

C6498859

MODEL 700™ M24

Model SMS™

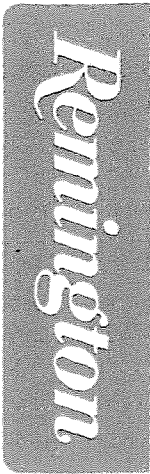
Action

Barrel Length

Capacity

Order No. 5715

*Includes 1 in chamber.



06498859

TM

	
RECORDS CONTROL SCHEDULE	
RECORDS CATEGORY OR TITLE: [REDACTED]	
[REDACTED]	
COPY "O" (OFFICIAL) ☐ "X" (EXTRA) ☒	
TOTAL RETENTION: [REDACTED]	
[REDACTED]	
GS-11050 Rev. 8/78	

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



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

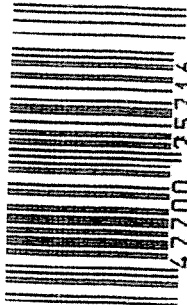
MODEL 700TM M24

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

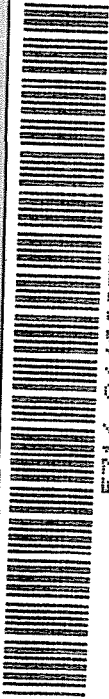
SERIAL NO.
C6498859

ORDER NO.
5716

UPC



0 47700 25716 7



5716 C6498859

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6498859

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	5 2	90	RW
600	Proof	5 2	90	RW
607	Check Headspace	5 2	90	RW
610	Dis-assemble Gun	5 2	90	RW
612	Magnaflux Barrel Action	5-8-90		KCR
	Magnaflux Bolt	5-8-90		KCR
615	Rollmark Caliber		5/8/90	GB
617	Drill and Tap Sight Holes		5/9/90	HB
618	Polish Barrel HB		5/10/90	WB
620	Apply Coatings (Barrel Action)		5/16/90	TJA
	Apply Coating (Bolt)		5/16/90	
625	Final Assembly A) Clean inside of Bolt Assembly		5/18/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/18/90	RW
	C) Inspect Ejector Hole for Chamfer		5/18/90	RW
	D) Oil Firing Pin Ass'y		5/18/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/23/90	HL

BARBER - M24 0009045

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/4	4 1/4			5/23/90	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			5/23/90	WB
	H) Trigger Pull Test & Retainability						5/23/90	RM
	I) Firing Pin Indent	.023	.022	.0225			5/23/90	WB
	J) Assemble Stock						5/23/90	RW
	K) Assemble Swivel Studs						6/13/90	RM
	L) Attach Front and Rear Sight Assemblies						5/23/90	RW
	M) Iron Sight Alignment						5/23/90	RW
	N) Detach Front & Rear Sights & place in numbered container						5/23/90	RW
	O) Attach Scope to Rifle						5/23/90	WB
	P) Detach & Attach Scope 20 Times						5/23/90	WB
640	Gallery Target & Test						5-24-90	RM
	A) Time						"	RM
	B) Malfunctions						"	RM
	C) Pierced Primers						"	RM
	D) Optical Clarity of Scope						"	RM
645	Inspect for Live Ammo						5-24-90	RM
655	Final Inspection							
	A) Headspace						6/13/90	RM
	B) Trigger Pull	2.90	2.91	2.89	2.72	2.85	6/13/90	GS
	C) Function						6/13/90	RM
660	Pack						6-9-90	DM

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6498859DATE 5/23/90TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.42	2.50	2.90	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.32	2.41	2.49	2.91	
PULL #3	2.37	2.43	2.53	2.89	
PULL #4	2.27	2.43	2.51	2.72	
PULL #5	2.49	2.44	2.28	2.85	
TOTAL	11.85	12.13	12.31		
AVG.	2.37	2.426	2.462		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.29	3.35		
PULL #2	3.25	3.31		
PULL #3	3.29	3.30		
PULL #4	3.35	3.32		
PULL #5	3.28	3.33		
TOTAL	16.46	16.61		
AVG.	3.292	3.322		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.15	4.14		4.31
PULL #2	4.19	4.06		4.37
PULL #3	4.36	4.08		4.37
PULL #4	4.36	4.18		4.35
PULL #5	4.25	4.28		4.26
TOTAL	21.31	20.74		21.66
AVG.	4.262	4.148		4.332

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6498859
25 May 1990

CENTROIDAL DISTANCES

0 TO 1	.247952
1 TO 2	.338163
1 TO 3	.43256
1 TO 4	.199612
1 TO 5	.283214

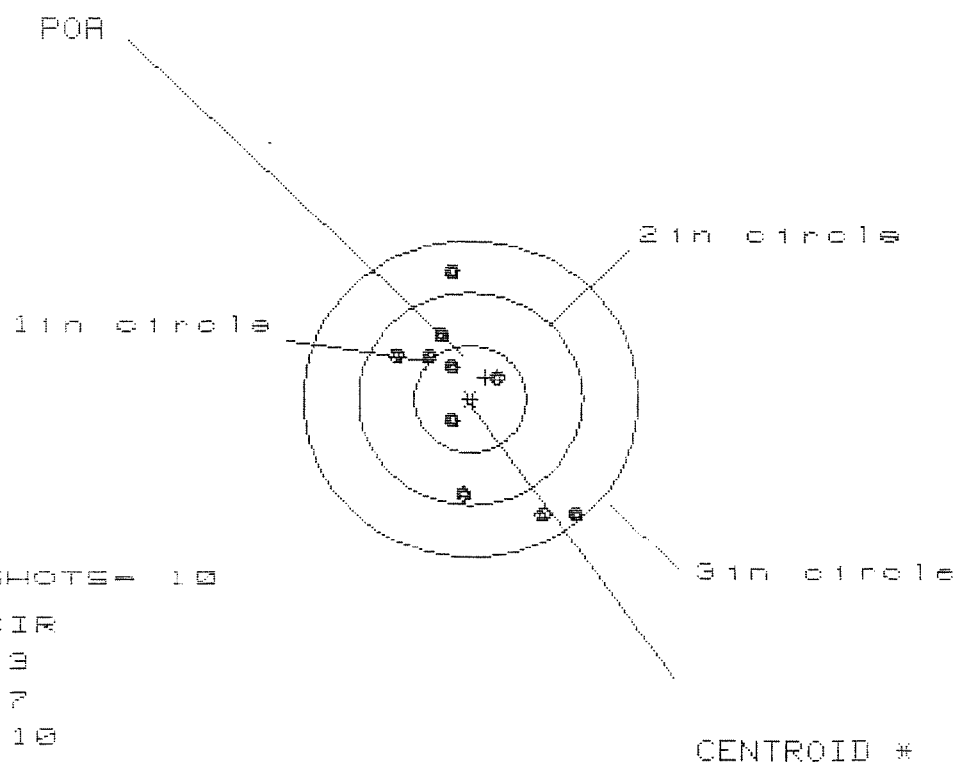
492 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.011
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0428
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0441909
THE ADR FOR THIS RIFLE IS: .7642

24 May 1998

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CENTERFIRE PATTERNS # 1

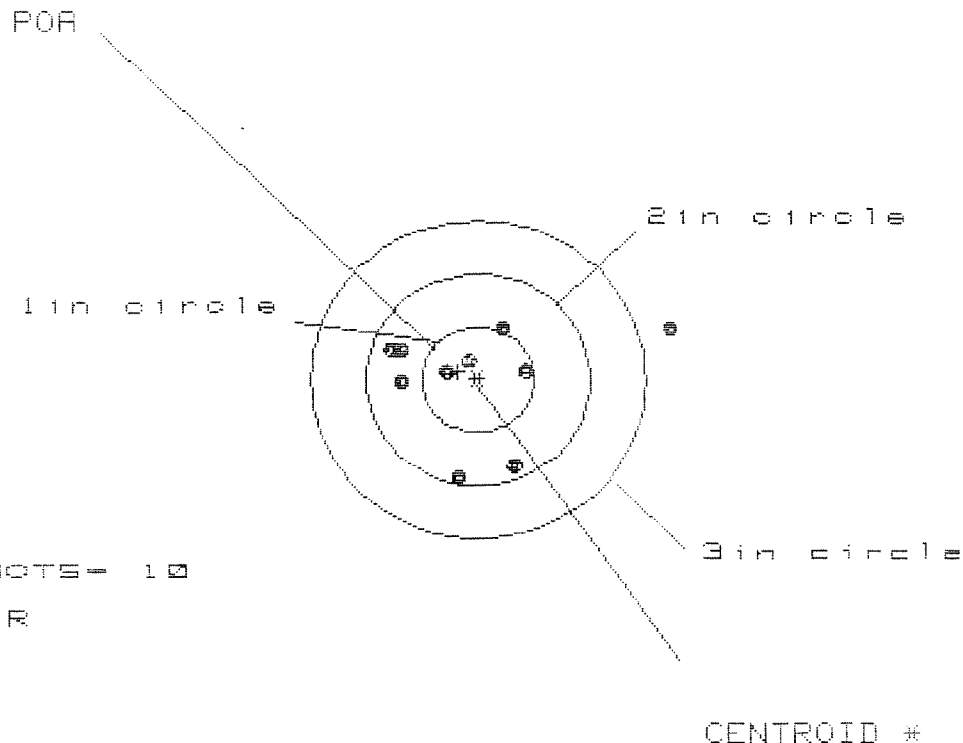


PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.987	.776	.437
MINIMUM X	:	-.682	-.573	-.476
MAXIMUM Y	:	1.225	1.105	.956
MINIMUM Y	:	-1.085	-1.186	-1.144
CENTROID X	:	-.138	-.248	-.345
CENTROID Y	:	-.206	-.086	.063
POR TO CENTROID in.	:	.248	.263	.351
MIN RADIUS	:	.251	.212	.051
MEAN RADIUS	:	.777	.657	.509
MAX RADIUS	:	1.467	1.418	1.151
HORIZONTAL SPREAD	:	1.670	1.349	.913
VERTICAL SPREAD	:	2.310	2.291	2.100
EXTREME SPREAD	:	2.597	2.449	2.104
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 2

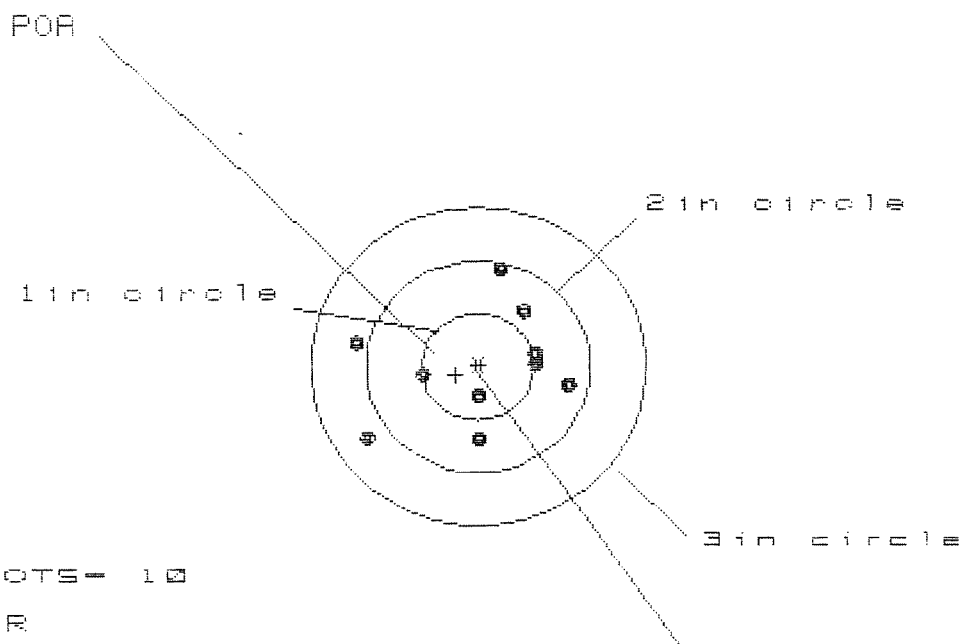


PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.710	.629	.631
MINIMUM X	:	-.754	-.564	-.562
MAXIMUM Y	:	.513	.516	.403
MINIMUM Y	:	-.960	-.903	-.903
CENTROID X	:	.177	-.013	-.015
CENTROID Y	:	-.083	-.140	-.027
POA TO CENTROID in.	:	.196	.141	.031
MIN RADIUS	:	.203	.211	.139
ACOM RADIUS	:	.739	.595	.523
MAX RADIUS	:	1.785	.967	1.062
HORIZONTAL SPREAD	:	2.464	1.193	1.193
VERTICAL SPREAD	:	1.473	1.419	1.306
EXTREME SPREAD	:	2.494	1.559	1.559
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.871

VS= 1.627

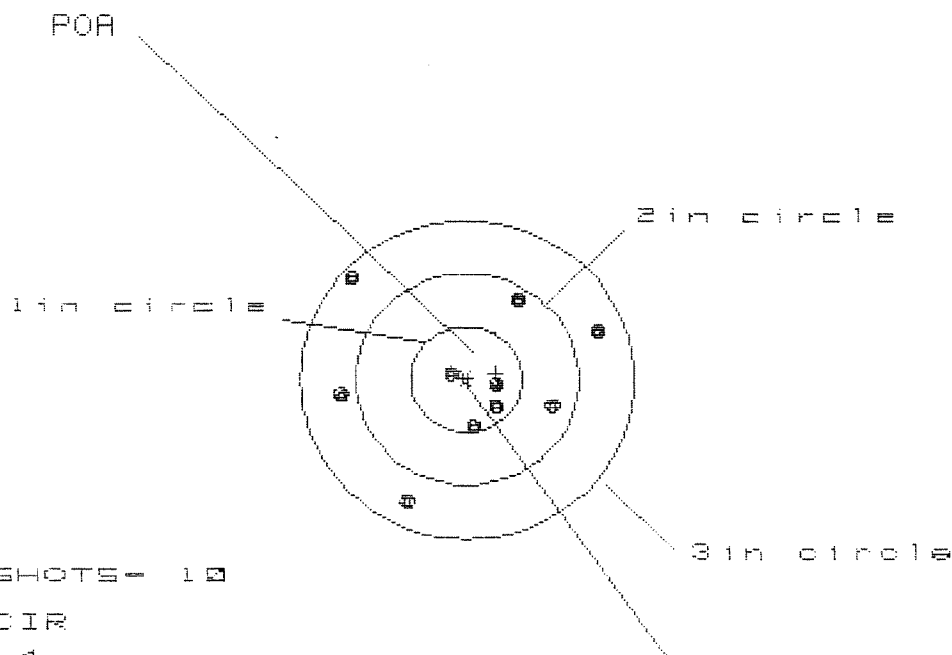
GS= 2.034

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.801	.692	.545
MINIMUM X	:	-1.070	-1.179	-.742
MAXIMUM Y	:	.911	.831	.852
MINIMUM Y	:	-.716	-.731	-.710
CENTROID X	:	.190	.299	.446
CENTROID Y	:	.076	.156	.135
POA TO CENTROID in.	:	.205	.337	.466
MIN RADIUS	:	.274	.361	.236
MEAN RADIUS	:	.719	.647	.543
MAX RADIUS	:	1.211	1.191	.852
HORIZONTAL SPREAD	:	1.871	1.871	1.287
VERTICAL SPREAD	:	1.627	1.562	1.562
EXTREME SPREAD	:	2.034	1.914	1.575
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 6

3 in = 10

HS= 2.271

VS= 2.127

GS= 2.346

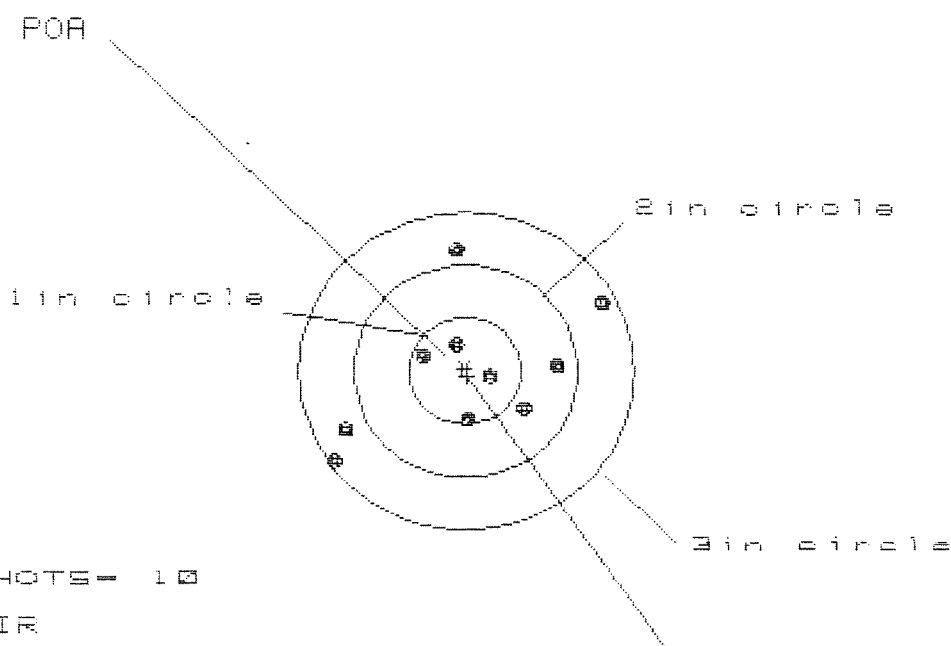
CENTROID #

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.140	1.030	.945
MINIMUM X	:	-1.131	-1.241	-1.327
MAXIMUM Y	:	.976	.830	.700
MINIMUM Y	:	-1.151	-1.042	-.448
CENTROID X	:	-.265	-.155	-.069
CENTROID Y	:	-.052	-.161	-.031
POA TO CENTROID in.	:	.270	.223	.076
MIN RADIUS	:	.203	.168	.090
MEAN RADIUS	:	.792	.694	.619
MAX RADIUS	:	1.391	1.245	1.336
HORIZONTAL SPREAD	:	2.271	2.271	2.271
VERTICAL SPREAD	:	2.127	1.872	1.148
EXTREME SPREAD	:	2.346	2.346	2.346
NUMBER IN ONE INCH CIRCLE	=	4		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	10		

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 4

2in = 6

3in = 10

HS= 2.355

VS= 2.067

GS= 2.784

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.197	1.068	.859
MINIMUM X	:	-1.158	-1.195	-1.061
MAXIMUM Y	:	1.187	1.090	1.153
MINIMUM Y	:	-.880	-.610	-.547
CENTROID X	:	-.019	.110	-.024
CENTROID Y	:	.051	.148	.085
POA TO CENTROID in.	:	.054	.184	.088
MIN RADIUS	:	.183	.143	.197
MEAN RADIUS	:	.794	.716	.644
MAX RADIUS	:	1.454	1.342	1.194
HORIZONTAL SPREAD	:	2.355	2.263	1.920
VERTICAL SPREAD	:	2.067	1.700	1.700
EXTREME SPREAD	:	2.784	2.524	2.015
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	