

C6611598

MODEL 700™ M24

Model 5145™

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 700™ H24

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

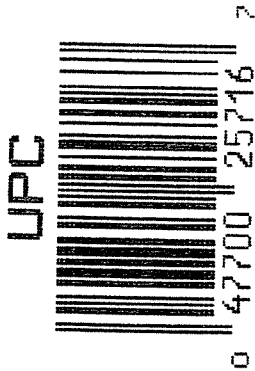
SERIAL NO.

C6611598

ORDER NO.

5716

46



MOD. _____ GA. CAL. _____ GUN # _____

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st	<i>Safe binds</i>	<i>KS</i>
	2nd	<i>Repaired</i>	<i>4/18/91</i> <i>KS</i>
	3rd		
	4th		

FUNCTION

RD 6654

Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6611598

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	LC
615	Rollmark Caliber	APR	2 1991	GL
617	Drill and Tap Sight Holes	APR	5 1991	FB
618	Polish Barrel	APR	5 1991	WB
620	Apply Coatings (Barrel Action)		4-10-91	DK
	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		4/15/91	AK

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			4/15/91	JL
	G) Safety Off Force	3	3	3			4/15/91	JL
	H) Trigger Pull Test & Retainability						4/15/91	JL
	I) Firing Pin Indent	1020	1020	1020			4/15/91	JL
	J) Assemble Stock						4/17/91	KS
	K) Assemble Swivel Studs						4-24-91	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 A) Headspace						4-24-91	DH
	B) Trigger Pull	2.16	2.15	2.15	2.18	2.17	4/23/91	JL
	C) Function						4-24-91	DH
660	Pack						6-18-91	DH

SWS TRIGGER PULL TEST

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

SERIAL NO

C6611598

DATE

4/15/91

TESTER

[Signature]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.48	2.36	2.25	2.16	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.34	2.20	2.15	
PULL #3	2.44	2.25	2.36	2.15	
PULL #4	2.39	2.18	2.22	2.18	
PULL #5	2.30	2.23	2.20	2.17	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.35	3.29		
PULL #2	3.37	3.33		
PULL #3	3.20	3.27		
PULL #4	3.20	3.30		
PULL #5	3.14	3.15		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.43	4.36		4.28
PULL #2	4.19	4.14		4.13
PULL #3	4.19	4.27		4.26
PULL #4	4.26	4.28		4.16
PULL #5	4.20	4.33		4.28
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611598
18 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.0650692
1 TO	2	.253712
1 TO	3	.191
1 TO	4	.141651
1 TO	5	.330946

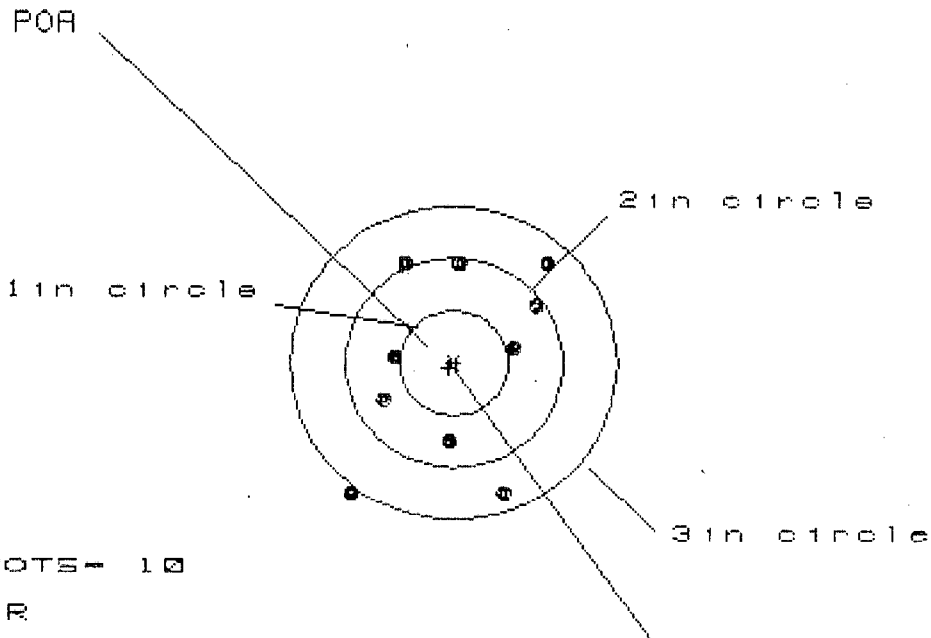
$\frac{2}{35}$ <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1352
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0366
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .140066
THE AMR FOR THIS RIFLE IS: 1.006

18 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6811598

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 0

2in = 6

3in = 9

HS= 1.821

VS= 2.254

GS= 2.893

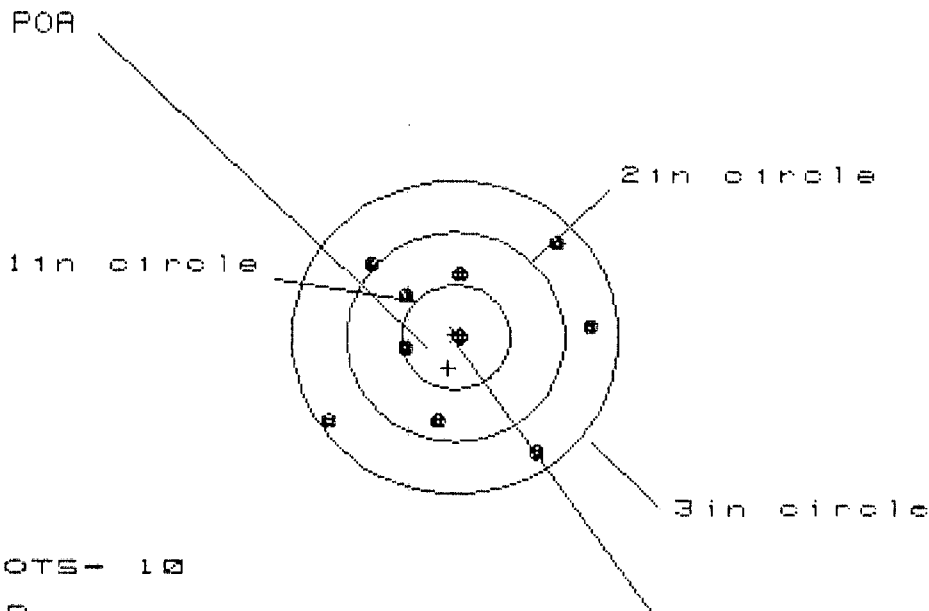
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.838	.729	.770
MINIMUM X	-.983	-.713	-.672
MAXIMUM Y	.971	.828	.657
MINIMUM Y	-1.283	-1.371	-1.063
CENTROID X	.045	.154	.113
CENTROID Y	.047	.190	.361
POA TO CENTROID in.	.065	.244	.378
MIN RADIUS	.538	.417	.497
MEAN RADIUS	.963	.874	.790
MAX RADIUS	1.616	1.408	1.068
HORIZONTAL SPREAD	1.821	1.442	1.442
VERTICAL SPREAD	2.254	2.199	1.720
EXTREME SPREAD	2.893	2.320	1.937
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

18 Apr 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 10

IS= 2.348

VS= 1.914

GS= 2.677

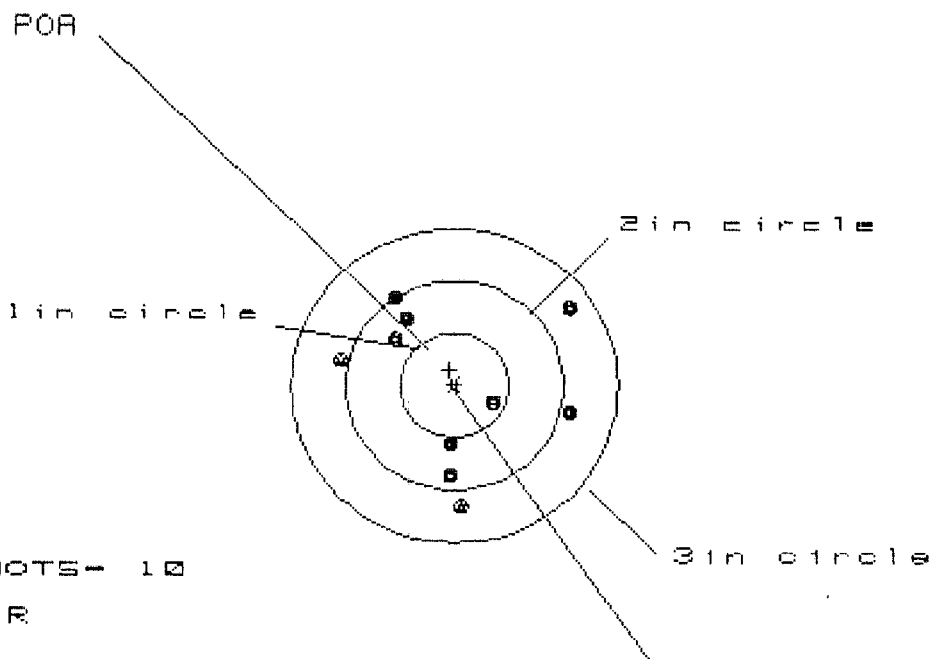
CENTROID *

PATTERN #	:	92		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.211	1.084	1.187
MINIMUM X	:	-1.137	-.922	-.819
MAXIMUM Y	:	.860	.769	.750
MINIMUM Y	:	-1.054	-1.145	-1.049
CENTROID X	:	.064	.191	.088
CENTROID Y	:	.300	.391	.295
POA TO CENTROID in.	:	.307	.435	.307
MIN RADIUS	:	.094	.139	.071
MEAN RADIUS	:	.883	.829	.769
MAX RADIUS	:	1.399	1.290	1.259
HORIZONTAL SPREAD	:	2.348	2.006	2.006
VERTICAL SPREAD	:	1.914	1.914	1.799
EXTREME SPREAD	:	2.677	2.353	2.353
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

HS= 2.076

VS= 2.005

GS= 2.157

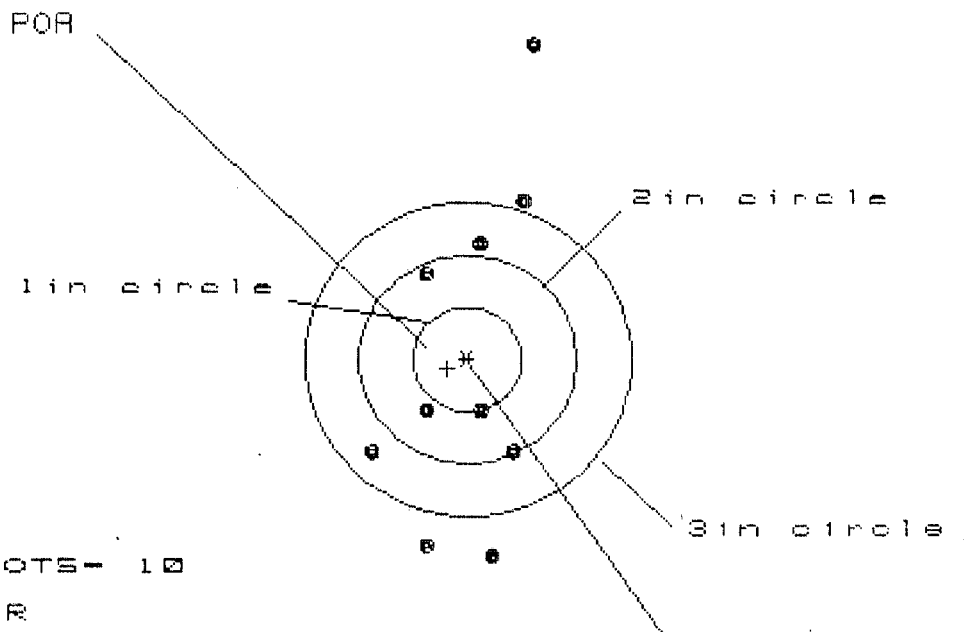
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.081	1.201	1.222
MINIMUM X	:	-.995	-.875	-.854
MAXIMUM Y	:	.876	.961	.831
MINIMUM Y	:	-1.129	-1.044	-.854
CENTROID X	:	.045	-.075	-.096
CENTROID Y	:	-.144	-.229	-.099
POA TO CENTROID in.	:	.151	.241	.137
MIN RADIUS	:	.421	.472	.563
MEAN RADIUS	:	.887	.825	.788
MAX RADIUS	:	1.323	1.217	1.264
HORIZONTAL SPREAD	:	2.076	2.076	2.076
VERTICAL SPREAD	:	2.005	2.005	1.685
EXTREME SPREAD	:	2.157	2.134	2.134
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 3

3 in = 6

MS = 1.542

VS = 4.902

GS = 4.920

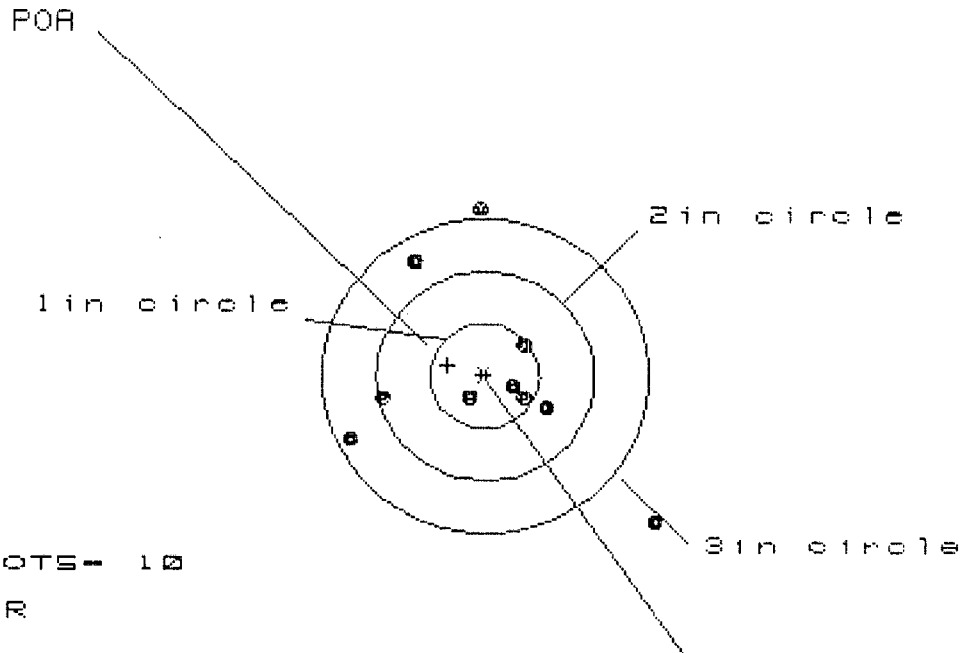
CENTROID *

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.638	.563	.599
MINIMUM X	:	-.904	-.833	-.797
MAXIMUM Y	:	2.986	1.829	1.631
MINIMUM Y	:	-1.916	-1.584	-1.612
CENTROID X	:	.182	.111	.075
CENTROID Y	:	.083	-.249	-.051
POA TO CENTROID in.	:	.200	.272	.090
MIN RADIUS	:	.504	.233	.397
MEAN RADIUS	:	1.369	1.101	1.058
MAX RADIUS	:	3.053	1.913	1.737
HORIZONTAL SPREAD	:	1.542	1.396	1.396
VERTICAL SPREAD	:	4.902	3.413	3.243
EXTREME SPREAD	:	4.920	3.424	3.363
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		6	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 8

HS= 2.772

VS= 3.002

GS= 3.389

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.511	.703	.716
MINIMUM X	:	-1.261	-1.093	-1.080
MAXIMUM Y	:	1.585	1.427	1.099
MINIMUM Y	:	-1.417	-.750	-.571
CENTROID X	:	.340	.172	.159
CENTROID Y	:	-.103	.055	-.123
POA TO CENTROID in.	:	.355	.181	.201
MIN RADIUS	:	.232	.358	.179
MEAN RADIUS	:	.928	.832	.720
MAX RADIUS	:	2.072	1.431	1.222
HORIZONTAL SPREAD	:	2.772	1.796	1.796
VERTICAL SPREAD	:	3.002	2.177	1.670
EXTREME SPREAD	:	3.389	2.485	1.891
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	