

C6611698

MODEL 700™ M24

Model **SMS**™

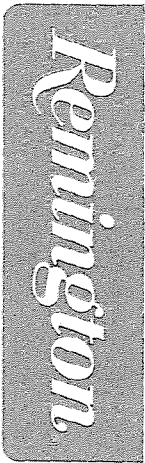
Action

Barrel Length

Capacity

Order No. **5715**

* Includes 1 in chamber.



 		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700™ M24		SERIAL NO. C6611698
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		ORDER NO. 5716



5716 C6611698



GUN SERIAL #

C6611698

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		1/22/91	KS
600	Proof		1/22/91	KS
607	Check Headspace		1/22/91	KS
610	Dis-assemble Gun		1/22/91	KS
612	Magnaflux Barrel Action		1/29/91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	LG.
617	Drill and Tap Sight Holes	2 2	91	LB
618	Polish Barrel <i>RBB</i>	2 2	91	WB
620	Apply Coatings (Barrel Action)		2-11-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/12/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/12/91	KS
	C) Inspect Ejector Hole for Chamfer		2/12/91	KS
	D) Oil Firing Pin Ass'y		2/12/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		2/13/91	JK

op. #	NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			2/13/91	WB
	G) Safety Off Force	2 3/4	2 3/4	2 3/4			2/13/91	WB
	H) Trigger Pull Test & Retainability						2/13/91	JV
	I) Firing Pin Indent	.0215	.021	.021			2/13/91	WB
	J) Assemble Stock						2/13/91	KJ
	K) Assemble Swivel Studs						2-21-91	AC
	L) Attach Front and Rear Sight Assemblies						2/13/91	KJ
	M) Iron Sight Alignment						2/13/91	KJ
	N) Detach Front & Rear Sights & place in numbered container						2/13/91	KJ
	O) Attach Scope to Rifle						2/13/91	KJ
	P) Detach & Attach Scope 20 Times						2/13/91	KJ
640	Gallery Target & Test						2-14-91	AC
	A) Time						2-14-91	AC
	B) Malfunctions						2-14-91	AC
	C) Pierced Primers						2-14-91	AC
	D) Optical Clarity of Scope						2-14-91	AC
645	Inspect for Live Ammo						2-14-91	AC
655	Final Inspection							
	A) Headspace						2-21-91	AC
	B) Trigger Pull	2.44	2.53	2.29	2.46	2.45	2/21/91	JV
	C) Function						2-21-91	AC
660	Pack						3/14/91	WB

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. 0611698

DATE 2/13/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.30	2.27	2.28	2.44	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.22	2.33	2.30	2.53	
PULL #3	2.29	2.32	2.29	2.29	
PULL #4	2.32	2.31	2.33	2.46	
PULL #5	2.28	2.29	2.30	2.45	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.41	3.40		
PULL #2	3.28	3.13		
PULL #3	3.51	3.48		
PULL #4	3.44	3.48		
PULL #5	3.50	3.48		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.27	4.21		4.31
PULL #2	4.25	4.29		4.30
PULL #3	4.28	4.35		4.41
PULL #4	4.11	4.41		4.35
PULL #5	4.29	4.43		4.45
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06611698
14 Feb 1991

CENTROIDAL DISTANCES

0 TO 1	.340037
1 TO 2	.339695
1 TO 3	.282577
1 TO 4	.273
1 TO 5	.290786

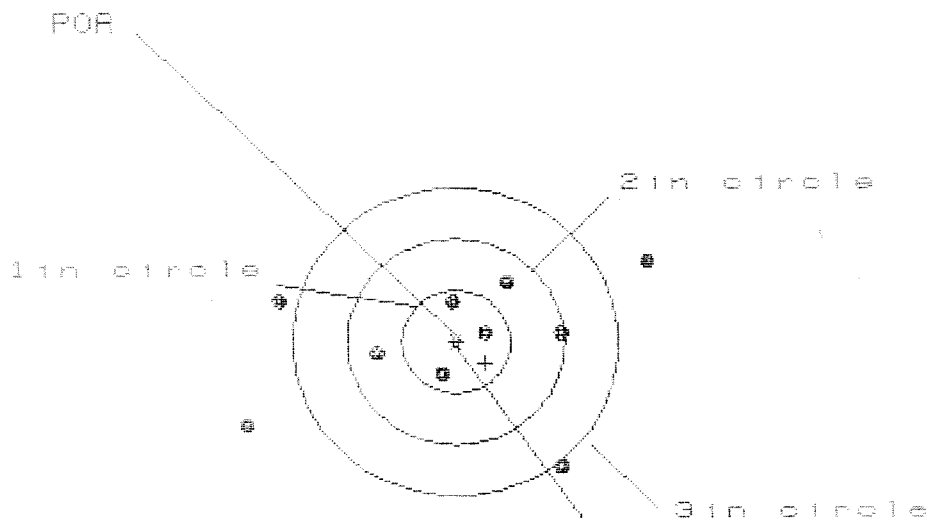
-----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1662
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0002
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .1662
THE AMR FOR THIS RIFLE IS: .9106

14 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CBB11698

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 3

2in = 6

3in = 6

HS= 3.765

VS= 2.029

GS= 4.081

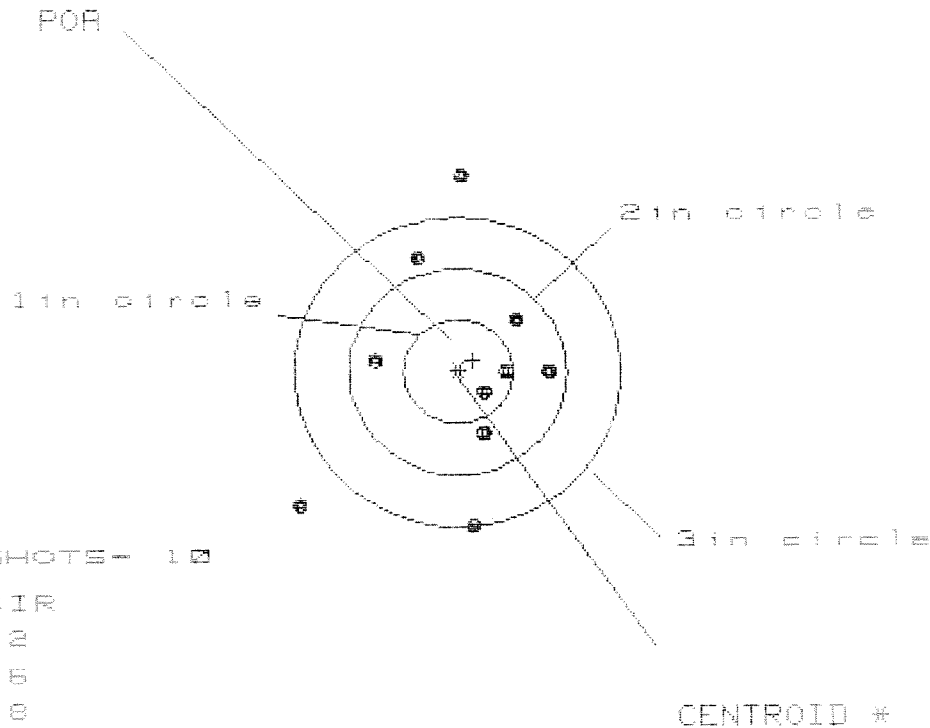
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.790	1.570	.989
MINIMUM X	-1.975	-1.839	-1.642
MAXIMUM Y	.802	.717	.560
MINIMUM Y	-1.227	-1.312	-1.223
CENTROID X	-.269	-.049	-.246
CENTROID Y	.208	.293	.204
POR TO CENTROID in.	.340	.298	.319
MIN RADIUS	.243	.012	.224
MEAN RADIUS	1.071	.918	.826
MAX RADIUS	2.121	1.871	1.639
HORIZONTAL SPREAD	3.765	3.409	2.631
VERTICAL SPREAD	2.029	2.029	1.783
EXTREME SPREAD	4.081	3.429	3.110
NUMBER IN ONE INCH CIRCLE	= 3		
NUMBER IN TWO INCH CIRCLE	= 6		
NUMBER IN THREE INCH CIRCLE	= 6		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.295

VS= 3.350

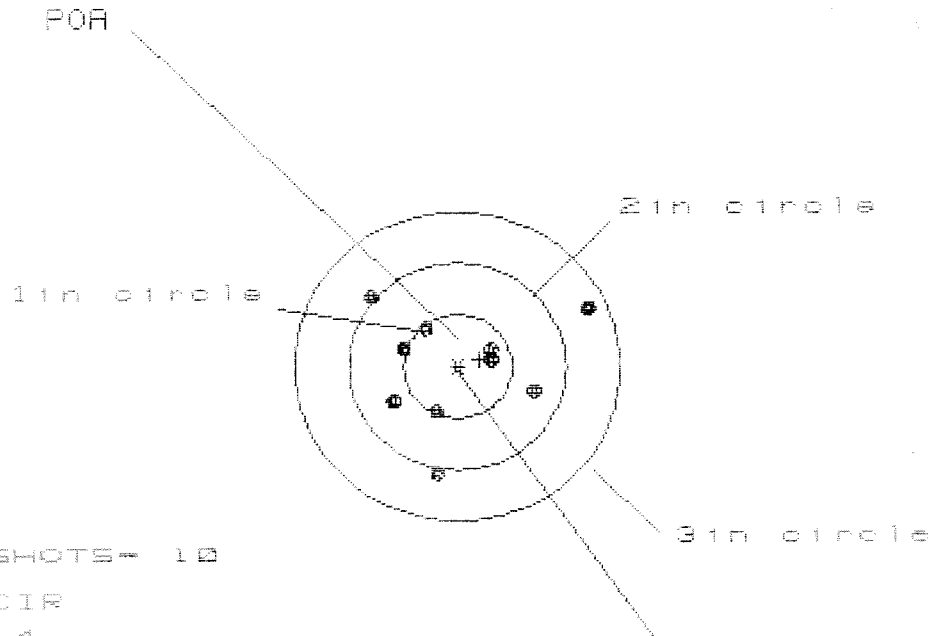
GS= 3.556

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.861	.701	.684
MINIMUM X	-1.434	-.911	-.928
MAXIMUM Y	1.903	1.754	1.160
MINIMUM Y	-1.447	-1.596	-1.377
CENTROID X	-.137	.023	.040
CENTROID Y	-.105	.044	-.175
POA TO CENTROID in.	.172	.050	.180
MIN RADIUS	.307	.290	.150
MEAN RADIUS	1.016	.881	.731
MAX RADIUS	1.964	1.759	1.377
HORIZONTAL SPREAD	2.295	1.612	1.612
VERTICAL SPREAD	3.350	3.350	2.537
EXTREME SPREAD	3.556	3.354	2.594
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 4

2in = 7

3in = 10

HS = 2.002

VS = 1.708

GS = 2.178

CENTROID *

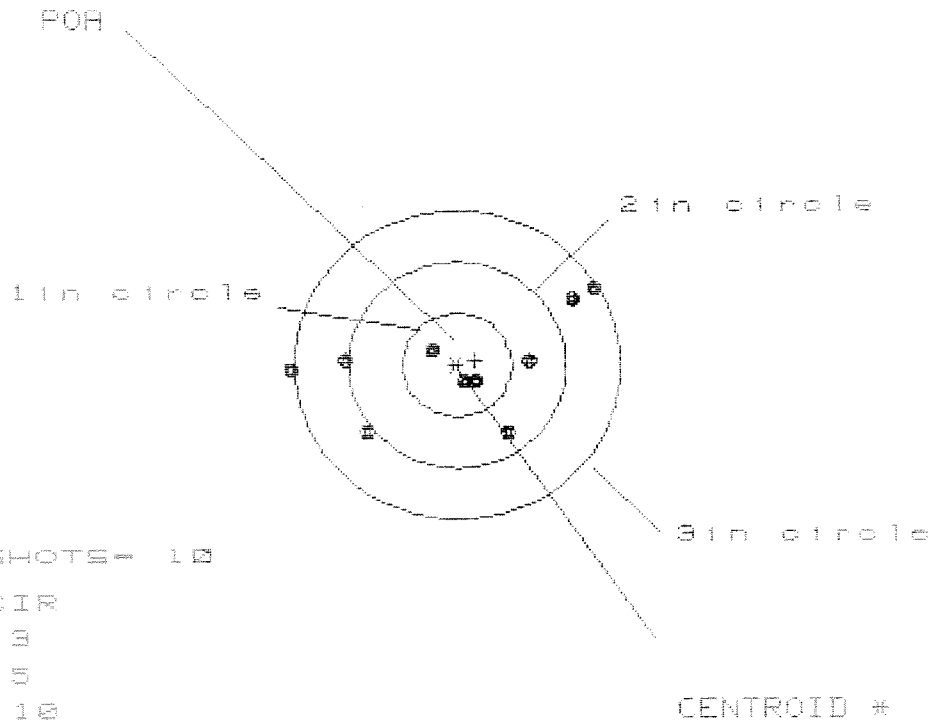
PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.249	.833	.824
MINIMUM X	-.753	-.615	-.624
MAXIMUM Y	.674	.739	.610
MINIMUM Y	-1.034	-.969	-.490
CENTROID X	-.204	-.342	-.333
CENTROID Y	-.067	-.132	-.011
POA TO CENTROID in.	.214	.367	.333
MIN RADIUS	.270	.372	.353
MEAN RADIUS	.703	.621	.565
MAX RADIUS	1.377	.972	.883
HORIZONTAL SPREAD	2.002	1.448	1.448
VERTICAL SPREAD	1.708	1.708	1.108
EXTREME SPREAD	2.178	1.791	1.723
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS

4



OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 10

HS= 2.774

VS= 1.399

GS= 2.865

CENTROID #

PATTERN #

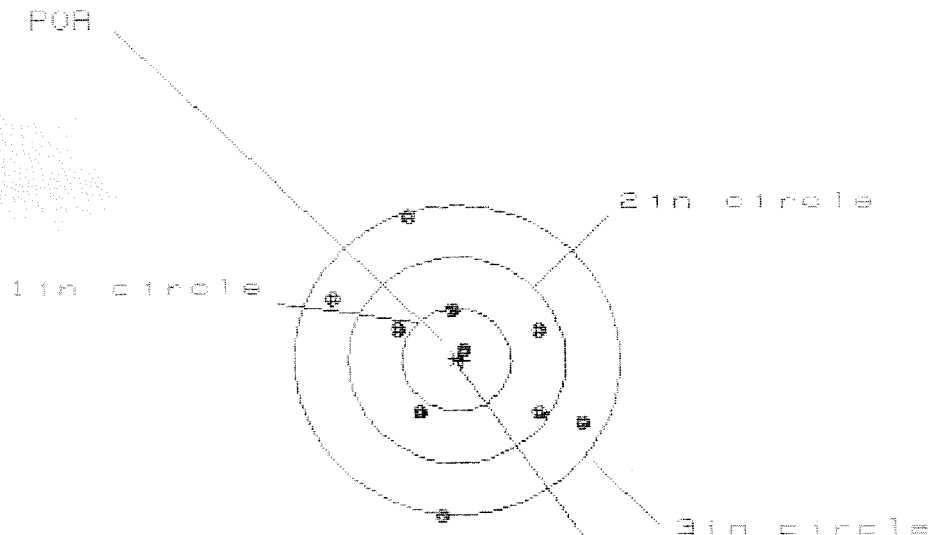
4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.284	1.119	1.024
MINIMUM X	-1.490	-1.244	-1.104
MAXIMUM Y	.698	.696	.708
MINIMUM Y	-.701	-.703	-.616
CENTROID X	-.164	.001	-.139
CENTROID Y	-.044	-.042	-.129
POA TO CENTROID in.	.170	.042	.190
MIN RADIUS	.173	.116	.096
MEAN RADIUS	.846	.758	.671
MAX RADIUS	1.490	1.318	1.245
HORIZONTAL SPREAD	2.774	2.363	2.128
VERTICAL SPREAD	1.399	1.399	1.324
EXTREME SPREAD	2.865	2.516	2.277
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		10	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

CENTROID #

HS= 2.306

VS= 2.968

GS= 2.984

PATTERN #

5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.123	1.109	1.054
MINIMUM X	-1.183	-1.197	-1.252
MAXIMUM Y	1.427	1.256	.539
MINIMUM Y	-1.541	-.759	-.602
CENTROID X	-.057	-.043	.012
CENTROID Y	.009	.180	.023
POA TO CENTROID in.	.058	.185	.028
MIN RADIUS	.119	.120	.068
MEAN RADIUS	.917	.830	.760
MAX RADIUS	1.546	1.344	1.363
HORIZONTAL SPREAD	2.306	2.306	2.306
VERTICAL SPREAD	2.968	2.015	1.141
EXTREME SPREAD	2.984	2.573	2.573
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	