

C6636211

MODEL 700TM M24

Model **SMS**TM

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 MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.	SERIAL NO. C6636211
	ORDER NO. 5716



5716 C6636211

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636211

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 30	91	RW
600	Proof	4 30	91	RW
607	Check Headspace	4 30	91	RW
610	Dis-assemble Gun	4 30	91	RW
612	Magnaflux Barrel Action	5 6	91	KCR
	Magnaflux Bolt	5 6	91	KCR
615	Rollmark Caliber	5 6	91	GS
617	Drill and Tap Sight Holes	5 10	91	FB
618	Polish Barrel	5 10	91	WB
620	Apply Coatings (Barrel Action)		5/30/91	TS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/30/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/91	RW
	C) Inspect Ejector Hole for Chamfer		5/30/91	RW
	D) Oil Firing Pin Ass'y		5/30/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		6-6-91	FW

op. #	BARBER - M24 0031783	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			6-6-91	QU
	G) Safety Off Force	3	3	3			6-6-91	QU
	H) Trigger Pull Test & Retainability						6-6-91	QU
	I) Firing Pin Indent	.021	.021	.021			6-6-91	QU
	J) Assemble Stock						6/7/91	RW
	K) Assemble Swivel Studs						6-8-91	D/H
	L) Attach Front and Rear Sight Assemblies						6/7/91	RW
	M) Iron Sight Alignment						6/7/91	RW
	N) Detach Front & Rear Sights & place in numbered container						6/7/91	RW
	O) Attach Scope to Rifle						6/7/91	RW
	P) Detach & Attach Scope 20 Times						6/7/91	RW
640	Gallery Target & Test						6/7/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						6/7/91	KT
655	Final Inspection							
	A) Headspace						6-8-91	D/H
	B) Trigger Pull	2.47	2.54	2.44	2.46	2.53	6-8-91	QU
	C) Function						6-8-91	D/H
660	Pack						9-11-91	W

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6636211

DATE 6-6-91

TESTER JU.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.57	2.39	2.38	2.47	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.37	2.43	2.30	2.54	
PULL #3	2.43	2.44	2.25	2.44	
PULL #4	2.42	2.43	2.40	2.46	
PULL #5	2.43	2.47	2.44	2.53	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.30		
PULL #2	3.28	3.24		
PULL #3	3.20	3.42		
PULL #4	3.29	3.28		
PULL #5	3.40	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	4.16	4.44		4.55
PULL #2	4.21	4.19		4.26
PULL #3	4.15	4.51		4.27
PULL #4	4.23	4.50		4.45
PULL #5	4.50	4.49		4.51
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636211
7 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.0917824
1 TO	2	.870759
1 TO	3	.411953
1 TO	4	.373066
1 TO	5	.255157

2 ~~18~~ (----POR

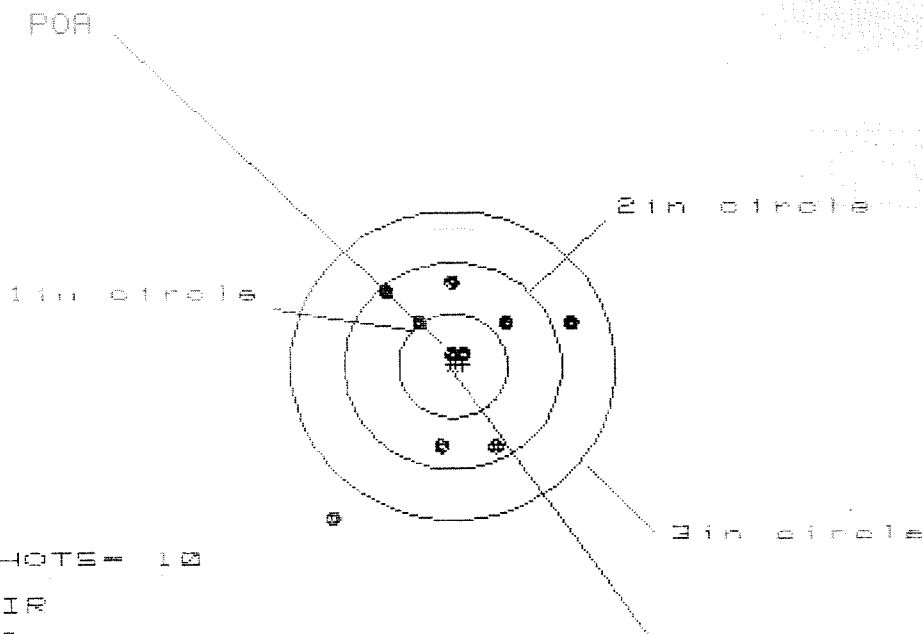
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0538
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0368
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0651819

THE AMR FOR THIS RIFLE IS: .817

7 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8838211

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 3

2in = 8

3in = 9

HS = 2.250

VS = 2.325

GS = 2.945

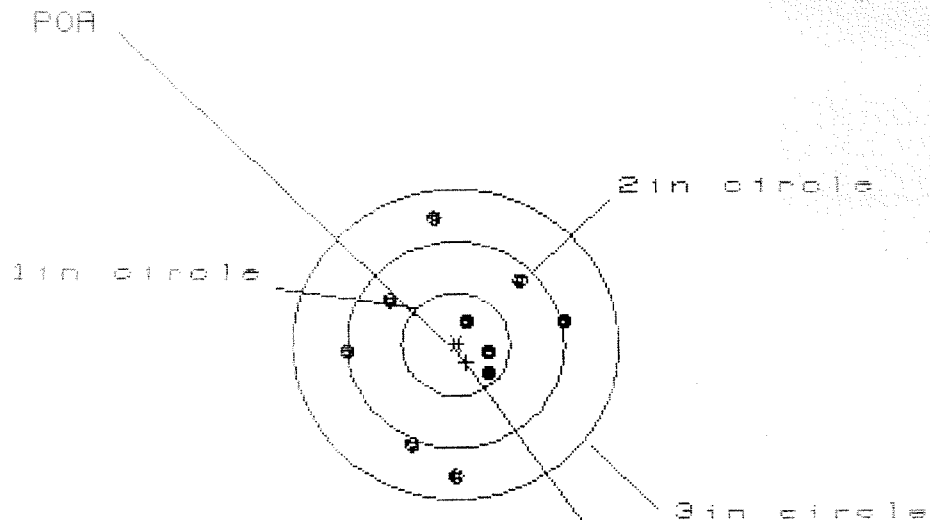
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.104	.977	.529
MINIMUM X	-1.146	-.710	-.588
MAXIMUM Y	.867	.705	.740
MINIMUM Y	-1.458	-.992	-.957
CENTROID X	-.090	.037	-.085
CENTROID Y	-.018	.144	.108
POA TO CENTROID in.	.092	.148	.138
MIN RADIUS	.106	.084	.044
MEAN RADIUS	.791	.637	.581
MAX RADIUS	1.854	1.027	.968
HORIZONTAL SPREAD	2.250	1.687	1.117
VERTICAL SPREAD	2.325	1.697	1.697
EXTREME SPREAD	2.945	1.780	1.754
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	9		

7 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6836211

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 3

2in = 6

3in = 10

HS = 2.006

VS = 2.554

GS = 2.558

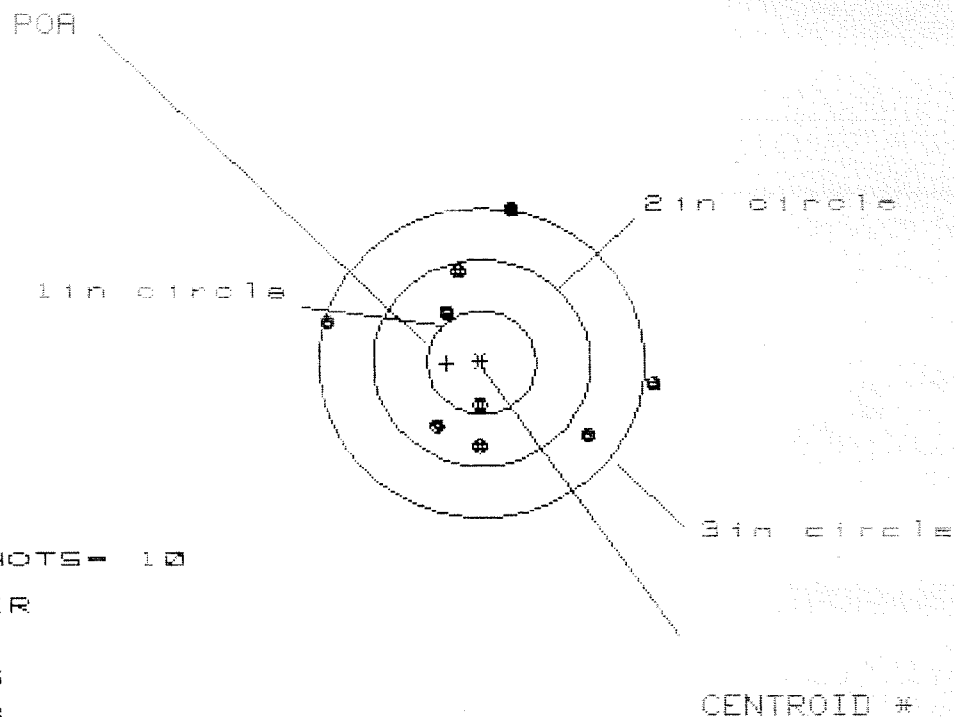
CENTROID #

PATTERN #	2	2	2
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.034	1.028	1.002
MINIMUM X	-.972	-.978	-1.004
MAXIMUM Y	1.266	1.123	.619
MINIMUM Y	-1.288	-1.097	-.956
CENTROID X	-.094	-.088	-.062
CENTROID Y	.171	.315	.174
POA TO CENTROID in.	.195	.327	.185
MIN RADIUS	.211	.099	.196
MEAN RADIUS	.818	.754	.695
MAX RADIUS	1.289	1.189	1.073
HORIZONTAL SPREAD	2.006	2.006	2.006
VERTICAL SPREAD	2.554	2.220	1.575
EXTREME SPREAD	2.558	2.234	2.039
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

7 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636211

CENTERFIRE PATTERNS # 3



HS= 3.006
VS= 2.303
GS= 3.069

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.617	1.207	1.261
MINIMUM X	:	-1.389	-1.210	-1.156
MAXIMUM Y	:	1.536	1.509	1.071
MINIMUM Y	:	-.767	-.794	-.606
CENTROID X	:	.321	.142	.088
CENTROID Y	:	.010	.037	-.151
POA TO CENTROID in.	:	.321	.146	.175
MIN RADIUS	:	.408	.466	.331
MEAN RADIUS	:	1.005	.914	.787
MAX RADIUS	:	1.635	1.568	1.358
HORIZONTAL SPREAD	:	3.006	2.417	2.417
VERTICAL SPREAD	:	2.303	2.303	1.677
EXTREME SPREAD	:	3.069	2.631	2.631
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			8	

7 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636211

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 8

HS = 2.338

VS = 2.295

GS = 3.276

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.268	.941	.825
MINIMUM X	:	-1.071	-.930	-.411
MAXIMUM Y	:	1.097	.964	.993
MINIMUM Y	:	-1.198	-1.192	-1.072
CENTROID X	:	.283	.143	.259
CENTROID Y	:	-.025	.108	-.012
POA TO CENTROID in.	:	.285	.179	.259
MIN RADIUS	:	.478	.481	.481
MEAN RADIUS	:	.962	.857	.792
MAX RADIUS	:	1.744	1.339	1.148
HORIZONTAL SPREAD	:	2.338	1.871	1.236
VERTICAL SPREAD	:	2.295	2.156	2.065
EXTREME SPREAD	:	3.276	2.553	2.073
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

7 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636211

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 6

2in = 9

3in = 10

HS= 1.721

VS= 1.467

GS= 1.722

CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.178	.267	.266
MINIMUM X	-.543	-.412	-.413
MAXIMUM Y	.967	.966	.438
MINIMUM Y	-.500	-.501	-.381
CENTROID X	.157	.026	.027
CENTROID Y	.046	.047	-.073
POA TO CENTROID in.	.164	.054	.078
MIN RADIUS	.172	.064	.132
MEAN RADIUS	.509	.411	.330
MAX RADIUS	1.178	.966	.449
HORIZONTAL SPREAD	1.721	.679	.679
VERTICAL SPREAD	1.467	1.467	.819
EXTREME SPREAD	1.722	1.488	.849
NUMBER IN ONE INCH CIRCLE =		6	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	