

C6649148

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.

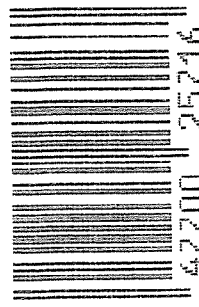
MODEL 700TM M24

SERIAL NO.
C6649143

ORDER NO.
5716

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

LPC



0 4700 25716 7



5716 C6649143

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6649148

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/26/91	KL
600	Proof		6/26/91	KL
607	Check Headspace		6/26/91	KL
610	Dis-assemble Gun		6/26/91	KL
612	Magnaflux Barrel Action		JUL 1 8 1991	GS
	Magnaflux Bolt		JUL 1 8 1991	GS
615	Rollmark Caliber		JUL 1 8 1991	GS
617	Drill and Tap Sight Holes		JUL 1 8 1991	LB
618	Polish Barrel		JUL 20 1991	WOB
620	Apply Coatings (Barrel Action)		8-7-91	AD
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/13/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/13/91	KL
	C) Inspect Ejector Hole for Chamfer		8/13/91	KL
	D) Oil Firing Pin Ass'y		8/13/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		8-15-91	KL

op. #	OP. NAME	READINGS			DATE	INIT
625 cont.	F) Safety On Force	5	5	5	8-15-91	JH
	G) Safety Off Force	3	3	3	8-15-91	JH
	H) Trigger Pull Test & Retainability				8-15-91	JH
	I) Firing Pin Indent	.020	.0205	.0205	8-15-91	JH
	J) Assemble Stock				8/15/91	KL
	K) Assemble Swivel Studs				8-21-91	AC
	L) Attach Front and Rear Sight Assemblies				8/15/91	KL
	M) Iron Sight Alignment				8/15/91	KL
	N) Detach Front & Rear Sights & place in numbered container				8/15/91	KL
	O) Attach Scope to Rifle				8/15/91	KL
	P) Detach & Attach Scope 20 Times				8/15/91	KL
640	Gallery Target & Test				8/20/91	KT
	A) Time					KT
	B) Malfunctions					KT
	C) Pierced Primers					KT
	D) Optical Clarity of Scope					KT
645	Inspect for Live Ammo				8/20/91	KT
655	Final Inspection					
	A) Headspace				8-21-91	AC
	B) Trigger Pull	2.47	2.36	2.51	8-21-91	DH
	C) Function				8-21-91	AC
660	Pack				9-19-91	NF

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649148
23 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.121824
1 TO	2	.159113
1 TO	3	.267255
1 TO	4	.0554707
1 TO	5	.173626

←----POB

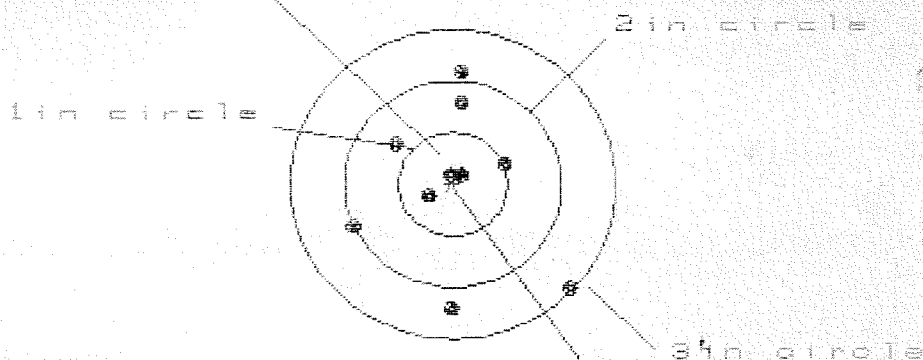
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0878
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0086
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0882202
THE AMR FOR THIS RIFLE IS: .9134

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649140

CENTERFIRE PATTERNS # 1

POA



OF SHOTS= 10

IN CIR

1in = 4

2in = 7

3in = 10

HS= 1.944

VS= 2.316

GS= 2.321

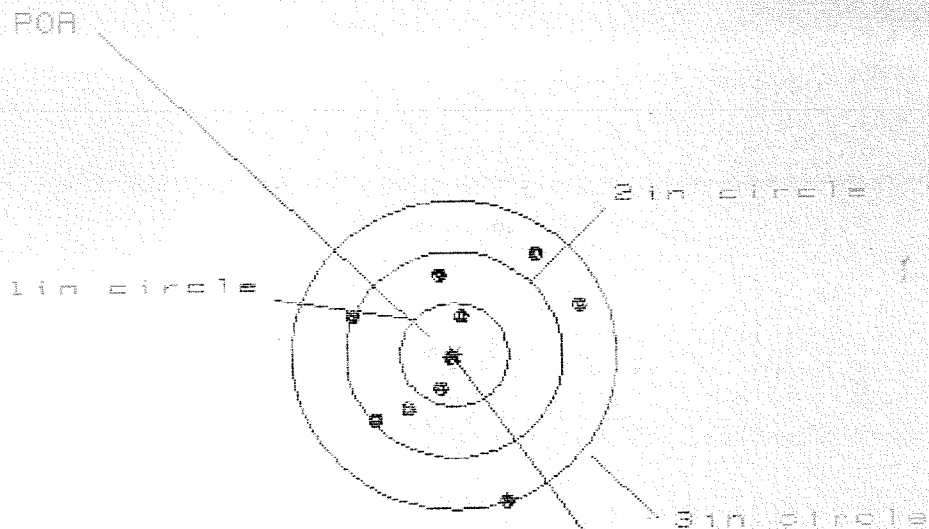
CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.045	.560	.565
MINIMUM X	-.899	-.782	-.777
MAXIMUM Y	1.108	.998	.834
MINIMUM Y	-1.208	-1.318	-.684
CENTROID X	-.075	-.192	-.197
CENTROID Y	-.096	.014	.178
POA TO CENTROID in.	.122	.192	.266
MIN RADIUS	.079	.092	.221
MEAN RADIUS	.716	.616	.532
MAX RADIUS	1.437	1.319	1.035
HORIZONTAL SPREAD	1.944	1.342	1.342
VERTICAL SPREAD	2.316	2.316	1.518
EXTREME SPREAD	2.321	2.319	1.786
NUMBER IN ONE INCH CIRCLE	= 4		
NUMBER IN TWO INCH CIRCLE	= 7		
NUMBER IN THREE INCH CIRCLE	= 10		

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in - 3

2in - 5

3in - 9

HS= 2.124

VS= 2.393

GS= 2.407

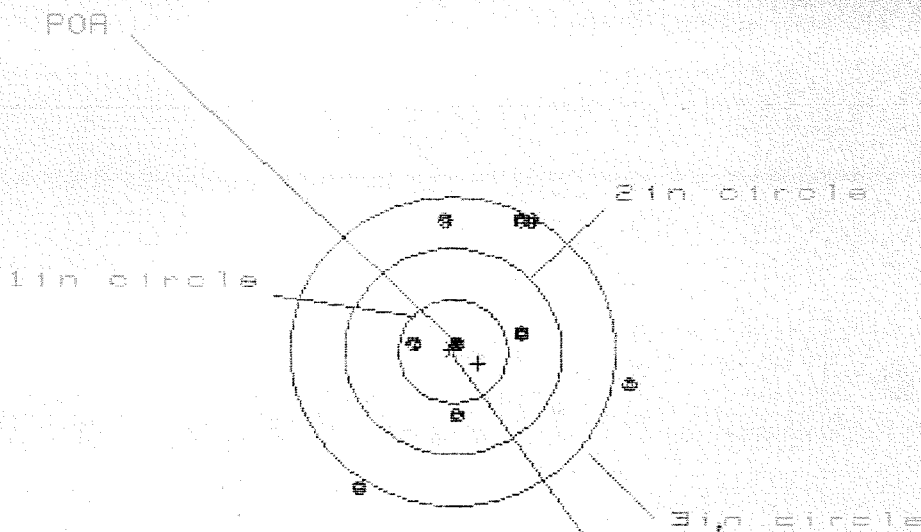
CENTROID #

PATTERN #	2	2	2
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.143	1.194	.922
MINIMUM X	-.981	-.930	-.781
MAXIMUM Y	.961	.802	.842
MINIMUM Y	-1.432	-.811	-.771
CENTROID X	.036	-.015	-.164
CENTROID Y	.018	.177	.137
POA TO CENTROID in.	.041	.178	.214
MIN RADIUS	.019	.148	.218
MEAN RADIUS	.819	.740	.675
MAX RADIUS	1.505	1.238	1.249
HORIZONTAL SPREAD	2.124	2.124	1.703
VERTICAL SPREAD	2.393	1.613	1.613
EXTREME SPREAD	2.407	2.207	2.182
NUMBER IN ONE INCH CIRCLE	=	3	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	9	

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CENTERFIRE PATTERNS # 3



* OF SHOTS = 10

IN CIR

1in = 2

2in = 4

3in = 7

HS = 3.934

VS = 3.186

GS = 4.389

PATTERN #

3

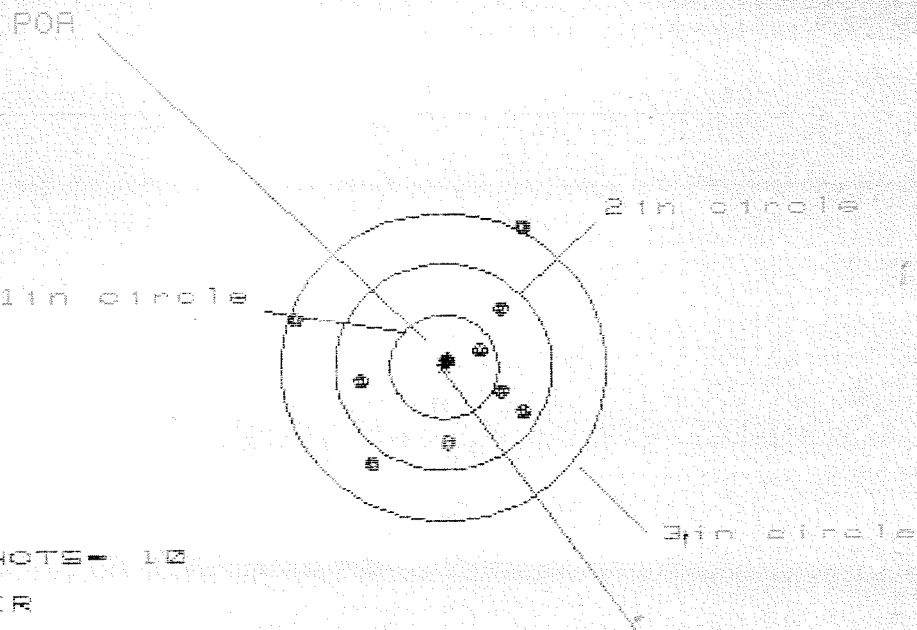
SHOTS (BEST OF)

	10	9	8
MAXIMUM X	1.585	1.325	.605
MINIMUM X	-2.349	-1.143	-.978
MAXIMUM Y	1.285	1.073	1.002
MINIMUM Y	-1.901	-1.568	-1.639
CENTROID X	-.231	.030	-.135
CENTROID Y	.121	.333	.404
POA TO CENTROID in.	.260	.334	.426
MIN RADIUS	.115	.252	.184
MEAN RADIUS	1.209	.976	.904
MAX RADIUS	3.022	1.940	1.909
HORIZONTAL SPREAD	3.934	2.468	1.583
VERTICAL SPREAD	3.186	2.641	2.641
EXTREME SPREAD	4.389	3.054	3.054
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		7	

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 2.168

VS= 2.337

GS= 2.713

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.773	.850	.685
MINIMUM X	:	-1.395	-1.318	-.864
MAXIMUM Y	:	1.379	.684	.760
MINIMUM Y	:	-.958	-.805	-.729
CENTROID X	:	-.029	-.106	.059
CENTROID Y	:	-.065	-.218	-.293
POA TO CENTROID in.	:	.071	.242	.299
MIN RADIUS	:	.061	.233	.293
MEAN RADIUS	:	.840	.772	.860
MAX RADIUS	:	1.542	1.451	1.064
HORIZONTAL SPREAD	:	2.168	2.168	1.549
VERTICAL SPREAD	:	2.337	1.489	1.489
EXTREME SPREAD	:	2.713	2.361	1.893
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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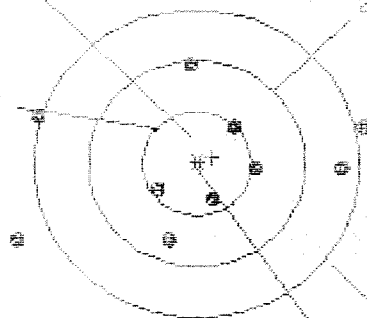
CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 5

3 in = 7

HS = 3.227

VS = 1.732

GS = 3.414

CENTROID *

PATTERN #

5

SHOTS (BEST OF)

	10	9	8
MAXIMUM X	1.542	1.355	1.309
MINIMUM X	-1.695	-1.662	-1.492
MAXIMUM Y	.961	.875	.907
MINIMUM Y	-.771	-.826	-.794
CENTROID X	-.140	-.048	-.122
CENTROID Y	-.065	-.021	-.011
POA TO CENTROID IN.	.154	.052	.122
MIN RADIUS	.321	.296	.365
MEAN RADIUS	.983	.863	.802
MAX RADIUS	1.853	1.699	1.542
HORIZONTAL SPREAD	3.227	3.017	2.001
VERTICAL SPREAD	1.732	1.701	1.701
EXTREME SPREAD	3.414	3.019	2.942
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		7	

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. C 6649148

DATE 8/14/91

TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.32	2.49	2.50	2.47	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.34	2.41	2.53	2.36	
PULL #3	2.34	2.40	2.44	2.51	
PULL #4	2.28	2.56	2.48	2.47	
PULL #5	2.33	2.44	2.40	2.51	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.23	3.54		
PULL #2	3.22	3.56		
PULL #3	3.50	3.53		
PULL #4	3.37	3.41		
PULL #5	3.51	3.55		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.27	4.56		4.39
PULL #2	4.33	4.46		4.47
PULL #3	4.34	4.51		4.49
PULL #4	4.30	4.26		4.45
PULL #5	4.23	4.45		4.48
TOTAL				
AVG.				