

C6611601

MODEL 700™ M24

Model **S&S**™

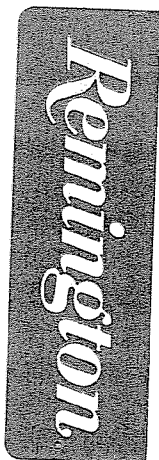
Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.






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

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. C6611601	46
ORDER NO. 5716	

UPC



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5716 C6611601

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6611601

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	FB
618	Polish Barrel	APR	5 1991	WB
620	Apply Coatings (Barrel Action)		4-10-91	JA
	Apply Coating (Bolt)			JA
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	JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			4/15/91	SL
	G) Safety Off Force	3	3	3			4/15/91	SL
	H) Trigger Pull Test & Retainability						4/15/91	SL
	I) Firing Pin Indent	.0215	.0215	.0215			4/15/91	SL
	J) Assemble Stock						4/17/91	KS
	K) Assemble Swivel Studs						5-2-91	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	AC
	B) Malfunctions						4-18-91	AC
	C) Pierced Primers						4-18-91	AC
	D) Optical Clarity of Scope						4-18-91	AC
645	Inspect for Live Ammo						4-18-91	AC
655	Final Inspection							
	A) Headspace						5-2-91	DH
	B) Trigger Pull	2.58	2.59	2.60	2.62	2.62	4/22/91	SL
	C) Function						5-2-91	DH
660	Pack						6-18-91	VF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6611601
DATE 4/15/91
TESTER JM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.50	2.31	2.28	2.58	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.34	2.22	2.30	2.59	
PULL #3	2.30	2.22	2.25	2.60	
PULL #4	2.28	2.23	2.29	2.62	
PULL #5	2.24	2.31	2.33	2.62	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.29	3.12		
PULL #2	3.26	3.49		
PULL #3	3.28	3.59		
PULL #4	3.17	3.25		
PULL #5	3.22	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	4.52	4.31		4.41
PULL #2	4.63	4.23		4.38
PULL #3	4.58	4.20		4.27
PULL #4	4.29	4.26		4.41
PULL #5	4.40	4.27		4.26
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611601
18 Apr 1991

CENTROIDAL DISTANCES

0 TO 1	.0355106
1 TO 2	.344449
1 TO 3	.676512
1 TO 4	.248871
1 TO 5	.257529

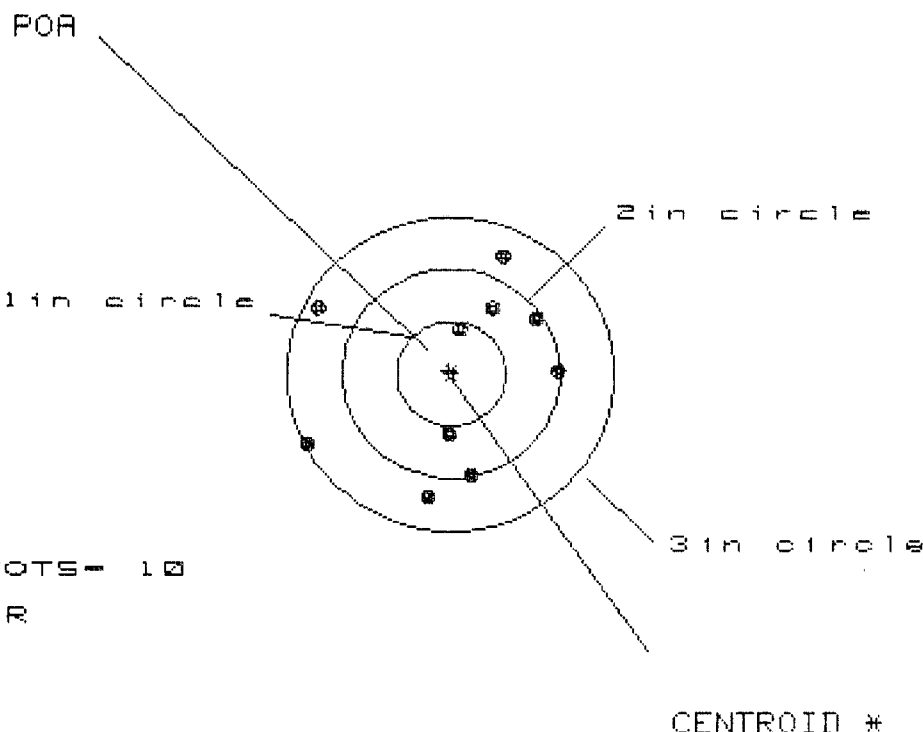
$\bar{x}_g$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .3132
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0582
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .318562
THE AMR FOR THIS RIFLE IS: 1.132

18 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611681

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 2.334

VS= 2.375

GS= 2.579

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.982	.831	.655
MINIMUM X	:	-1.352	-1.409	-.508
MAXIMUM Y	:	1.177	1.104	1.178
MINIMUM Y	:	-1.198	-1.271	-1.197
CENTROID X	:	.019	.170	.346
CENTROID Y	:	-.030	.043	-.031
POA TO CENTROID in.	:	.036	.175	.347
MIN RADIUS	:	.415	.345	.482
MEAN RADIUS	:	.992	.905	.812
MAX RADIUS	:	1.503	1.528	1.300
HORIZONTAL SPREAD	:	2.334	2.240	1.163
VERTICAL SPREAD	:	2.375	2.375	2.375
EXTREME SPREAD	:	2.579	2.461	2.461
NUMBER IN ONE INCH CIRCLE =	:	1		
NUMBER IN TWO INCH CIRCLE =	:	6		
NUMBER IN THREE INCH CIRCLE =	:	9		

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CENTERFIRE PATTERNS

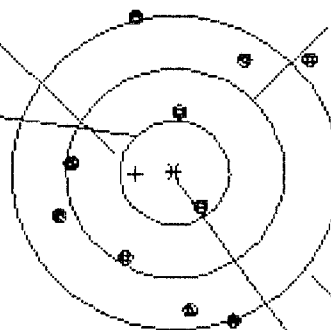
2

POA

1in circle

2in circle

3in circle



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 8

HS= 2.214

VS= 2.870

GS= 3.000

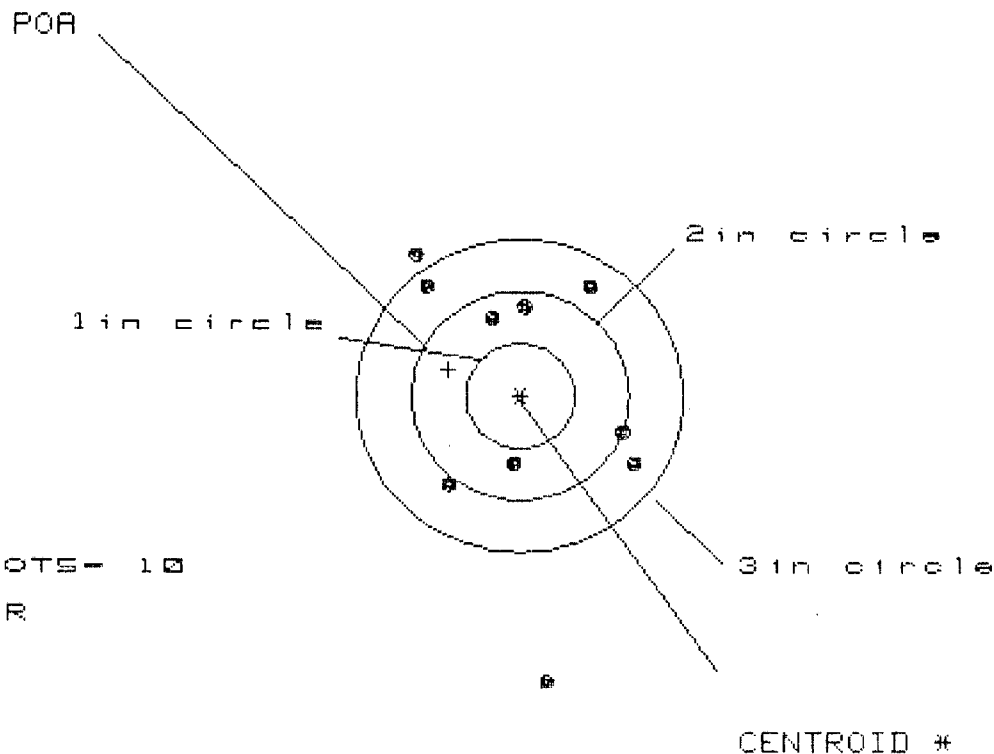
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.203	.735	.711
MINIMUM X	:	-1.011	-.878	-.902
MAXIMUM Y	:	1.483	1.602	1.409
MINIMUM Y	:	-1.387	-1.268	-1.067
CENTROID X	:	.361	.228	.252
CENTROID Y	:	.011	-.109	-.310
POA TO CENTROID in.	:	.362	.253	.399
MIN RADIUS	:	.445	.472	.392
MEAN RADIUS	:	1.121	1.047	.952
MAX RADIUS	:	1.616	1.614	1.578
HORIZONTAL SPREAD	:	2.214	1.613	1.613
VERTICAL SPREAD	:	2.870	2.870	2.476
EXTREME SPREAD	:	3.000	3.000	2.477
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 3

3 in = 8

HS= 1.998

VS= 4.122

GS= 4.280

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.044
MINIMUM X	-.954
MAXIMUM Y	1.391
MINIMUM Y	-2.731
CENTROID X	.657
CENTROID Y	-.255
POA TO CENTROID in.	.705
MIN RADIUS	.618
MEAN RADIUS	1.266
MAX RADIUS	2.738
HORIZONTAL SPREAD	1.998
VERTICAL SPREAD	4.122
EXTREME SPREAD	4.280
NUMBER IN ONE INCH CIRCLE	= 0
NUMBER IN TWO INCH CIRCLE	= 3
NUMBER IN THREE INCH CIRCLE	= 8

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CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 0

2in = 6

3in = 9

HS= 2.388

VS= 2.398

GS= 2.922

PATTERN #

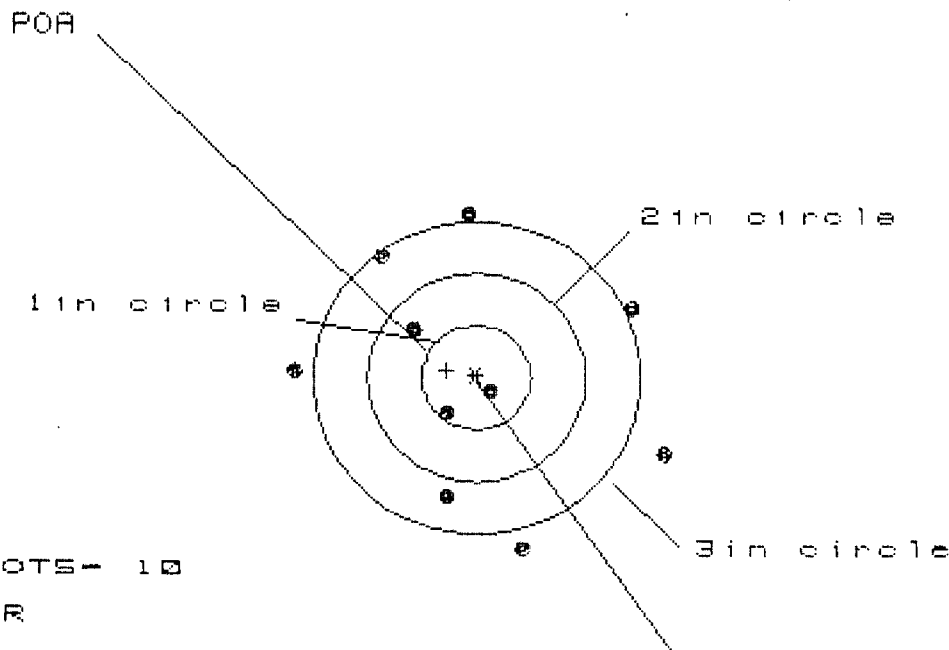
4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.463	1.596	1.053
MINIMUM X	-.925	-.792	-.593
MAXIMUM Y	1.446	1.217	1.256
MINIMUM Y	-.952	-.792	-.754
CENTROID X	.255	.122	-.077
CENTROID Y	.049	-.111	-.150
POA TO CENTROID in.	.260	.165	.168
MIN RADIUS	.610	.540	.398
MEAN RADIUS	1.056	.920	.791
MAX RADIUS	1.875	1.625	1.306
HORIZONTAL SPREAD	2.388	2.388	1.646
VERTICAL SPREAD	2.398	2.009	2.009
EXTREME SPREAD	2.922	2.492	2.191
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 3

3in = 5

HS= 3.401

VS= 3.149

GS= 3.505

CENTROID #

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.757	1.579	1.398
MINIMUM X	-1.644	-1.449	-.833
MAXIMUM Y	1.559	1.477	1.479
MINIMUM Y	-1.590	-1.672	-1.670
CENTROID X	.274	.079	.260
CENTROID Y	-.066	.016	.014
POA TO CENTROID in.	.282	.080	.260
MIN RADIUS	.183	.372	.262
MEAN RADIUS	1.223	1.134	1.093
MAX RADIUS	1.908	1.783	1.726
HORIZONTAL SPREAD	3.401	3.028	2.231
VERTICAL SPREAD	3.149	3.149	3.149
EXTREME SPREAD	3.505	3.194	3.194
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	5		