

CBS94524

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.

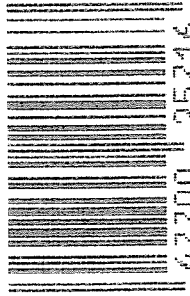
MODEL 700™ H24

SERIAL NO.
C6594524

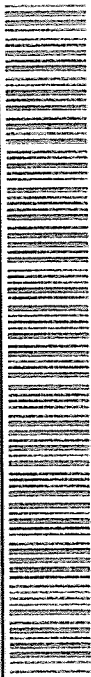
ORDER NO.
5716

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

UPC



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5716 C6594524

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6594524

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1228	90	RW
600	Proof	1228	90	RW
607	Check Headspace	1228	90	RW
610	Dis-assemble Gun	1228	90	RW
612	Magnaflux Barrel Action		1-7-91	KR.
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	GL
617	Drill and Tap Sight Holes	1 10	91	FB
618	Polish Barrel	1 10	91	WB
620	Apply Coatings (Barrel Action)		1-13-91	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		1/19/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/19/91	RW
	C) Inspect Ejector Hole for Chamfer		1/19/91	RW
	D) Oil Firing Pin Ass'y		1/19/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		1-25-91	RU

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			1/25/91	RW
	G) Safety Off Force	3	3	3			1/25/91	RW
	H) Trigger Pull Test & Retainability						1-25-91	82/
	I) Firing Pin Indent	.020	.020	.020			1/25/91	WLB
	J) Assemble Stock						1/25/91	RW
	K) Assemble Swivel Studs						2-4-91	K
	L) Attach Front and Rear Sight Assemblies						1/25/91	RW
	M) Iron Sight Alignment						1/25/91	RW
	N) Detach Front & Rear Sights & place in numbered container						1/25/91	RW
	O) Attach Scope to Rifle						1/25/91	RW
	P) Detach & Attach Scope 20 Times						1/25/91	RW
640	Gallery Target & Test						1-25-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						1-25-91	NF
655	Final Inspection							
	A) Headspace						2-4-91	K
	B) Trigger Pull	2.13	2.16	2.16	2.19	2.18	2-1-91	82/
	C) Function						2-4-91	K
660	Pack						3-19-91	D/H

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6594524

DATE 1-25-91

TESTER JM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.29	2.35	2.24	2.13	MIN. SETTING,
PULL #2	2.26	2.28	2.22	2.16	NO AVG. OF 5
PULL #3	2.26	2.28	2.17	2.16	READINGS ACCEPT-
PULL #4	2.29	2.21	2.15	2.19	ABLE LESS THAN 2#
PULL #5	2.29	2.24	2.20	2.18	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.44	3.29		
PULL #2	3.46	3.26		
PULL #3	3.35	3.26		
PULL #4	3.32	3.33		
PULL #5	3.36	3.25		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.44	4.42		4.45
PULL #2	4.38	4.49		4.40
PULL #3	4.38	4.21		4.43
PULL #4	4.41	4.40		4.37
PULL #5	4.29	4.42		4.41
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594524
26 Jan 1991

CENTROIDAL DISTANCES

0 TO	1	.0510098
1 TO	2	.158382
1 TO	3	.0664078
1 TO	4	.045793
1 TO	5	.29867

5 <----POA

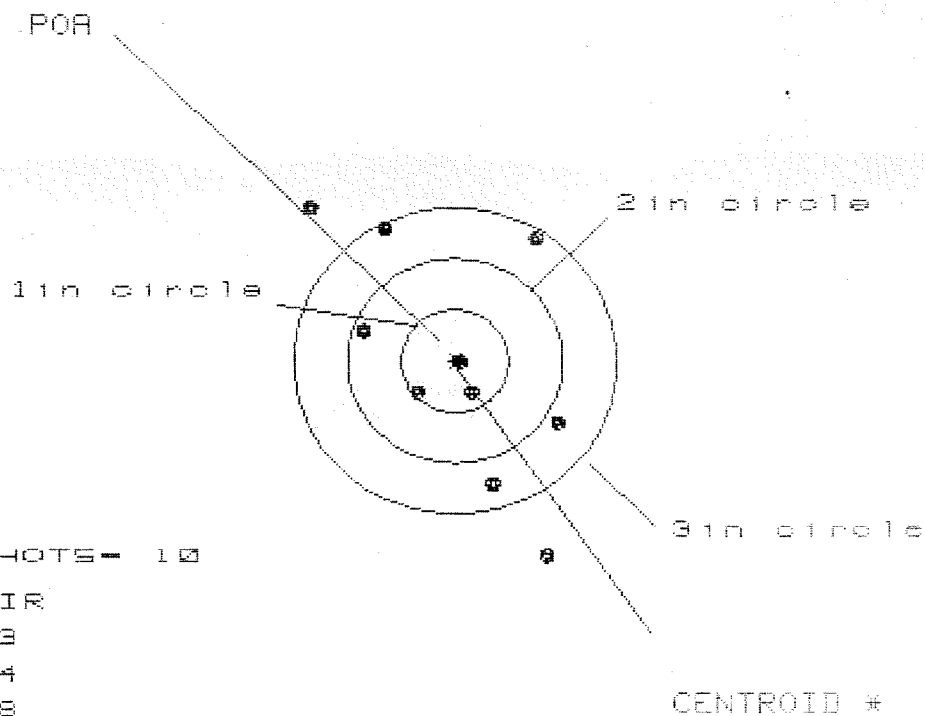
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0356
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0972
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .103514

THE AMR FOR THIS RIFLE IS: .915

26 Jan 1991

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CENTERFIRE PATTERNS # 1



PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.956	1.051	.898
MINIMUM X	:	-1.314	-1.219	-.900
MAXIMUM Y	:	1.515	1.302	1.284
MINIMUM Y	:	-1.916	-1.436	-1.273
CENTROID X	:	-.051	-.146	.007
CENTROID Y	:	.001	.214	.051
POA TO CENTROID in.	:	.051	.259	.052
MIN RADIUS	:	.080	.276	.056
MEAN RADIUS	:	1.116	1.034	.886
MAX RADIUS	:	2.095	1.784	1.466
HORIZONTAL SPREAD	:	2.270	2.270	1.798
VERTICAL SPREAD	:	3.431	2.738	2.557
EXTREME SPREAD	:	4.055	3.206	2.747
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 4

2 in = 6

3 in = 8

HS= 2.478

VS= 3.014

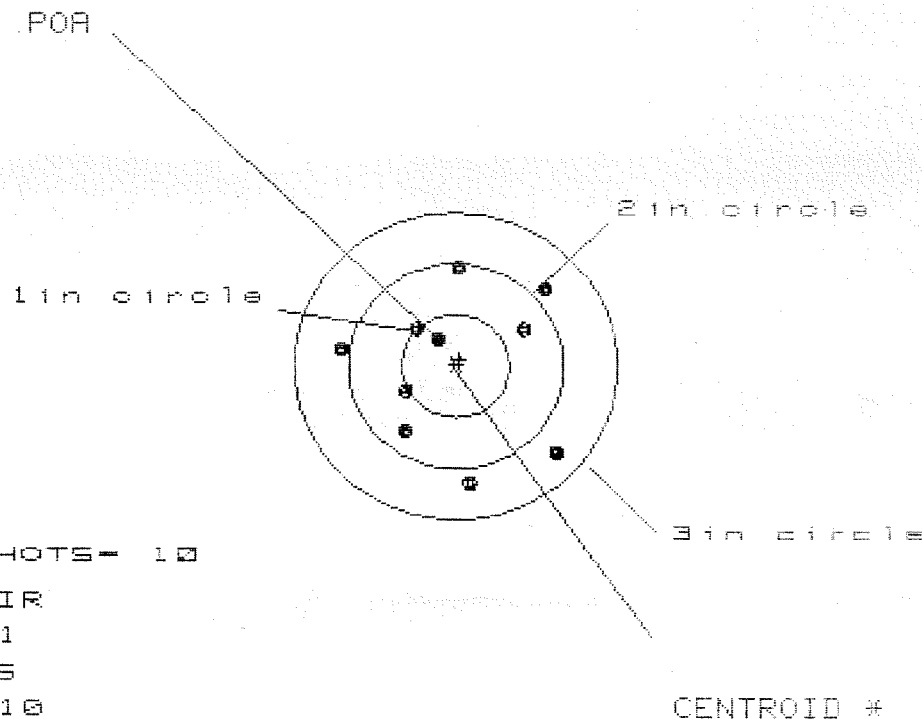
CS= 3.091

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.196	1.221	1.337
MINIMUM X	-1.282	-1.257	-1.141
MAXIMUM Y	1.780	1.123	.993
MINIMUM Y	-1.234	-1.036	-.690
CENTROID X	-.014	-.039	-.155
CENTROID Y	-.153	-.351	-.221
POA TO CENTROID in.	.154	.353	.270
MIN RADIUS	.013	.133	.131
MEAN RADIUS	.868	.777	.659
MAX RADIUS	1.793	1.391	1.504
HORIZONTAL SPREAD	2.478	2.478	2.478
VERTICAL SPREAD	3.014	2.159	1.683
EXTREME SPREAD	3.091	2.517	2.517
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 6

3 in = 10

HS = 1.957

VS = 2.135

GS = 2.181

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.907	.934	.961
MINIMUM X	-1.050	-.950	-.923
MAXIMUM Y	.952	.862	.702
MINIMUM Y	-1.183	-1.273	-.840
CENTROID X	-.030	-.130	-.157
CENTROID Y	-.062	.028	.188
POA TO CENTROID in.	.069	.133	.245
MIN RADIUS	.273	.142	.054
MEAN RADIUS	.833	.758	.662
MAX RADIUS	1.219	1.291	1.102
HORIZONTAL SPREAD	1.957	1.884	1.884
VERTICAL SPREAD	2.135	2.135	1.542
EXTREME SPREAD	2.181	2.136	1.991
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 1

2in = 8

3in = 9

HS = 2.022

VS = 2.303

GS = 2.892

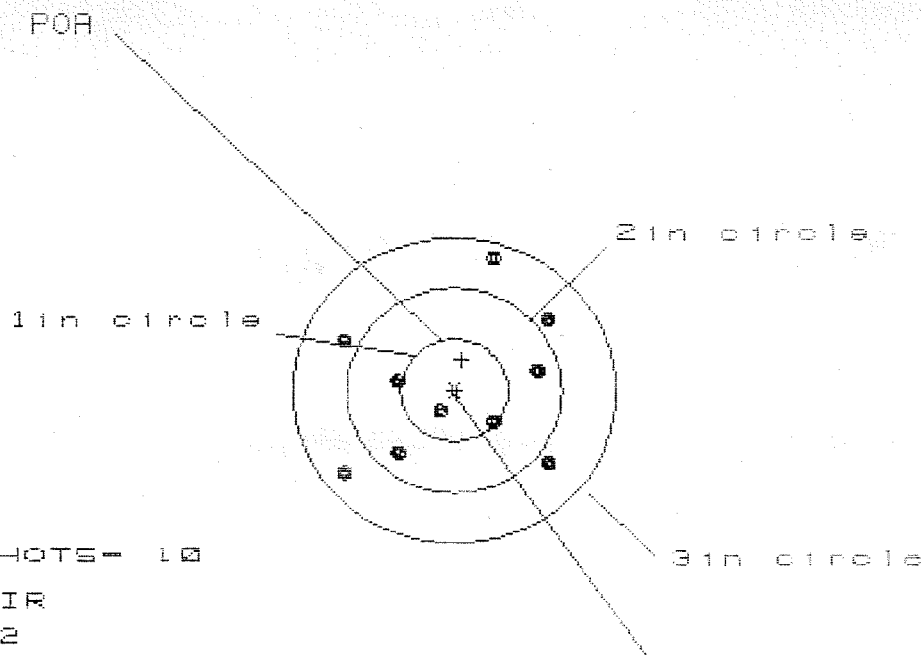
CENTROID #

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.696	.549	.382
MINIMUM X	-1.326	-1.340	-.796
MAXIMUM Y	.851	.690	.644
MINIMUM Y	-1.452	-.836	-.882
CENTROID X	-.012	.135	.303
CENTROID Y	.025	.186	.232
POA TO CENTROID in.	.028	.230	.381
MIN RADIUS	.343	.217	.150
MEAN RADIUS	.873	.683	.542
MAX RADIUS	1.966	1.388	1.016
HORIZONTAL SPREAD	2.022	1.889	1.167
VERTICAL SPREAD	2.303	1.526	1.526
EXTREME SPREAD	2.892	2.041	1.921
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1in - 2

2in - 5

3in - 10

HS = 1.913

VS = 2.131

GS = 2.541

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.898	.939	.818
MINIMUM X	-1.015	-.974	-1.068
MAXIMUM Y	1.287	.832	.744
MINIMUM Y	-.844	-.701	-.633
CENTROID X	-.071	-.112	.010
CENTROID Y	-.297	-.440	-.352
POA TO CENTROID in.	.305	.454	.352
MIN RADIUS	.280	.139	.288
MEAN RADIUS	.885	.808	.766
MAX RADIUS	1.339	1.255	1.201
HORIZONTAL SPREAD	1.913	1.913	1.885
VERTICAL SPREAD	2.131	1.533	1.377
EXTREME SPREAD	2.541	2.451	2.162
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		

NUMBER IN THREE INCH CIRCLE =

10