

C6349180

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.

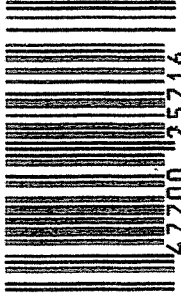
MODEL 700™ M24

SERIAL NO. C6349180

ORDER NO. 5716

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

UPC



0 47700 25716 7



5716 C6349180

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # 06349180

| OP. #        | OP. NAME                                                       | READINGS | DATE    | INIT |
|--------------|----------------------------------------------------------------|----------|---------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   | 3 31     | 90      | RW   |
| 600          | Proof                                                          | 3 31     | 90      | RW   |
| 607          | Check Headspace                                                | 3 31     | 90      | RW   |
| 610          | Dis-assemble Gun                                               | 3 31     | 90      | RW   |
| 612          | Magnaflux Barrel<br>Action                                     | 4-2-90   |         | KCR  |
|              | Magnaflux Bolt                                                 | 4-2-90   |         | KCR  |
| 615          | Rollmark Caliber                                               | 4-2-90   |         | GL   |
| 617          | Drill and Tap Sight Holes                                      |          | 4/4/90  | LB   |
| 618          | Polish Barrel RB                                               |          | 4/5/90  | WB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 4-9-90  | JA   |
|              | Apply Coating (Bolt)                                           |          |         |      |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 4/18/90 | RW   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 4/18/90 | RW   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 4/18/90 | RW   |
|              | D) Oil Firing Pin Ass'y                                        |          | 4/18/90 | RW   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 4/25/90 | RL   |

| op. #        | OP. NAME                                                    | READINGS |      |      |      |      | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|------|------|------|------|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 5        | 5    | 5    |      |      | 4/24/90 | JA   |
|              | G) Safety Off Force                                         | 3        | 3    | 5    |      |      | 4/24/90 | JA   |
|              | H) Trigger Pull Test & Retainability                        |          |      |      |      |      | 4/25/90 | JEL  |
|              | I) Firing Pin Indent                                        | .0225    | .022 | .022 |      |      | 4/26/90 | JA   |
|              | J) Assemble Stock                                           |          |      |      |      |      | 4/26/90 | RW   |
|              | K) Assemble Swivel Studs                                    |          |      |      |      |      | 5/8/90  | WB   |
|              | L) Attach Front and Rear Sight Assemblies                   |          |      |      |      |      | 4/26/90 | RW   |
|              | M) Iron Sight Alignment                                     |          |      |      |      |      | 4/26/90 | RW   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |      |      |      |      | 4/26/90 | RW   |
|              | O) Attach Scope to Rifle                                    |          |      |      |      |      | 4/27/90 | JA   |
|              | P) Detach & Attach Scope 20 Times                           |          |      |      |      |      | 4/27/90 | JA   |
| 640          | Gallery Target & Test                                       |          |      |      |      |      | 4-27-90 | AC   |
|              | A) Time                                                     |          |      |      |      |      | 4-27-90 | AC   |
|              | B) Malfunctions                                             |          |      |      |      |      | 4-27-90 | AC   |
|              | C) Pierced Primers                                          |          |      |      |      |      | 4-27-90 | AC   |
|              | D) Optical Clarity of Scope                                 |          |      |      |      |      | 4-27-90 | AC   |
| 645          | Inspect for Live Ammo                                       |          |      |      |      |      | 4-27-90 | AC   |
| 655          | Final Inspection                                            |          |      |      |      |      | 5/8/90  | WB   |
|              | A) Headspace                                                |          |      |      |      |      |         |      |
|              | B) Trigger Pull                                             | 2.56     | 2.65 | 2.69 | 2.66 | 2.45 | 5/11/90 | WB   |
|              | C) Function                                                 |          |      |      |      |      | 5/8/90  | WB   |
| 660          | Pack                                                        |          |      |      |      |      | 6/19/90 | DH   |

SWS TRIGGER PULL TEST

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

SERIAL NO. C6349180

DATE 4/25/90

TESTER J.P.

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.32             | 2.45                     | 2.31                           | 2.56 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.45             | 2.38                     | 2.23                           | 2.65 |                                                                        |
| PULL #3 | 2.35             | 2.32                     | 2.35                           | 2.59 |                                                                        |
| PULL #4 | 2.35             | 2.25                     | 2.21                           | 2.66 |                                                                        |
| PULL #5 | 2.44             | 2.43                     | 2.30                           | 2.45 |                                                                        |
| TOTAL   | 11.91            | 11.83                    | 11.40                          |      |                                                                        |
| AVG.    | 2.382            | 2.366                    | 2.28                           |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.15             | 3.45                     |  |          |
| PULL #2 | 3.15             | 3.52                     |  |          |
| PULL #3 | 3.44             | 3.53                     |  |          |
| PULL #4 | 3.48             | 3.15                     |  |          |
| PULL #5 | 3.50             | 3.30                     |  |          |
| TOTAL   | 16.72            | 16.95                    |  |          |
| AVG.    | 3.344            | 3.39                     |  |          |

|         | 4.00#<br>INITIAL | 4.00# AFTER<br>20 CYCLES | MAX SETTING<br>GREATER THAN 4# | RESET TO 4# FOR<br>TARGET & ACCURACY |
|---------|------------------|--------------------------|--------------------------------|--------------------------------------|
| PULL #1 | 4.41             | 4.32                     |                                | 4.21                                 |
| PULL #2 | 4.41             | 4.34                     |                                | 4.28                                 |
| PULL #3 | 4.33             | 4.33                     |                                | 4.21                                 |
| PULL #4 | 4.28             | 4.26                     |                                | 4.12                                 |
| PULL #5 | 4.25             | 4.34                     |                                | 4.15                                 |
| TOTAL   | 21.68            | 21.59                    |                                | 20.97                                |
| AVG.    | 4.336            | 4.318                    |                                | 4.194                                |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6349180  
27 Apr 1990

CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| 0 TO | 1 | .101922 |
| 1 TO | 2 | .235697 |
| 1 TO | 3 | .214084 |
| 1 TO | 4 | .621514 |
| 1 TO | 5 | .460331 |

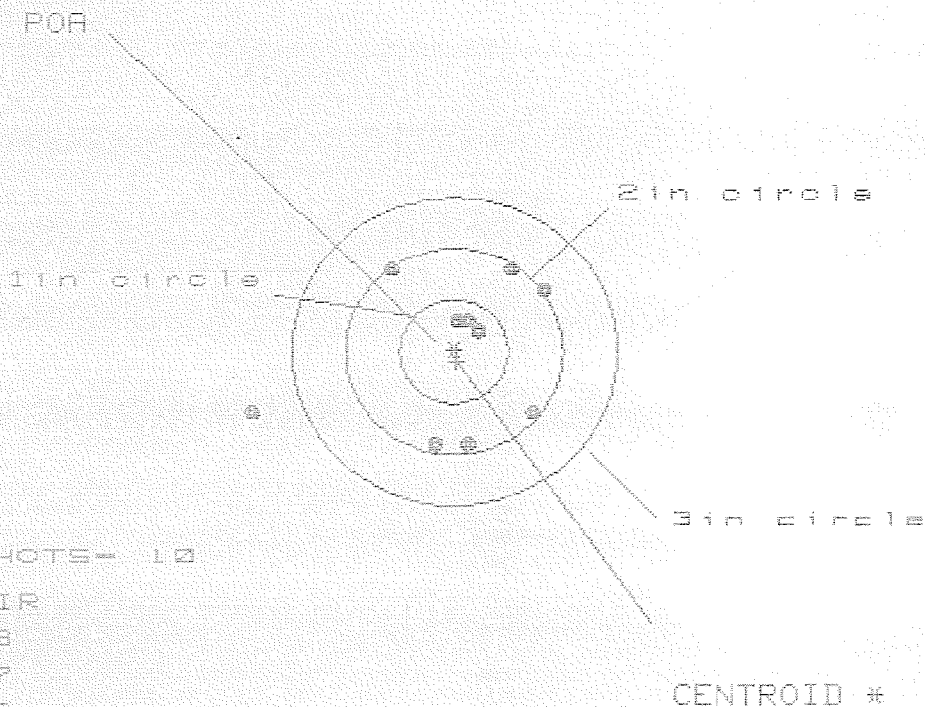
2.334 <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .159  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .233  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .282082  
THE AMR FOR THIS RIFLE IS: .8608

27 Apr 1998

FILE: \PATTERNING\CENTERFIRE\_PATT\083491B0

# CENTERFIRE PATTERNS # 1



# OF SHOTS= 10

# IN CIR

1in = 3

2in = 7

3in = 9

HS= 2.718

VS= 1.760

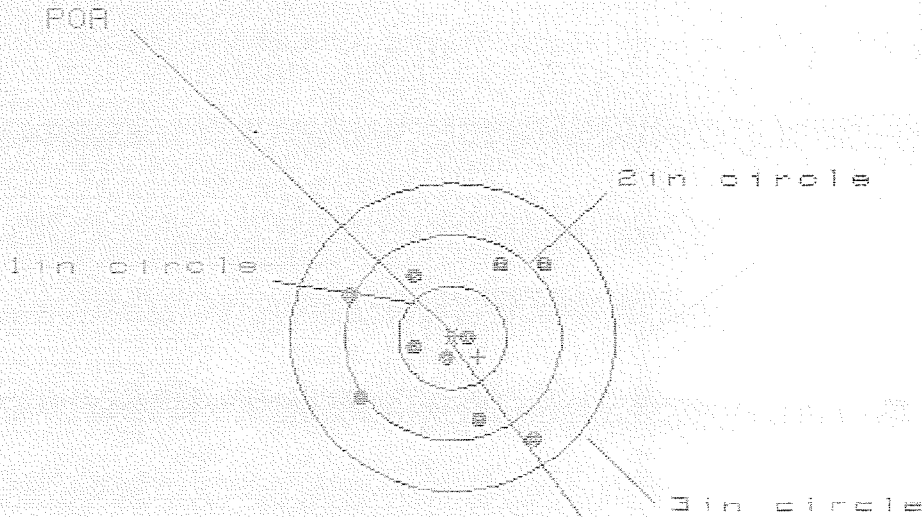
GS= 2.950

|                               |   |        |       |       |
|-------------------------------|---|--------|-------|-------|
| PATTERN #                     | : | 1      |       |       |
| SHOTS (BEST OF)               | : | 10     | 9     | 8     |
| MAXIMUM X                     | : | .876   | .671  | .632  |
| MINIMUM X                     | : | -1.842 | -.817 | -.733 |
| MAXIMUM Y                     | : | .847   | .784  | .848  |
| MINIMUM Y                     | : | -.913  | -.976 | -.912 |
| CENTROID X                    | : | -.028  | .177  | .093  |
| CENTROID Y                    | : | .098   | .161  | .097  |
| POA TO CENTROID in.           | : | .102   | .239  | .134  |
| MIN RADIUS                    | : | .208   | .111  | .213  |
| MEAN RADIUS                   | : | .869   | .703  | .697  |
| MAX RADIUS                    | : | 1.928  | 1.132 | 1.121 |
| HORIZONTAL SPREAD             | : | 2.718  | 1.488 | 1.365 |
| VERTICAL SPREAD               | : | 1.760  | 1.760 | 1.760 |
| EXTREME SPREAD                | : | 2.950  | 1.977 | 1.977 |
| NUMBER IN ONE INCH CIRCLE =   |   |        | 3     |       |
| NUMBER IN TWO INCH CIRCLE =   |   |        | 7     |       |
| NUMBER IN THREE INCH CIRCLE = |   |        | 9     |       |

27 Apr 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/C8349180

# CENTERFIRE PATTERNS # 2



# OF SHOTS= 10

# IN CIR

1in = 3

2in = 7

3in = 10

HS= 1.774

VS= 1.719

GS= 2.192

CENTROID #

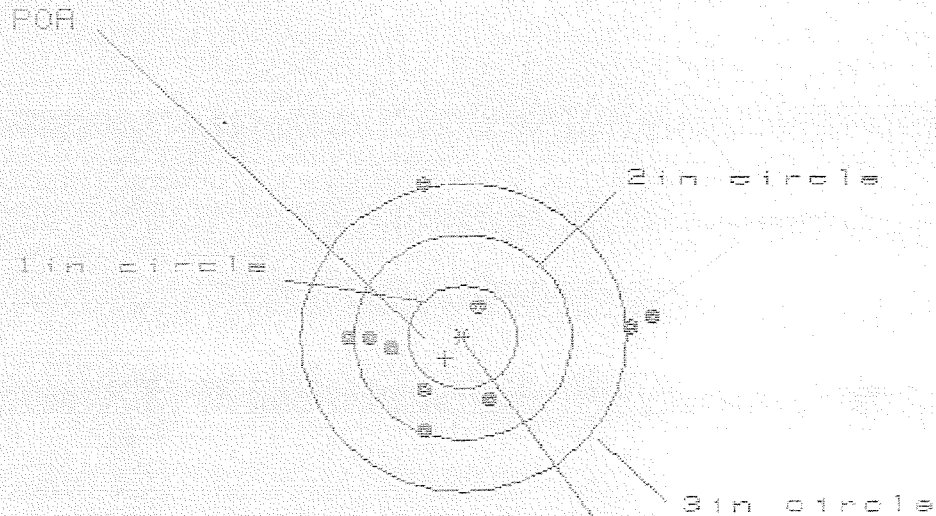
|                             |   |       |       |       |
|-----------------------------|---|-------|-------|-------|
| PATTERN #                   | : | 2     |       |       |
| SHOTS (BEST OF)             | : | 10    | 9     | 8     |
| MAXIMUM X                   | : | .841  | .928  | .647  |
| MINIMUM X                   | : | -.933 | -.846 | -.730 |
| MAXIMUM Y                   | : | .746  | .638  | .690  |
| MINIMUM Y                   | : | -.973 | -.896 | -.816 |
| CENTROID X                  | : | -.245 | -.332 | -.448 |
| CENTROID Y                  | : | .190  | .298  | .218  |
| POA TO CENTROID in.         | : | .310  | .446  | .498  |
| MIN RADIUS                  | : | .179  | .269  | .168  |
| MEAN RADIUS                 | : | .748  | .691  | .619  |
| MAX RADIUS                  | : | 1.248 | 1.126 | .945  |
| HORIZONTAL SPREAD           | : | 1.774 | 1.774 | 1.377 |
| VERTICAL SPREAD             | : | 1.719 | 1.534 | 1.506 |
| EXTREME SPREAD              | : | 2.192 | 2.102 | 1.785 |
| NUMBER IN ONE INCH CIRCLE   | = | 3     |       |       |
| NUMBER IN TWO INCH CIRCLE   | = | 7     |       |       |
| NUMBER IN THREE INCH CIRCLE | = | 10    |       |       |



27 Apr 1988

FILE: \PATTERNING\CENTERFIRE\_PATT\08349100

# CENTERFIRE PATTERNS # 3



# OF SHOTS= 10

# IN CIR

1in = 1

2in = 5

3in = 7

HS= 2.810

VS= 2.327

GS= 2.822

CENTROID \*

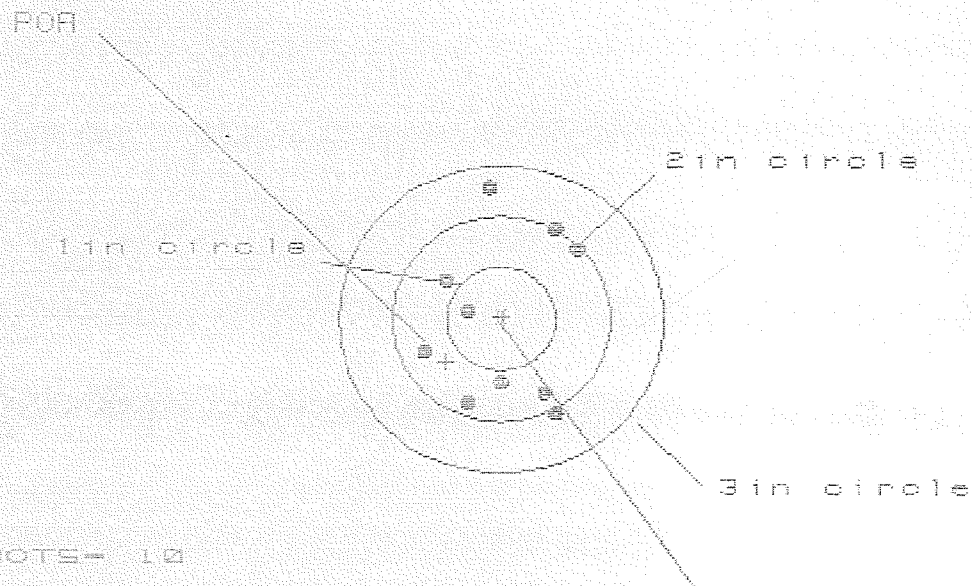
|                             |   |        |       |       |
|-----------------------------|---|--------|-------|-------|
| PATTERN #                   | : | 3      |       |       |
| SHOTS (BEST OF)             | : | 10     | 9     | 8     |
| MAXIMUM X                   | : | 1.706  | 1.738 | .639  |
| MINIMUM X                   | : | -1.104 | -.914 | -.697 |
| MAXIMUM Y                   | : | 1.465  | 1.492 | 1.503 |
| MINIMUM Y                   | : | -.862  | -.835 | -.824 |
| CENTROID X                  | : | .158   | -.832 | -.249 |
| CENTROID Y                  | : | .204   | .177  | .166  |
| POA TO CENTROID in.         | : | .258   | .188  | .299  |
| MIN RADIUS                  | : | .362   | .435  | .221  |
| MEAN RADIUS                 | : | .993   | .869  | .710  |
| MAX RADIUS                  | : | 1.723  | 1.740 | 1.503 |
| HORIZONTAL SPREAD           | : | 2.810  | 2.652 | 1.336 |
| VERTICAL SPREAD             | : | 2.327  | 2.327 | 2.327 |
| EXTREME SPREAD              | : | 2.822  | 2.653 | 2.327 |
| NUMBER IN ONE INCH CIRCLE   | = | 1      |       |       |
| NUMBER IN TWO INCH CIRCLE   | = | 6      |       |       |
| NUMBER IN THREE INCH CIRCLE | = | 7      |       |       |

27 Apr 1998

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# CENTERFIRE PATTERNS

# 4



# OF SHOTS= 10

# IN CIR

1in = 1

2in = 8

3in = 10

HS= 1.399

VS= 2.195

GS= 2.277

CENTROID \*

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.655

.641

.698

MINIMUM X

-.744

-.758

-.762

MAXIMUM Y

1.279

.984

.887

MINIMUM Y

-.916

-.774

-.806

CENTROID X

.506

.520

.463

CENTROID Y

.416

.274

.370

POA TO CENTROID in.

.655

.588

.593

MIN RADIUS

.307

.373

.279

MEAN RADIUS

.832

.764

.740

MAX RADIUS

1.286

1.085

1.045

HORIZONTAL SPREAD

1.399

1.399

1.399

VERTICAL SPREAD

2.195

1.758

1.694

EXTREME SPREAD

2.277

1.861

1.861

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

8

NUMBER IN THREE INCH CIRCLE =

10

27 Apr 1998

FILE:/PATTERNING/CENTERFIRE\_PATT/C8349180

# CENTERFIRE PATTERNS

# 5

POA

1in circle

2in circle

3in circle

# OF SHOTS- 10

# IN CIR

1in = 3

2in = 5

3in = 10

HS= 2.370

VS= 2.265

ES= 2.692

CENTROID \*

|                               |   |        |        |        |
|-------------------------------|---|--------|--------|--------|
| PATTERN #                     | : | 5      |        |        |
| SHOTS (BEST OF)               | : | 10     | 9      | 8      |
| MAXIMUM X                     | : | .990   | .837   | .908   |
| MINIMUM X                     | : | -1.380 | -1.175 | -1.104 |
| MAXIMUM Y                     | : | 1.215  | 1.267  | .509   |
| MINIMUM Y                     | : | -1.050 | -.998  | -.839  |
| CENTROID X                    | : | .404   | .557   | .486   |
| CENTROID Y                    | : | .257   | .205   | .046   |
| POA TO CENTROID in.           | : | .479   | .594   | .488   |
| MIN RADIUS                    | : | .174   | .113   | .066   |
| MEAN RADIUS                   | : | .862   | .783   | .708   |
| MAX RADIUS                    | : | 1.459  | 1.391  | 1.104  |
| HORIZONTAL SPREAD             | : | 2.370  | 2.012  | 2.012  |
| VERTICAL SPREAD               | : | 2.265  | 2.265  | 1.348  |
| EXTREME SPREAD                | : | 2.692  | 2.374  | 2.106  |
| NUMBER IN ONE INCH CIRCLE =   |   |        | 3      |        |
| NUMBER IN TWO INCH CIRCLE =   |   |        | 5      |        |
| NUMBER IN THREE INCH CIRCLE = |   |        | 10     |        |