

C6611706

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.

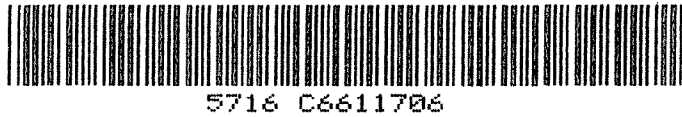
MODEL 700TM H24

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

20

SERIAL NO.
C6611706

ORDER NO.
5716



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611706

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 28 91		RW
600	Proof	3 28 91		RW
607	Check Headspace	3 28 91		RW
610	Dis-assemble Gun	3 28 91		RW
612	Magnaflux Barrel Action	APR 2 1991		KR
	Magnaflux Bolt	APR 2 1991		U
615	Rollmark Caliber	APR 2 1991		GS
617	Drill and Tap Sight Holes	APR 5 1991		SB
618	Polish Barrel	APR 5 1991		WB
620	Apply Coatings (Barrel Action)		4-9-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/10/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/10/91	RW
	C) Inspect Ejector Hole for Chamfer		4/10/91	RW
	D) Oil Firing Pin Ass'y		4/10/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4/30/91	RL

op. #	NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5/1/91	JY
	G) Safety Off Force	4	4	4			5/1/91	Re.
	H) Trigger Pull Test & Retainability						4/30/91	JY
	I) Firing Pin Indent	.021	.021	.021			5/1/91	JY
	J) Assemble Stock						5/1/91	RW
	K) Assemble Swivel Studs						5-1-91	DH
	L) Attach Front and Rear Sight Assemblies						5/1/91	RW
	M) Iron Sight Alignment						5/1/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/1/91	RW
	O) Attach Scope to Rifle						5/1/91	RW
	P) Detach & Attach Scope 20 Times						5/1/91	RW
640	Gallery Target & Test						5/1/91	KT
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	KT
645	Inspect for Live Ammo						5/1/91	KT
655	Final Inspection							
	A) Headspace						5-1-91	DH
	B) Trigger Pull	2.44	2.53	2.60	2.62	2.65	5/1/91	JY
	C) Function						5-1-91	DH
660	Pack						6-18-91	NF

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

SERIAL NO. C6611706DATE 4/30/91TESTER RL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.36	2.47	2.52	2.44	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.33	2.37	2.50	2.53	
PULL #3	2.40	2.59	2.45	2.60	
PULL #4	2.35	2.50	2.48	2.62	
PULL #5	2.50	2.51	2.50	2.65	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.60	3.25		
PULL #2	3.57	3.32		
PULL #3	3.57	3.24		
PULL #4	3.35	3.24		
PULL #5	3.32	3.31		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.45	4.40		4.43
PULL #2	4.45	4.45		4.59
PULL #3	4.39	4.57		4.51
PULL #4	4.43	4.42		4.46
PULL #5	4.37	4.54		4.41
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06611706
1 May 1991

CENTROIDAL DISTANCES

0 TO	1	.0921954
1 TO	2	.10246
1 TO	3	.333402
1 TO	4	.36723
1 TO	5	.179335

34 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0972
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0112
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0978431

THE AMP FOR THIS RIFLE IS: .8278

1 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06611706

CENTERFIRE PATTERNS # 1

POR

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 8

HS= 3.488

VS= 1.872

GS= 3.637

CENTROID #

PATTERN #

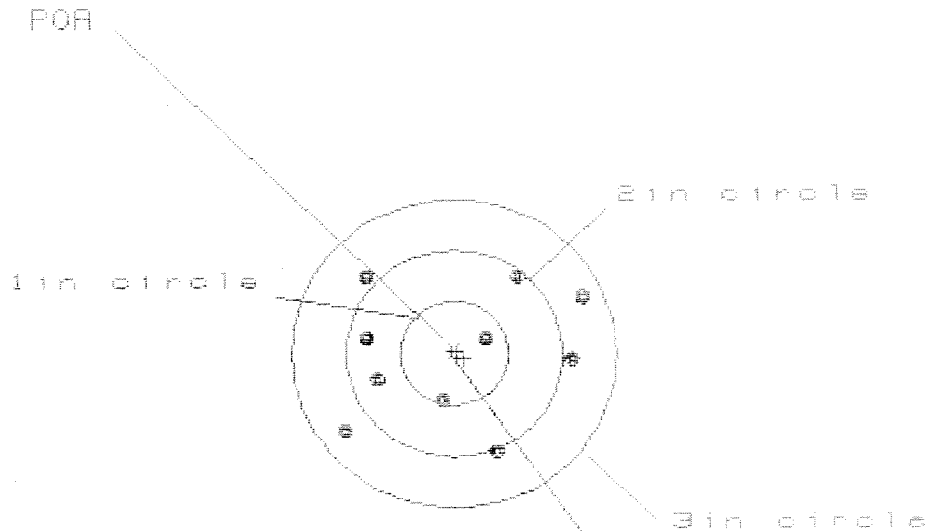
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SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.549	1.334	1.202
MINIMUM X	-1.939	-1.047	-.881
MAXIMUM Y	.936	.881	.940
MINIMUM Y	-.936	-.991	-.932
CENTROID X	.006	.221	.055
CENTROID Y	.092	.147	.088
POR TO CENTROID in.	.092	.266	.104
MIN RADIUS	.377	.597	.423
MEAN RADIUS	1.031	.929	.838
MAX RADIUS	2.003	1.416	1.371
HORIZONTAL SPREAD	3.488	2.381	2.083
VERTICAL SPREAD	1.872	1.072	1.072
EXTREME SPREAD	3.637	2.407	2.137
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	

1 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611786

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 6

3 in = 10

HS = 2.181

VS = 1.683

GS = 2.523

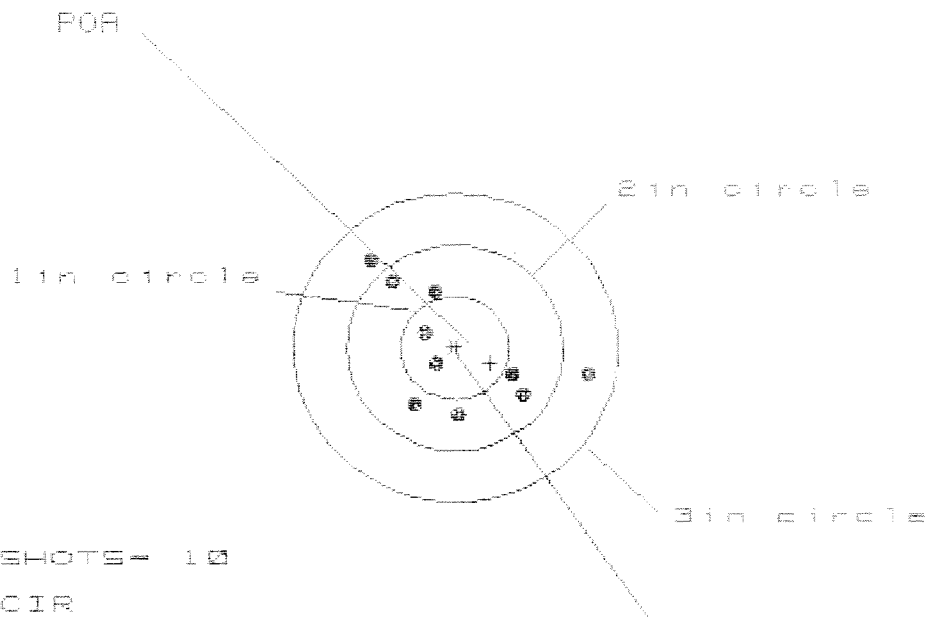
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.151	1.035	1.076
MINIMUM X	-1.040	-0.916	-0.787
MAXIMUM Y	.762	.679	.731
MINIMUM Y	-0.921	-1.004	-0.952
CENTROID X	-0.087	.029	-0.100
CENTROID Y	.049	.132	.080
POA TO CENTROID in.	.100	.135	.128
MIN RADIUS	.327	.184	.321
MEAN RADIUS	.900	.846	.808
MAX RADIUS	1.282	1.117	1.079
HORIZONTAL SPREAD	2.191	1.951	1.863
VERTICAL SPREAD	1.683	1.683	1.683
EXTREME SPREAD	2.523	2.064	2.023
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

1 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08611706

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 8

3in = 10

HS= 0.047

VS= 1.543

GS= 2.310

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.267	.724	.644
MINIMUM X	-.780	-.639	-.514
MAXIMUM Y	.853	.829	.701
MINIMUM Y	-.690	-.714	-.610
CENTROID X	-.323	-.464	-.384
CENTROID Y	.146	.170	.066
POA TO CENTROID in.	.354	.494	.389
MIN RADIUS	.231	.150	.144
MEAN RADIUS	.709	.621	.566
MAX RADIUS	1.285	1.047	.869
HORIZONTAL SPREAD	2.047	1.363	1.158
VERTICAL SPREAD	1.543	1.543	1.311
EXTREME SPREAD	2.310	1.878	1.570
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	8	
NUMBER IN THREE INCH CIRCLE	=	10	

1 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06611706

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= .975

VS= 2.242

GS= 2.295

CENTROID *

PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	.514
MINIMUM X	-.461
MAXIMUM Y	1.324
MINIMUM Y	-.918
CENTROID X	-.007
CENTROID Y	-.275
POA TO CENTROID in.	.275
MIN RADIUS	.275
MEAN RADIUS	.683
MAX RADIUS	1.325
HORIZONTAL SPREAD	.975
VERTICAL SPREAD	2.242
EXTREME SPREAD	2.295
NUMBER IN ONE INCH CIRCLE	3
NUMBER IN TWO INCH CIRCLE	8
NUMBER IN THREE INCH CIRCLE	10

1 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611786

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 1.849

VS= 2.916

GS= 3.271

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.033
MINIMUM X	-.816
MAXIMUM Y	1.284
MINIMUM Y	-1.632
CENTROID X	-.075
CENTROID Y	-.068
POA TO CENTROID in.	.101
MIN RADIUS	.171
MEAN RADIUS	.816
MAX RADIUS	1.839
HORIZONTAL SPREAD	1.849
VERTICAL SPREAD	2.916
EXTREME SPREAD	3.271
NUMBER IN ONE INCH CIRCLE	3
NUMBER IN TWO INCH CIRCLE	7
NUMBER IN THREE INCH CIRCLE	9