

C6594609

MODEL 700™ M24

Model **SMS**™

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™ H24		SERIAL NO. C6594609
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		ORDER NO. 5716
20		
 5716 C6594609		

UPC



0 47700 25716 7

CONTRACT #. DAAA21-87-C-0086

GUN SERIAL # C 6594609

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		12/27/90	K.S.
600	Proof		12/27/90	K.S.
607	Check Headspace		12/27/90	K.S.
610	Dis-assemble Gun		12/27/90	K.S.
612	Magnaflux Barrel Action		1/9/91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	LS.
617	Drill and Tap Sight Holes	1 10 91		EB
618	Polish Barrel	1 10 91		WB
620	Apply Coatings (Barrel Action)		1-22-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/4/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/4/91	KS
	C) Inspect Ejector Hole for Chamfer		2/4/91	KS
	D) Oil Firing Pin Ass'y		2/4/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		2/5/91	JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 3/4	5 3/4	5 3/4			2/5/91	WB
	G) Safety Off Force	7 3/4	7 3/4	7 3/4			2/5/91	WB
	H) Trigger Pull Test & Retainability						2/5/91	JM
	I) Firing Pin Indent	.0205	.0205	.0205			2/5/91	WB
	J) Assemble Stock						2/5/91	KH
	K) Assemble Swivel Studs						2-26-91	A
	L) Attach Front and Rear Sight Assemblies						2/5/91	KH
	M) Iron Sight Alignment						2/5/91	KH
	N) Detach Front & Rear Sights & place in numbered container						2/5/91	KH
	O) Attach Scope to Rifle						2/5/91	KH
	P) Detach & Attach Scope 20 Times						2/5/91	KH
640	Gallery Target & Test						2-6-91	A
	A) Time						"	A
	B) Malfunctions						"	A
	C) Pierced Primers						"	A
	D) Optical Clarity of Scope						"	A
645	Inspect for Live Ammo						"	A
655	Final Inspection						2-6-91	A
	A) Headspace							
	B) Trigger Pull	2.37	2.47	2.26	2.45	2.37	2/25/91	JM
	C) Function						2-26-91	AC
660	Pack						3-11-91	N

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

SERIAL NO. C6594609
DATE 2-5-91
TESTER JF.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.42	2.34	2.50	2.37	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.42	2.51	2.43	2.47	
PULL #3	2.50	2.48	2.48	2.26	
PULL #4	2.52	2.52	2.35	2.45	
PULL #5	2.50	2.47	2.40	2.37	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.40	3.41		
PULL #2	3.40	3.28		
PULL #3	3.46	3.30		
PULL #4	3.48	3.35		
PULL #5	3.41	3.34		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.44		4.40
PULL #2	4.34	4.37		4.38
PULL #3	4.20	4.37		4.39
PULL #4	4.21	4.39		4.40
PULL #5	4.17	4.40		4.43
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594609
7 Feb 1991

CENTROIDAL DISTANCES

0 TO	1	.3614
1 TO	2	.438289
1 TO	3	.513004
1 TO	4	.491065
1 TO	5	.170426

$\frac{5}{4}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: $-.073$
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: $.1526$
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: $.169162$
THE AMR FOR THIS RIFLE IS: $.8168$

7 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C65346B9

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 10

HS= 2.338

VS= 2.388

GS= 2.405

CENTROID *

PATTERN #	:	1.	2.	3.
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.031	1.024	.860
MINIMUM X	:	-1.307	-1.314	-.569
MAXIMUM Y	:	1.060	.913	.900
MINIMUM Y	:	-1.328	-.753	-.766
CENTROID X	:	.017	.024	.189
CENTROID Y	:	.361	.508	.521
POA TO CENTROID in.	:	.361	.509	.554
MIN RADIUS	:	.116	.233	.349
MEAN RADIUS	:	.812	.759	.701
MAX RADIUS	:	1.329	1.318	.952
HORIZONTAL SPREAD	:	2.338	2.338	1.428
VERTICAL SPREAD	:	2.388	1.666	1.666
EXTREME SPREAD	:	2.405	2.363	1.743
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

7 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594689

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS= 2.271

VS= 1.761

GS= 2.610

CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.123	.967	.882
MINIMUM X	:	-1.148	-1.023	-1.108
MAXIMUM Y	:	.840	.711	.608
MINIMUM Y	:	-.921	-.828	-.734
CENTROID X	:	.128	.003	.088
CENTROID Y	:	-.063	-.156	-.053
POA TO CENTROID in.	:	.143	.156	.103
MIN RADIUS	:	.200	.199	.222
MEAN RADIUS	:	.854	.796	.742
MAX RADIUS	:	1.402	1.140	1.178
HORIZONTAL SPREAD	:	2.271	1.990	1.990
VERTICAL SPREAD	:	1.761	1.539	1.342
EXTREME SPREAD	:	2.610	2.175	2.175
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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FILE:/PATTERNING/CENTERFIRE_PATT/C6594609

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 4

2in = 6

3in = 8

HS= 3.209

VS= 2.570

GS= 3.582

PATTERN #

3

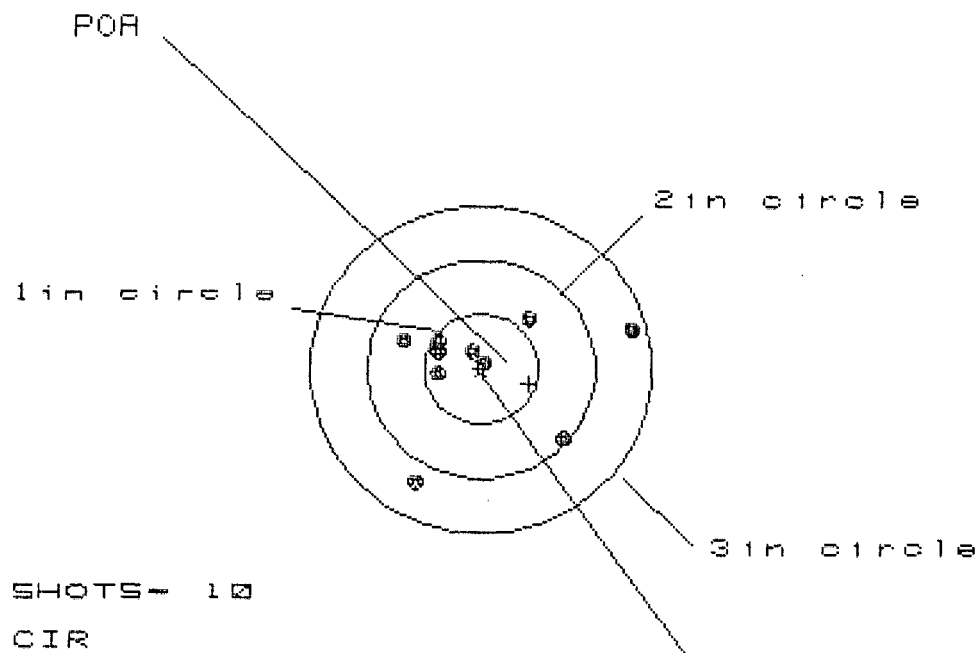
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.242	1.024	1.074
MINIMUM X	:	-1.967	-.754	-.626
MAXIMUM Y	:	1.445	1.354	1.202
MINIMUM Y	:	-1.125	-1.216	-.664
CENTROID X	:	.015	.233	.105
CENTROID Y	:	-.152	-.061	.091
POA TO CENTROID in.	:	.153	.241	.139
MIN RADIUS	:	.158	.113	.174
MEAN RADIUS	:	.882	.764	.663
MAX RADIUS	:	2.131	1.590	1.268
HORIZONTAL SPREAD	:	3.209	1.778	1.700
VERTICAL SPREAD	:	2.570	2.570	1.866
EXTREME SPREAD	:	3.582	2.716	2.017
NUMBER IN ONE INCH CIRCLE	=	4		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	8		

7 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594689

CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1in = 5

2in = 8

3in = 10

HS= 1.925

VS= 1.456

GS= 2.328

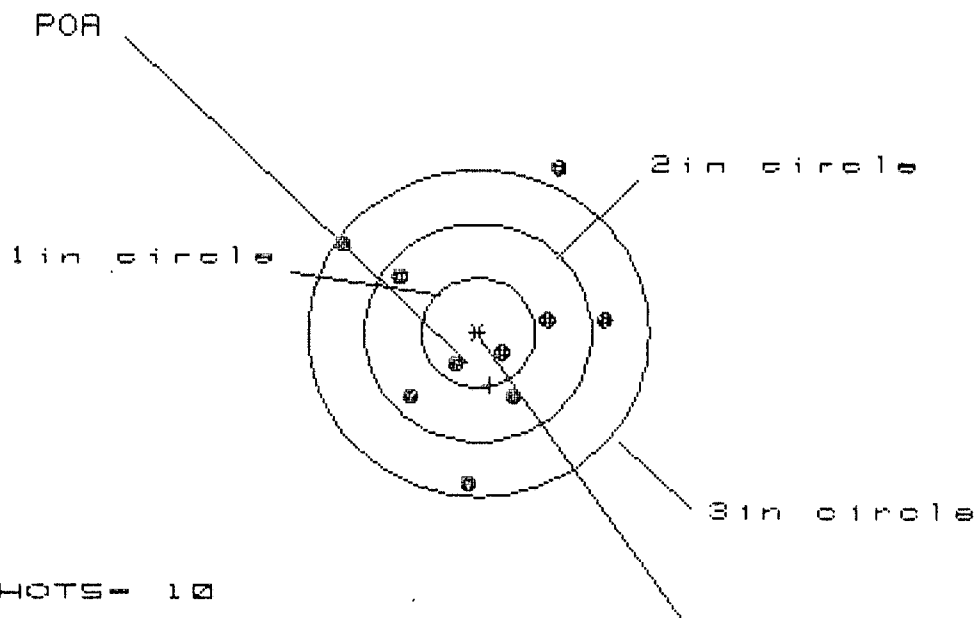
CENTROID *

PATTERN #	4	4	4
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.288	.845	.790
MINIMUM X	-.637	-.494	-.549
MAXIMUM Y	.421	.460	.336
MINIMUM Y	-1.035	-.996	-.728
CENTROID X	-.420	-.563	-.508
CENTROID Y	.137	.098	.222
POA TO CENTROID in.	.441	.571	.554
MIN RADIUS	.077	.163	.065
MEAN RADIUS	.620	.524	.414
MAX RADIUS	1.334	1.089	1.074
HORIZONTAL SPREAD	1.925	1.339	1.339
VERTICAL SPREAD	1.456	1.456	1.064
EXTREME SPREAD	2.328	1.754	1.611
NUMBER IN ONE INCH CIRCLE	5		

7 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594609

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 3

HS= 2.248

VS= 2.943

GS= 3.045

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.060	1.134	.994
MINIMUM X	:	-1.188	-1.114	-.767
MAXIMUM Y	:	1.518	.995	.789
MINIMUM Y	:	-1.425	-1.256	-1.132
CENTROID X	:	-.105	-.179	-.040
CENTROID Y	:	.480	.311	.187
POA TO CENTROID in.	:	.491	.359	.191
MIN RADIUS	:	.239	.217	.145
MEAN RADIUS	:	.916	.801	.686
MAX RADIUS	:	1.658	1.494	1.146
HORIZONTAL SPREAD	:	2.248	2.248	1.761

BARBER - M24 0020196

NUMBER IN ONE INCH CIRCLE	=	2
NUMBER IN TWO INCH CIRCLE	=	6
NUMBER IN THREE INCH CIRCLE	=	9

R 94-18834

FROM:

COMMANDER (W52H094138H226)
DEFENSE DIST DEPOT ANNISTON
ATTN DDAA-UR BLDG 112
ANNISTON AL

AL 36201-5025

SHIP TO:

COMMANDER (W52H094138H226)
DEFENSE DIST DEPOT ANNISTON
ATTN DDAA-UR BLDG 112
ANNISTON AL

36201-5025

CUST NO: 098397 C.O.D

ACCOUNT NUMBER		ACCOUNT NUMBER N/C		WRITE ☐		PROM. DATE		ESTIMATED		VIA UPS		
GUN CONDITION										REPAIR CHARGE		
☐ NEW										REPAIR CHARGE		
☐ LIGHTLY WORN										EXCISE		
☐ WORN										TAX		
☐ VERY WORN										INSURANCE		
☐ UNREPAIRABLE										UPS		
☐ MARRED										PARCEL POST		
										TOTAL		

CUSTOMER CONCERN	AMMO	FUNCTION	FINISH	ACCURACY	FIT	INSPECT
CYCLE	A1	B1				
TRIGGER GROUP		B2			E1	F1
BOLT ASSY.		B3			E2	F2
BARREL ASSY.		B4		D1	E3	F3
REC. ASSY.		B5		D2	E4	F4
WOOD			C1	D3	E5	F5
METAL			C2			

MAIN FAULT

[illegible]

OFFICE COPY

RD6925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

BARBER - M24 M2400020236

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6594609DATE 2-17-96TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.66	2.50	2.71		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.57	2.54	2.70		
PULL #3	2.50	2.52	2.73		
PULL #4	2.51	2.52	2.59		
PULL #5	2.59	2.55	2.59		
TOTAL	12.83	12.63	13.32		
AVG.	2.56	2.52	2.66		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.35	3.03		
PULL #2	3.33	3.22		
PULL #3	3.00	3.35		
PULL #4	3.28	3.19		
PULL #5	3.31	3.35		
TOTAL	16.27	16.14		
AVG.	3.25	3.22		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.37		4.15
PULL #2	4.27	4.37		4.08
PULL #3	4.24	4.34		4.12
PULL #4	4.13	4.37		4.17
PULL #5	4.22	4.43		4.13
TOTAL	21.08	21.88		20.65
AVG.	4.21	4.37		4.13

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6594609

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