

C6648926

MODEL 700™ M24

Model SMS

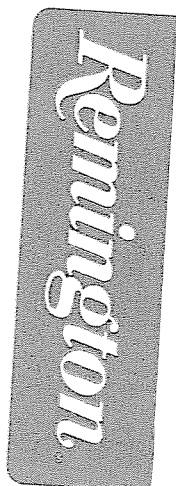
Action™

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.






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

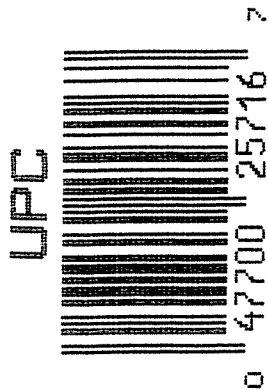
REG. U.S. PAT. & TM. OFF.

MODEL 700™ H24

SERIAL NO.
C6648926

ORDER NO.
5716

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



GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6648926

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 2	9 1	RW
600	Proof	7 2	9 1	RW
607	Check Headspace	7 2	9 1	RW
610	Dis-assemble Gun	7 2	9 1	RW
612	Magnaflux Barrel Action		JUL 22 1991	GS
	Magnaflux Bolt		JUL 22 1991	GS
615	Rollmark Caliber		JUL 22 1991	GS
617	Drill and Tap Sight Holes		JUL 22 1991	FB
618	Polish Barrel		7/22/91	WB
620	Apply Coatings (Barrel Action)		7-22-91	DA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/29/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/29/91	RW
	C) Inspect Ejector Hole for Chamfer		8/29/91	RW
	D) Oil Firing Pin Ass'y		8/29/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9/10/91	GU

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	5½			9-10-91	DH
	G) Safety Off Force	2	2	2			9-10-91	DH
	H) Trigger Pull Test & Retainability						9/10/91	RU
	I) Firing Pin Indent	.022	.023	.021			9-10-91	DH
	J) Assemble Stock						9/10/91	RW
	K) Assemble Swivel Studs						9/13/91	JH
	L) Attach Front and Rear Sight Assemblies						9/11/91	RW
	M) Iron Sight Alignment						9/11/91	RW
	N) Detach Front & Rear Sights & place in numbered container						9/11/91	RW
	O) Attach Scope to Rifle						9/12/91	RW
	P) Detach & Attach Scope 20 Times						9/14/91	RW
640	Gallery Target & Test						9-11-91	DH
	A) Time						9-11-91	DH
	B) Malfunctions						9-11-91	DH
	C) Pierced Primers						9-11-91	DH
	D) Optical Clarity of Scope						9-11-91	DH
645	Inspect for Live Ammo						9-11-91	DH
655	Final Inspection						9/13/91	RU
	A) Headspace						9-12-91	RU
	B) Trigger Pull	2.27	2.39	2.32	2.28	2.43	9-12-91	RU
	C) Function						9/13/91	RU
660	Pack						9-12-91	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 6648926

DATE 9-10-91

TESTER JM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.29	2.25	2.47	2.27	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.39	2.23	2.43	2.39	
PULL #3	2.26	2.35	2.40	2.32	
PULL #4	2.45	2.42	2.44	2.28	
PULL #5	2.31	2.39	2.41	2.43	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.58	3.51		
PULL #2	3.60	3.41		
PULL #3	3.58	3.22		
PULL #4	3.24	3.33		
PULL #5	3.56	3.45		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.45	4.37		4.41
PULL #2	4.43	4.34		4.41
PULL #3	4.33	4.34		4.48
PULL #4	4.43	4.47		4.35
PULL #5	4.35	4.41		4.34
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6648926
11 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.0446542
1 TO	2	.096566
1 TO	3	.245018
1 TO	4	.33864
1 TO	5	.199023

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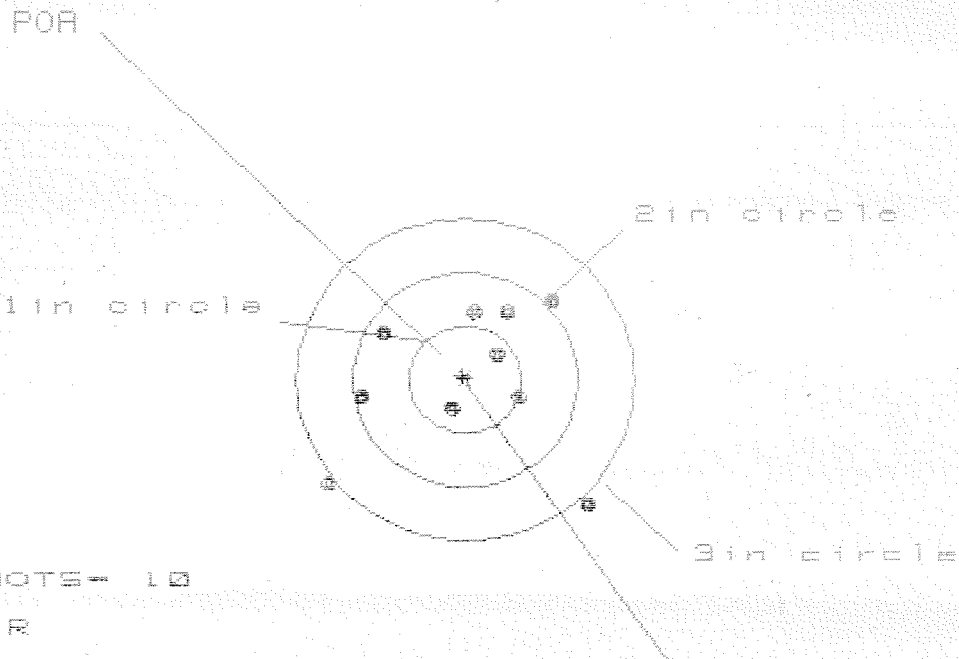
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0488
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.034
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0594764
THE AMR FOR THIS RIFLE IS: .8964

11 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6648926

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 7

3 in = 8

HS= 2.247

VS= 1.820

GS= 2.550

CENTROID *

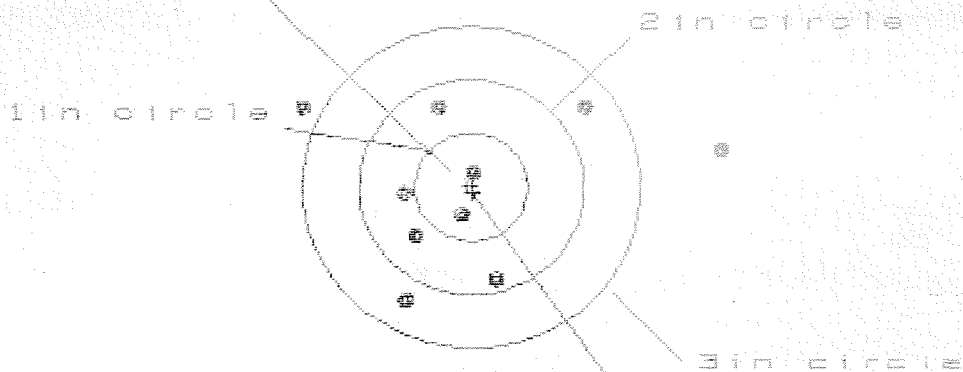
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.043	.872	.736
MINIMUM X	-1.204	-1.088	-.927
MAXIMUM Y	.690	.564	.430
MINIMUM Y	-1.131	-1.067	-.479
CENTROID X	.025	-.091	.045
CENTROID Y	-.037	.089	.223
FOR TO CENTROID in.	.044	.128	.227
MIN RADIUS	.256	.346	.229
MEAN RADIUS	.829	.744	.606
MAX RADIUS	1.538	1.524	1.024
HORIZONTAL SPREAD	2.247	1.960	1.663
VERTICAL SPREAD	1.820	1.631	.909
EXTREME SPREAD	2.550	2.550	1.875
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		

11 Sep 1991

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CENTERFIRE PATTERNS # 2

POA



OF SHOTS = 10

IN CIR

1in = 2

2in = 6

3in = 8

HS = 3.729

VS = 1.846

GS = 3.749

CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.254	1.308	1.155
MINIMUM X	:	-1.475	-1.225	-.491
MAXIMUM Y	:	.749	.788	.866
MINIMUM Y	:	-1.097	-1.058	-.959
CENTROID X	:	-.010	-.260	-.107
CENTROID Y	:	.053	.013	-.086
POA TO CENTROID in.	:	.053	.260	.137
MIN RADIUS	:	.182	.254	.116
MEAN RADIUS	:	.981	.798	.702
MAX RADIUS	:	2.282	1.507	1.432
HORIZONTAL SPREAD	:	3.729	2.533	1.646
VERTICAL SPREAD	:	1.846	1.846	1.825
EXTREME SPREAD	:	3.749	2.533	2.443
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS= 3.002

VS= 2.853

GS= 3.285

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.142	.911	.853
MINIMUM X	:	-.860	-.622	-.509
MAXIMUM Y	:	1.543	1.517	1.271
MINIMUM Y	:	-1.310	-1.336	-1.146
CENTROID X	:	-.072	-.310	-.423
CENTROID Y	:	-.262	-.236	-.426
POA TO CENTROID in.	:	.271	.389	.601
MIN RADIUS	:	.411	.507	.287
MEAN RADIUS	:	1.111	.956	.814
MAX RADIUS	:	2.154	1.770	1.369
HORIZONTAL SPREAD	:	3.002	1.533	1.362
VERTICAL SPREAD	:	2.853	2.853	2.417
EXTREME SPREAD	:	3.285	2.946	2.545
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

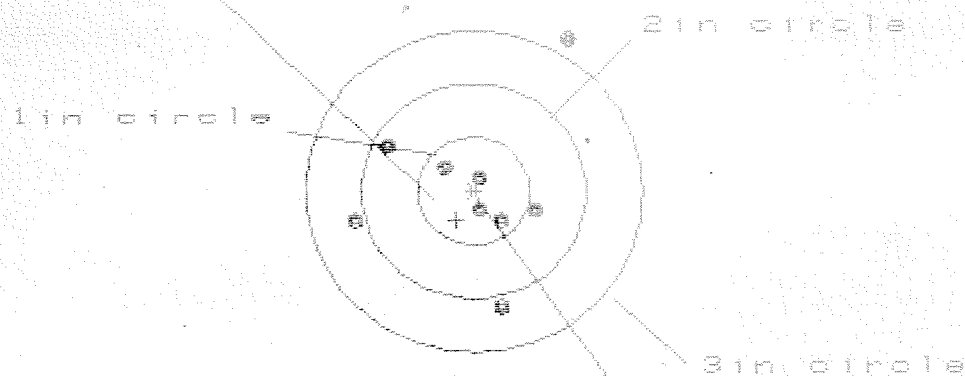
11 Sep 1991

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CENTERFIRE PATTERNS

4

POA



OF SHOTS- 10

IN CIR

1in = 5

2in = 7

3in = 9

HS= 1.845

VS= 2.516

GS= 2.573

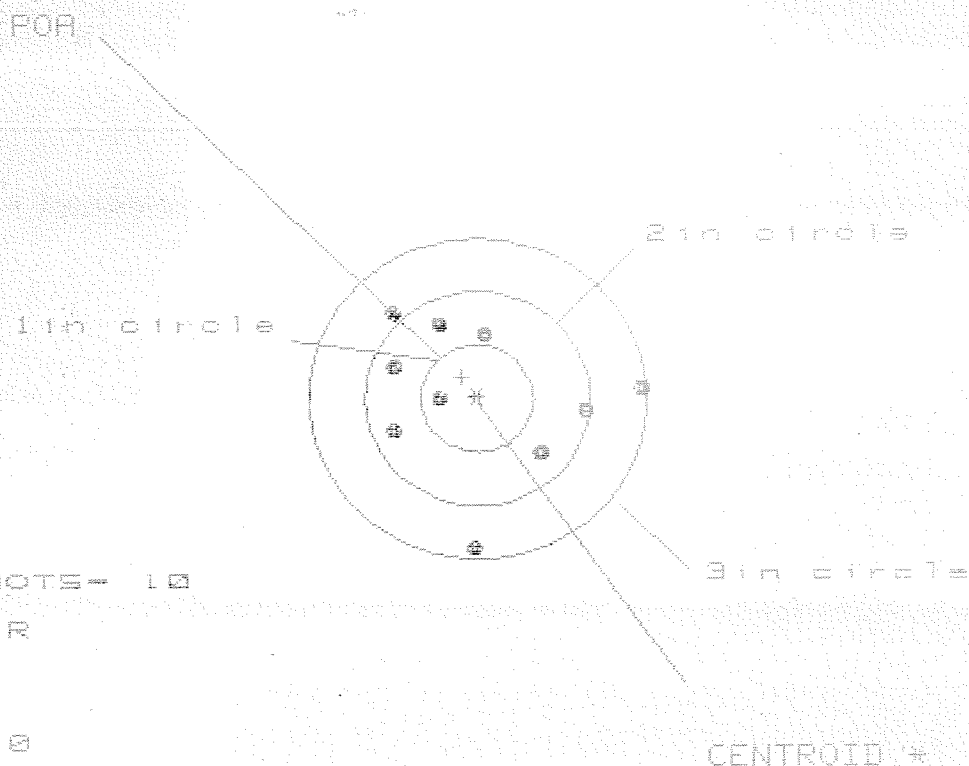
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.796	.669	.712
MINIMUM X	:	-1.049	-.960	-.917
MAXIMUM Y	:	1.454	.554	.441
MINIMUM Y	:	-1.062	-.900	-.260
CENTROID X	:	.159	.070	.027
CENTROID Y	:	.274	.112	.225
POA TO CENTROID in.	:	.317	.132	.227
MIN RADIUS	:	.168	.140	.222
MEAN RADIUS	:	.661	.548	.497
MAX RADIUS	:	1.658	.968	.946
HORIZONTAL SPREAD	:	1.845	1.629	1.629
VERTICAL SPREAD	:	2.516	1.454	.701
EXTREME SPREAD	:	2.573	1.794	1.631
NUMBER IN ONE INCH CIRCLE =			5	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			9	

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 1

2in = 7

3in = 10

HS= 2.244

VS= 2.183

GS= 2.289

PATTERN #

SHOTS (BEST OF)

MAXIMUM X

MINIMUM X

MAXIMUM Y

MINIMUM Y

CENTROID X

CENTROID Y

POA TO CENTROID in.

MIN RADIUS

MEAN RADIUS

MAX RADIUS

HORIZONTAL SPREAD

VERTICAL SPREAD

EXTREME SPREAD

NUMBER IN ONE INCH CIRCLE =

NUMBER IN TWO INCH CIRCLE =

NUMBER IN THREE INCH CIRCLE =

5

10

1.457

-.787

.753

-1.430

.142

-.198

.244

.348

.900

1.461

2.244

2.183

2.289

=

=

=

9

1.081

-.625

.765

-1.418

-.020

-.210

.211

.186

.806

1.427

1.706

2.183

2.289

=

=

=

8

1.101

-.605

.587

-.689

-.040

-.032

.051

.269

.702

1.126

1.700

1.276

1.816

=

=

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