

C6611597

MODEL 700™ M24

Model S&S™

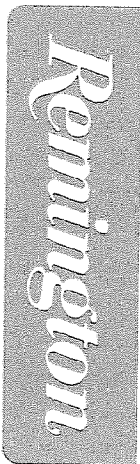
Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.






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

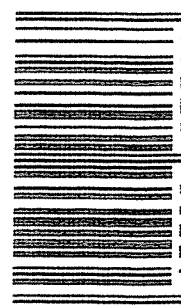
MODEL 700™ M24

SERIAL NO. C6611597

ORDER NO. 5716

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

UPC



0 47700 25716 7



5716 C6611597

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611597

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 30 91		Rw
600	Proof	4 30 91		Rw
607	Check Headspace	4 30 91		Rw
610	Dis-assemble Gun	4 30 91		Rw
612	Magnaflux Barrel Action	5 6 91		Kcd
	Magnaflux Bolt	5 6 91		Kcd
615	Rollmark Caliber	5 6 91		GS.
617	Drill and Tap Sight Holes	5 10 91		LB
618	Polish Barrel	5 10 91		WB
620	Apply Coatings (Barrel Action)		5-30-91	DA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		5/30/91	Rw
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/91	Rw
	C) Inspect Ejector Hole for Chamfer		5/30/91	Rw
	D) Oil Firing Pin Ass'y		5/30/91	Rw
	E) Adjust Trigger Pull to Min Setting and Stake		6-13-91	DH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7	6 1/4	6			6-13-91	DH
	G) Safety Off Force	3	3	3			6-13-91	DH
	H) Trigger Pull Test & Retainability						6-13-91	DH
	I) Firing Pin Indent	.020	.020	.020			6-13-91	DH
	J) Assemble Stock						6-13-91	RW
	K) Assemble Swivel Studs						6-14-91	JH
	L) Attach Front and Rear Sight Assemblies						6-13-91	RW
	M) Iron Sight Alignment						6-13-91	RW
	N) Detach Front & Rear Sights & place in numbered container						6-13-91	RW
	O) Attach Scope to Rifle						6-13-91	RW
	P) Detach & Attach Scope 20 Times						6-13-91	RW
640	Gallery Target & Test						6-14-91	DH
	A) Time						6-14-91	DH
	B) Malfunctions						6-14-91	DH
	C) Pierced Primers						6-14-91	DH
	D) Optical Clarity of Scope						6-14-91	DH
645	Inspect for Live Ammo						6-14-91	DH
655	Final Inspection						6-14-91	JH
	A) Headspace						6-14-91	JH
	B) Trigger Pull	2.25	2.18	2.19	2.17	2.15	6-14-91	JH
	C) Function						6-14-91	JH
660	Pack						6-20-91	RF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6611597

DATE 6-13-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.22	2.04	2.12	2.25	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.21	2.12	2.26	2.18	
PULL #3	2.22	2.12	2.27	2.19	
PULL #4	2.05	2.26	2.33	2.17	
PULL #5	2.03	2.11	2.57	2.15	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.29	3.00		
PULL #2	3.23	3.10		
PULL #3	3.11	3.26		
PULL #4	3.00	3.26		
PULL #5	3.10	3.26		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.42	4.46		4.19
PULL #2	4.19	4.27		4.18
PULL #3	4.07	4.22		4.17
PULL #4	4.15	4.36		4.19
PULL #5	4.13	4.25		4.11
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611597
14 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.29481
1 TO	2	.478072
1 TO	3	.319708
1 TO	4	.2014
1 TO	5	.0393573

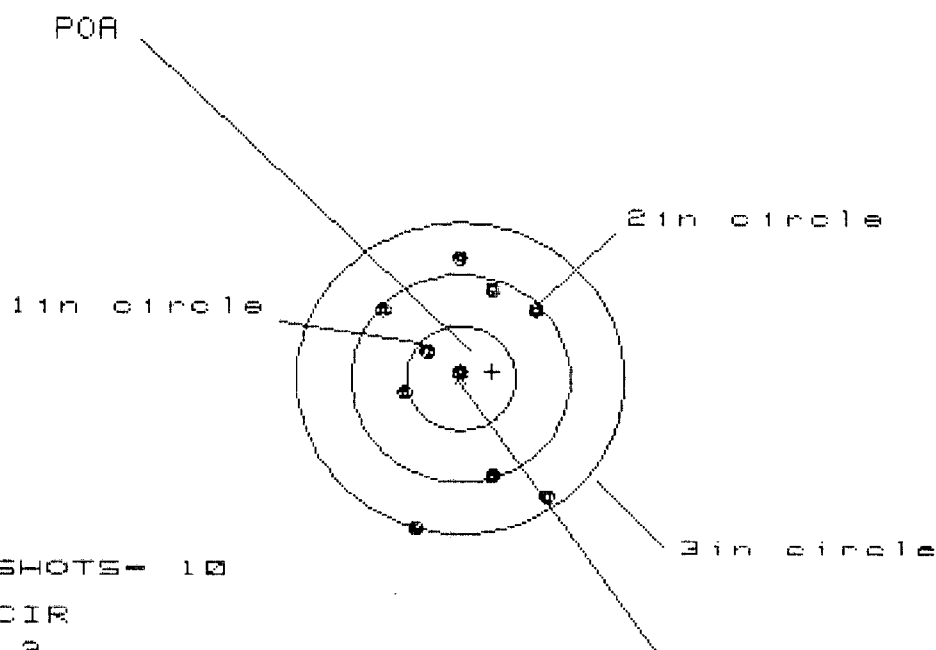
$\bar{x}^2$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2426
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0458
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .246885
THE AMR FOR THIS RIFLE IS: .8442

14 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611597

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 1.491

VS= 2.553

GS= 2.588

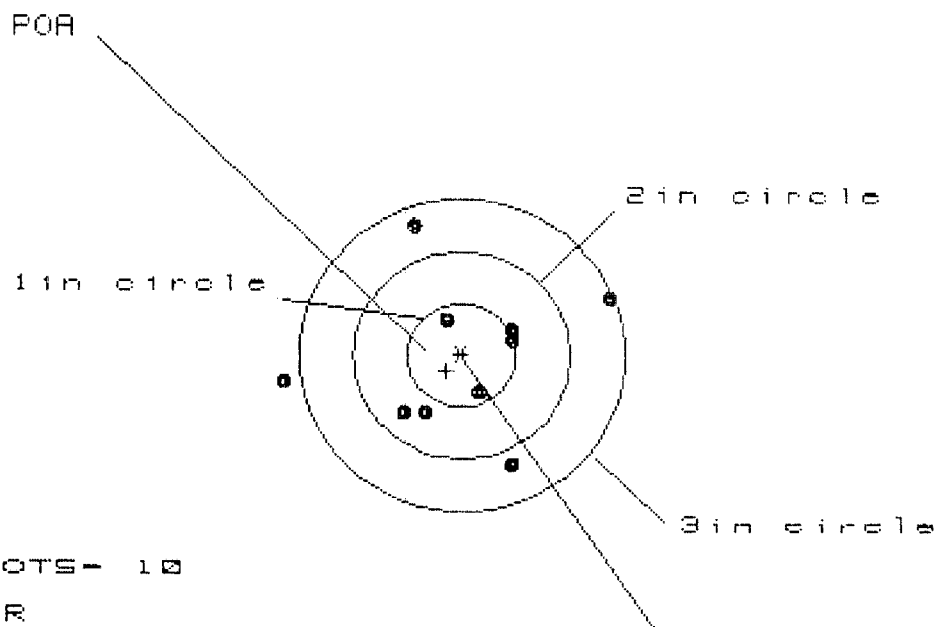
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.788	.743	.695
MINIMUM X	-.703	-.748	-.655
MAXIMUM Y	1.142	.985	.817
MINIMUM Y	-1.411	-1.340	-1.214
CENTROID X	-.288	-.243	-.336
CENTROID Y	-.063	.094	.262
POA TO CENTROID in.	.295	.260	.426
MIN RADIUS	.037	.130	.291
MEAN RADIUS	.881	.804	.689
MAX RADIUS	1.468	1.532	1.253
HORIZONTAL SPREAD	1.491	1.491	1.350
VERTICAL SPREAD	2.553	2.325	2.031
EXTREME SPREAD	2.588	2.449	2.046
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

14 Jun 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS= 2.929

VS= 2.322

GS= 3.048

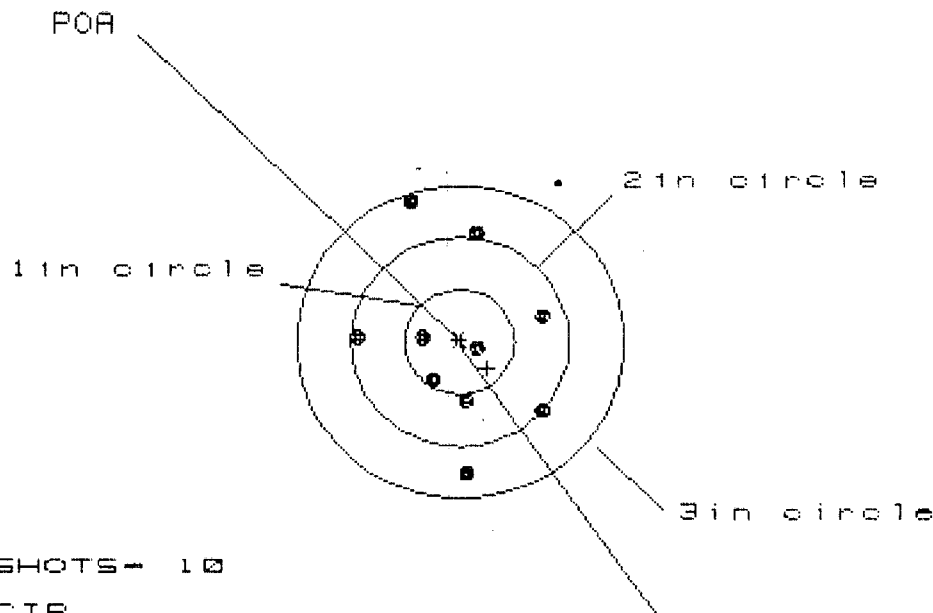
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.338	1.162	.455
MINIMUM X	:	-1.591	-.789	-.564
MAXIMUM Y	:	1.279	1.251	1.320
MINIMUM Y	:	-1.043	-1.071	-1.002
CENTROID X	:	.140	.316	.171
CENTROID Y	:	.150	.178	.109
POA TO CENTROID in.	:	.205	.363	.203
MIN RADIUS	:	.374	.345	.323
MEAN RADIUS	:	.881	.779	.712
MAX RADIUS	:	1.612	1.398	1.404
HORIZONTAL SPREAD	:	2.929	1.871	1.019
VERTICAL SPREAD	:	2.322	2.322	2.322
EXTREME SPREAD	:	3.048	2.499	2.499
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

14 Jun 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 10

HSI = 1.740

VS = 2.588

GS = 2.629

CENTROID #

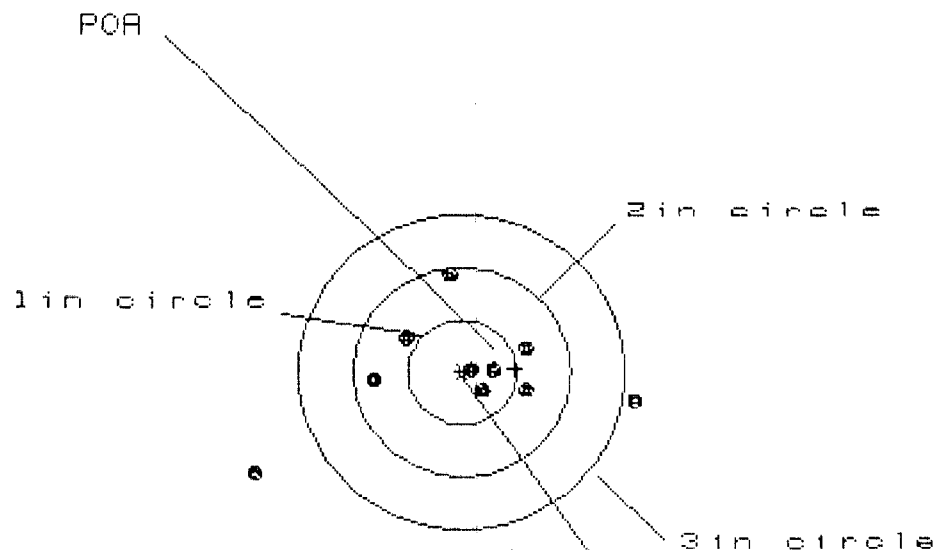
PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.804	.757	.756
MINIMUM X	:	-.936	-.983	-.985
MAXIMUM Y	:	1.362	1.221	1.086
MINIMUM Y	:	-1.226	-1.074	-.599
CENTROID X	:	-.255	-.208	-.207
CENTROID Y	:	.255	.103	.238
POA TO CENTROID in.	:	.361	.232	.315
MIN RADIUS	:	.167	.135	.116
MEAN RADIUS	:	.792	.700	.655
MAX RADIUS	:	1.427	1.225	1.091
HORIZONTAL SPREAD	:	1.740	1.740	1.740
VERTICAL SPREAD	:	2.588	2.295	1.685
EXTREME SPREAD	:	2.629	2.298	1.859
NUMBER IN ONE INCH CIRCLE =	:	3		
NUMBER IN TWO INCH CIRCLE =	:	6		
NUMBER IN THREE INCH CIRCLE =	:	10		

14 Jun 1981

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CENTERFIRE PATTERNS

4



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 8

3 in = 8

HS = 3.423

VS = 1.920

GS = 3.513

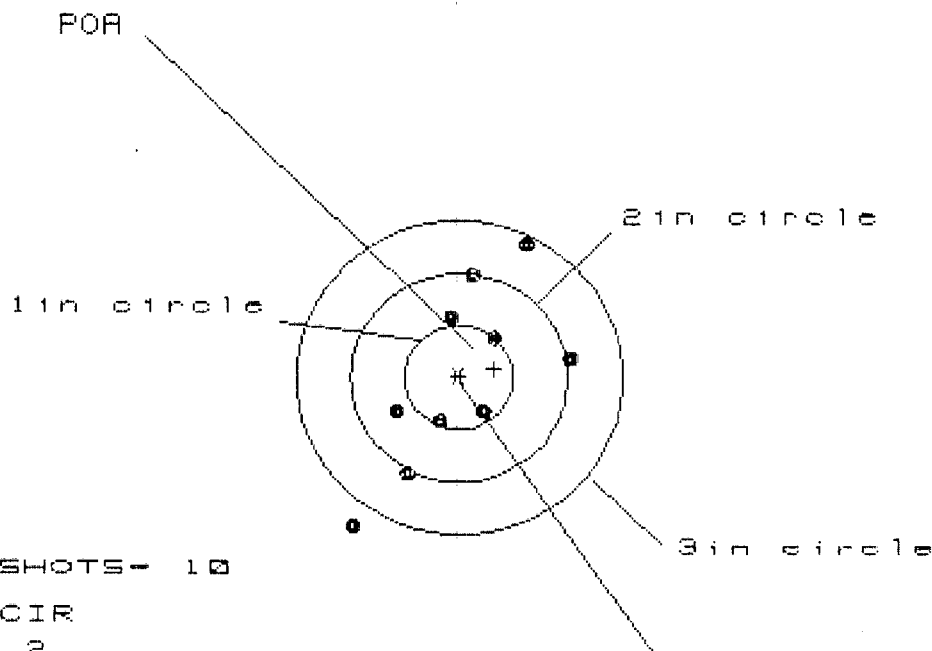
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.541	1.332	.569
MINIMUM X	:	-1.882	-.973	-.806
MAXIMUM Y	:	.908	.795	.753
MINIMUM Y	:	-1.012	-.336	-.317
CENTROID X	:	-.487	-.278	-.445
CENTROID Y	:	-.032	.081	.123
POA TO CENTROID in.	:	.488	.290	.461
MIN RADIUS	:	.083	.068	.140
MEAN RADIUS	:	.781	.588	.505
MAX RADIUS	:	2.137	1.374	.831
HORIZONTAL SPREAD	:	3.423	2.305	1.375
VERTICAL SPREAD	:	1.920	1.131	1.070
EXTREME SPREAD	:	3.513	2.312	1.377
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		8	

14 Jun 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 3

HS= 2.000

VS= 2.718

GS= 3.150

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.071
MINIMUM X	-1.009
MAXIMUM Y	1.318
MINIMUM Y	-1.400
CENTROID X	-.323
CENTROID Y	-.081
POA TO CENTROID in.	.333
MIN RADIUS	.344
MEAN RADIUS	.886
MAX RADIUS	1.726
HORIZONTAL SPREAD	2.000
VERTICAL SPREAD	2.718
EXTREME SPREAD	3.150
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	3