

C6611722

MODEL 700™ M24

Model SMS™

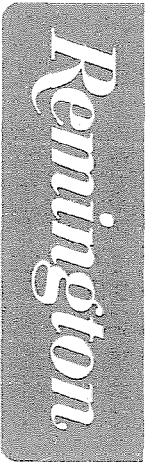
Action _____

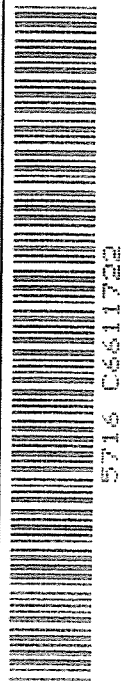
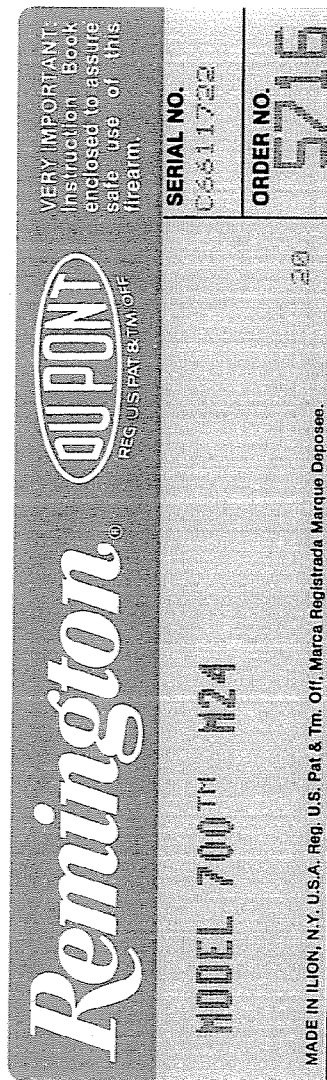
Barrel Length _____

Capacity _____

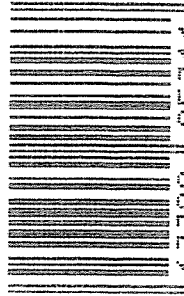
Order No. 5715

*Includes 1 in chamber.





UPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611722

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 10	91	RW
600	Proof	1 10	91	RW
607	Check Headspace	1 10	91	RW
610	Dis-assemble Gun	1 10	91	RW
612	Magnaflux Barrel Action		1/16/91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	GL
617	Drill and Tap Sight Holes	1 17	91	EB
618	Polish Barrel	1 17	91	WB
620	Apply Coatings (Barrel Action)		2-12-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/19/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/19/91	RW
	C) Inspect Ejector Hole for Chamfer		2/19/91	RW
	D) Oil Firing Pin Ass'y		2/19/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		3/6/91	RU

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/2	5 1/2	5 1/2			3/6/91	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			3/6/91	WB
	H) Trigger Pull Test & Retainability						3-6-91	JH
	I) Firing Pin Indent	.0215	.022	.022			3/6/91	WB
	J) Assemble Stock						3/6/91	RW
	K) Assemble Swivel Studs						3-11-91	DH
	L) Attach Front and Rear Sight Assemblies						3/6/91	RW
	M) Iron Sight Alignment						3/6/91	RW
	N) Detach Front & Rear Sights & place in numbered container						3/6/91	RW
	O) Attach Scope to Rifle						3/6/91	RW
	P) Detach & Attach Scope 20 Times						3/6/91	RW
640	Gallery Target & Test						3-6-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						3-6-91	AF
655	Final Inspection							
	A) Headspace						3-11-91	DH
	B) Trigger Pull	2.30	2.29	2.25	2.27	2.49	3/11/91	JH
	C) Function						3-11-91	DH
660	Pack						3-20-91	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO C6611922

DATE 3-6-91

TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.55	2.14	2.32	2.30	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.31	2.38	2.30	2.29	
PULL #3	2.31	2.38	2.39	2.25	
PULL #4	2.23	2.30	2.38	2.27	
PULL #5	2.24	2.28	2.30	2.49	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.32	3.40		
PULL #2	3.33	3.38		
PULL #3	3.35	3.34		
PULL #4	3.34	3.36		
PULL #5	3.34	3.37		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.37	4.36		4.36
PULL #2	4.33	4.39		4.37
PULL #3	4.25	4.38		4.37
PULL #4	4.35	4.37		4.38
PULL #5	4.38	4.38		4.37
TOTAL				
AVG.				

MOD. _____ GA. CAL. _____ GUN # 1722

#	TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
		1st		
NF		2/6	check safe	RW
		2nd		
		3/17	New Safety	
		4/1	ARM	RW
			Bench Tested	
			OK	
		3rd		
		4th		
			FUNCTION	

RD 6654 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

CENTROIDAL DISTANCE CALCULATIONS

FOR RIFLE # C6611722

2 Mar 1991

CENTROIDAL DISTANCES

0	TO	1	.548263
1	TO	2	.424042
1	TO	3	.695507
1	TO	4	.693003
1	TO	5	.649693

1 <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0016
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0572
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .9572224

THE AMR FOR THIS RIFLE IS: .9116

7 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611722

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS - 10

IN CIR

1in = 2

2in = 7

3in = 8

HS = 2.970

VS = 2.151

GS = 2.990

PATTERN #

1

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.170

.970

.903

MINIMUM X

-1.800

-1.026

-1.093

MAXIMUM Y

.471

.422

.218

MINIMUM Y

-1.680

-1.628

-.328

CENTROID X

.017

.217

.284

CENTROID Y

-.549

-.601

-.397

POA TO CENTROID in.

.549

.639

.489

MIN RADIUS

.400

.283

.247

MEAN RADIUS

.932

.781

.596

MAX RADIUS

1.861

1.714

1.141

HORIZONTAL SPREAD

2.970

1.996

1.996

VERTICAL SPREAD

2.151

2.050

.546

EXTREME SPREAD

2.990

2.352

2.019

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

7

NUMBER IN THREE INCH CIRCLE =

8

7 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611722

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 0

2in = 3

3in = 6

HS= 2.721

VS= 3.743

GS= 3.756

CENTROID #

PATTERN #

2

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.040	1.049	1.021
MINIMUM X	-1.601	-1.672	-1.700
MAXIMUM Y	1.773	1.554	.764
MINIMUM Y	-1.970	-.938	-.744
CENTROID X	.011	.002	.030
CENTROID Y	-.125	.094	-.100
POA TO CENTROID in.	.125	.094	.105
MIN RADIUS	.654	.742	.641
MEAN RADIUS	1.312	1.235	1.167
MAX RADIUS	1.971	1.673	1.708
HORIZONTAL SPREAD	2.721	2.721	2.721
VERTICAL SPREAD	3.743	2.492	1.508
EXTREME SPREAD	3.756	2.944	2.944
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		6	

7 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8811722

CENTERFIRE PATTERNS # 3

POR

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in - 2

2in - 8

3in - 9

HS- 2.486

VS- 1.685

GS- 3.003

CENTROID #

PATTERN #

3

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.465

1.019

.911

MINIMUM X

-1.021

-.858

-.913

MAXIMUM Y

.793

.565

.465

MINIMUM Y

-.892

-.804

-.759

CENTROID X

-.042

-.205

-.097

CENTROID Y

.144

.056

.157

POR TO CENTROID in.

.150

.212

.184

MIN RADIUS

.100

.284

.152

MEAN RADIUS

.839

.755

.675

MAX RADIUS

1.666

1.176

.915

HORIZONTAL SPREAD

2.486

1.977

1.825

VERTICAL SPREAD

1.685

1.369

1.224

EXTREME SPREAD

3.003

2.093

1.825

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

8

NUMBER IN THREE INCH CIRCLE =

9

7 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611722

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 1.994

VS= 1.948

GS= 2.059

CENTROID #

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.263

.601

.612

MINIMUM X

-.731

-.590

-.579

MAXIMUM Y

1.104

1.102

.641

MINIMUM Y

-.844

-.846

-.708

CENTROID X

.019

-.122

-.133

CENTROID Y

.144

.146

.008

POA TO CENTROID in.

.145

.190

.133

MIN RADIUS

.181

.298

.245

MEAN RADIUS

.696

.631

.558

MAX RADIUS

1.263

1.106

.887

HORIZONTAL SPREAD

1.994

1.191

1.191

VERTICAL SPREAD

1.948

1.948

1.349

EXTREME SPREAD

2.059

2.030

1.729

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

7

NUMBER IN THREE INCH CIRCLE =

10

7 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8511722

CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 4

2in = 6

3in = 9

HS= 2.419

VS= 2.063

GS= 2.827

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.593

.800

.779

MINIMUM X

-.826

-.649

-.670

MAXIMUM Y

1.292

1.206

.855

MINIMUM Y

-.771

-.704

-.553

CENTROID X

-.013

-.190

-.169

CENTROID Y

.100

.186

.035

POA TO CENTROID in.

.101

.266

.173

MIN RADIUS

.228

.169

.059

MEAN RADIUS

.779

.656

.565

MAX RADIUS

1.770

1.217

.970

HORIZONTAL SPREAD

2.419

1.449

1.449

VERTICAL SPREAD

2.063

1.910

1.408

EXTREME SPREAD

2.827

2.026

1.781

NUMBER IN ONE INCH CIRCLE =

4

NUMBER IN TWO INCH CIRCLE =

6

NUMBER IN THREE INCH CIRCLE =

9