

C6522329

MODEL 700™ M24

Model **SMS**™

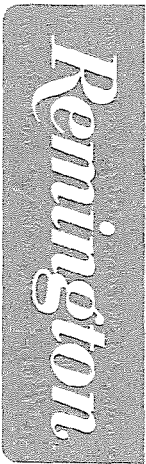
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.





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

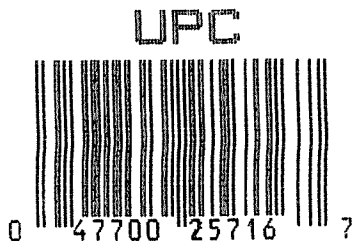
MODEL 700™ H24	SERIAL NO. C6522329
	ORDER NO. 5716

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

01



5716 C6522329



CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522329
7 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.186024
1 TO	2	.324025
1 TO	3	.187545
1 TO	4	.255721
1 TO	5	.252121

 <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0698
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0098
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0704846
THE AMR FOR THIS RIFLE IS: .8552

6 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08522329

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS= 1.722

VS= 2.731

GS= 2.783

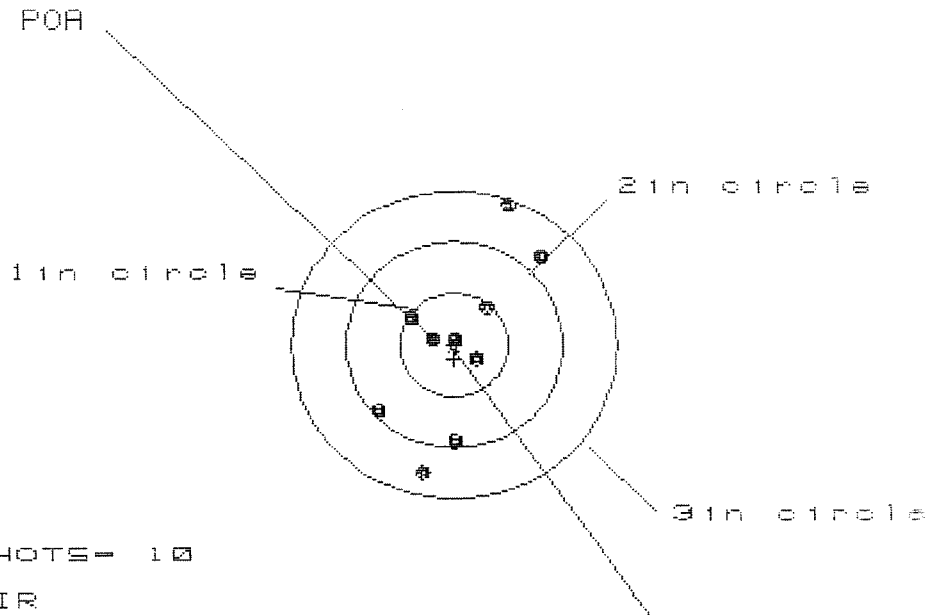
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.766	.789	.758
MINIMUM X	:	-.956	-.933	-.972
MAXIMUM Y	:	1.549	.842	.715
MINIMUM Y	:	-1.182	-1.010	-.899
CENTROID X	:	-.003	-.026	.013
CENTROID Y	:	-.186	-.358	-.231
POA TO CENTROID in.	:	.186	.359	.232
MIN RADIUS	:	.270	.136	.221
MEAN RADIUS	:	.897	.800	.769
MAX RADIUS	:	1.562	1.104	1.170
HORIZONTAL SPREAD	:	1.722	1.722	1.722
VERTICAL SPREAD	:	2.731	1.852	1.614
EXTREME SPREAD	:	2.783	2.099	2.099
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 4

2 in = 7

3 in = 10

HS = 1.454

VS = 2.632

GS = 2.731

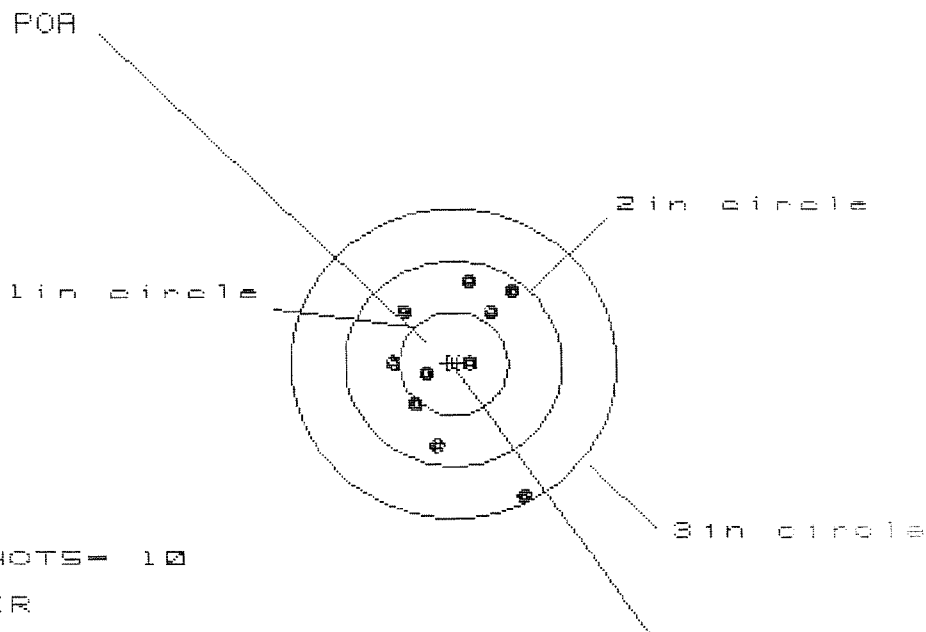
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.750	.802	.775
MINIMUM X	:	-.704	-.652	-.679
MAXIMUM Y	:	1.358	.967	.827
MINIMUM Y	:	-1.274	-1.124	-.892
CENTROID X	:	.001	-.051	-.024
CENTROID Y	:	.138	-.012	.128
POA TO CENTROID in.	:	.138	.052	.130
MIN RADIUS	:	.032	.187	.044
MEAN RADIUS	:	.716	.651	.554
MAX RADIUS	:	1.435	1.257	1.134
HORIZONTAL SPREAD	:	1.454	1.454	1.454
VERTICAL SPREAD	:	2.632	2.091	1.719
EXTREME SPREAD	:	2.731	2.324	2.055
NUMBER IN ONE INCH CIRCLE =			4	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			10	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 9

3 in = 10

HS= 1.222

VS= 2.094

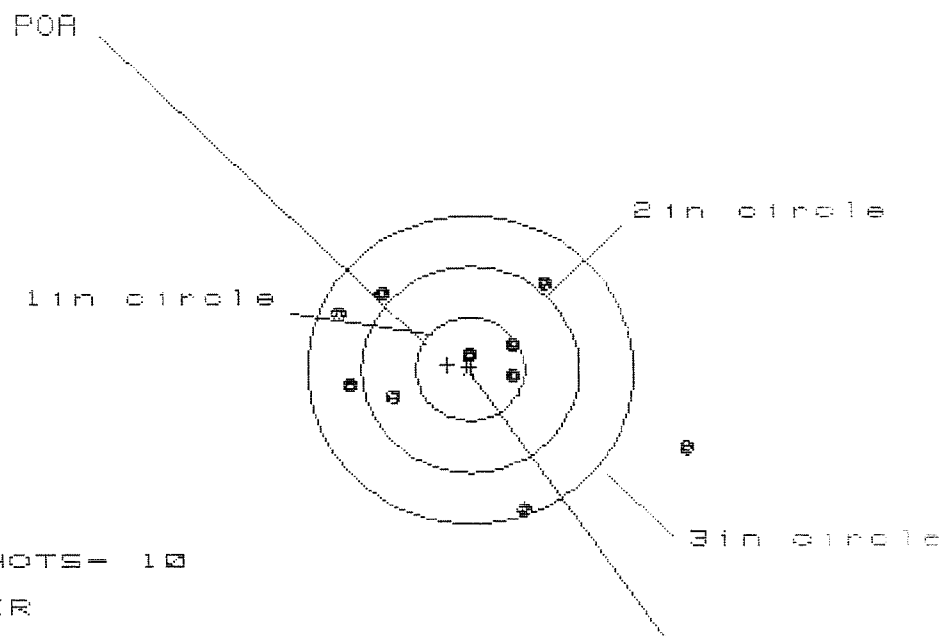
GS= 2.170

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	.673
MINIMUM X	-.549
MAXIMUM Y	.822
MINIMUM Y	-1.272
CENTROID X	.059
CENTROID Y	-.009
POA TO CENTROID in.	.059
MIN RADIUS	.184
MEAN RADIUS	.683
MAX RADIUS	1.439
HORIZONTAL SPREAD	1.222
VERTICAL SPREAD	2.094
EXTREME SPREAD	2.170
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	9
NUMBER IN THREE INCH CIRCLE =	10

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 3

2in = 4

3in = 9

HS= 3.121

VS= 2.123

GS= 3.380

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.957	.874	.960
MINIMUM X	:	-1.164	-.947	-.861
MAXIMUM Y	:	.808	.726	.551
MINIMUM Y	:	-1.315	-1.397	-.477
CENTROID X	:	.209	-.008	-.094
CENTROID Y	:	-.043	.039	.214
POA TO CENTROID in.	:	.213	.040	.234
MIN RADIUS	:	.178	.229	.304
MEAN RADIUS	:	.979	.844	.748
MAX RADIUS	:	2.092	1.556	1.107
HORIZONTAL SPREAD	:	3.121	1.821	1.821
VERTICAL SPREAD	:	2.123	2.123	1.028
EXTREME SPREAD	:	3.380	2.483	2.004
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 8

HS= 3.174

VS= 1.597

GS= 3.192

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.659	1.245	1.879
MINIMUM X	:	-1.515	-1.331	-1.165
MAXIMUM Y	:	.864	.871	.838
MINIMUM Y	:	-.733	-.726	-.759
CENTROID X	:	.083	-.101	.065
CENTROID Y	:	.051	.044	.077
POA TO CENTROID in.	:	.097	.110	.100
MIN RADIUS	:	.118	.302	.134
MEAN RADIUS	:	1.001	.937	.854
MAX RADIUS	:	1.660	1.410	1.325
HORIZONTAL SPREAD	:	3.174	2.576	2.244
VERTICAL SPREAD	:	1.597	1.597	1.597
EXTREME SPREAD	:	3.192	2.606	2.605
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO C65 22329

DATE 9-1-90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.31	2.34	2.30	2.82	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.20	2.24	2.28	2.83	
PULL #3	2.44	2.28	2.30	2.92	
PULL #4	2.33	2.21	2.25	2.92	
PULL #5	2.27	2.21	2.22	2.86	
TOTAL	11.55	11.28	11.35		
AVG.	2.31	2.256	2.27		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.20	3.46		
PULL #2	3.43	3.50		
PULL #3	3.44	3.48		
PULL #4	3.41	3.50		
PULL #5	3.45	3.46		
TOTAL	16.93	17.40		
AVG.	3.386	3.48		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.34	4.25		4.33
PULL #2	4.39	4.42		4.33
PULL #3	4.40	4.46		4.38
PULL #4	4.43	4.37		4.42
PULL #5	4.40	4.39		4.34
TOTAL	21.96	21.89		21.80
AVG.	4.392	4.378		4.36

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6522329

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		7/9/90	KQ
600	Proof		7/9/90	KQ
607	Check Headspace		7/9/90	KQ
610	Dis-assemble Gun		7/9/90	KQ
612	Magnaflux Barrel Action		7/17/90	KR
	Magnaflux Bolt		7/17/90	KR
615	Rollmark Caliber		7/17/90	LD
617	Drill and Tap Sight Holes		7/23/90	EB
618	Polish Barrel <i>LB</i>		7/24/90	WB
620	Apply Coatings (Barrel Action)		7/26/90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/22/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/22/90	KS
	C) Inspect Ejector Hole for Chamfer		8/22/90	KS
	D) Oil Firing Pin Ass'y		8/22/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		9-1-90	SL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			9/4/90	WB
	G) Safety Off Force	3	3	3			9/4/90	WB
	H) Trigger Pull Test & Retainability						9/1/90	YM
	I) Firing Pin Indent	.0275	.0275	.0275			9/4/90	WB
	J) Assemble Stock						9/4/90	KS
	K) Assemble Swivel Studs						9/8/90	JS
	L) Attach Front and Rear Sight Assemblies						9/4/90	KS
	M) Iron Sight Alignment						9/4/90	KS
	N) Detach Front & Rear Sights & place in numbered container						9/4/90	KS
	O) Attach Scope to Rifle						9/4/90	KS
	P) Detach & Attach Scope 20 Times						9/4/90	KS
640	Gallery Target & Test						9-6-90	DH
	A) Time						9-6-90	DH
	B) Malfunctions						9-6-90	DH
	C) Pierced Primers						9-6-90	DH
	D) Optical Clarity of Scope						9-6-90	DH
643	Inspect for Live Ammo						9-6-90	DH
655	Final Inspection							
	A) Headspace						9/8/90	JS
	B) Trigger Pull	282	283	282	292	286	9/8/90	JS
	C) Function						9/8/90	JS
660	Pack						9-19-90	DH