

C6611583

MODEL 700™ M24

Model S&S™

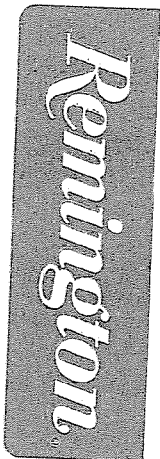
Action _____

Barrel Length _____

Capacity _____

Order No. 5716

*Includes 1 in chamber.






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

REG. U.S. PAT. & TM. OFF.

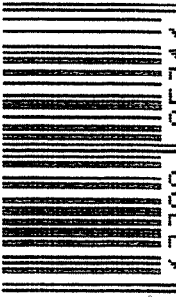
MODEL 700TM H24

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

SERIAL NO.	ORDER NO.
C6611583	5716

46

UPC



0 47700 25716 2



5716 C6611583

Repaired
Stock

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611583

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/26/91	K.S.
600	Proof		3/26/91	K.S.
607	Check Headspace		3/26/91	K.S.
610	Dis-assemble Gun		3/26/91	K.S.
612	Magnaflux Barrel Action	APR 2 1991		KR
	Magnaflux Bolt	APR 2 1991		U
615	Rollmark Caliber	APR 2 1991		LS
617	Drill and Tap Sight Holes	APR 5 1991		LB
618	Polish Barrel	APR 5 1991		WB
620	Apply Coatings (Barrel Action)		4/10/91	JS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/10/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/10/91	KS
	C) Inspect Ejector Hole for Chamfer		4/10/91	KS
	D) Oil Firing Pin Ass'y		4/10/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		4/11/91	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2			4/12/91	CSB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			4/12/91	CSB
	H) Trigger Pull Test & Retainability						4/11/91	JH
	I) Firing Pin Indent	.0225	.0225	.0225			4/12/91	CSB
	J) Assemble Stock						4/17/91	KS
	K) Assemble Swivel Studs						4-22-91	DH
	L) Attach Front and Rear Sight Assemblies						4/17/91	KS
	M) Iron Sight Alignment						4/17/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/17/91	KS
	O) Attach Scope to Rifle						4/17/91	KS
	P) Detach & Attach Scope 20 Times						4/17/91	KS
640	Gallery Target & Test						4-18-91	DH
	A) Time						4-18-91	DH
	B) Malfunctions						4-18-91	DH
	C) Pierced Primers						4-18-91	DH
	D) Optical Clarity of Scope						4-18-91	DH
645	Inspect for Live Ammo						4-18-91	DH
655	Final Inspection						4-22-91	DH
	A) Headspace							
	B) Trigger Pull	2.42	2.38	2.35	2.42	2.22	4/22/91	JH
	C) Function						4-22-91	DH
660	Pack						6-14-91	NF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6611583
DATE 4/11/91
TESTER JPL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.36	2.20	2.29	2.42	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.40	2.19	2.30	2.38	
PULL #3	2.36	2.20	2.27	2.35	
PULL #4	2.45	2.23	2.20	2.42	
PULL #5	2.42	2.29	2.22	2.22	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.25	3.30		
PULL #2	3.27	3.42		
PULL #3	3.42	3.48		
PULL #4	3.33	3.39		
PULL #5	3.39	3.48		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.20	4.32		4.23
PULL #2	4.40	4.41		4.40
PULL #3	4.29	4.38		4.32
PULL #4	4.41	4.35		4.35
PULL #5	4.22	4.36		4.28
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611583
18 Apr 1991

CENTROIDAL DISTANCES

Ø TO	1	.213378
1 TO	2	.287446
1 TO	3	.309013
1 TO	4	.377139
1 TO	5	.377139

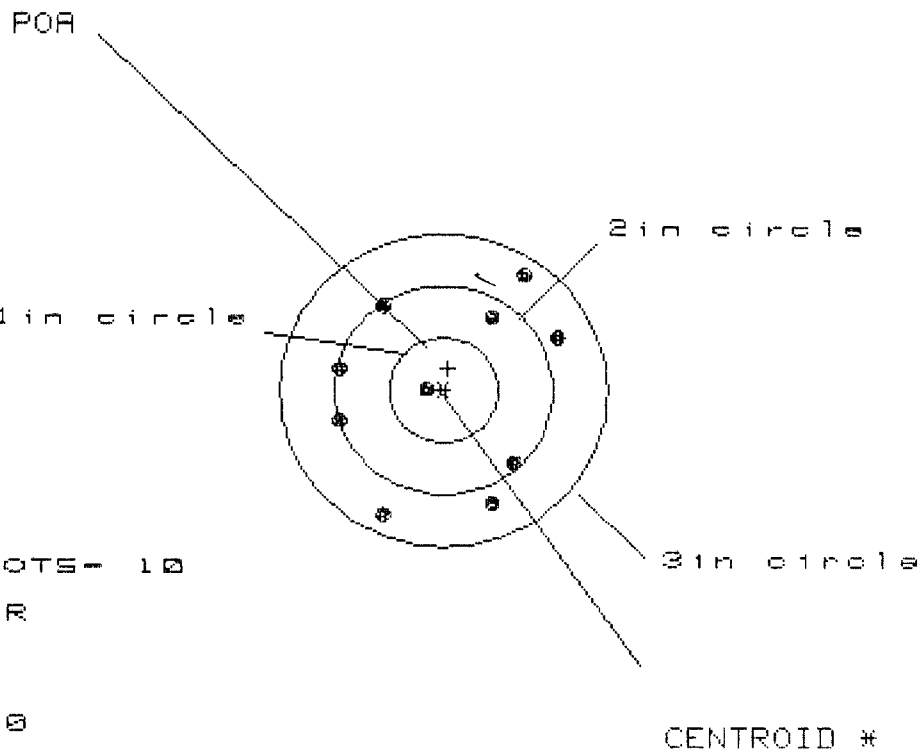
35 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0774
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0214
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0003039
THE AMR FOR THIS RIFLE IS: .9356

18 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611583

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 2.023

VS= 2.307

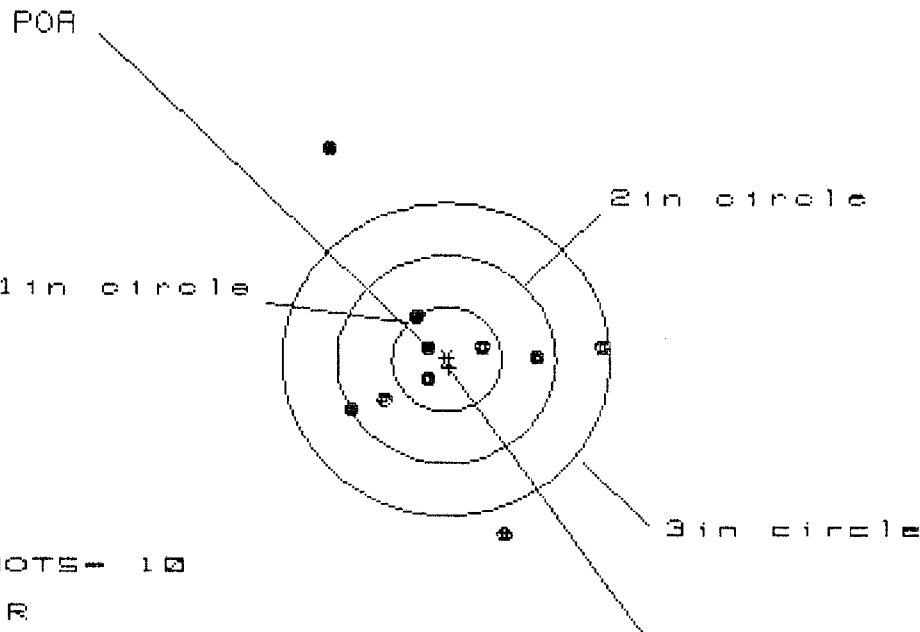
GS= 2.643

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.024	1.105	1.044
MINIMUM X	-.999	-.918	-.979
MAXIMUM Y	1.125	.885	.752
MINIMUM Y	-1.182	-1.057	-1.073
CENTROID X	-.043	-.124	-.063
CENTROID Y	-.209	-.334	-.201
POA TO CENTROID in.	.213	.356	.211
MIN RADIUS	.187	.159	.168
MEAN RADIUS	.992	.943	.907
MAX RADIUS	1.338	1.289	1.171
HORIZONTAL SPREAD	2.023	2.023	2.023
VERTICAL SPREAD	2.307	1.942	1.825
EXTREME SPREAD	2.643	2.342	2.196
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10
IN CIR
1in = 4
2in = 6
3in = 8
HS= 2.539
VS= 3.754
GS= 4.091

CENTROID #

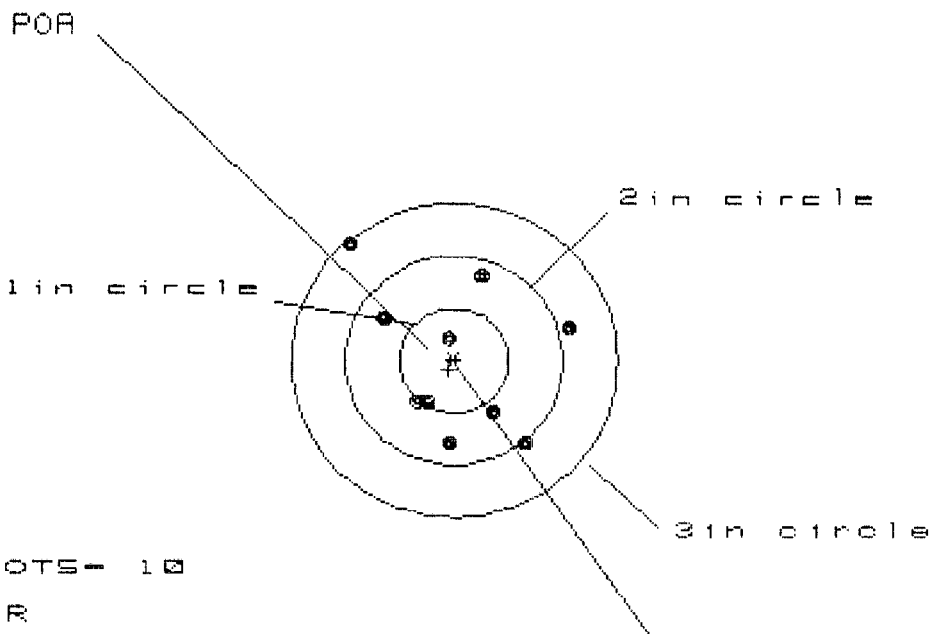
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.468	1.349	1.403
MINIMUM X	:	-1.071	-.982	-.928
MAXIMUM Y	:	2.045	.599	.414
MINIMUM Y	:	-1.709	-1.482	-.474
CENTROID X	:	-.027	.092	.038
CENTROID Y	:	.078	-.149	.036
POA TO CENTROID in.	:	.082	.175	.052
MIN RADIUS	:	.175	.283	.252
MEAN RADIUS	:	.938	.813	.671
MAX RADIUS	:	2.309	1.545	1.408
HORIZONTAL SPREAD	:	2.539	2.331	2.331
VERTICAL SPREAD	:	3.754	2.081	.888
EXTREME SPREAD	:	4.091	2.405	2.405
NUMBER IN ONE INCH CIRCLE	=	4		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	8		

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CENTERFIRE PATTERNS

3



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

HS = 2.017

VS = 1.901

GS = 2.536

CENTROID #

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.035	.926	1.000
MINIMUM X	-.982	-.795	-.722
MAXIMUM Y	1.080	.938	.850
MINIMUM Y	-.821	-.701	-.748
CENTROID X	.049	.158	.085
CENTROID Y	.086	-.034	.054
POA TO CENTROID in.	.099	.161	.100
MIN RADIUS	.222	.364	.259
MEAN RADIUS	.780	.694	.658
MAX RADIUS	1.459	1.004	1.044
HORIZONTAL SPREAD	2.017	1.721	1.721
VERTICAL SPREAD	1.901	1.639	1.598
EXTREME SPREAD	2.536	1.869	1.729
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

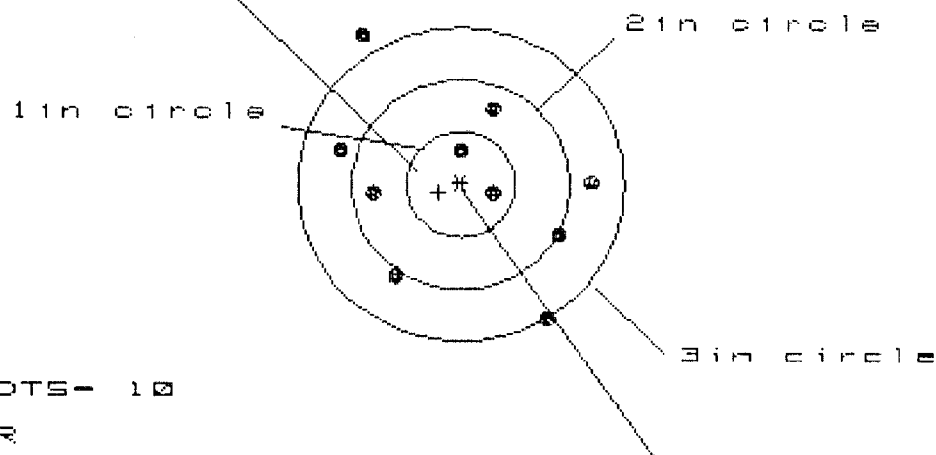
18 Apr 1991

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CENTERFIRE PATTERNS

4

POA



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 2.287

VS= 2.714

GS= 3.227

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.224	1.120	1.207
MINIMUM X	:	-1.063	-1.167	-1.080
MAXIMUM Y	:	1.428	.906	.765
MINIMUM Y	:	-1.286	-1.127	-.835
CENTROID X	:	.204	.308	.221
CENTROID Y	:	.076	-.083	.058
POA TO CENTROID in.	:	.217	.319	.229
MIN RADIUS	:	.302	.222	.291
MEAN RADIUS	:	.984	.899	.827
MAX RADIUS	:	1.712	1.325	1.207
HORIZONTAL SPREAD	:	2.287	2.287	2.287
VERTICAL SPREAD	:	2.714	2.033	1.600
EXTREME SPREAD	:	3.227	2.449	2.309
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 9

HS= 3.215

VS= 1.528

GS= 3.383

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.339	1.130	.744
MINIMUM X	:	-1.876	-1.660	-1.518
MAXIMUM Y	:	.591	.572	.581
MINIMUM Y	:	-.938	-.956	-.884
CENTROID X	:	.164	.373	.231
CENTROID Y	:	.082	.100	.028
POA TO CENTROID in.	:	.183	.386	.233
MIN RADIUS	:	.299	.341	.356
MEAN RADIUS	:	.973	.825	.787
MAX RADIUS	:	1.883	1.660	1.523
HORIZONTAL SPREAD	:	3.215	2.790	2.262
VERTICAL SPREAD	:	1.528	1.528	1.465
EXTREME SPREAD	:	3.383	2.839	2.265
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	