

66649238

MODEL 700™ M24

Model 545™

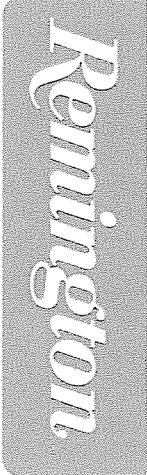
Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.






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

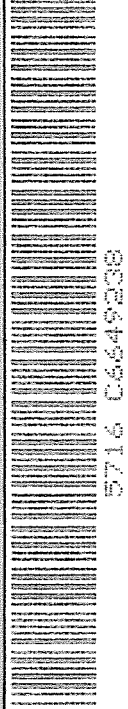
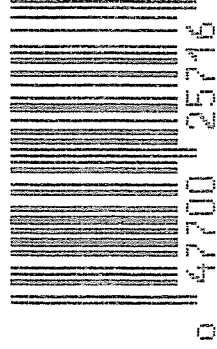
MODEL 700™ H24

SERIAL NO.
C6649238

ORDER NO.
5716

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

LPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649238

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 2 9 1		RW
600	Proof	7 2 9 1		RW
607	Check Headspace	7 2 9 1		RW
610	Dis-assemble Gun	7 2 9 1		RW
612	Magnaflux Barrel Action		JUL 22 1991	LS
	Magnaflux Bolt		JUL 22 1991	LS
615	Rollmark Caliber		JUL 22 1991	LS
617	Drill and Tap Sight Holes		JUL 22 1991	LB
618	Polish Barrel		7/29/91	WB
620	Apply Coatings (Barrel Action)		8-8-91	LB
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/9/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/9/91	RW
	C) Inspect Ejector Hole for Chamfer		8/9/91	RW
	D) Oil Firing Pin Ass'y		8/9/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8-13-91	HL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8-13-91	JU
	G) Safety Off Force	4	4	4			8-13-91	JU
	H) Trigger Pull Test & Retainability						8-13-91	JU
	I) Firing Pin Indent	.0205	.0205	.0205			8-13-91	JU
	J) Assemble Stock						8-15-91	RW
	K) Assemble Swivel Studs						8-17-91	DH
	L) Attach Front and Rear Sight Assemblies						8-15-91	RW
	M) Iron Sight Alignment						8-15-91	RW
	N) Detach Front & Rear Sights & place in numbered container						8-15-91	RW
	O) Attach Scope to Rifle						8-15-91	RW
	P) Detach & Attach Scope 20 Times						8-15-91	RW
640	Gallery Target & Test						8-15-91	DH
	A) Time						8-15-91	DH
	B) Malfunctions						8-15-91	DH
	C) Pierced Primers						8-15-91	DH
	D) Optical Clarity of Scope						8-15-91	DH
645	Inspect for Live Ammo						8-15-91	DH
655	Final Inspection						8-17-91	DH
	A) Headspace						8-17-91	DH
	B) Trigger Pull	2.74	2.68	2.67	2.68	2.78	8-17-91	DH
	C) Function						8-17-91	DH
660	Pack						8-17-91	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6649238

DATE 8-13-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.27	2.25	2.59	2.74	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.20	2.29	2.57	2.68	
PULL #3	2.48	2.20	2.60	2.67	
PULL #4	2.29	2.51	2.44	2.68	
PULL #5	2.42	2.60	2.54	2.78	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.38	3.25		
PULL #2	3.37	3.37		
PULL #3	3.37	3.36		
PULL #4	3.27	3.32		
PULL #5	3.34	3.28		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.50	4.47		4.46
PULL #2	4.55	4.37		4.37
PULL #3	4.22	4.37		4.44
PULL #4	4.40	4.43		4.60
PULL #5	4.54	4.49		4.50
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06649238
20 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.268187
1 TO	2	.442764
1 TO	3	.468386
1 TO	4	.417528
1 TO	5	.525298

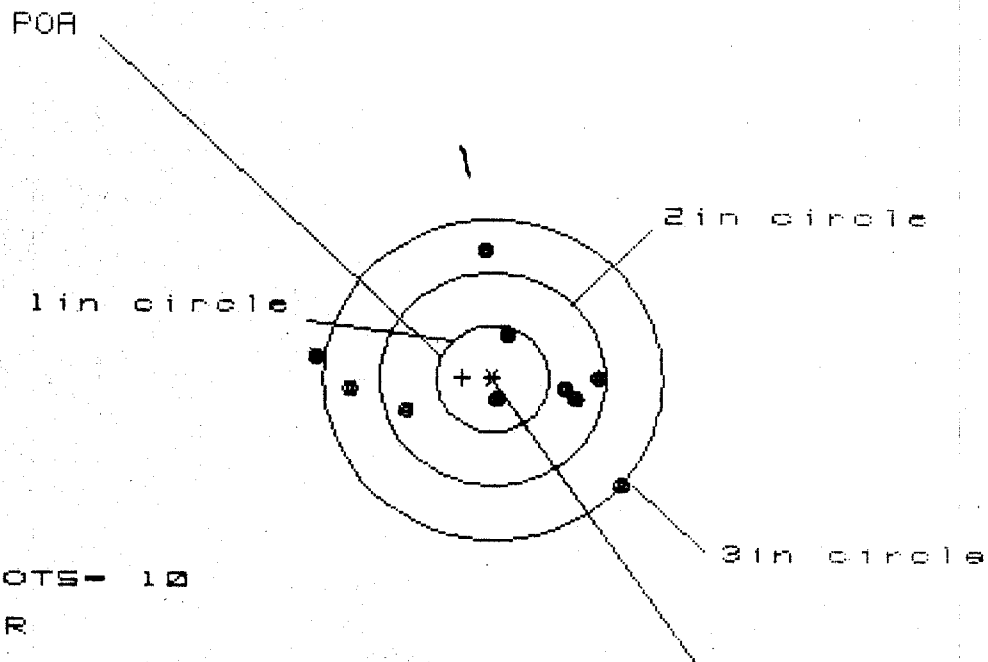
St1 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0742
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1052
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .128735
THE AMR FOR THIS RIFLE IS: .8062

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649238

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 2.675

VS= 2.166

ES= 2.935

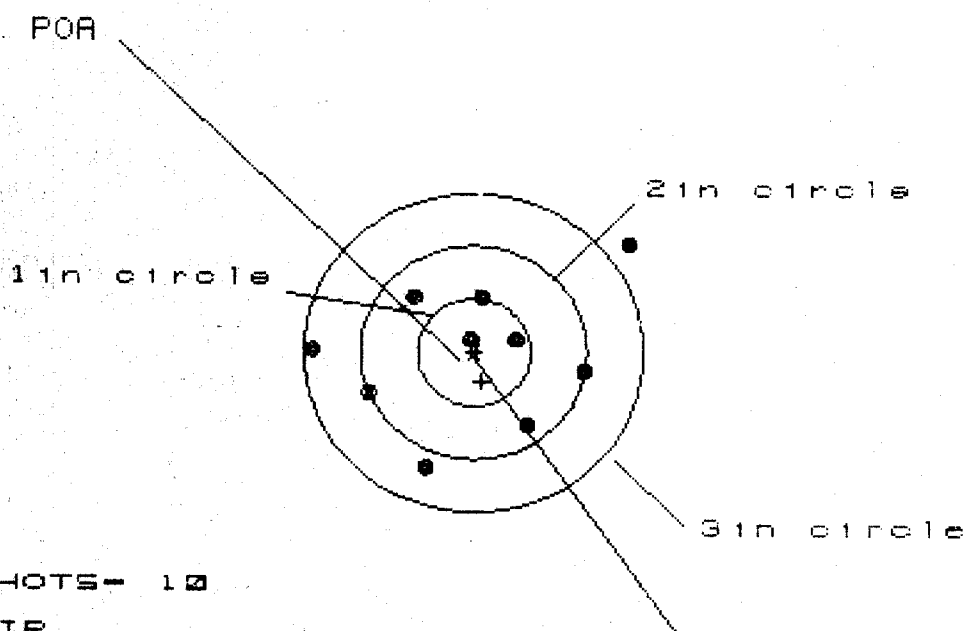
CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.125	.953	.918
MINIMUM X	:	-1.550	-1.447	-1.328
MAXIMUM Y	:	1.163	1.186	1.063
MINIMUM Y	:	-1.003	-.980	-.438
CENTROID X	:	.268	.440	.321
CENTROID Y	:	-.010	-.033	.090
POA TO CENTROID in.	:	.268	.441	.333
MIN RADIUS	:	.166	.186	.259
MEAN RADIUS	:	.933	.835	.775
MAX RADIUS	:	1.563	1.450	1.345
HORIZONTAL SPREAD	:	2.675	2.400	2.246
VERTICAL SPREAD	:	2.166	2.166	1.501
EXTREME SPREAD	:	2.935	2.560	2.251
NUMBER IN ONE INCH CIRCLE =	:	2	2	2
NUMBER IN TWO INCH CIRCLE =	:	6	6	6
NUMBER IN THREE INCH CIRCLE =	:	8	8	8

23 Aug 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 9

HS= 2.731

VS= 2.169

GS= 2.934

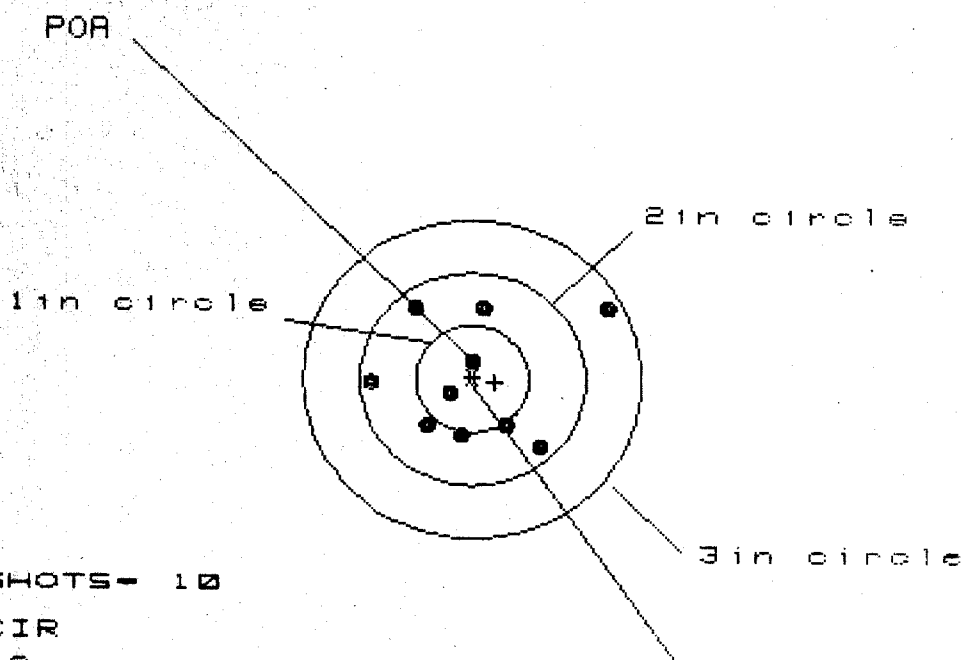
CENTROID *

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.335	1.140	.984
MINIMUM X	:	-1.396	-1.247	-.934
MAXIMUM Y	:	1.049	.660	.671
MINIMUM Y	:	-1.120	-1.003	-.991
CENTROID X	:	-.070	-.219	-.063
CENTROID Y	:	.276	.159	.147
POA TO CENTROID in.	:	.285	.270	.160
MIN RADIUS	:	.150	.296	.279
MEAN RADIUS	:	.898	.826	.752
MAX RADIUS	:	1.698	1.251	1.079
HORIZONTAL SPREAD	:	2.731	2.387	1.918
VERTICAL SPREAD	:	2.169	1.663	1.663
EXTREME SPREAD	:	2.934	2.392	1.924
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 = 3

2in = 8

3in = 10

HS= 2.070

VS= 1.373

GS= 2.186

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.164	.742	.645
MINIMUM X	:	-.906	-.777	-.503
MAXIMUM Y	:	.715	.778	.789
MINIMUM Y	:	-.658	-.578	-.567
CENTROID X	:	-.199	-.328	-.231
CENTROID Y	:	.026	-.054	-.065
POA TO CENTROID in.	:	.201	.333	.240
MIN RADIUS	:	.142	.146	.224
MEAN RADIUS	:	.685	.585	.559
MAX RADIUS	:	1.366	.941	.936
HORIZONTAL SPREAD	:	2.070	1.519	1.148
VERTICAL SPREAD	:	1.373	1.356	1.356
EXTREME SPREAD	:	2.186	1.777	1.777
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

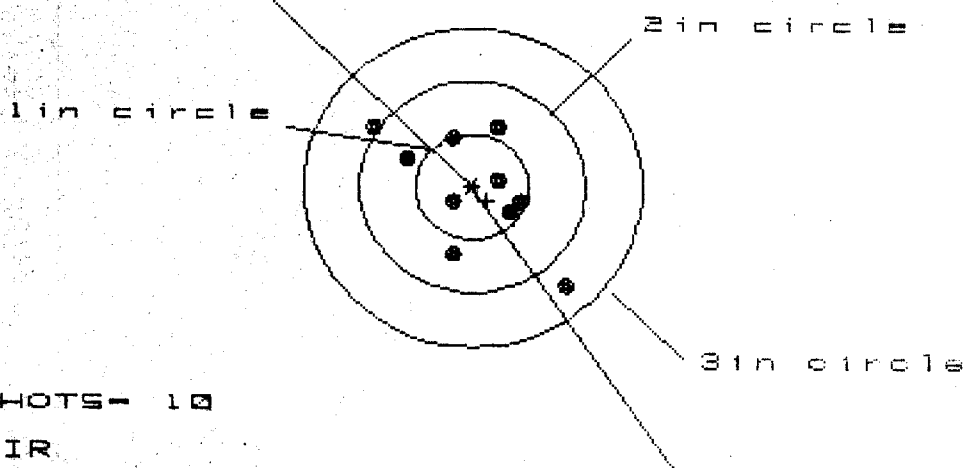
23 Aug 1991

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CENTERFIRE PATTERNS

4

POA



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 8

3 in = 10

HS= 1.650

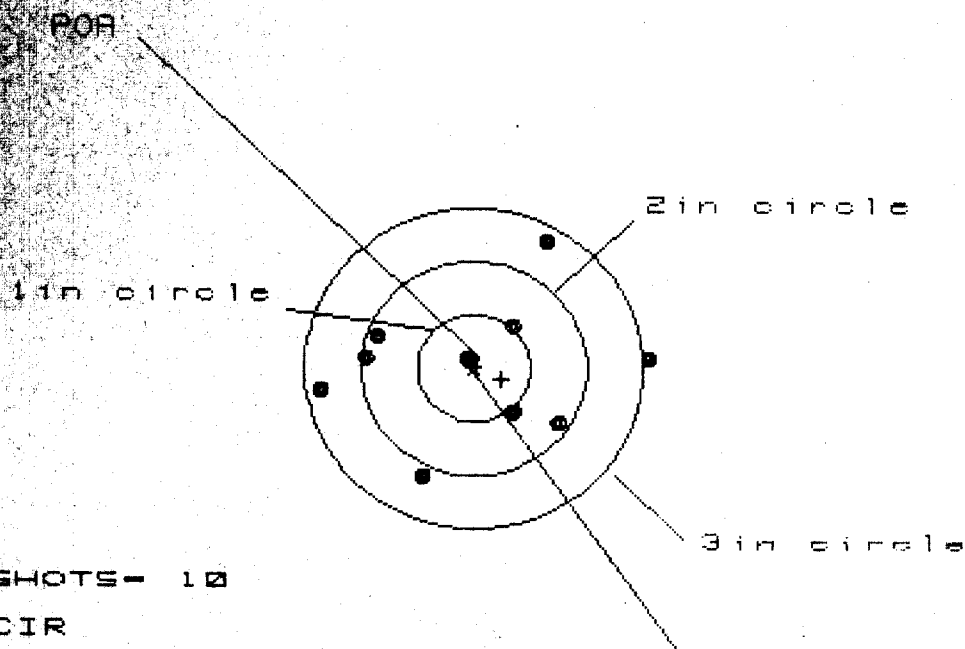
VS= 1.504

GS= 2.180

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.788	.503	.406
MINIMUM X	:	-.862	-.774	-.557
MAXIMUM Y	:	.616	.517	.572
MINIMUM Y	:	-.888	-.747	-.692
CENTROID X	:	-.125	-.213	-.116
CENTROID Y	:	.131	.230	.175
POA TO CENTROID in.	:	.181	.313	.210
MIN RADIUS	:	.191	.208	.192
MEAN RADIUS	:	.594	.526	.466
MAX RADIUS	:	1.187	.890	.713
HORIZONTAL SPREAD	:	1.650	1.277	.963
VERTICAL SPREAD	:	1.504	1.264	1.264
EXTREME SPREAD	:	2.180	1.452	1.311
NUMBER IN ONE INCH CIRCLE	:	4	4	4
NUMBER IN TWO INCH CIRCLE	:	8	8	8
NUMBER IN THREE INCH CIRCLE	:	10	10	10

CENTERFIRE PATTERNS

5



OF SHOTS - 10

IN CIR

1in = 1

2in = 6

3in = 9

HS = 2.878

VS = 2.158

GS = 2.889

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.535	.934	.788
MINIMUM X	:	-1.343	-1.173	-.930
MAXIMUM Y	:	1.163	1.168	1.144
MINIMUM Y	:	-.995	-.990	-1.014
CENTROID X	:	-.245	-.415	-.269
CENTROID Y	:	.103	.098	.122
POA TO CENTROID in.	:	.266	.427	.295
MIN RADIUS	:	.104	.182	.083
MEAN RADIUS	:	.921	.854	.789
MAX RADIUS	:	1.536	1.419	1.320
HORIZONTAL SPREAD	:	2.978	2.107	1.718
VERTICAL SPREAD	:	2.158	2.158	2.158
EXTREME SPREAD	:	2.889	2.433	2.433
NUMBER IN ONE INCH CIRCLE =	:		1	
NUMBER IN TWO INCH CIRCLE =	:		6	
NUMBER IN THREE INCH CIRCLE =	:		9	