

C5611818

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

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

20

SERIAL NO.
C6611818

ORDER NO.
5716



5716 C6611818

UPC



0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

C6611818

GUN SERIAL #

~~C-6587684~~

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/18/90	Kel
600	Proof		10/18/90	Kel
607	Check Headspace		10/18/90	Kel
610	Dis-assemble Gun		10/18/90	Kel
612	Magnaflux Barrel Action		10/22/90	KR
	Magnaflux Bolt		10/22/90	KR
615	Rollmark Caliber		10/22/90	KR
617	Drill and Tap Sight Holes		10/24/90	KB
618	Polish Barrel <i>KB</i>		10/24/90	KB
620	Apply Coatings (Barrel Action)		11-7-90	<i>JA</i>
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		5/2/91	K.S.
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/2/91	K.S.
	C) Inspect Ejector Hole for Chamfer		5/2/91	K.S.
	D) Oil Firing Pin Ass'y		5/2/91	K.S.
	E) Adjust Trigger Pull to Min Setting and Stake		5-9-91	DH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	7	7			5-9-91	K
	G) Safety Off Force	4	4	4			5-9-91	K
	H) Trigger Pull Test & Retainability						5-9-91	D/H
	I) Firing Pin Indent	.20	.021	.020			5-9-91	AC
	J) Assemble Stock						5/9/91	KS
	K) Assemble Swivel Studs						5-21-91	D/H
	L) Attach Front and Rear Sight Assemblies						5/9/91	KS
	M) Iron Sight Alignment						5/9/91	KS
	N) Detach Front & Rear Sights & place in numbered container						5/9/91	KS
	O) Attach Scope to Rifle						5/9/91	KS
	P) Detach & Attach Scope 20 Times						5/9/91	KS
640	Gallery Target & Test						5/13/91	KF
	A) Time							KF
	B) Malfunctions							KF
	C) Pierced Primers							KF
	D) Optical Clarity of Scope							KF
645	Inspect for Live Ammo						5/13/91	KF
655	Final Inspection							
	A) Headspace						5-21-91	D/H
	B) Trigger Pull	2.55	2.60	2.63	2.65	2.67	5/20/91	JF
	C) Function						5-21-91	D/H
660	Pack						6-17-91	N

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. CCG11818

DATE 5-9-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.54	2.66	2.39	2.55	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.48	2.58	2.56	2.60	
PULL #3	2.42	2.66	2.56	2.63	
PULL #4	2.39	2.72	2.53	2.65	
PULL #5	2.42	2.57	2.57	2.67	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.34	3.64		
PULL #2	3.44	3.85		
PULL #3	3.36	3.63		
PULL #4	3.50	3.70		
PULL #5	3.50	3.67		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.20	4.49		4.33
PULL #2	4.09	4.51		4.54
PULL #3	4.28	4.56		4.49
PULL #4	4.38	4.59		4.57
PULL #5	4.35	4.50		4.53
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611818
13 May 1991

CENTROIDAL DISTANCES

0 TO	1	.308934
1 TO	2	.417968
1 TO	3	.474532
1 TO	4	.0582151
1 TO	5	.197464

1/4 <----FOR

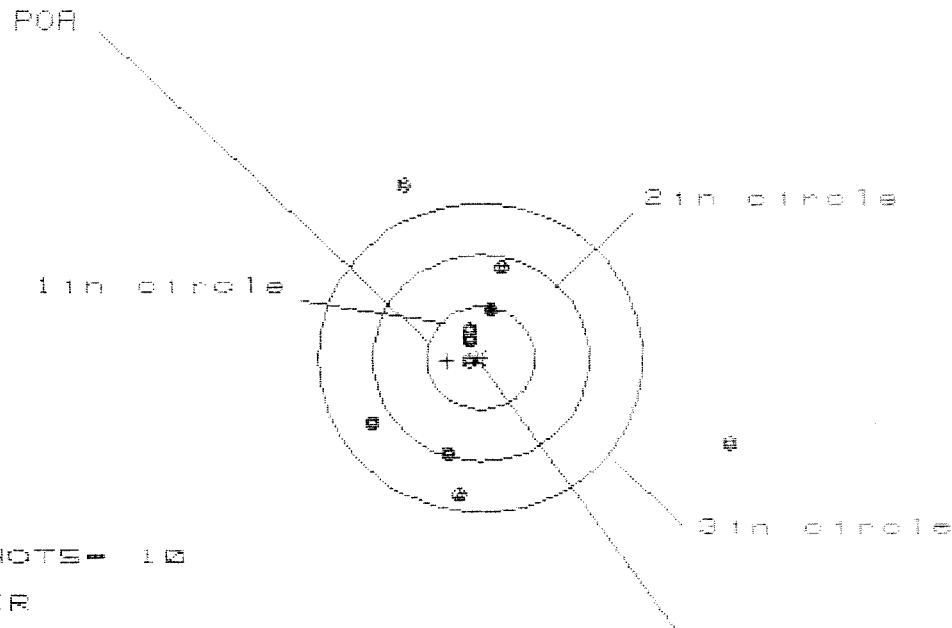
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1452
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1094
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .1818

THE AMR FOR THIS RIFLE IS: .9548

(3 May 1991)

FILE:/PATTERNING/CENTERFIRE_PATT/C8B11018

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 3

2in = 6

3in = 8

HS = 3.299

VS = 3.026

GS = 3.926

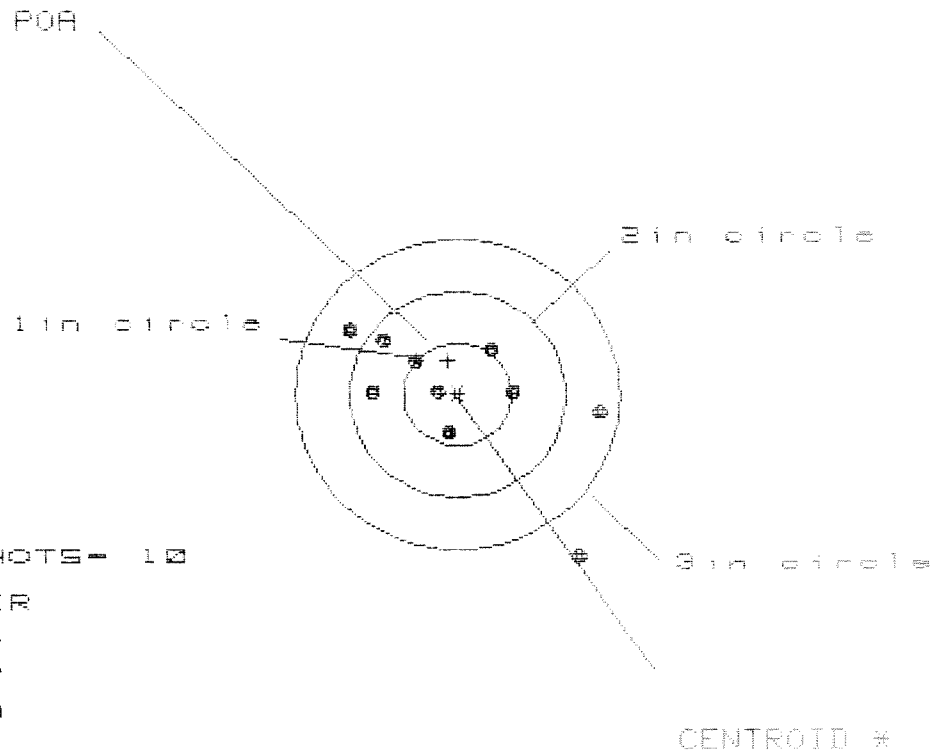
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.292	.434	.374
MINIMUM X	-1.007	-.753	-.813
MAXIMUM Y	1.716	1.631	1.002
MINIMUM Y	-1.308	-1.395	-1.191
CENTROID X	.308	.054	.114
CENTROID Y	.024	.111	-.093
POA TO CENTROID in.	.309	.123	.147
MIN RADIUS	.078	.171	.167
MEAN RADIUS	.983	.806	.707
MAX RADIUS	2.421	1.701	1.192
HORIZONTAL SPREAD	3.299	1.187	1.187
VERTICAL SPREAD	3.026	3.026	2.193
EXTREME SPREAD	3.926	3.068	2.231
NUMBER IN ONE INCH CIRCLE	= 3		
NUMBER IN TWO INCH CIRCLE	= 6		
NUMBER IN THREE INCH CIRCLE	= 8		

13 May 1991

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CENTERFIRE PATTERNS # 2



HS= 2.281

VS= 2.166

GS= 2.996

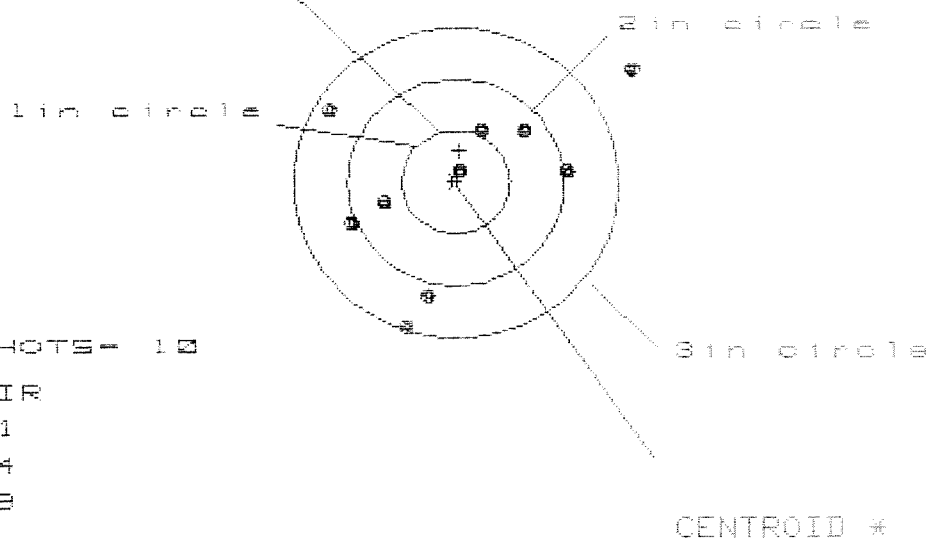
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.311	1.434	.785
MINIMUM X	:	-.978	-.847	-.668
MAXIMUM Y	:	.599	.425	.388
MINIMUM Y	:	-1.567	-.554	-.591
CENTROID X	:	.089	-.034	-.213
CENTROID Y	:	-.332	-.158	-.121
POA TO CENTROID in.	:	.344	.162	.245
MIN RADIUS	:	.212	.191	.196
MEAN RADIUS	:	.819	.661	.532
MAX RADIUS	:	1.914	1.464	.796
HORIZONTAL SPREAD	:	2.281	2.281	1.453
VERTICAL SPREAD	:	2.166	.979	.979
EXTREME SPREAD	:	2.996	2.392	1.543
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

13 May 1991

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CENTERFIRE PATTERNS # 3

POA



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 5

HS = 2.855

VS = 2.501

GS = 3.299

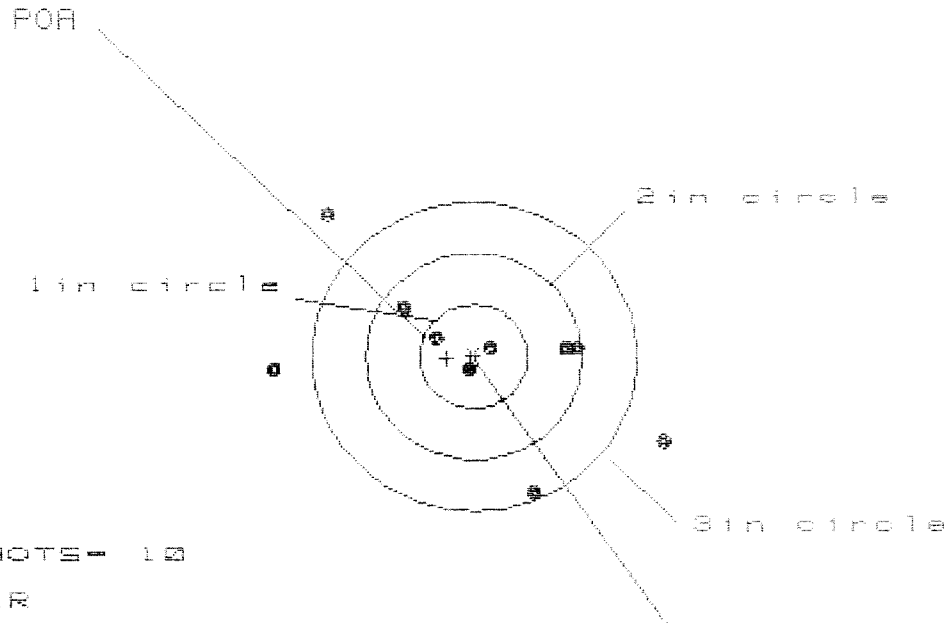
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.679	1.193	1.157
MINIMUM X	:	-1.176	-0.990	-1.026
MAXIMUM Y	:	1.108	.852	.694
MINIMUM Y	:	-1.393	-1.270	-1.116
CENTROID X	:	-.033	-.228	-.184
CENTROID Y	:	-.306	-.429	-.271
POA TO CENTROID in.	:	.308	.483	.327
MIN RADIUS	:	.108	.288	.155
MEAN RADIUS	:	1.021	.968	.836
MAX RADIUS	:	2.011	1.306	1.238
HORIZONTAL SPREAD	:	2.855	2.183	2.103
VERTICAL SPREAD	:	2.501	2.122	1.810
EXTREME SPREAD	:	3.299	2.271	2.271
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

13 May 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1in = 3

2in = 6

3in = 7

HS = 3.548

VS = 2.731

GS = 3.812

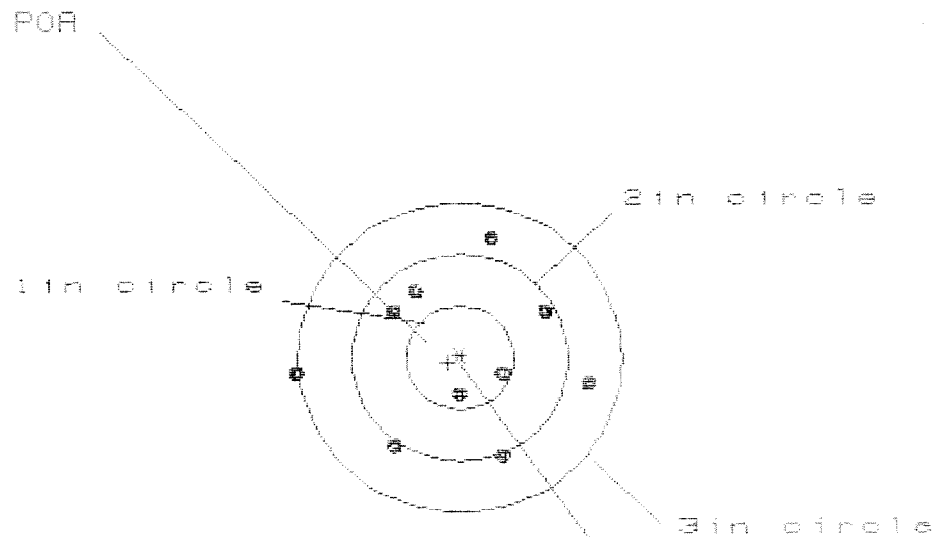
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.741	1.588	1.002
MINIMUM X	:	-1.807	-1.960	-1.761
MAXIMUM Y	:	1.412	.640	.562
MINIMUM Y	:	-1.319	-1.162	-1.240
CENTROID X	:	.250	.403	.204
CENTROID Y	:	.019	-.137	-.059
POA TO CENTROID in.	:	.251	.426	.213
MIN RADIUS	:	.084	.195	.097
MEAN RADIUS	:	1.041	.947	.818
MAX RADIUS	:	1.971	1.962	1.761
HORIZONTAL SPREAD	:	3.548	3.548	2.763
VERTICAL SPREAD	:	2.731	1.802	1.802
EXTREME SPREAD	:	3.812	3.619	2.767
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

13 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8511010

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 2.687

VS= 2.092

GS= 2.698

CENTROID #

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.205	1.039	.755
MINIMUM X	-1.492	-.793	-.663
MAXIMUM Y	1.119	1.105	1.077
MINIMUM Y	-.973	-.987	-1.015
CENTROID X	.112	.278	.148
CENTROID Y	.048	.062	.090
POA TO CENTROID in.	.122	.285	.173
MIN RADIUS	.363	.223	.347
MEAN RADIUS	.910	.826	.797
MAX RADIUS	1.497	1.158	1.109
HORIZONTAL SPREAD	2.697	1.832	1.418
VERTICAL SPREAD	2.092	2.092	2.092
EXTREME SPREAD	2.698	2.157	2.157
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		10	