

C6587519

MODEL 700TM M24

Model **SMS**TM

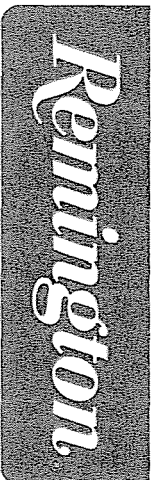
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.






MODEL 700™ M24

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

01

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

SERIAL NO.
C6587519

ORDER NO.
5716



5716 C6587519

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6587519

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/22/90	KQ
600	Proof		10/22/90	KQ
607	Check Headspace		10/22/90	KQ
610	Dis-assemble Gun		10/22/90	KQ
612	Magnaflux Barrel Action		10/24/90	KR
	Magnaflux Bolt		10/24/90	KR
615	Rollmark Caliber		10/24/90	JS
617	Drill and Tap Sight Holes		10/25/90	FV
618	Polish Barrel <i>RB</i>		10/26/90	W
620	Apply Coatings (Barrel Action)		11-90	TH
	Apply Coating (Bolt)			TH
625	Final Assembly A) Clean inside of Bolt Assembly		11/4/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/8/90	KS
	C) Inspect Ejector Hole for Chamfer		11/8/90	KS
	D) Oil Firing Pin Ass'y		11/8/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		11.12.90	TH

Op. #	Op. NAME	READINGS					DATE	INIT.
625 cont.	F) Safety On Force	5	5	5			11/12/90	W
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			11/12/90	W
	H) Trigger Pull Test & Retainability						11/12/90	JH
	I) Firing Pin Indent	.022	.022	.022			11/12/90	W
	J) Assemble Stock						11/15/90	KS
	K) Assemble Swivel Studs						11-20-90	DH
	L) Attach Front and Rear Sight Assemblies						11/15/90	KS
	M) Iron Sight Alignment						11/15/90	KS
	N) Detach Front & Rear Sights & place in numbered container						11/15/90	KS
	O) Attach Scope to Rifle						11/15/90	KS
	P) Detach & Attach Scope 20 Times						11/15/90	KS
640	Gallery Target & Test						11-17-90	DH
	A) Time						11-17-90	DH
	B) Malfunctions						11-17-90	DH
	C) Pierced Primers						11-17-90	DH
	D) Optical Clarity of Scope						11-17-90	DH
645	Inspect for Live Ammo						11-17-90	DH
655	Final Inspection							
	A) Headspace						11-20-90	DH
	B) Trigger Pull	2.65	2.70	2.38	2.69	2.61	11-20-90	DH
	C) Function						11-20-90	DH
660	Pack						12-19-90	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 06587519

DATE 11-12-90

TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.26	2.42	2.44	265	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.32	2.43	2.43	270	
PULL #3	2.26	2.35	2.30	238	
PULL #4	2.29	2.40	2.31	269	
PULL #5	2.27	2.41	2.42	261	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.35	3.21		
PULL #2	3.44	3.42		
PULL #3	3.34	3.48		
PULL #4	3.45	3.30		
PULL #5	3.34	3.40		
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	4.21		4.27
PULL #2	4.46	4.28		4.26
PULL #3	4.31	4.33		4.30
PULL #4	4.27	4.21		4.26
PULL #5	4.25	4.34		4.36
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587519
17 Nov 1990

CENTROIDAL DISTANCES

0 TO	1	.305895
1 TO	2	.361001
1 TO	3	.288903
1 TO	4	.310266
1 TO	5	.692615

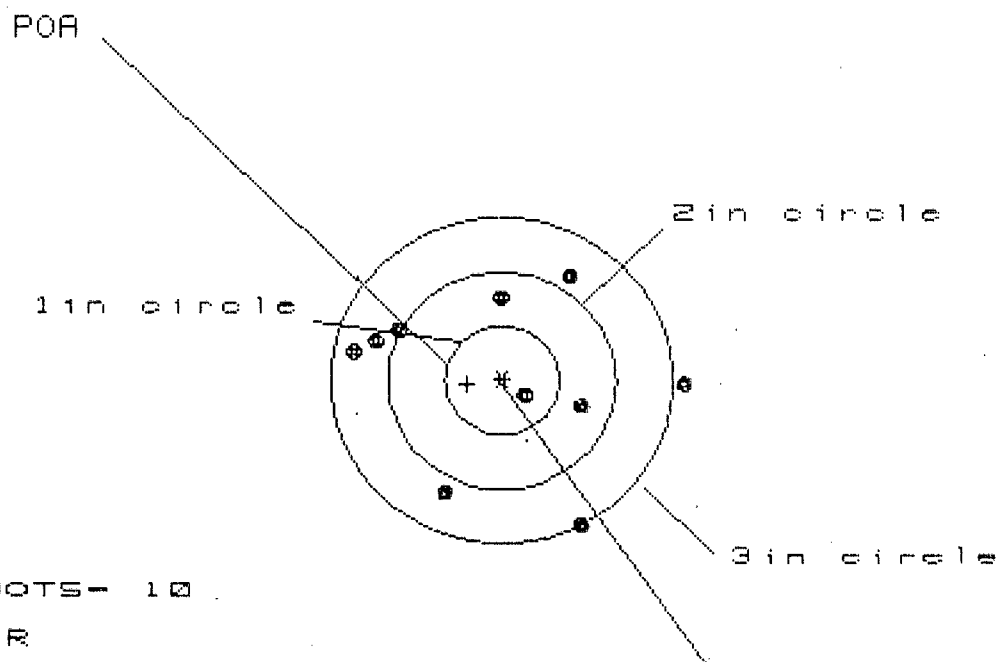
$\frac{2}{7}$ <----POI
5

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .14
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0708
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .156884
THE AMR FOR THIS RIFLE IS: .9312

17 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587519

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 8

HS= 2.899

VS= 2.261

GS= 2.919

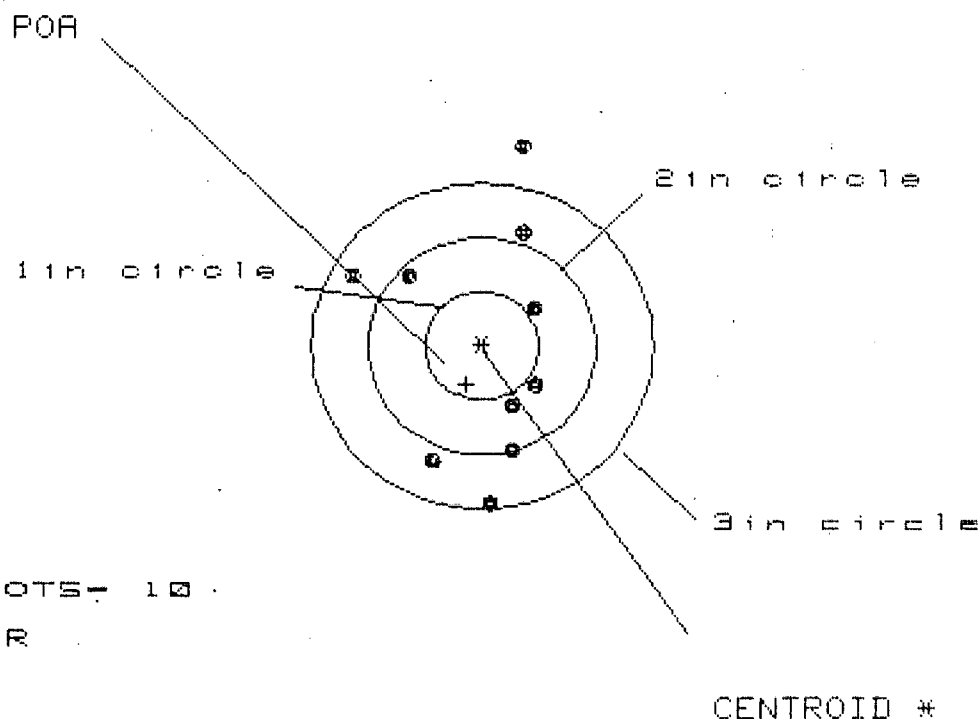
CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.557	.886	.987
MINIMUM X	:	-1.342	-1.169	-1.058
MAXIMUM Y	:	.920	.914	.746
MINIMUM Y	:	-1.341	-1.347	-1.253
CENTROID X	:	.304	.131	.020
CENTROID Y	:	.034	.040	.208
POA TO CENTROID in.	:	.306	.137	.209
MIN RADIUS	:	.211	.373	.544
MEAN RADIUS	:	1.059	1.004	.908
MAX RADIUS	:	1.558	1.612	1.265
HORIZONTAL SPREAD	:	2.899	2.055	2.045
VERTICAL SPREAD	:	2.261	2.261	1.999
EXTREME SPREAD	:	2.919	2.622	2.259
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	3		
NUMBER IN THREE INCH CIRCLE	=	8		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 4

3 in = 9

HS= 1.574

VS= 3.305

GS= 3.313

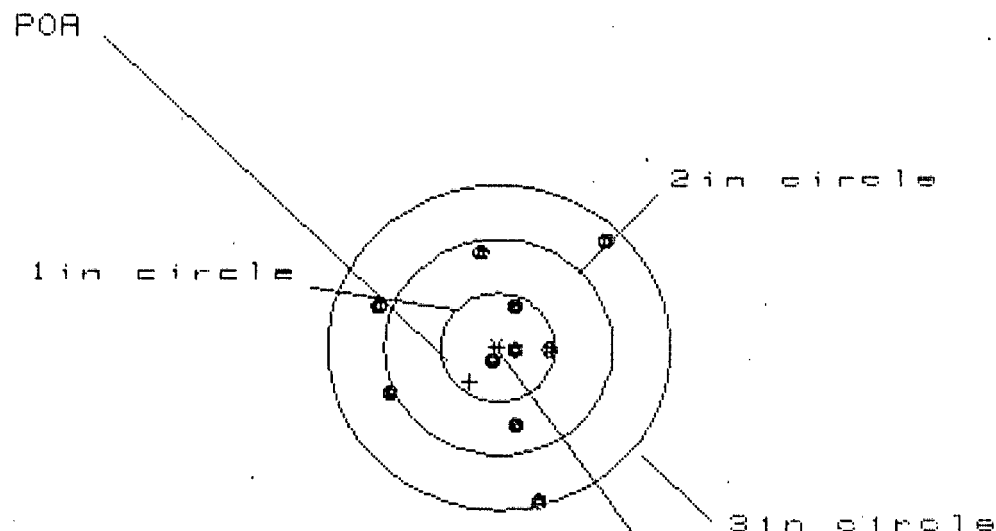
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.467	.504	.519
MINIMUM X	:	-1.107	-1.070	-1.054
MAXIMUM Y	:	1.810	1.241	1.080
MINIMUM Y	:	-1.495	-1.294	-1.024
CENTROID X	:	.135	.098	.082
CENTROID Y	:	.353	.152	.313
POA TO CENTROID in.	:	.377	.181	.324
MIN RADIUS	:	.560	.455	.597
MEAN RADIUS	:	1.060	.949	.910
MAX RADIUS	:	1.839	1.360	1.253
HORIZONTAL SPREAD	:	1.574	1.574	1.574
VERTICAL SPREAD	:	3.305	2.535	2.104
EXTREME SPREAD	:	3.313	2.552	2.260
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 6

3 in = 10

HS= 1.996

VS= 2.311

GS= 2.397

CENTROID *

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.955	.990	.604
MINIMUM X	:	-1.041	-1.006	-.882
MAXIMUM Y	:	.938	.785	.803
MINIMUM Y	:	-1.373	-.872	-.773
CENTROID X	:	.251	.216	.092
CENTROID Y	:	.318	.471	.372
POA TO CENTROID in.	:	.405	.518	.384
MIN RADIUS	:	.085	.236	.198
MEAN RADIUS	:	.763	.699	.638
MAX RADIUS	:	1.409	1.264	.954
HORIZONTAL SPREAD	:	1.996	1.996	1.486
VERTICAL SPREAD	:	2.311	1.657	1.576
EXTREME SPREAD	:	2.397	2.339	1.631
NUMBER IN ONE INCH CIRCLE	=	4		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	10		

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CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 1.893

VS= 1.936

GS= 2.461

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.071	1.021	1.048
MINIMUM X	:	-.822	-.872	-.745
MAXIMUM Y	:	.760	.629	.695
MINIMUM Y	:	-1.176	-1.043	-.977
CENTROID X	:	.052	.102	-.025
CENTROID Y	:	.215	.346	.280
POA TO CENTROID in.	:	.221	.361	.281
MIN RADIUS	:	.216	.082	.188
MEAN RADIUS	:	.912	.848	.817
MAX RADIUS	:	1.260	1.360	1.228
HORIZONTAL SPREAD	:	1.893	1.893	1.793
VERTICAL SPREAD	:	1.936	1.672	1.672
EXTREME SPREAD	:	2.461	2.461	2.144
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS

5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 4

2 in = 5

3 in = 9

HS= 2.694

VS= 2.342

GS= 2.785

CENTROID #

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.783	.767	.743
MINIMUM X	-.911	-.713	-.737
MAXIMUM Y	1.242	1.195	.737
MINIMUM Y	-1.100	-1.147	-.998
CENTROID X	-.042	-.240	-.216
CENTROID Y	-.566	-.519	-.668
POA TO CENTROID in.	.567	.572	.702
MIN RADIUS	.144	.147	.058
MEAN RADIUS	.862	.722	.660
MAX RADIUS	1.832	1.380	1.244
HORIZONTAL SPREAD	2.694	1.480	1.480
VERTICAL SPREAD	2.342	2.342	1.735
EXTREME SPREAD	2.785	2.532	2.206
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	