

C6636016

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 700TM M24

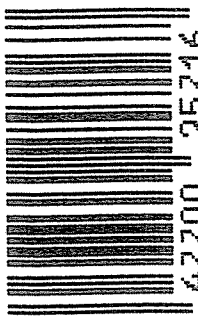
SERIAL NO.
C6636016

ORDER NO.
5716

20

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

UPC



0 47700 25716 7



5716 C6636016

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636016

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 8	91	RW
600	Proof	4 8	91	RW
607	Check Headspace			RW
610	Dis-assemble Gun			RW
612	Magnaflux Barrel Action		APR 9 1991	KR
	Magnaflux Bolt		APR 9 1991	IC
615	Rollmark Caliber		APR 9 1991	JS
617	Drill and Tap Sight Holes		APR 10 1991	EB
618	Polish Barrel		APR 19 1991	WB
620	Apply Coatings (Barrel Action)		5-10-91	TS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/14/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/14/91	RW
	C) Inspect Ejector Hole for Chamfer		5/14/91	RW
	D) Oil Firing Pin Ass'y		5/14/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/28/91	JS

Op. #	OP. NAME	READINGS					DATE	INIT
525 cont.	F) Safety On Force	5	5	5			5/28/91	98
	G) Safety Off Force	4	4	4			5/28/91	98
	H) Trigger Pull Test & Retainability						5/28/91	98
	I) Firing Pin Indent	.0205	.021	.021			5/28/91	98
	J) Assemble Stock						5/28/91	Rw
	K) Assemble Swivel Studs						6-1-91	D/H
	L) Attach Front and Rear Sight Assemblies						5/28/91	Rw
	M) Iron Sight Alignment						5/28/91	Rw
	N) Detach Front & Rear Sights & place in numbered container						5/28/91	Rw
	O) Attach Scope to Rifle						5/28/91	Rw
	P) Detach & Attach Scope 20 Times						5/28/91	Rw
540	Gallery Target & Test						5-29-91	D/H
	A) Time						5-29-91	D/H
	B) Malfunctions						5-29-91	D/H
	C) Pierced Primers						5-29-91	D/H
	D) Optical Clarity of Scope						5-29-91	D/H
545	Inspect for Live Ammo						5-29-91	D/H
555	Final Inspection							
	A) Headspace						6-1-91	D/H
	B) Trigger Pull	2.48	2.35	2.47	2.48	2.43	6-1/91	98
	C) Function						6-1-91	D/H
660	Pack						6-20-91	VF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6636016

DATE 5/28/91

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.27	2.18	2.25	2.48	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.26	2.34	2.28	2.35	
PULL #3	2.34	2.33	2.19	2.47	
PULL #4	2.26	2.22	2.26	2.48	
PULL #5	2.54	2.19	2.20	2.43	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.54	3.60		
PULL #2	3.34	3.20		
PULL #3	3.57	3.60		
PULL #4	3.57	3.63		
PULL #5	3.51	3.67		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.20	4.32		4.46
PULL #2	4.44	4.46		4.48
PULL #3	4.44	4.49		4.41
PULL #4	4.42	4.50		4.36
PULL #5	4.45	4.32		4.50
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636016
29 May 1991

CENTROIDAL DISTANCES

0 TO	1	.406282
1 TO	2	.598372
1 TO	3	.465715
1 TO	4	.404969
1 TO	5	1.27048

5
4
3
2
1
0

<----POA

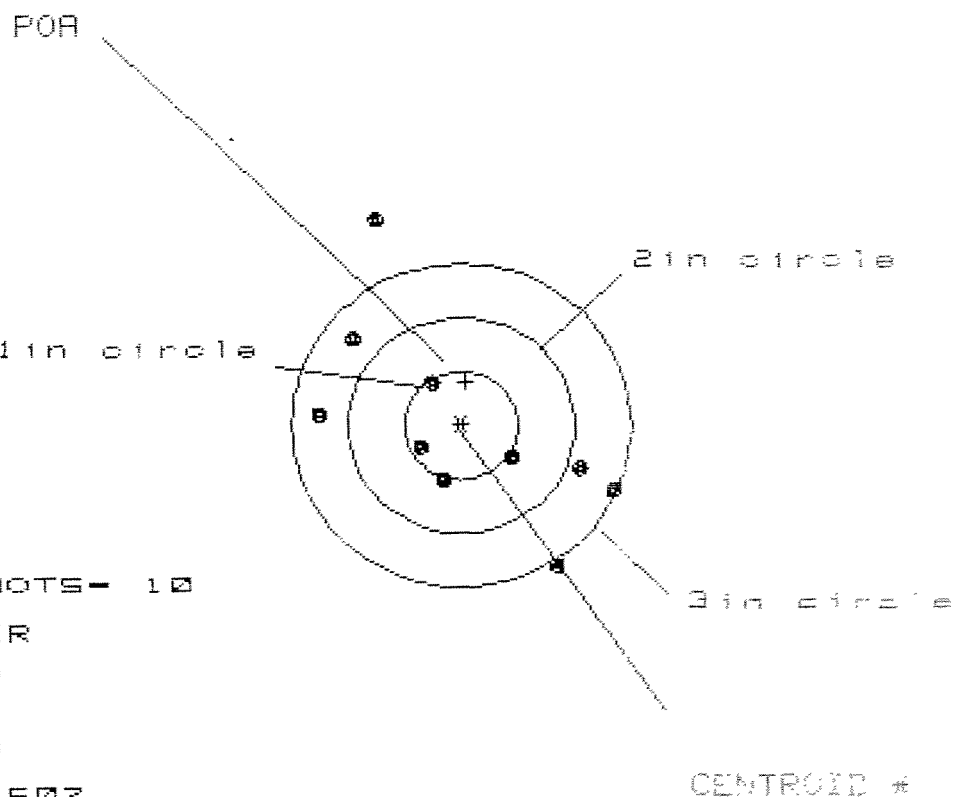
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.176
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1208
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .213468
THE AMR FOR THIS RIFLE IS: .9272

29 May 1981

FILE:/PATTERNING/CENTERFIRE_PATT/06036006

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1in - 3

2in - 4

3in - 8

HS- 2.607

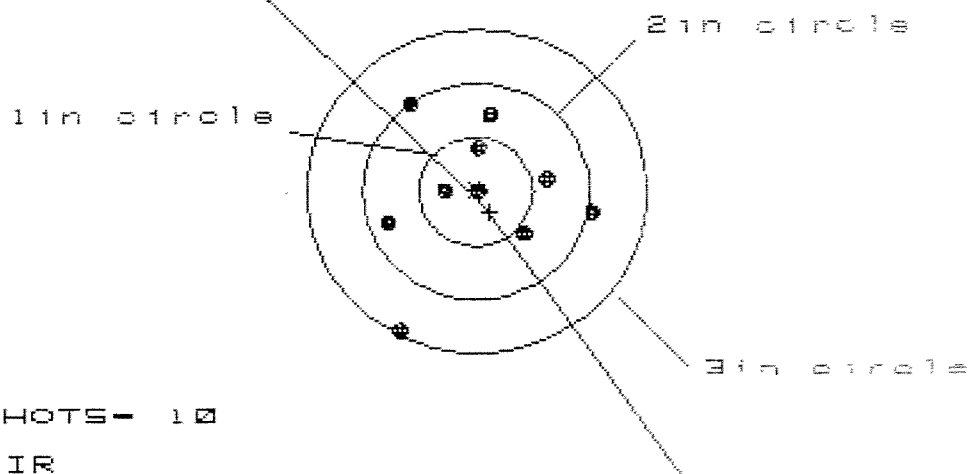
VS- 3.236

GS- 3.608

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.365	1.287	1.398
MINIMUM X	-1.242	-1.320	-1.219
MAXIMUM Y	1.947	.976	.842
MINIMUM Y	-1.288	-1.072	-.492
CENTROID X	-.043	.035	-.066
CENTROID Y	-.404	-.621	-.487
POA TO CENTROID in.	.407	.622	.491
MIN RADIUS	.424	.330	.368
MEAN RADIUS	1.068	.928	.868
MAX RADIUS	2.072	1.431	1.472
HORIZONTAL SPREAD	2.607	2.607	2.607
VERTICAL SPREAD	3.236	2.048	1.334
EXTREME SPREAD	3.608	2.763	2.692
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

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POA



IN CIR

Zin - 7

$$317 = 10$$
HS- 1.77 ☒
$$V_S = 2.044$$

GS= 2.157

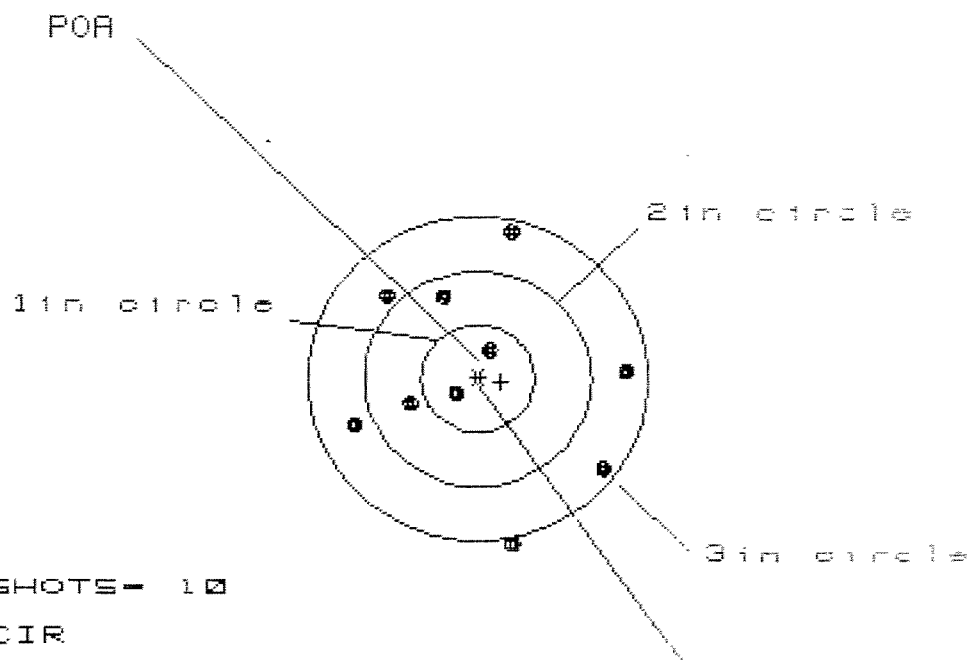
CENTROID $\bar{x}$ $\bar{y}$ $\bar{z}$

PATTERN #	:	2	:	
SHOTS (BEST OF)	:	10	:	9
MAXIMUM X	:	1.032	:	.957
MINIMUM X	:	-.738	:	-.813
MAXIMUM Y	:	.800	:	.662
MINIMUM Y	:	-1.244	:	-.529
CENTROID X	:	-.123	:	-.048
CENTROID Y	:	.189	:	.327
FOR TO CENTROID in.	:	.225	:	.330
MIN RADIUS	:	.049	:	.110
MEAN RADIUS	:	.703	:	.611
MAX RADIUS	:	1.418	:	1.000
HORIZONTAL SPREAD	:	1.770	:	1.770
VERTICAL SPREAD	:	2.044	:	1.191
EXTREME SPREAD	:	2.157	:	1.896
NUMBER IN ONE INCH CIRCLE	=		:	3
NUMBER IN TWO INCH CIRCLE	=		:	7
NUMBER IN THREE INCH CIRCLE	=		:	10

29 May 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 2

2in = 4

3in = 9

HS = 2.387

VS = 2.850

GS = 2.850

CENTROID *

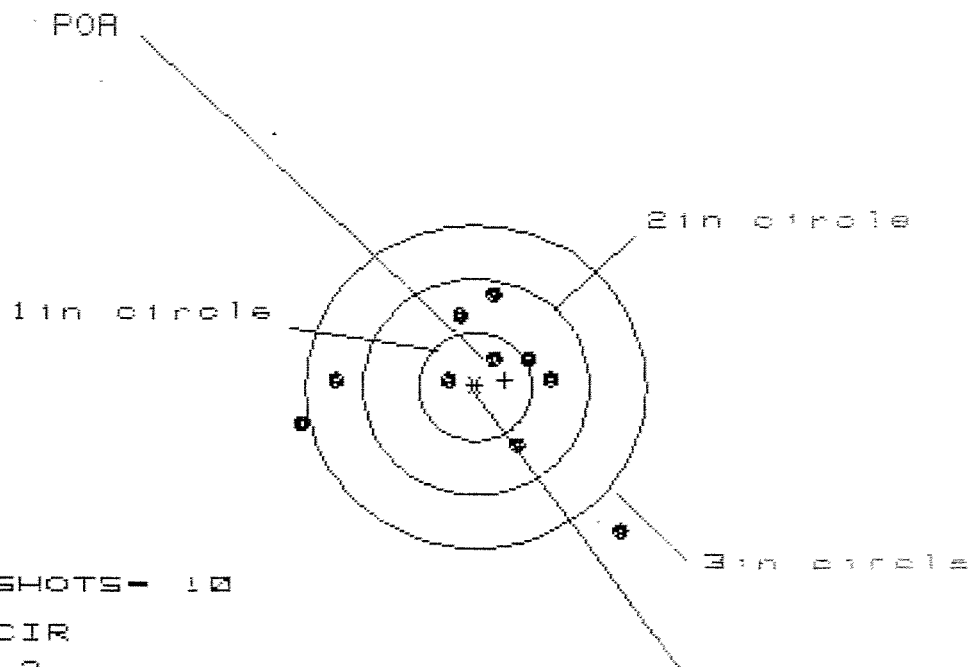
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.309	1.345	1.437
MINIMUM X	:	-1.078	-1.042	-0.900
MAXIMUM Y	:	1.346	1.178	1.050
MINIMUM Y	:	-1.504	-1.027	-0.761
CENTROID X	:	-0.204	-0.240	-0.382
CENTROID Y	:	0.033	0.201	0.329
POA TO CENTROID in.	:	0.207	0.313	0.504
MIN RADIUS	:	0.228	0.110	0.251
MEAN RADIUS	:	0.994	0.908	0.814
MAX RADIUS	:	1.537	1.532	1.502
HORIZONTAL SPREAD	:	2.387	2.387	2.327
VERTICAL SPREAD	:	2.850	2.205	1.811
EXTREME SPREAD	:	2.850	2.500	2.448
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	9		

29 May 1991

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CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 8

HS= 2.778

VS= 2.176

GS= 2.943

CENTROID *

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.227	.816	.639
MINIMUM X	:	-1.551	-1.414	-1.238
MAXIMUM Y	:	.875	.731	.672
MINIMUM Y	:	-1.301	-.725	-.784
CENTROID X	:	-.263	-.400	-.223
CENTROID Y	:	-.064	.080	.139
POA TO CENTROID in.	:	.271	.408	.263
MIN RADIUS	:	.294	.162	.161
MEAN RADIUS	:	.864	.746	.609
MAX RADIUS	:	1.788	1.491	1.247
HORIZONTAL SPREAD	:	2.778	2.230	1.877
VERTICAL SPREAD	:	2.176	1.456	1.456
EXTREME SPREAD	:	2.943	2.264	1.877
NUMBER IN ONE INCH CIRCLE	=	2	7	8
NUMBER IN TWO INCH CIRCLE	=	7	7	8
NUMBER IN THREE INCH CIRCLE	=	8	7	8

