530	1.343
MINIMUM Y	:	-1.634	-1.499	-1.103
CENTROID X	:	-.200	-.342	-.283
CENTROID Y	:	-.198	-.333	-.146
POA TO CENTROID in.	:	.282	.477	.318
MIN RADIUS	:	.245	.373	.180
MEAN RADIUS	:	1.244	1.165	1.106
MAX RADIUS	:	1.763	1.844	1.657
HORIZONTAL SPREAD	:	2.293	1.901	1.901
VERTICAL SPREAD	:	3.029	3.029	2.446
EXTREME SPREAD	:	3.418	3.380	2.869
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	2		
NUMBER IN THREE INCH CIRCLE	=	7		

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FILE:/PATTERNING/CENTERFIRE_PATT/C6649135

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 0

2in = 8

3in = 9

HS= 2.962

VS= 1.345

GS= 3.011

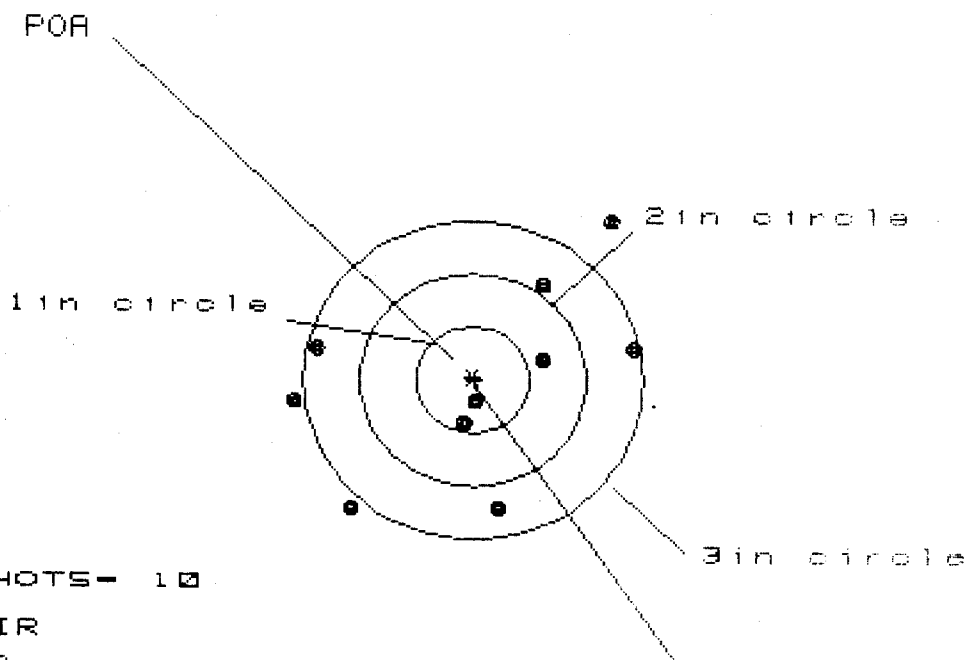
PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.339	1.159	.762
MINIMUM X	:	-1.623	-.879	-.734
MAXIMUM Y	:	.736	.729	.651
MINIMUM Y	:	-.609	-.616	-.609
CENTROID X	:	.179	.359	.214
CENTROID Y	:	-.102	-.095	-.018
POA TO CENTROID in.	:	.206	.371	.215
MIN RADIUS	:	.538	.370	.534
MEAN RADIUS	:	.918	.827	.760
MAX RADIUS	:	1.624	1.313	.927
HORIZONTAL SPREAD	:	2.962	2.038	1.496
VERTICAL SPREAD	:	1.345	1.345	1.260
EXTREME SPREAD	:	3.011	2.390	1.847
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS

5



OF SHOTS- 10

IN CIR

1in = 2

2in = 3

3in = 7

HS= 2.986

VS= 2.700

GS= 3.496

CENTROID *

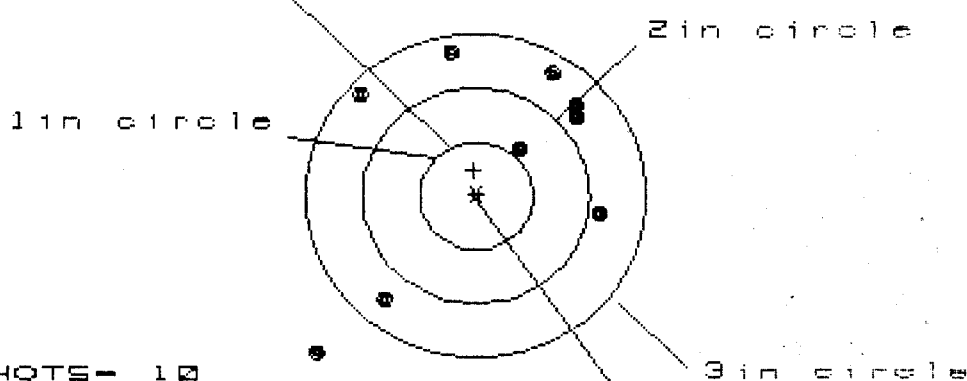
PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.403	1.535	1.422
MINIMUM X	-1.583	-1.451	-1.564
MAXIMUM Y	1.456	1.063	.928
MINIMUM Y	-1.244	-1.082	-1.145
CENTROID X	-.019	-.151	-.038
CENTROID Y	.003	-.159	-.024
POA TO CENTROID in.	.019	.219	.045
MIN RADIUS	.160	.142	.136
MEAN RADIUS	1.145	1.043	.991
MAX RADIUS	1.879	1.615	1.573
HORIZONTAL SPREAD	2.986	2.986	2.986
VERTICAL SPREAD	2.700	2.145	2.073
EXTREME SPREAD	3.496	3.034	3.034
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	7		

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CENTERFIRE PATTERNS # 4

POB



OF SHOTS- 10

IN CIR

1in = 0

2in = 1

3in = 8

HS= 2.572

VS= 4.312

GS= 4.327

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.111	1.060	.871
MINIMUM X	:	-1.461	-1.512	-1.300
MAXIMUM Y	:	1.320	.987	.768
MINIMUM Y	:	-2.992	-1.753	-1.497
CENTROID X	:	.018	.069	.258
CENTROID Y	:	-.241	.092	.311
POB TO CENTROID in.	:	.241	.115	.404
MIN RADIUS	:	.636	.402	.200
MEAN RADIUS	:	1.454	1.182	.937
MAX RADIUS	:	3.028	2.315	1.838
HORIZONTAL SPREAD	:	2.572	2.572	2.171
VERTICAL SPREAD	:	4.312	2.740	2.265
EXTREME SPREAD	:	4.327	3.388	2.622
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		1	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS

3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS - 10

IN CIR

1in = 0

2in = 5

3in = 9

HS= 2.368

VS= 2.157

GS= 2.776

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.130	1.023	.855
MINIMUM X	:	-1.238	-1.345	-1.121
MAXIMUM Y	:	.681	.517	.566
MINIMUM Y	:	-1.476	-.905	-.856
CENTROID X	:	.141	.248	.416
CENTROID Y	:	-.092	.072	.023
POA TO CENTROID in.	:	.168	.258	.416
MIN RADIUS	:	.565	.540	.471
MEAN RADIUS	:	1.035	.928	.846
MAX RADIUS	:	1.763	1.400	1.210
HORIZONTAL SPREAD	:	2.368	2.368	1.976
VERTICAL SPREAD	:	2.157	1.422	1.422
EXTREME SPREAD	:	2.776	2.698	2.172
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	