

C6636246

MODEL 700™ M24

Model **SMS**™

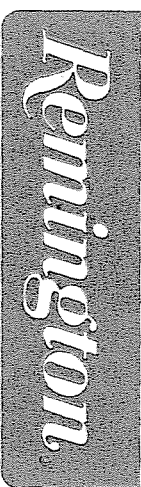
Action

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. C6636246
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		ORDER NO. 5716



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # 06636246

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		GB
617	Drill and Tap Sight Holes	5 10 91		FB
618	Polish Barrel	5 10 91		WB
620	Apply Coatings (Barrel Action)		5/20/91	PA
	Apply Coating (Bolt)		5/20/91	PA
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	WB

Op. #	DESCRIPTION	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6 1/2	6 1/4	6 1/4	6/6/91	WB		
	G) Safety Off Force	7 3/4	8 3/4	7 3/4	6/6/91	WB		
	H) Trigger Pull Test & Retainability				6/6/91	WB		
	I) Firing Pin Indent	.022	.022	.022	6/6/91	WB		
	J) Assemble Stock				6/7/91	RW		
	K) Assemble Swivel Studs				6-8-91	NH		
	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				6/7/91	KT		
	B) Malfunctions				6/7/91	KT		
	C) Pierced Primers				6/7/91	KT		
	D) Optical Clarity of Scope				6/7/91	KT		
645	Inspect for Live Ammo				6/7/91	KT		
655	Final Inspection				6-8-91	DH		
	A) Headspace				6-8-91	DH		
	B) Trigger Pull	2.17	2.15	2.20	2.17	2.19	6-8-91	DH
	C) Function				6-8-91	DH		
660	Pack				9-18-91	RW		

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

SERIAL NO. C6636246
DATE 6/6/91
TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.31	2.34	2.26	2.17	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.34	2.34	2.19	2.15	
PULL #3	2.31	2.31	2.20	2.20	
PULL #4	2.34	2.25	2.22	2.17	
PULL #5	2.25	2.24	2.25	2.19	
TOTAL	11.55	11.48	11.12		
AVG.	2.31	2.30	2.22		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.10	3.10		
PULL #2	3.13	3.08		
PULL #3	3.09	3.08		
PULL #4	3.12	3.00		
PULL #5	3.07	2.90		
TOTAL	15.51	15.16		
AVG.	3.10	3.03		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.05	3.90		4.28
PULL #2	4.01	3.85		4.28
PULL #3	3.95	3.85		4.23
PULL #4	4.00	3.80		4.32
PULL #5	4.02	3.85		4.36
TOTAL	20.03	19.25		21.47
AVG.	4.01	3.85		4.29

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636246
7 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.40017
1 TO	2	.441956
1 TO	3	.63843
1 TO	4	.633979
1 TO	5	.47844

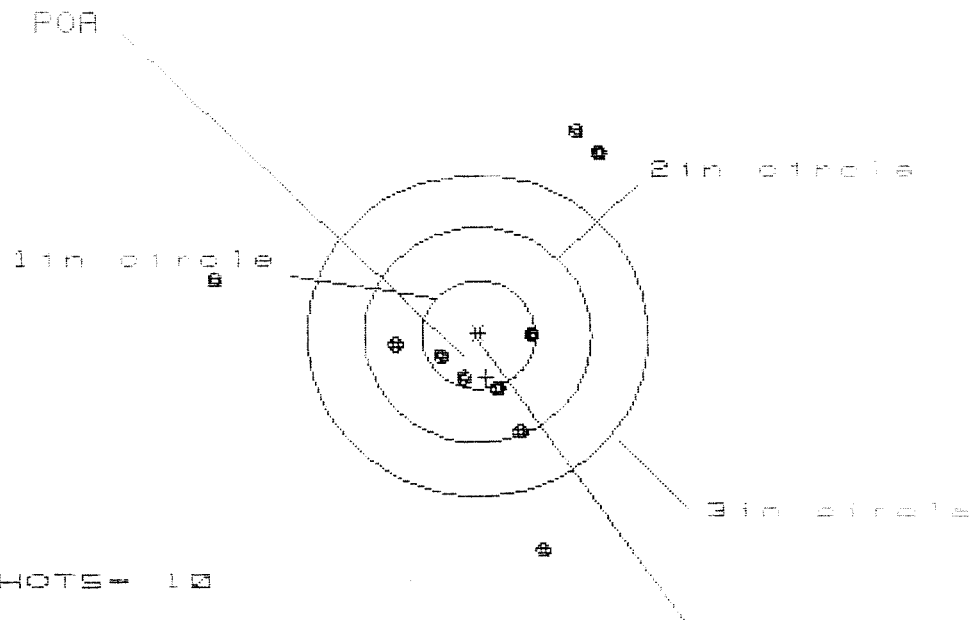
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step (----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0886
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0624
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .108366
THE AMR FOR THIS RIFLE IS: 1.033

7 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8638246

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 3

2in = 5

3in = 6

HS = 3.363

VS = 3.965

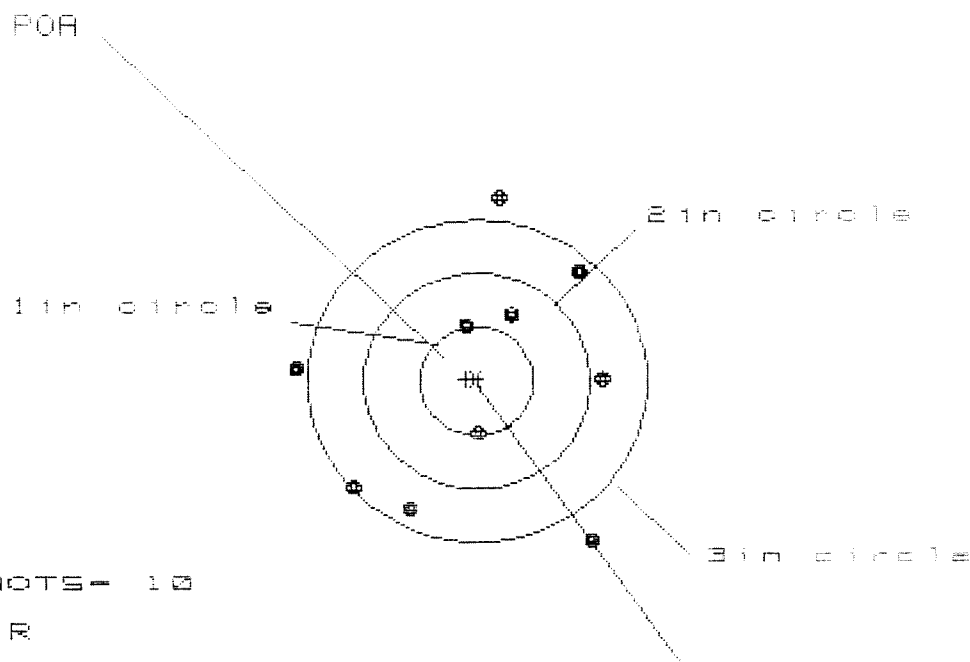
GS = 3.976

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.023	.763	.804
MINIMUM X	:	-2.340	-1.031	-1.990
MAXIMUM Y	:	1.925	1.984	1.736
MINIMUM Y	:	-2.040	-1.981	-1.131
CENTROID X	:	-.070	.190	.149
CENTROID Y	:	.394	.335	.583
POA TO CENTROID in.	:	.401	.385	.601
MIN RADIUS	:	.338	.242	.306
MEAN RADIUS	:	1.217	1.074	1.003
MAX RADIUS	:	2.400	2.080	1.859
HORIZONTAL SPREAD	:	3.363	1.794	1.794
VERTICAL SPREAD	:	3.965	3.965	2.867
EXTREME SPREAD	:	3.976	3.976	2.916
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	6		

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 1

2in = 3

3in = 7

HS= 2.713

VS= 3.294

GS= 3.383

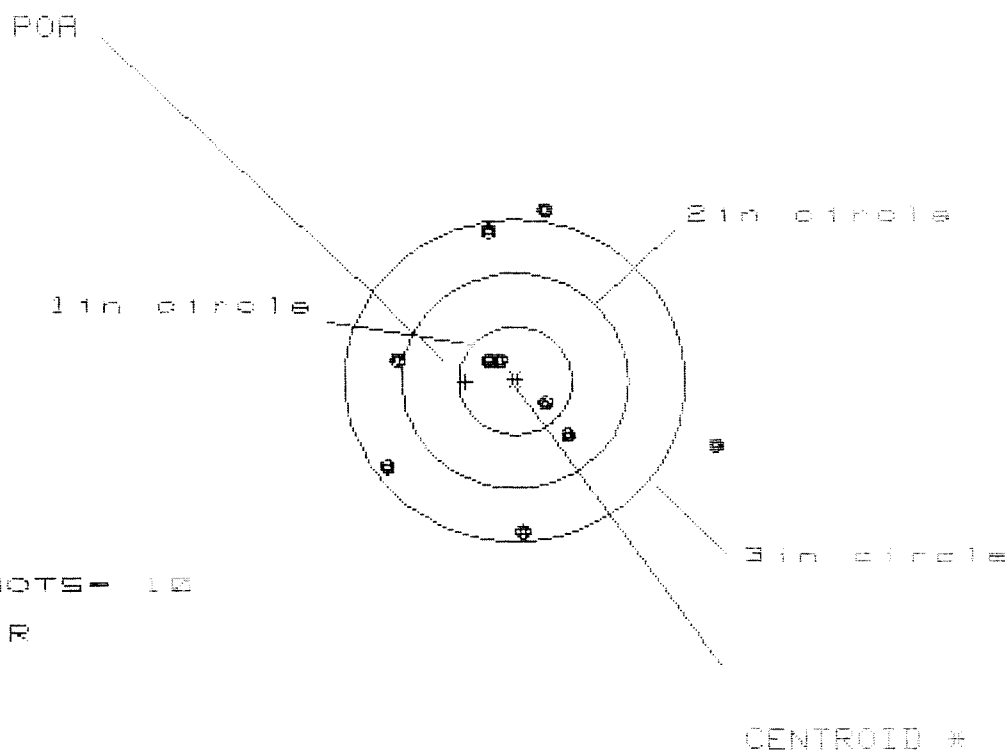
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.107	1.215	1.253
MINIMUM X	:	-1.606	-1.498	-1.460
MAXIMUM Y	:	1.762	1.591	1.074
MINIMUM Y	:	-1.532	-1.341	-1.142
CENTROID X	:	.095	-.013	-.051
CENTROID Y	:	-.016	.154	-.045
POA TO CENTROID in.	:	.096	.154	.068
MIN RADIUS	:	.447	.379	.434
MEAN RADIUS	:	1.214	1.135	1.072
MAX RADIUS	:	1.814	1.620	1.483
HORIZONTAL SPREAD	:	2.713	2.713	2.713
VERTICAL SPREAD	:	3.294	2.932	2.216
EXTREME SPREAD	:	3.383	3.041	2.835
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 12

IN CIR

1in = 3

2in = 4

3in = 8

HS= 2.951

VS= 2.951

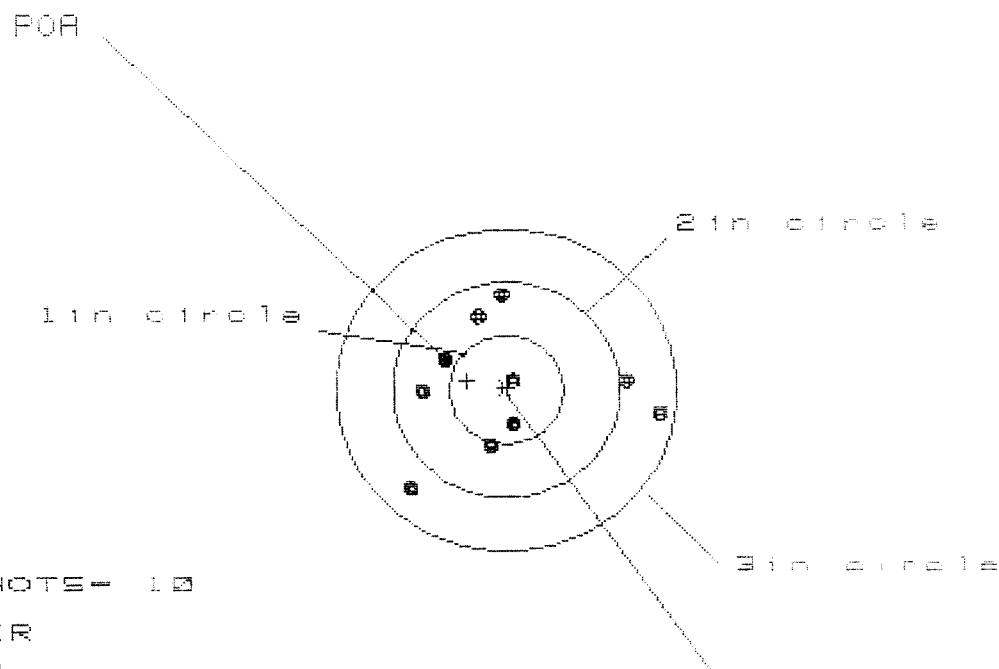
GS= 2.964

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.784	.623	.685
MINIMUM X	:	-1.167	-.969	-.987
MAXIMUM Y	:	1.577	1.511	1.494
MINIMUM Y	:	-1.374	-1.440	-1.251
CENTROID X	:	.437	.239	.177
CENTROID Y	:	.006	.072	-.117
POA TO CENTROID in.	:	.437	.249	.213
MIN RADIUS	:	.273	.134	.330
MEAN RADIUS	:	1.031	.911	.844
MAX RADIUS	:	1.879	1.590	1.494
HORIZONTAL SPREAD	:	2.951	1.592	1.592
VERTICAL SPREAD	:	2.951	2.951	2.745
EXTREME SPREAD	:	2.964	2.964	2.759
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 2.270

VS= 1.750

GS= 2.356

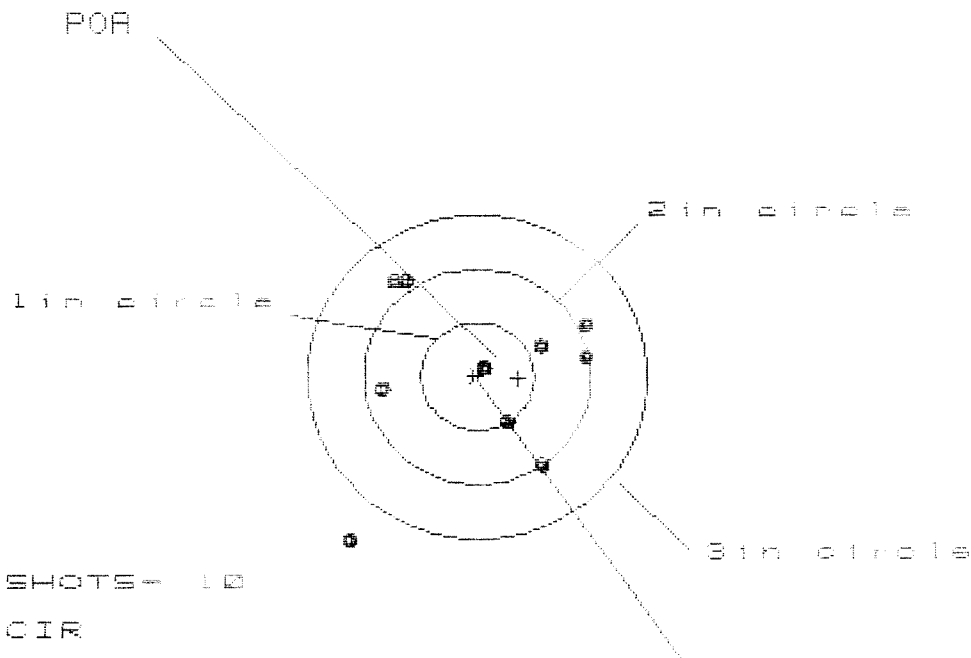
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.396	1.248	1.159
MINIMUM X	:	-.874	-.719	-.637
MAXIMUM Y	:	.873	.845	.732
MINIMUM Y	:	-.877	-.905	-.659
CENTROID X	:	.343	.188	.277
CENTROID Y	:	-.087	-.060	.053
POA TO CENTROID in.	:	.354	.197	.282
MIN RADIUS	:	.072	.180	.111
MEAN RADIUS	:	.767	.682	.618
MAX RADIUS	:	1.418	1.249	1.161
HORIZONTAL SPREAD	:	2.270	1.967	1.796
VERTICAL SPREAD	:	1.750	1.750	1.391
EXTREME SPREAD	:	2.356	2.184	1.798
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS= 2.129

VS= 2.459

GS= 2.913

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.987	.861	.757
MINIMUM X	:	-1.142	-.963	-1.067
MAXIMUM Y	:	.916	.745	.804
MINIMUM Y	:	-1.543	-1.032	-.939
CENTROID X	:	-.362	-.236	-.132
CENTROID Y	:	.015	.186	.093
POA TO CENTROID in.	:	.363	.300	.162
MIN RADIUS	:	.093	.126	.197
MEAN RADIUS	:	.934	.801	.746
MAX RADIUS	:	1.919	1.113	1.190
HORIZONTAL SPREAD	:	2.129	1.824	1.824
VERTICAL SPREAD	:	2.459	1.777	1.743
EXTREME SPREAD	:	2.913	2.155	2.097
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	