

C664922B

MODEL 700™ N24

Model S&S™

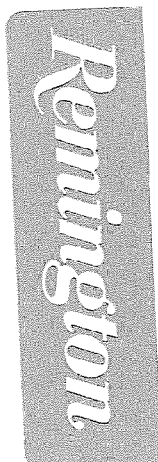
Action _____

Barrel Length _____

Capacity _____

Order No. 5715

*Includes 1 in chamber.





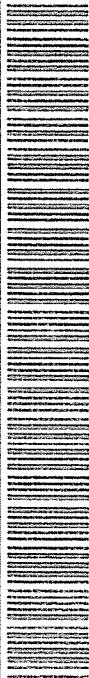

VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700™ M24

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

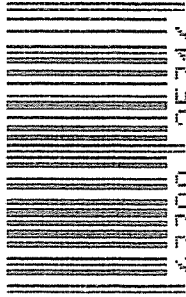
SERIAL NO.
C6649228

ORDER NO.
5716



5716 C6649228

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649228

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 25	9 1	RW
600	Proof	6 25	9 1	RW
607	Check Headspace	6 25	9 1	RW
610	Dis-assemble Gun	6 25	9 1	RW
612	Magnaflux Barrel Action		JUL 1 1991	KR
	Magnaflux Bolt		JUL 1 1991	KR
615	Rollmark Caliber		JUL 1 1991	GS.
617	Drill and Tap Sight Holes		JUL 1 1991	LB
618	Polish Barrel		JUL 2 1991	WB
620	Apply Coatings (Barrel Action)		8/27/91	AS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/28/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/28/91	RW
	C) Inspect Ejector Hole for Chamfer		8/28/91	RW
	D) Oil Firing Pin Ass'y		8/28/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9/4/91	AL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			9/4/91	WJ
	G) Safety Off Force	4	4	4			9/4/91	WJ
	H) Trigger Pull Test & Retainability						9/4/91	WJ
	I) Firing Pin Indent	.020	.021	.021			9/4/91	WJ
	J) Assemble Stock						9/4/91	RW
	K) Assemble Swivel Studs						9-10-91	AC
	L) Attach Front and Rear Sight Assemblies						9/4/91	RW
	M) Iron Sight Alignment						9/4/91	RW
	N) Detach Front & Rear Sights & place in numbered container						9/4/91	RW
	O) Attach Scope to Rifle						9/4/91	RW
	P) Detach & Attach Scope 20 Times						9/4/91	RW
640	Gallery Target & Test						9-5-91	DH
	A) Time						9-5-91	DH
	B) Malfunctions						9-5-91	DH
	C) Pierced Primers						9-5-91	DH
	D) Optical Clarity of Scope						9-5-91	DH
645	Inspect for Live Ammo						9-5-91	DH
655	Final Inspection							
	A) Headspace						9-10-91	AC
	B) Trigger Pull	2.71	2.63	2.57	2.47	2.47	9-6-91	WJ
	C) Function						9-10-91	AC
660	Pack						9-17-91	DH

SWS TRIGGER PULL TEST

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

SERIAL NO 26649228
DATE 9-4-91
TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.47	2.52	2.48	2.71	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.44	2.47	2.44	2.63	
PULL #3	2.35	2.42	2.50	2.52	
PULL #4	2.37	2.48	2.43	2.47	
PULL #5	2.34	2.43	2.44	2.47	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.48	3.40		
PULL #2	3.50	3.42		
PULL #3	3.53	3.44		
PULL #4	3.50	3.60		
PULL #5	3.56	3.53		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.35	4.25		4.53
PULL #2	4.32	4.30		4.43
PULL #3	4.28	4.21		4.35
PULL #4	4.44	4.26		4.37
PULL #5	4.44	4.51		4.40
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649228
5 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.175824
1 TO	2	.210535
1 TO	3	.593001
1 TO	4	.26466
1 TO	5	.467372

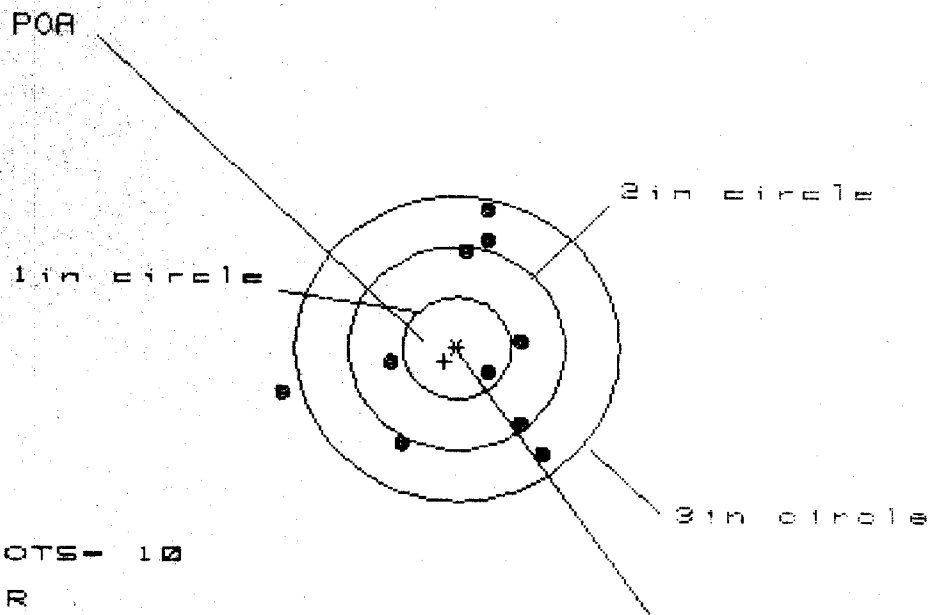
37 <----POB

COORDINATE FOR THIS RIFLE IS: -.1592
COORDINATE FOR THIS RIFLE IS: .0142
AVERAGE POI RADIUS FOR THIS RIFLE IS: .159882
THIS RIFLE IS: .9458

5 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649228

CENTERFIRE PATTERNS # 1



* OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 2.402

VS= 2.343

GS= 2.598

CENTROID *

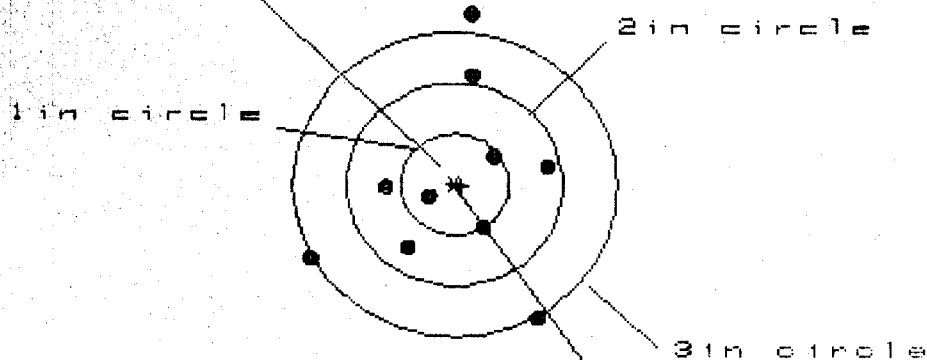
PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.755	.573	.586
MINIMUM X	:	-1.647	-.830	-.817
MAXIMUM Y	:	1.334	1.289	1.168
MINIMUM Y	:	-1.009	-1.054	-.893
CENTROID X	:	.115	.297	.284
CENTROID Y	:	.133	.178	.017
POA TO CENTROID in.	:	.176	.347	.285
MIN RADIUS	:	.368	.279	.162
MEAN RADIUS	:	1.002	.896	.823
MAX RADIUS	:	1.695	1.293	1.179
HORIZONTAL SPREAD	:	2.402	1.403	1.403
VERTICAL SPREAD	:	2.343	2.343	2.061
EXTREME SPREAD	:	2.598	2.444	2.199
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

5 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649228

CENTERFIRE PATTERNS # 2

POA



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.148

VS= 3.061

GS= 3.130

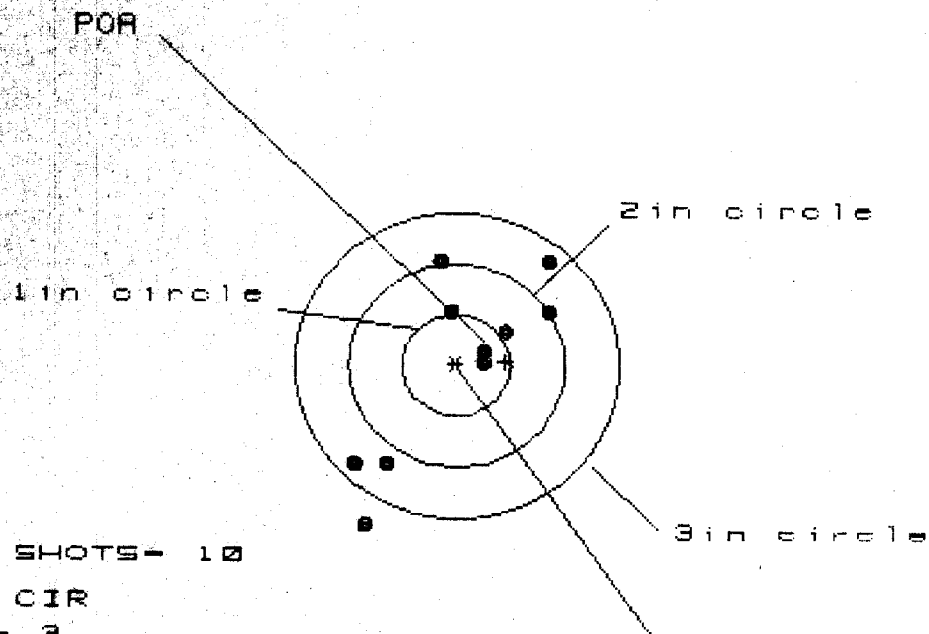
CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.856	.870	.971
MINIMUM X	:	-1.292	-1.278	-1.178
MAXIMUM Y	:	1.728	1.270	1.127
MINIMUM Y	:	-1.333	-1.141	-.689
CENTROID X	:	-.062	-.076	-.176
CENTROID Y	:	.019	-.173	-.030
POA TO CENTROID in.	:	.065	.189	.179
MIN RADIUS	:	.241	.230	.116
MEAN RADIUS	:	.926	.819	.732
MAX RADIUS	:	1.733	1.394	1.364
HORIZONTAL SPREAD	:	2.148	2.148	2.148
VERTICAL SPREAD	:	3.061	2.411	1.816
EXTREME SPREAD	:	3.130	2.488	2.334
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

5 Sep 1991

FILE: PATTERNING/CENTERFIRE_PATT/C6649228

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 9

HS= 1.757

VS= 2.564

GS= 3.084

CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.846	.749	.623
MINIMUM X	:	-.911	-1.008	-.898
MAXIMUM Y	:	.995	.821	.674
MINIMUM Y	:	-1.569	-1.169	-1.252
CENTROID X	:	-.454	-.357	-.231
CENTROID Y	:	-.034	.140	.286
POA TO CENTROID in.	:	.455	.384	.368
MIN RADIUS	:	.277	.127	.157
MEAN RADIUS	:	.916	.746	.600
MAX RADIUS	:	1.793	1.544	1.540
HORIZONTAL SPREAD	:	1.757	1.757	1.521
VERTICAL SPREAD	:	2.564	1.990	1.926
EXTREME SPREAD	:	3.084	2.655	2.454
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

5 Sep 1991

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CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

* OF SHOTS - 10

* IN CIR

1 in = 2

2 in = 5

3 in = 7

HS = 3.901

VS = 2.052

GS = 3.977

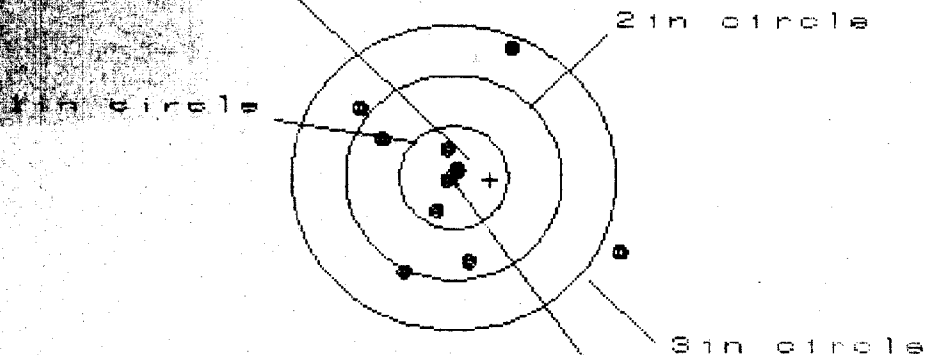
CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.669	1.421	1.188
MINIMUM X	:	-2.232	-1.754	-1.576
MAXIMUM Y	:	.867	.735	.667
MINIMUM Y	:	-1.185	-1.786	-1.854
CENTROID X	:	-.056	.192	.014
CENTROID Y	:	-.069	.063	.131
POA TO CENTROID in.	:	.089	.202	.131
MIN RADIUS	:	.431	.214	.404
MEAN RADIUS	:	1.141	.915	.862
MAX RADIUS	:	2.527	1.784	1.625
HORIZONTAL SPREAD	:	3.901	3.175	2.764
VERTICAL SPREAD	:	2.052	1.521	1.521
EXTREME SPREAD	:	3.977	3.182	2.792
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	7		

FILE:/PATTERNING/CENTERFIRE_PATT/C6649228

CENTERFIRE PATTERNS # 5

POA



OF SHOTS - 10

IN CIR

1in = 4

2in = 6

3in = 9

HS = 2.330

VS = 2.162

GS = 2.685

CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.499	.658	.382
MINIMUM X	:	-.831	-.665	-.582
MAXIMUM Y	:	1.285	1.209	.723
MINIMUM Y	:	-.877	-.953	-.802
CENTROID X	:	-.339	-.505	-.588
CENTROID Y	:	.022	.098	-.053
POA TO CENTROID in.	:	.340	.515	.590
MIN RADIUS	:	.085	.181	.195
MEAN RADIUS	:	.744	.640	.546
MAX RADIUS	:	1.648	1.376	.928
HORIZONTAL SPREAD	:	2.330	1.323	.964
VERTICAL SPREAD	:	2.162	2.162	1.525
EXTREME SPREAD	:	2.685	2.373	1.717
NUMBER IN ONE INCH CIRCLE =	:	4		
NUMBER IN TWO INCH CIRCLE =	:	6		
NUMBER IN THREE INCH CIRCLE =	:	9		