

C6636304

MODEL 700™ M24

Model **SMS**™

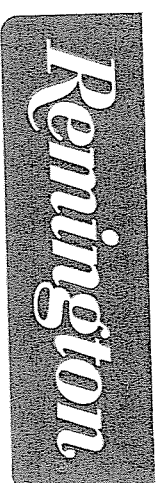
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.






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

MODEL 700™

W24

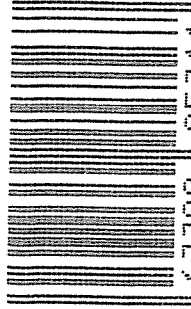
SERIAL NO.
C6636304

ORDER NO.
5716

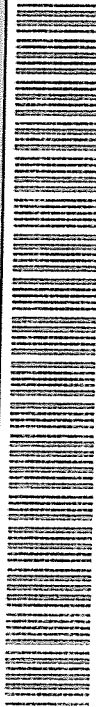
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

20

UPC



0 47700 25716 7



5716 C6636304

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636304

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 25	9 1	RW
600	Proof	6 25	9 1	RW
607	Check Headspace	6 25	9 1	RW
610	Dis-assemble Gun	6 25	9 1	RW
612	Magnaflux Barrel Action	JUL	1 1991	KR
	Magnaflux Bolt	JUL	1 1991	KR
615	Rollmark Caliber	JUL	1 1991	JS
617	Drill and Tap Sight Holes	JUL	1 1991	FB
618	Polish Barrel	JUL	2 1991	WB
620	Apply Coatings (Barrel Action)		8/27/91	WB
	Apply Coating (Bolt)			WB
625	Final Assembly			
	A) Clean inside of Bolt Assembly		8/28/91	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/28/91	WB
	C) Inspect Ejector Hole for Chamfer		8/28/91	WB
	D) Oil Firing Pin Ass'y		8/28/91	WB
	E) Adjust Trigger Pull to Min Setting and Stake		8/26/91	JO

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8/26/91	DH
	G) Safety Off Force	2	2	2			8/26/91	DH
	H) Trigger Pull Test & Retainability						8/26/91	JU
	I) Firing Pin Indent	.022	.021	.022			8/26/91	DH
	J) Assemble Stock						8-28-91	DH
	K) Assemble Swivel Studs						8-28-91	DH
	L) Attach Front and Rear Sight Assemblies						8/28/91	RW
	M) Iron Sight Alignment						8/28/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/28/91	RW
	O) Attach Scope to Rifle						8/28/91	RW
	P) Detach & Attach Scope 20 Times						8/28/91	RW
640	Gallery Target & Test						8-28-91	AC
	A) Time						8-28-91	AC
	B) Malfunctions						8-28-91	AC
	C) Pierced Primers						8-28-91	AC
	D) Optical Clarity of Scope						8-28-91	AC
645	Inspect for Live Ammo						8-28-91	AC
655	Final Inspection						8-28-91	DH
	A) Headspace						8-28-91	DH
	B) Trigger Pull	249	251	246	248	246	8-27-91	DH
	C) Function						8-28-91	DH
660	Pack						9-17-91	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C-6636304

DATE 8-26-91

TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.36	2.44	2.49	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.44	2.43	2.40	2.51	
PULL #3	2.42	2.41	2.38	2.46	
PULL #4	2.36	2.43	2.38	2.48	
PULL #5	2.42	2.36	2.36	2.46	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.33	3.37		
PULL #2	3.37	3.39		
PULL #3	3.29	3.31		
PULL #4	3.19	3.35		
PULL #5	3.29	3.31		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.60	4.31		4.35
PULL #2	4.33	4.46		4.47
PULL #3	4.45	4.18		4.55
PULL #4	4.29	4.31		4.61
PULL #5	4.38	4.39		4.45
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636304
26 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.202054
1 TO	2	.276481
1 TO	3	.11905
1 TO	4	.249227
1 TO	5	.226982

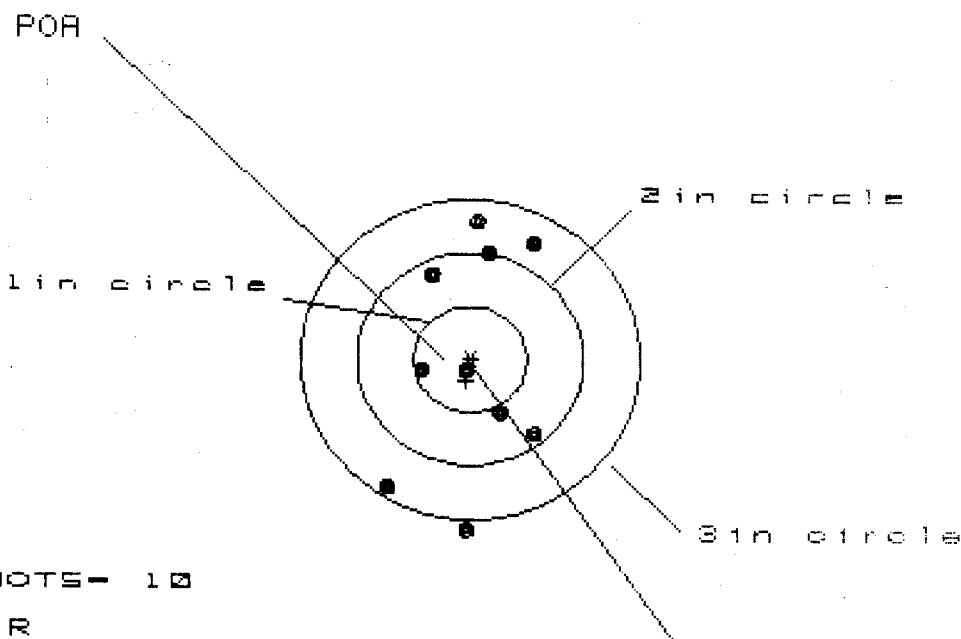
☛ <----POA

AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0738
AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0786
AVERAGE POI RADIUS FOR THIS RIFLE IS: .107817
AVERAGE FOR THIS RIFLE IS: 1.057

05 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636304

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 3

HS= 1.312

VS= 2.883

GS= 2.885

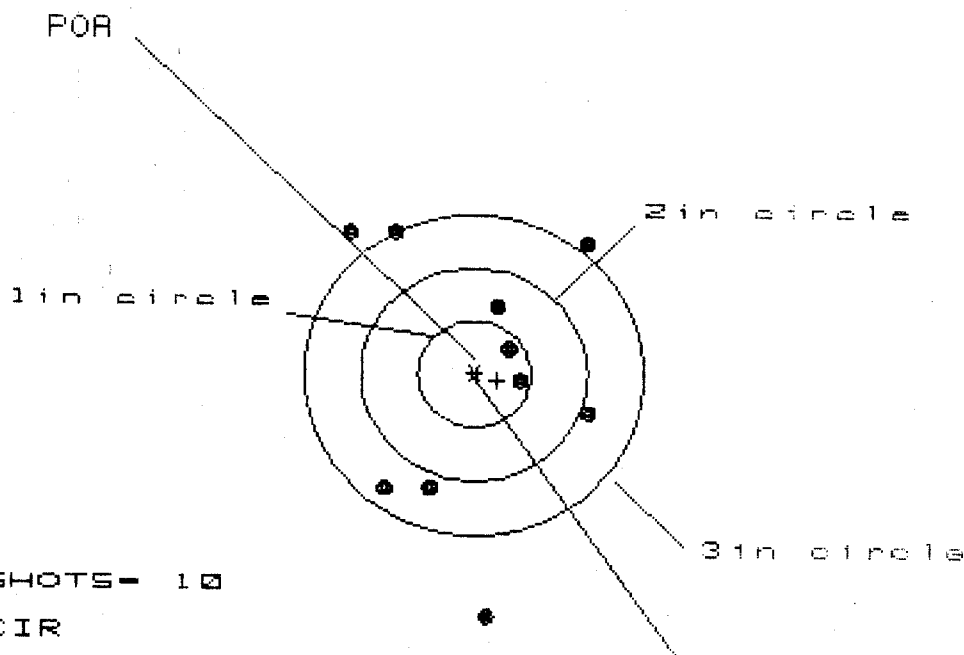
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.580	.571	.478
MINIMUM X	:	-.732	-.741	-.521
MAXIMUM Y	:	1.260	1.080	.905
MINIMUM Y	:	-1.623	-1.402	-1.068
CENTROID X	:	.035	.044	.137
CENTROID Y	:	.199	.380	.555
POA TO CENTROID in.	:	.203	.382	.572
MIN RADIUS	:	.134	.308	.502
MEAN RADIUS	:	.958	.888	.798
MAX RADIUS	:	1.624	1.586	1.157
HORIZONTAL SPREAD	:	1.312	1.312	.999
VERTICAL SPREAD	:	2.883	2.482	1.973
EXTREME SPREAD	:	2.885	2.690	2.042
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

20 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636304

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 3

3 in = 7

HS= 2.126

VS= 3.661

GS= 3.862

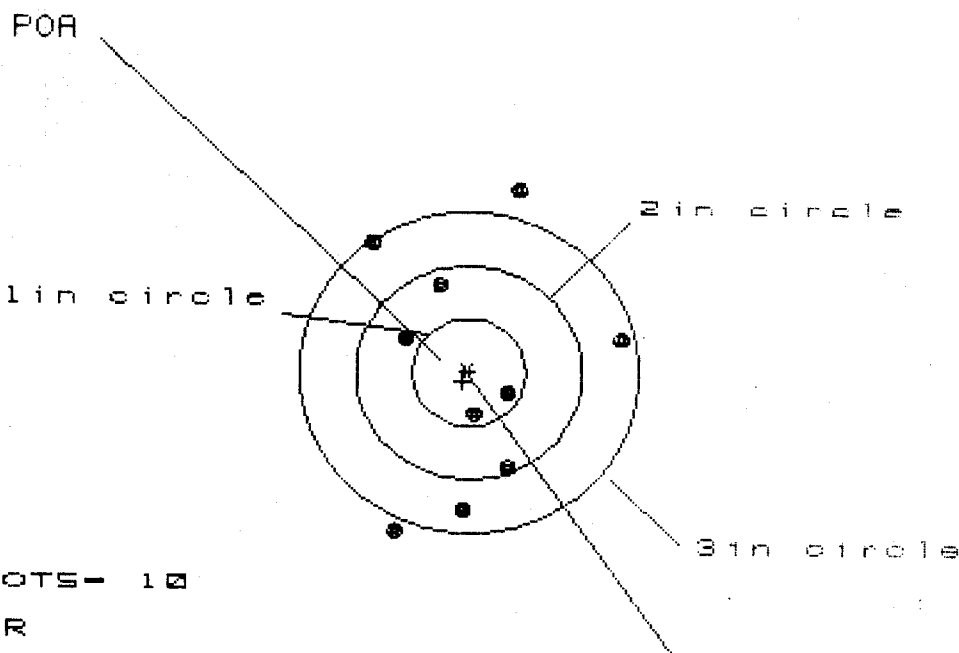
CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.039	1.055	.921
MINIMUM X	:	-1.087	-1.071	-.948
MAXIMUM Y	:	1.365	1.109	1.200
MINIMUM Y	:	-2.296	-1.364	-1.225
CENTROID X	:	-.204	-.220	-.086
CENTROID Y	:	.060	.316	.177
POA TO CENTROID in.	:	.212	.385	.197
MIN RADIUS	:	.371	.292	.206
MEAN RADIUS	:	1.209	1.061	.965
MAX RADIUS	:	2.301	1.542	1.486
HORIZONTAL SPREAD	:	2.126	2.126	1.869
VERTICAL SPREAD	:	3.661	2.473	2.425
EXTREME SPREAD	:	3.862	2.951	2.951
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		7	

26 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636304

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS= 2.192

VS= 3.219

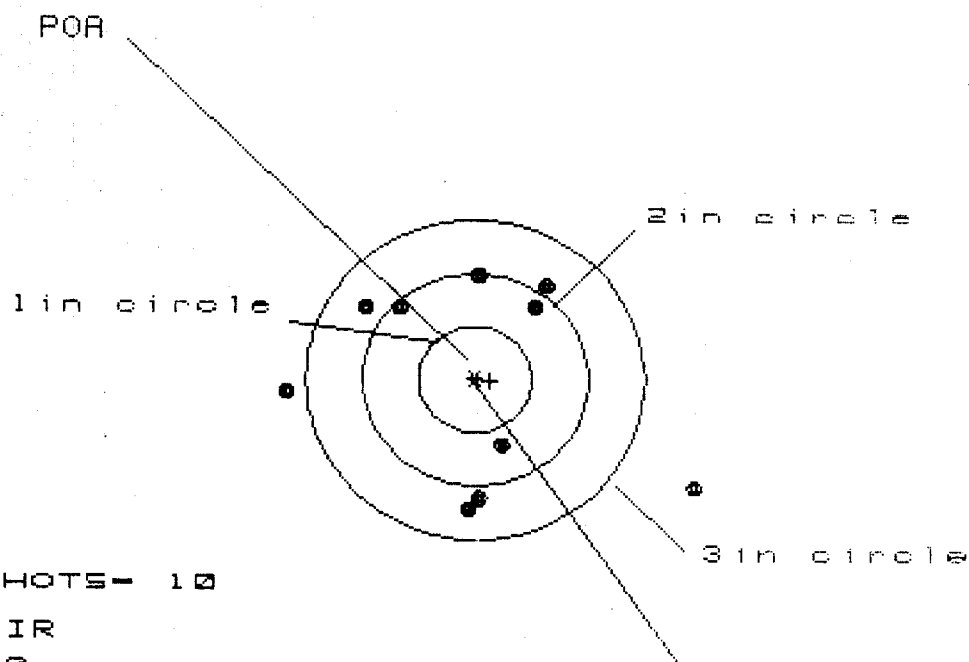
GS= 3.427

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.306	1.361	1.281
MINIMUM X	:	-.885	-.831	-.910
MAXIMUM Y	:	1.737	1.390	1.229
MINIMUM Y	:	-1.482	-1.289	-1.285
CENTROID X	:	.057	.002	.032
CENTROID Y	:	.082	-.111	.050
POA TO CENTROID in.	:	.100	.111	.096
MIN RADIUS	:	.397	.226	.358
MEAN RADIUS	:	1.078	.969	.913
MAX RADIUS	:	1.804	1.620	1.529
HORIZONTAL SPREAD	:	2.192	2.192	2.192
VERTICAL SPREAD	:	3.219	2.679	2.514
EXTREME SPREAD	:	3.427	2.686	2.637
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

26 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636384

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 8

HS= 3.631

VS= 2.217

GS= 3.751

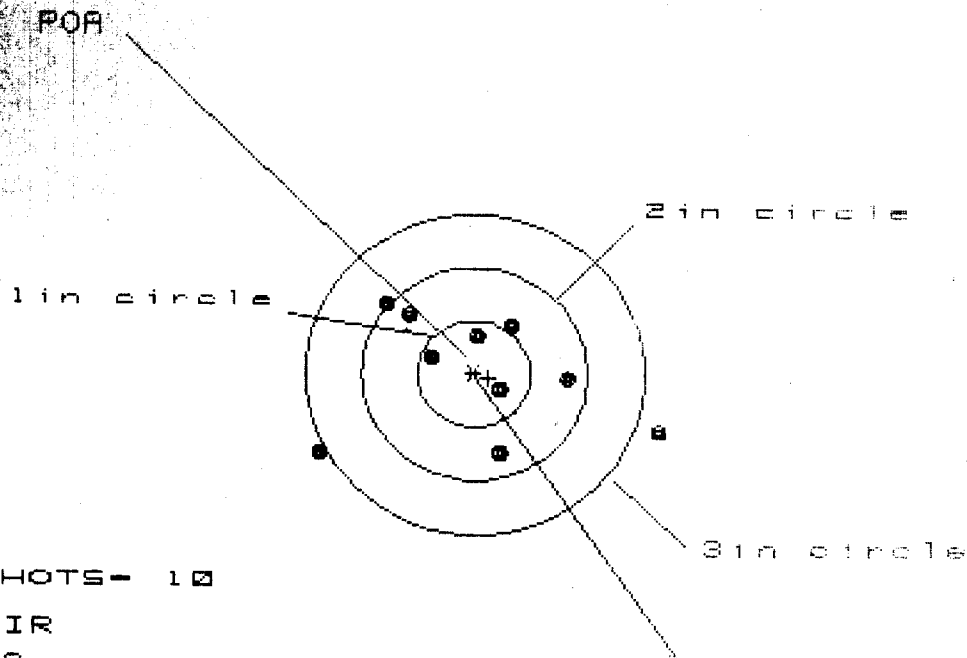
CENTROID #

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.922	.849	.662
MINIMUM X	:	-1.709	-1.496	-.991
MAXIMUM Y	:	.990	.875	.849
MINIMUM Y	:	-1.227	-1.342	-1.368
CENTROID X	:	-.132	-.345	-.158
CENTROID Y	:	.014	.129	.155
POA TO CENTROID in.	:	.133	.369	.221
MIN RADIUS	:	.623	.756	.763
MEAN RADIUS	:	1.201	1.076	1.001
MAX RADIUS	:	2.182	1.510	1.368
HORIZONTAL SPREAD	:	3.631	2.345	1.653
VERTICAL SPREAD	:	2.217	2.217	2.217
EXTREME SPREAD	:	3.751	2.556	2.254
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	8		

May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6696304

CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 7

3 in = 8

HS = 3.063

VS = 1.395

GS = 3.074

CENTROID *

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.653	1.031	.878
MINIMUM X	:	-1.410	-1.227	-.785
MAXIMUM Y	:	.614	.555	.450
MINIMUM Y	:	-.781	-.840	-.903
CENTROID X	:	-.125	-.308	-.155
CENTROID Y	:	.038	.097	.202
POA TO CENTROID in.	:	.130	.323	.255
MIN RADIUS	:	.219	.246	.235
MEAN RADIUS	:	.841	.732	.606
MAX RADIUS	:	1.735	1.487	.932
HORIZONTAL SPREAD	:	3.063	2.258	1.663
VERTICAL SPREAD	:	1.395	1.395	1.353
EXTREME SPREAD	:	3.074	2.376	1.787
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	