

C6523415

MODEL 700™ M24

Model SMS™

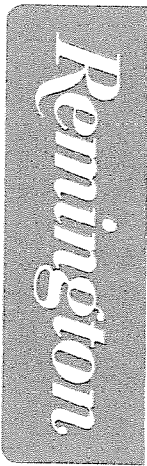
Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.





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

MODEL 700TM H24

01

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

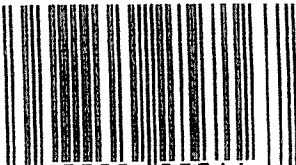


5716 C6523415

SERIAL NO.
C6523415

ORDER NO.
5716

UPC



0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6523415

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10 9	90	RW
600	Proof	10 9	90	RW
607	Check Headspace	10 9	90	RW
610	Dis-assemble Gun	10 9	90	RW
612	Magnaflux Barrel Action		10/17/90	KR
	Magnaflux Bolt		10/17/90	KR
615	Rollmark Caliber		10/17/90	GL
617	Drill and Tap Sight Holes		10/18/90	FB
618	Polish Barrel RB		10/19/90	RB
620	Apply Coatings (Barrel Action)		11-5-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/7/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/7/90	RW
	C) Inspect Ejector Hole for Chamfer		11/7/90	RW
	D) Oil Firing Pin Ass'y		11/7/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11-13-90	RU

op. #	OP. NAME	READINGS			DATE	INIT		
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2	11/15/90	WB		
	G) Safety Off Force	2 1/2	2 1/2	2 1/2	11/15/90	WB		
	H) Trigger Pull Test & Retainability				11/13/90	JH		
	I) Firing Pin Indent	.020	.020	.0205	11/15/90	WB		
	J) Assemble Stock				11/15/90	RW		
	K) Assemble Swivel Studs				11-26-90	928		
	L) Attach Front and Rear Sight Assemblies				11/15/90	RW		
	M) Iron Sight Alignment				11/15/90	RW		
	N) Detach Front & Rear Sights & place in numbered container				11/15/90	RW		
	O) Attach Scope to Rifle				11/15/90	RW		
	P) Detach & Attach Scope 20 Times				11/15/90	RW		
640	Gallery Target & Test				11-21-90	DH		
	A) Time				11-21-90	DH		
	B) Malfunctions				11-21-90	DH		
	C) Pierced Primers				11-21-90	DH		
	D) Optical Clarity of Scope				11-21-90	DH		
645	Inspect for Live Ammo				11-21-90	DH		
655	Final Inspection							
	A) Headspace				11-26-90	928		
	B) Trigger Pull	261	231	217	216	215	11-26-90	928
	C) Function						11-26-90	928
660	Pack						12/14/90	NF

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

SERIAL NO. 06523415DATE 11-13-90TESTER Jell.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.32	2.33	2.45	2.61	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.25	2.38	2.47	2.31	
PULL #3	2.37	2.27	2.19	2.17	
PULL #4	2.34	2.39	2.18	2.10	
PULL #5	2.36	2.43	2.37	2.15	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.35	3.42		
PULL #2	3.31	3.41		
PULL #3	3.19	3.48		
PULL #4	3.34	3.46		
PULL #5	3.46	3.30		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.28	4.38		4.41
PULL #2	4.43	4.49		4.42
PULL #3	4.31	4.47		4.44
PULL #4	4.37	4.40		4.43
PULL #5	4.51	4.20		4.49
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523415
26 Nov 1990

CENTROIDAL DISTANCES

0 TO	1	.162197
1 TO	2	.22064
1 TO	3	.278604
1 TO	4	.118089
1 TO	5	.0563649

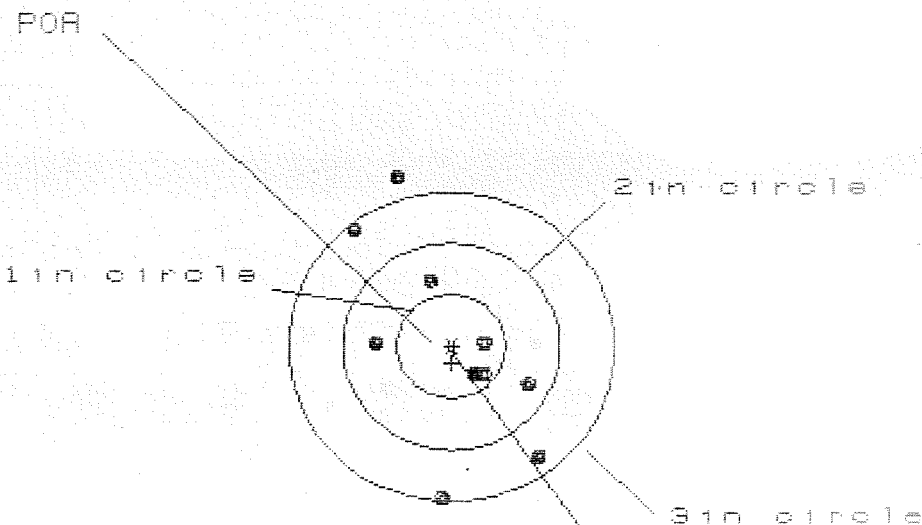
4 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .019
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0494
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0529279
THE AMR FOR THIS RIFLE IS: .9438

26 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8523415

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS= 1.694

VS= 3.062

GS= 3.085

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.803	.751	.734
MINIMUM X	-.891	-.943	-.960
MAXIMUM Y	1.614	1.313	1.154
MINIMUM Y	-1.448	-1.269	-1.028
CENTROID X	-.008	.044	.061
CENTROID Y	.162	-.017	.142
POA TO CENTROID in.	.162	.047	.154
MIN RADIUS	.319	.162	.260
MEAN RADIUS	.903	.781	.721
MAX RADIUS	1.679	1.616	1.501
HORIZONTAL SPREAD	1.694	1.694	1.694
VERTICAL SPREAD	3.062	2.582	2.182
EXTREME SPREAD	3.085	2.762	2.762
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

26 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06523415

CENTERFIRE PATTERNS # 2

POR

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 2.965

VS= 1.861

GS= 2.965

CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.594	.861	.712
MINIMUM X	:	-1.371	-1.194	-1.150
MAXIMUM Y	:	.878	.913	.963
MINIMUM Y	:	-.983	-.948	-.898
CENTROID X	:	.121	-.056	.093
CENTROID Y	:	-.017	-.052	-.102
POR TO CENTROID in.	:	.122	.077	.138
MIN RADIUS	:	.371	.551	.414
MEAN RADIUS	:	.972	.903	.838
MAX RADIUS	:	1.624	1.258	1.185
HORIZONTAL SPREAD	:	2.965	2.055	1.862
VERTICAL SPREAD	:	1.861	1.861	1.861
EXTREME SPREAD	:	2.965	2.339	1.971
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

26 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/05523415

CENTERFIRE PATTERNS

3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS = 2.529

VS = 2.468

GS = 3.234

CENTROID #

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.391
MINIMUM X	-1.138
MAXIMUM Y	1.109
MINIMUM Y	-1.359
CENTROID X	.030
CENTROID Y	-.114
POA TO CENTROID in.	.118
MIN RADIUS	.379
MEAN RADIUS	1.013
MAX RADIUS	1.773
HORIZONTAL SPREAD	2.529
VERTICAL SPREAD	2.468
EXTREME SPREAD	3.234
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	8

26 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8523415

CENTERFIRE PATTERNS

4

POR

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 2

2in = 6

3in = 9

HS = 2.719

VS = 1.932

GS = 3.141

CENTROID *

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.565	.740	.618
MINIMUM X	-1.154	-.980	-.992
MAXIMUM Y	1.039	1.138	1.065
MINIMUM Y	-.893	-.794	-.867
CENTROID X	-.091	-.265	-.143
CENTROID Y	.078	-.021	.052
POR TO CENTROID in.	.120	.266	.152
MIN RADIUS	.406	.335	.374
MEAN RADIUS	.903	.789	.735
MAX RADIUS	1.800	1.173	1.077
HORIZONTAL SPREAD	2.719	1.720	1.610
VERTICAL SPREAD	1.932	1.932	1.932
EXTREME SPREAD	3.141	2.139	1.948
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

26 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06523415

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 0

2in = 5

3in = 10

HS = 2.210

VS = 2.483

GS = 2.585

CENTROID #

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.831	.678	.628
MINIMUM X	-1.379	-.508	-.558
MAXIMUM Y	1.161	1.215	1.056
MINIMUM Y	-1.322	-1.268	-1.069
CENTROID X	.043	.196	.246
CENTROID Y	.138	.084	.243
POA TO CENTROID in.	.145	.214	.345
MIN RADIUS	.528	.411	.386
MEAN RADIUS	.928	.857	.761
MAX RADIUS	1.463	1.328	1.149
HORIZONTAL SPREAD	2.210	1.186	1.186
VERTICAL SPREAD	2.483	2.483	2.125

EXTREME	SPREAD :	2.585	2.533	2.179
NUMBER IN ONE	INCH CIRCLE	=	0	
NUMBER IN TWO	INCH CIRCLE	=	6	
NUMBER IN THREE	INCH CIRCLE	=	10	