

C6611568

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™ H24	SERIAL NO. C6611568
	ORDER NO. 5716

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

46



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611568

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	2 1 91		RW
600	Proof	2 1 91		RW
607	Check Headspace	2 1 91		RW
610	Dis-assemble Gun	2 1 91		RW
612	Magnaflux Barrel Action	2 1 1 91		Kcd
	Magnaflux Bolt	2 1 1 91		Kcd
615	Rollmark Caliber	2 1 1 91		GS
617	Drill and Tap Sight Holes	2 1 3 91		LB
618	Polish Barrel RHB	2 1 3 91		WB
620	Apply Coatings (Barrel Action)		3/22/91	WB
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		3/25/91	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		3/25/91	WB
	C) Inspect Ejector Hole for Chamfer		3/25/91	WB
	D) Oil Firing Pin Ass'y		3/25/91	WB
	E) Adjust Trigger Pull to Min Setting and Stake		4/4/91	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			4-4-91	DH
	G) Safety Off Force	2	3	2			4-4-91	DH
	H) Trigger Pull Test & Retainability						4/4/91	JH
	I) Firing Pin Indent	.021	.022	.021			4-4-91	DH
	J) Assemble Stock						4/5/91	RW
	K) Assemble Swivel Studs						4-17-91	T
	L) Attach Front and Rear Sight Assemblies						4/5/91	RW
	M) Iron Sight Alignment						4/5/91	RW
	N) Detach Front & Rear Sights & place in numbered container						4/5/91	RW
	O) Attach Scope to Rifle						4/5/91	RW
	P) Detach & Attach Scope 20 Times						4/5/91	RW
640	Gallery Target & Test						4/8/91	KS
	A) Time							KS
	B) Malfunctions							KS
	C) Pierced Primers							KS
	D) Optical Clarity of Scope							KS
645	Inspect for Live Ammo						4/8/91	KS
655	Final Inspection							
	A) Headspace						4-17-91	T
	B) Trigger Pull	2.25	2.19	2.30	2.21	2.32	4/16/91	JH
	C) Function						4-17-91	T
660	Pack						6-19-91	RF

TIME

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6611568DATE 4-4-91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.34	2.31	2.30	2.25	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.24	2.14	2.38	2.19	
PULL #3	2.28	2.31	2.24	2.30	
PULL #4	2.24	2.26	2.30	2.21	
PULL #5	2.22	2.37	2.30	2.32	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.22	3.48		
PULL #2	3.22	3.39		
PULL #3	3.48	3.56		
PULL #4	3.55	3.46		
PULL #5	3.52	3.20		
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	4.38		4.26
PULL #2	4.51	4.23		4.41
PULL #3	4.48	4.29		4.12
PULL #4	4.50	4.27		4.37
PULL #5	4.46	4.50		4.38
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611568
8 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.299313
1 TO	2	.307586
1 TO	3	.316661
1 TO	4	.3628
1 TO	5	.220581

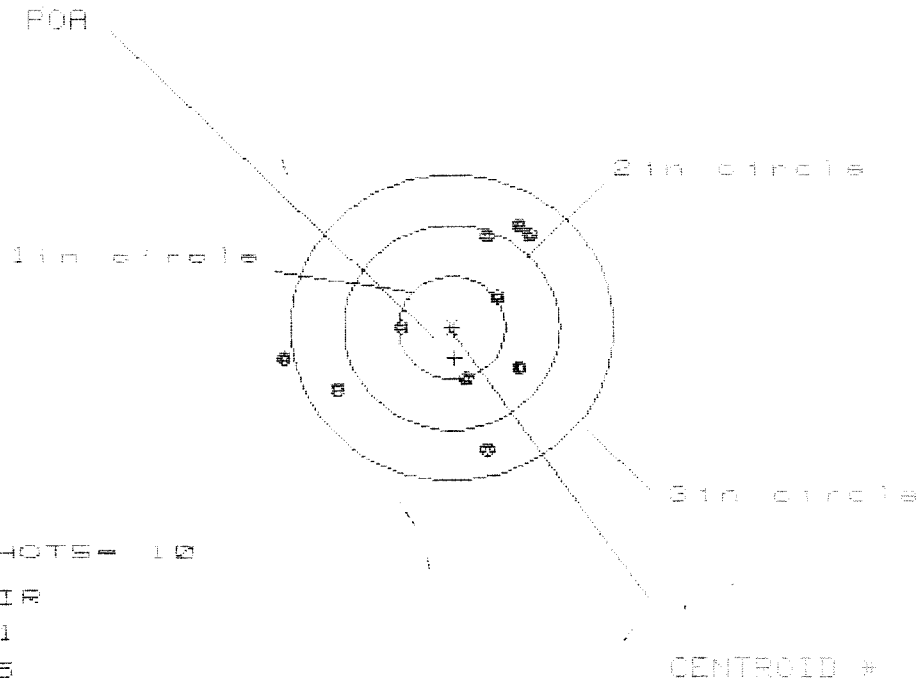
1 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0654
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0852
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .107407
THE AMR FOR THIS RIFLE IS: 1.017

8 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06611568

CENTERFIRE PATTERNS # 1



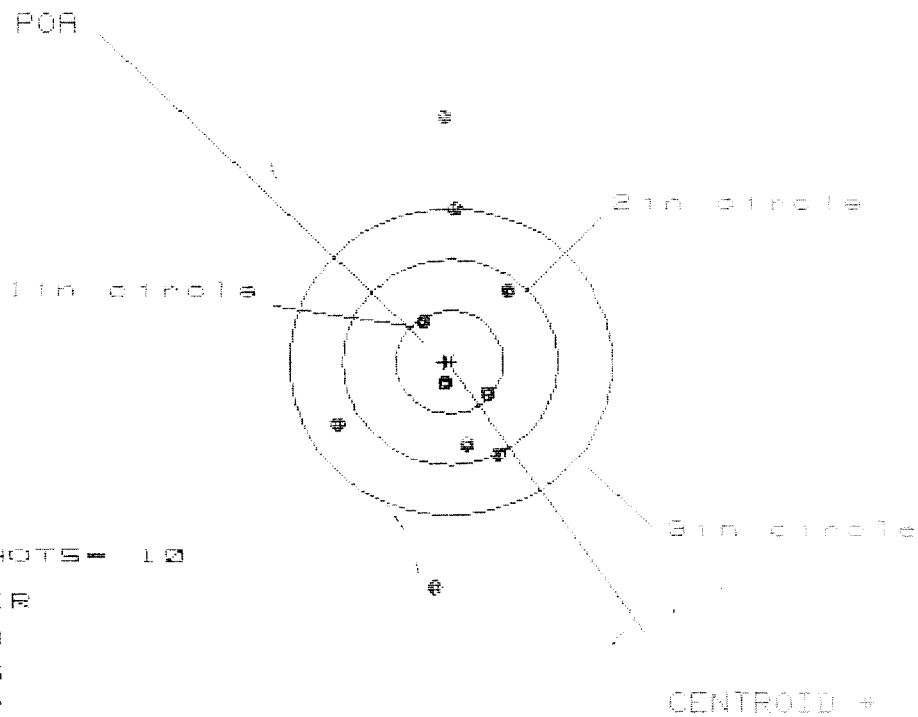
OF SHOTS = 10
 # IN CIR
 1in = 1
 2in = 5
 3in = 9
 HS = 2.378
 VS = 2.178
 GS = 2.695

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.759	.579	.592
MINIMUM X	-1.619	-1.244	-1.232
MAXIMUM Y	.954	.919	.761
MINIMUM Y	-1.224	-1.259	-1.833
CENTROID X	-.028	.152	.189
CENTROID Y	.298	.333	.491
POA TO CENTROID in.	.299	.366	.510
MIN RADIUS	.444	.361	.285
MEAN RADIUS	.972	.872	.808
MAX RADIUS	1.650	1.415	1.487
HORIZONTAL SPREAD	2.378	1.823	1.822
VERTICAL SPREAD	2.178	2.178	1.594
EXTREME SPREAD	2.695	2.418	2.418
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 5

3 in = 7

HS = 1.611

VS = 4.586

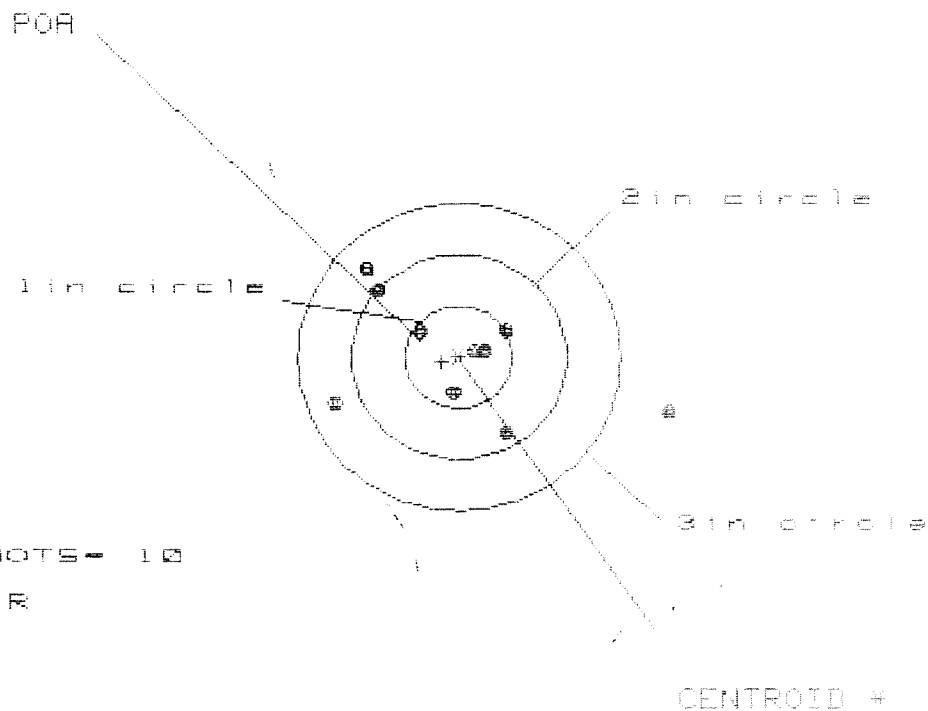
GS = 4.586

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.564	.554	.537
MINIMUM X	:	-1.047	-1.057	-1.074
MAXIMUM Y	:	2.418	1.776	1.539
MINIMUM Y	:	-2.168	-1.900	-1.884
CENTROID X	:	.052	.062	.079
CENTROID Y	:	.001	-.267	-.030
POA TO CENTROID in.	:	.052	.274	.085
MIN RADIUS	:	.200	.068	.176
MEAN RADIUS	:	1.121	.928	.820
MAX RADIUS	:	2.419	1.905	1.540
HORIZONTAL SPREAD	:	1.611	1.611	1.611
VERTICAL SPREAD	:	4.586	3.676	2.423
EXTREME SPREAD	:	4.586	3.683	2.447
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 4

2in = 6

3in = 9

LS = 3.078

VS = 1.593

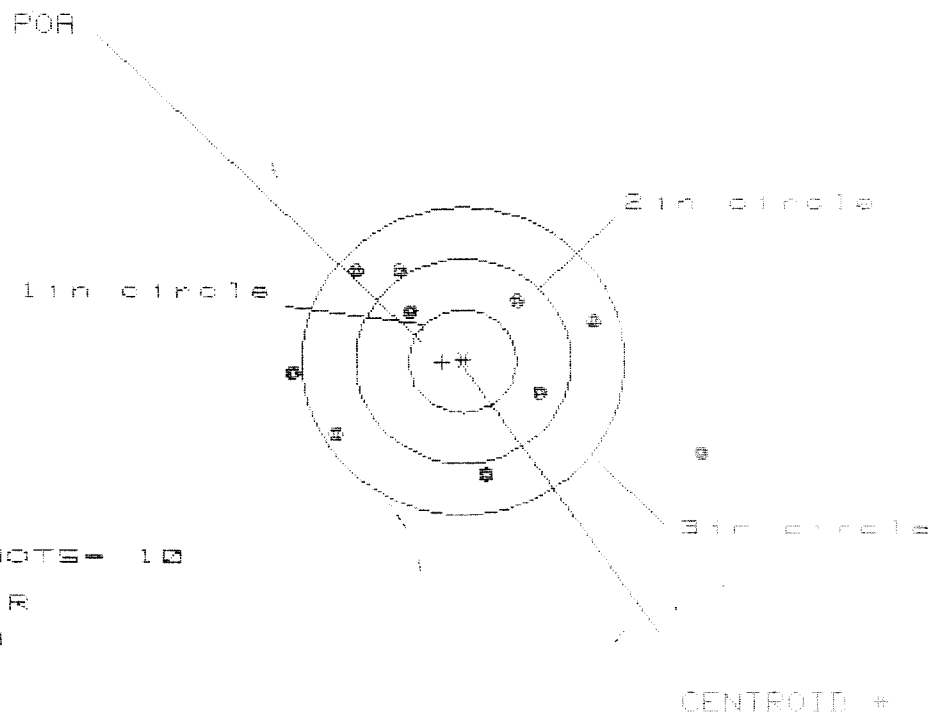
GS = 3.111

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.984	.782	.582
MINIMUM X	-1.173	-.962	-.745
MAXIMUM Y	.887	.822	.754
MINIMUM Y	-.786	-.771	-.839
CENTROID X	.157	-.054	.066
CENTROID Y	.041	.106	.174
POA TO CENTROID in.	.163	.119	.186
MIN RADIUS	.128	.187	.227
MEAN RADIUS	.797	.673	.596
MAX RADIUS	1.992	1.185	1.060
HORIZONTAL SPREAD	3.078	1.664	1.327
VERTICAL SPREAD	1.593	1.593	1.593
EXTREME SPREAD	3.111	2.073	2.073
NUMBER IN ONE INCH CIRCLE	= 4		
NUMBER IN TWO INCH CIRCLE	= 6		
NUMBER IN THREE INCH CIRCLE	= 9		

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 0

3 in = 0

IS = 0.042

VS = 2.046

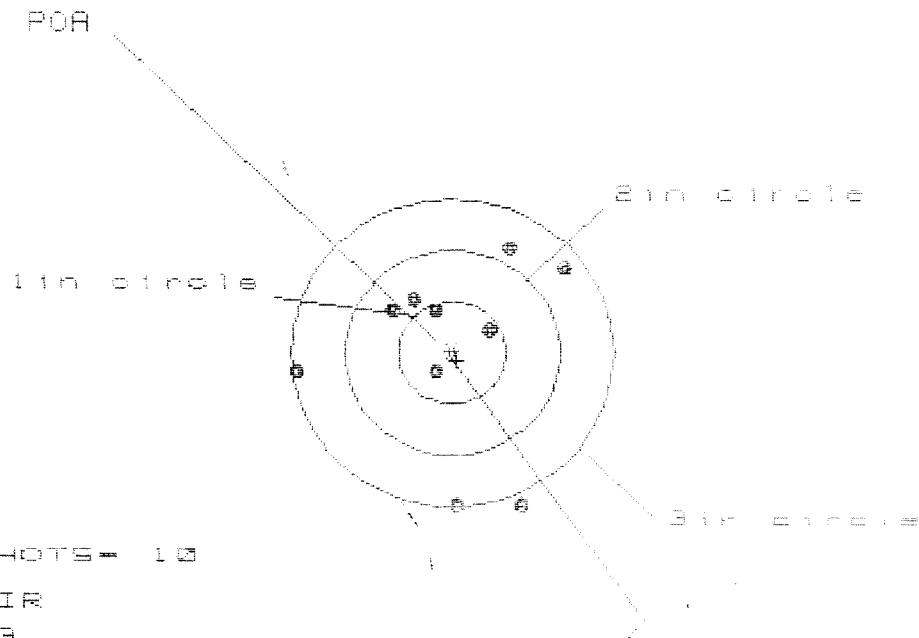
GS = 3.925

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.229	1.466	1.296
MINIMUM X	:	-1.613	-1.366	-1.065
MAXIMUM Y	:	.891	.788	.761
MINIMUM Y	:	-1.155	-1.258	-1.285
CENTROID X	:	.190	-.057	.113
CENTROID Y	:	.008	.111	.138
POA TO CENTROID in.	:	.190	.125	.179
MIN RADIUS	:	.682	.438	.540
MEAN RADIUS	:	1.243	1.078	1.031
MAX RADIUS	:	2.412	1.499	1.348
HORIZONTAL SPREAD	:	3.842	2.832	2.361
VERTICAL SPREAD	:	2.046	2.046	2.046
EXTREME SPREAD	:	3.925	2.882	2.609
NUMBER IN ONE INCH CIRCLE	=	0	0	0
NUMBER IN TWO INCH CIRCLE	=	0	0	0
NUMBER IN THREE INCH CIRCLE	=	0	0	0

8 Apr 1981

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 8

HS= 2.553

VS= 2.551

GS= 2.739

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.087	1.163	1.173
MINIMUM X	-1.466	-1.398	-1.300
MAXIMUM Y	1.044	.879	.670
MINIMUM Y	-1.507	-1.672	-1.580
CENTROID X	-.044	-.120	-.130
CENTROID Y	.078	.243	.452
POA TO CENTROID in.	.090	.271	.471
MIN RADIUS	.256	.241	.056
MEAN RADIUS	.954	.836	.690
MAX RADIUS	1.635	1.674	1.487
HORIZONTAL SPREAD	2.553	2.553	2.553
VERTICAL SPREAD	2.551	2.551	1.250
EXTREME SPREAD	2.739	2.739	2.739
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		8	