

C6498784

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6498784

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 12	90	RW
600	Proof	7 12	90	RW
607	Check Headspace	7 12	90	RW
610	Dis-assemble Gun			RW
612	Magnaflux Barrel Action		7-17-90	RR
	Magnaflux Bolt		7-17-90	RR
615	Rollmark Caliber		7-17-90	LS
617	Drill and Tap Sight Holes		7/23/90	LB
618	Polish Barrel RB		7/24/90	WB
620	Apply Coatings (Barrel Action)		7-6-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/8/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/8/90	RW
	C) Inspect Ejector Hole for Chamfer		8/8/90	RW
	D) Oil Firing Pin Ass'y		8/8/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/27/90	OH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2			8/24/90	WB
	G) Safety Off Force	3 1/2	3 1/2	3 1/2			8/24/90	WB
	H) Trigger Pull Test & Retainability						8/23/90	OH
	I) Firing Pin Indent	.022	.0225	.0225			8/24/90	WB
	J) Assemble Stock						8/24/90	RW
	K) Assemble Swivel Studs						8/30/90	JD
	L) Attach Front and Rear Sight Assemblies						8/24/90	RW
	M) Iron Sight Alignment						8/24/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/24/90	RW
	O) Attach Scope to Rifle						8/24/90	RW
	P) Detach & Attach Scope 20 Times						8/24/90	RW
640	Gallery Target & Test						8/24/90	NF
	A) Time						8/24/90	NF
	B) Malfunctions						8/24/90	NF
	C) Pierced Primers						8/24/90	NF
	D) Optical Clarity of Scope						8/24/90	NF
645	Inspect for Live Ammo						8/24/90	NF
655	Final Inspection							
	A) Headspace						8/30/90	JD
	B) Trigger Pull	2.51	2.60	2.44	2.46	2.53	8/25/90	JK
	C) Function						8/30/90	JD
660	Pack						9/19/90	NF

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

SERIAL NO. C6498784DATE 8-23-90TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.36	2.29	2.47	2.51	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.35	2.23	2.53	2.60	
PULL #3	2.37	2.21	2.60	2.44	
PULL #4	2.46	2.19	2.63	2.46	
PULL #5	2.28	2.29	2.64	2.53	
TOTAL	11.85	11.21	12.87	12.54	
AVG.	2.37	2.24	2.57	2.508	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.16	3.20		
PULL #2	3.18	3.29		
PULL #3	3.19	3.24		
PULL #4	3.14	3.16		
PULL #5	3.14	3.20		
TOTAL	15.79	16.09		
AVG.	3.15	3.21		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.17	4.48		4.02
PULL #2	4.19	4.45		4.17
PULL #3	4.20	4.09		4.18
PULL #4	4.18	4.15		4.03
PULL #5	4.08	4.18		4.11
TOTAL	20.82	21.35		20.51
AVG.	4.16	4.27		4.10

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6498784
24 Aug 1990

CENTROIDAL DISTANCES

Ø TO	1	.164757
1 TO	2	.554777
1 TO	3	.288979
1 TO	4	.8623
1 TO	5	.398016

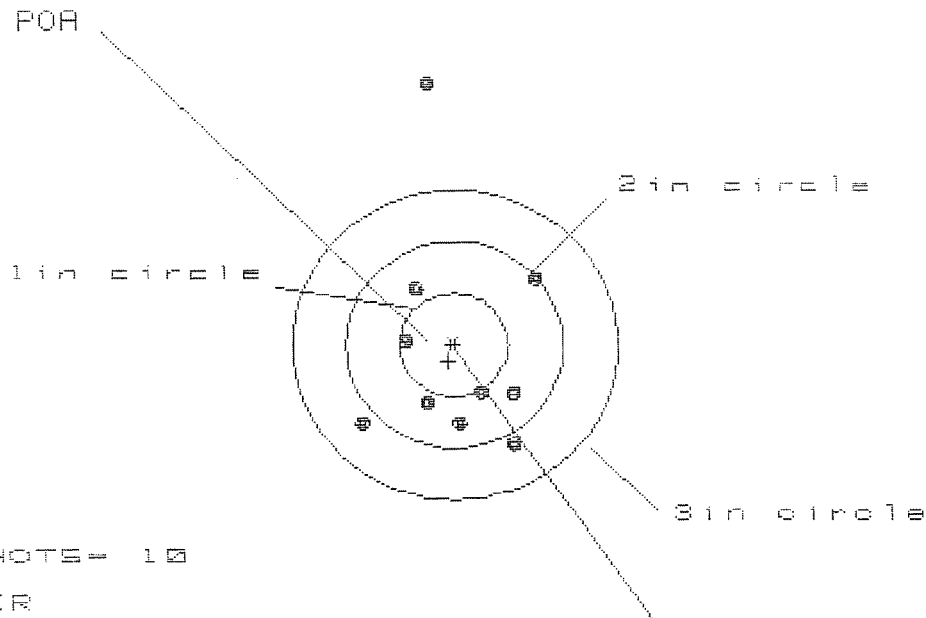
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 $\begin{matrix} 95 \\ 96 \end{matrix}$
 $\begin{matrix} 97 \\ 98 \end{matrix}$
 $\begin{matrix} 99 \\ 100 \end{matrix}$

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0308
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2442
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .246135
 THE AMR FOR THIS RIFLE IS: 1.176

24 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06496784

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS= 1.635

VS= 3.494

GS= 3.576

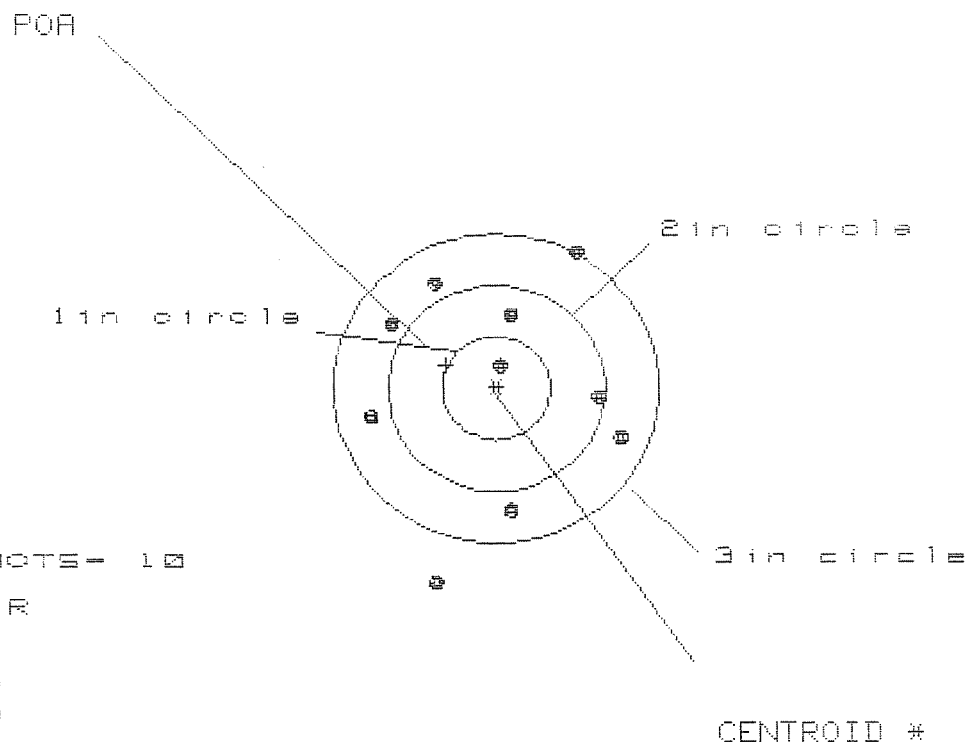
CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.740	.712	.597
MINIMUM X	:	-.895	-.923	-.560
MAXIMUM Y	:	2.561	.941	.887
MINIMUM Y	:	-.933	-.648	-.702
CENTROID X	:	.053	.081	.196
CENTROID Y	:	.156	-.129	-.075
POA TO CENTROID in.	:	.165	.152	.210
MIN RADIUS	:	.425	.292	.283
MEAN RADIUS	:	.951	.695	.657
MAX RADIUS	:	2.573	1.180	1.069
HORIZONTAL SPREAD	:	1.635	1.635	1.157
VERTICAL SPREAD	:	3.494	1.589	1.589
EXTREME SPREAD	:	3.576	2.134	1.738
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	9		

24 Aug 1998

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 9

HS= 2.306

VS= 3.137

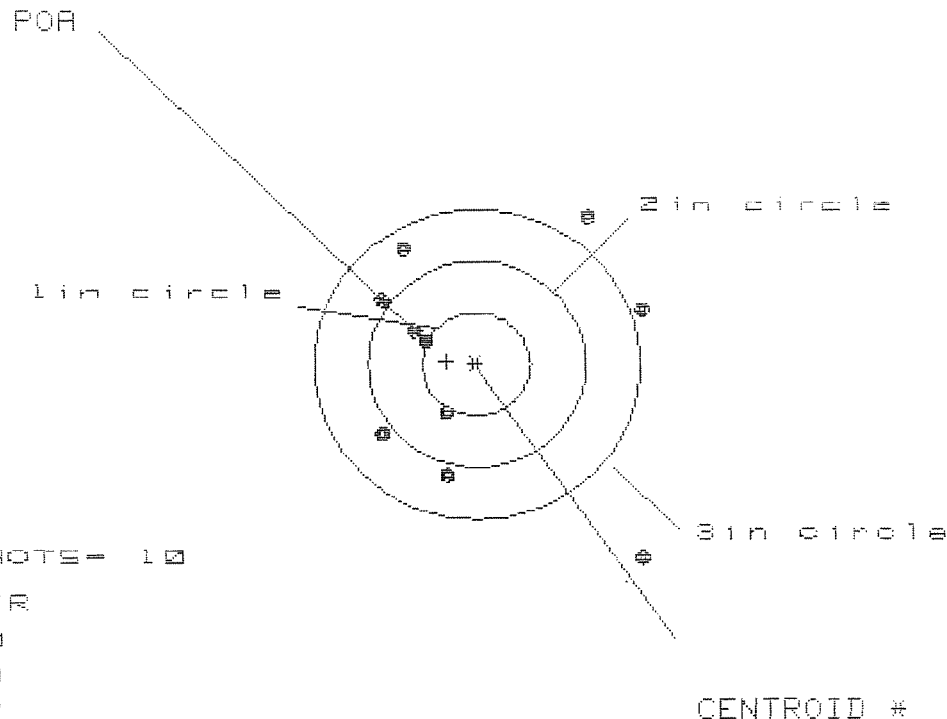
GS= 3.367

PATTERN #	1	2	3
SHOTS (BEST QF)	10	9	8
MAXIMUM X	1.165	1.109	1.191
MINIMUM X	-1.141	-1.197	-1.115
MAXIMUM Y	1.273	1.066	.972
MINIMUM Y	-1.864	-1.412	-1.279
CENTROID X	.460	.516	.434
CENTROID Y	-.221	-.014	-.147
POA TO CENTROID in.	.510	.517	.459
MIN RADIUS	.244	.053	.175
MEAN RADIUS	1.121	.979	.963
MAX RADIUS	1.932	1.417	1.307
HORIZONTAL SPREAD	2.306	2.306	2.306
VERTICAL SPREAD	3.137	2.478	2.251
EXTREME SPREAD	3.367	2.535	2.369
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 3

3 in = 7

HS= 2.444

VS= 3.312

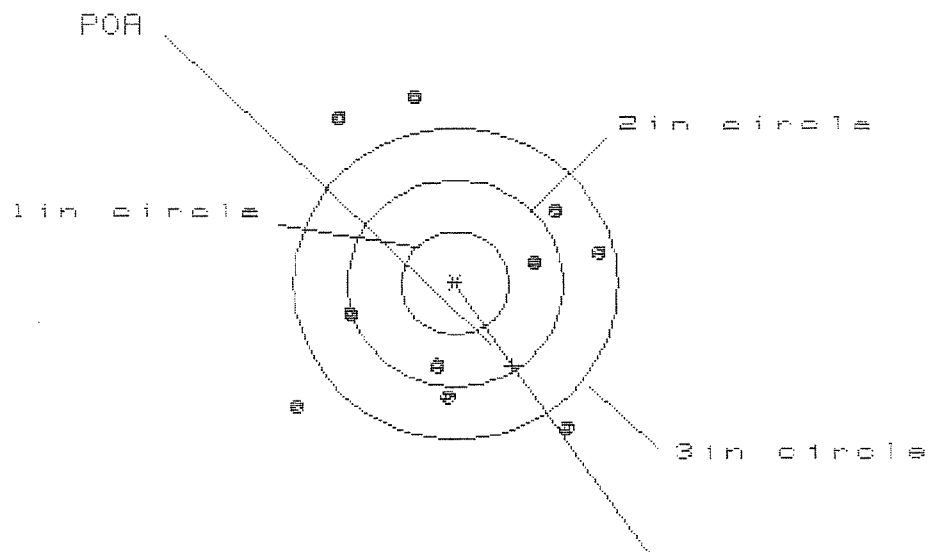
GS= 3.793

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.562
MINIMUM X	-0.882
MAXIMUM Y	1.398
MINIMUM Y	-1.914
CENTROID X	.275
CENTROID Y	-.029
POA TO CENTROID in.	.276
MIN RADIUS	.503
MEAN RADIUS	1.204
MAX RADIUS	2.471
HORIZONTAL SPREAD	2.444
VERTICAL SPREAD	3.312
EXTREME SPREAD	3.793
NUMBER IN ONE INCH CIRCLE	= 0
NUMBER IN TWO INCH CIRCLE	= 3
NUMBER IN THREE INCH CIRCLE	= 7

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 2

3 in = 8

HS= 2.714

VS= 3.222

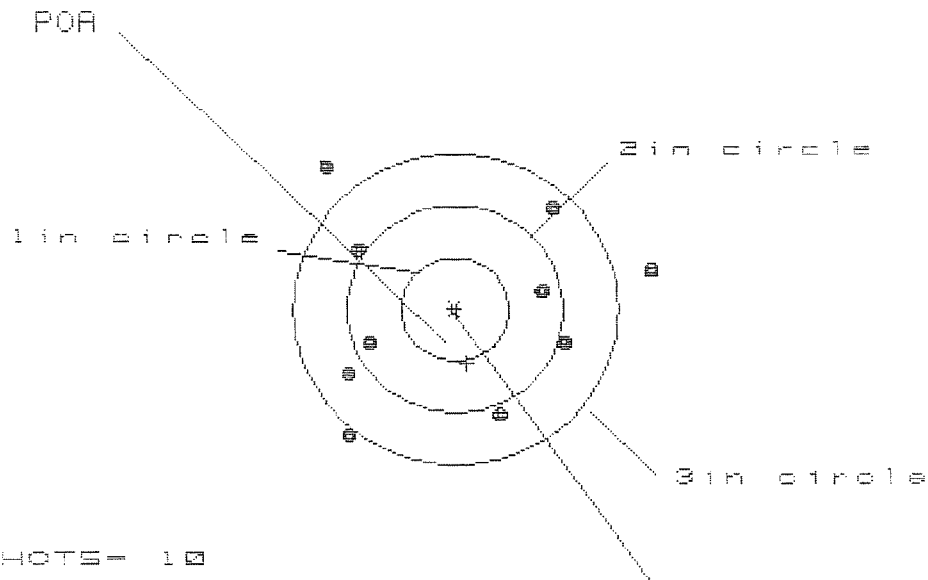
GS= 3.709

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.298	1.170	1.112
MINIMUM X	:	-1.424	-1.544	-1.602
MAXIMUM Y	:	1.846	2.029	1.122
MINIMUM Y	:	-1.376	-1.193	-.940
CENTROID X	:	-.526	-.406	-.348
CENTROID Y	:	.795	.612	.359
POA TO CENTROID in.	:	.953	.735	.500
MIN RADIUS	:	.785	.678	.518
MEAN RADIUS	:	1.366	1.266	1.130
MAX RADIUS	:	1.969	2.080	1.761
HORIZONTAL SPREAD	:	2.714	2.714	2.714
VERTICAL SPREAD	:	3.222	3.222	2.062
EXTREME SPREAD	:	3.709	3.516	3.100
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 0

2 in = 2

3 in = 7

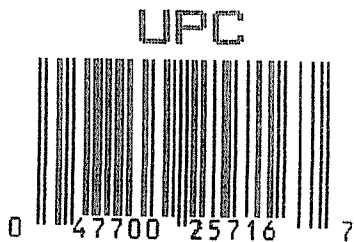
HS = 3.018

VS = 2.554

GS = 3.220

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.782	1.214	1.085
MINIMUM X	:	-1.236	-1.038	-.965
MAXIMUM Y	:	1.333	1.377	1.222
MINIMUM Y	:	-1.221	-1.177	-1.005
CENTROID X	:	-.108	-.306	-.176
CENTROID Y	:	.520	.476	.304
POR TO CENTROID in.	:	.531	.566	.351
MIN RADIUS	:	.815	.617	.688
MEAN RADIUS	:	1.266	1.186	1.101
MAX RADIUS	:	1.826	1.724	1.534
HORIZONTAL SPREAD	:	3.018	2.252	2.049
VERTICAL SPREAD	:	2.554	2.554	2.227
EXTREME SPREAD	:	3.220	2.901	2.901
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		7	



		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700™ H24		SERIAL NO. C6498784
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off. Marca Registrada Marque Deposee.		ORDER NO. 5716



5716 C6498784