

C6636139

MODEL 700™ M24

Model **SMS**™

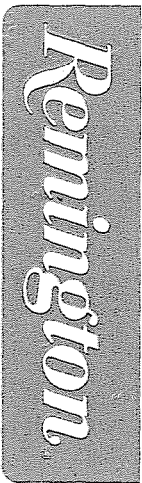
Action

Barrel Length

Capacity

Order No. **5716**

* Includes 1 in chamber.





VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700™ M24

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

20

SERIAL NO.
C6636139

ORDER NO.
5716



5716 C6636139

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636139

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	4/3/91	K.S.
600	Proof		4/3/91	K.S.
607	Check Headspace		4/3/91	K.S.
610	Dis-assemble Gun		4/3/91	K.S.
612	Magnaflux Barrel Action		4/10/91	KR
	Magnaflux Bolt		4/10/91	4
615	Rollmark Caliber		4/10/91	98
617	Drill and Tap Sight Holes		APR 19 1991	FB
618	Polish Barrel		APR 19 1991	WB
620	Apply Coatings (Barrel Action)		5-10-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/22/91	K.S.
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/22/91	K.S.
	C) Inspect Ejector Hole for Chamfer		5/22/91	K.S.
	D) Oil Firing Pin Ass'y		5/22/91	K.S.
	E) Adjust Trigger Pull to Min Setting and Stake		5/28/91	JP

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5/28/91	JH
	G) Safety Off Force	4	4	4			5/28/91	JH
	H) Trigger Pull Test & Retainability						5-28-91	JH
	I) Firing Pin Indent	.021	.021	.021			5/28/91	JH
	J) Assemble Stock						5/28/91	KS
	K) Assemble Swivel Studs						6-1-91	D/H
	L) Attach Front and Rear Sight Assemblies						5/28/91	KS
	M) Iron Sight Alignment						5/28/91	ICS
	N) Detach Front & Rear Sights & place in numbered container						5/28/91	KS
	O) Attach Scope to Rifle						5/28/91	KS
	P) Detach & Attach Scope - 20 Times						5/28/91	KS
640	Gallery Target & Test						5/29/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						5/29/91	KT
655	Final Inspection						6-1-91	D/H
	A) Headspace							
	B) Trigger Pull	2.43	2.44	2.44	2.45	2.51	6/1/91	JH
	C) Function						6-1-91	D/H
660	Pack						6-19-91	NE

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6636139DATE 5-28-91TESTER JEL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.48	2.46	2.50	2.43	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.40	2.50	2.55	2.44	
PULL #3	2.50	2.47	2.51	2.44	
PULL #4	2.20	2.49	2.48	2.45	
PULL #5	2.17	2.48	2.49	2.51	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.53	3.55		
PULL #2	3.52	3.59		
PULL #3	3.57	3.59		
PULL #4	3.57	3.56		
PULL #5	3.58	3.63		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.67	4.37		4.50
PULL #2	4.59	4.42		4.11
PULL #3	4.62	4.45		4.49
PULL #4	4.69	4.47		4.47
PULL #5	4.61	4.44		4.58
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636139
29 May 1991

CENTROIDAL DISTANCES

0 TO 1	.0885494
1 TO 2	.192816
1 TO 3	.217706
1 TO 4	.165895
1 TO 5	.46676

5.7 (----)POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0562
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0956
THE RESULTING AVERAGE POLY-BIL FOR THIS RIFLE IS: .110895
THE WMR FOR THIS RIFLE IS: .9261

29 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636139

CENTERFIRE PATTERNS # 1

POR

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 7

HS= 3.244

VS= 3.835

GS= 4.873

CENTROID #

PATTERN #

1

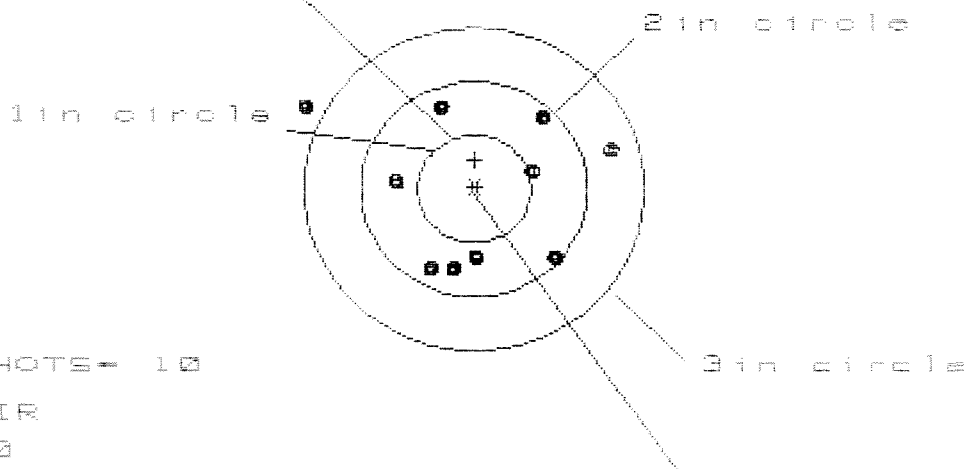
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.725	1.557	1.120
MINIMUM X	-1.519	-1.145	-.951
MAXIMUM Y	1.911	.948	.759
MINIMUM Y	-1.925	-1.712	-1.901
CENTROID X	.040	.208	.014
CENTROID Y	-.079	-.291	-.102
POR TO CENTROID in.	.086	.358	.103
MIN RADIUS	.249	.479	.276
MEAN RADIUS	1.247	1.171	.952
MAX RADIUS	2.441	2.171	1.947
HORIZONTAL SPREAD	3.244	2.702	2.071
VERTICAL SPREAD	3.835	2.660	2.660
EXTREME SPREAD	4.873	3.646	2.981
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		7	

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FILE:/PATTERNING/CENTERFIRE_PATT/08635139

CENTERFIRE PATTERNS # 2

POA



OF SHOTS = 10

IN CIR

1in = 0

2in = 8

3in = 8

HS = 2.705

VS = 1.582

GS = 2.743

CENTROID *

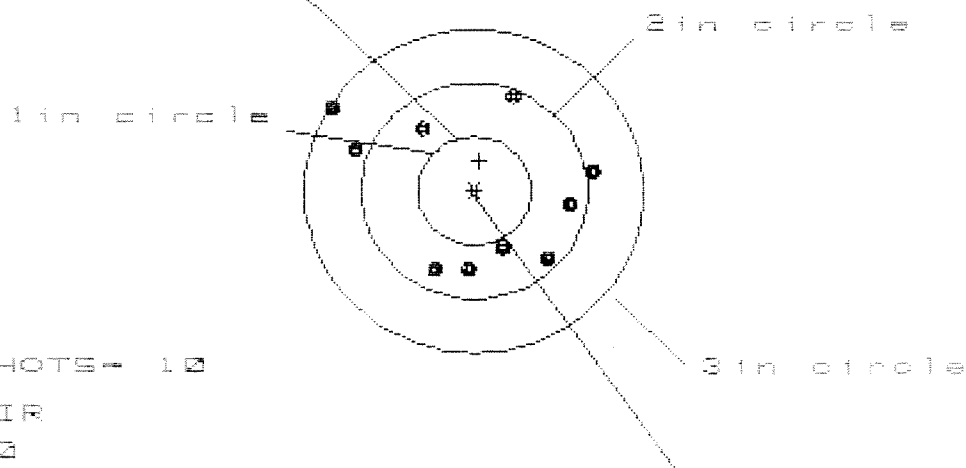
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.241	1.078	.680
MINIMUM X	:	-1.464	-.899	-.764
MAXIMUM Y	:	.802	.888	.940
MINIMUM Y	:	-.780	-.694	-.643
CENTROID X	:	-.007	.156	.021
CENTROID Y	:	-.266	-.352	-.404
POA TO CENTROID in.	:	.266	.385	.404
MIN RADIUS	:	.503	.392	.492
MEAN RADIUS	:	.924	.820	.768
MAX RADIUS	:	1.657	1.153	1.036
HORIZONTAL SPREAD	:	2.705	1.977	1.444
VERTICAL SPREAD	:	1.582	1.582	1.582
EXTREME SPREAD	:	2.743	1.998	1.816
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3

POA



OF SHOTS- 10

IN CIR

1in = 0

2in = 7

3in = 10

HS= 2.217

VS= 1.647

GS= 2.336

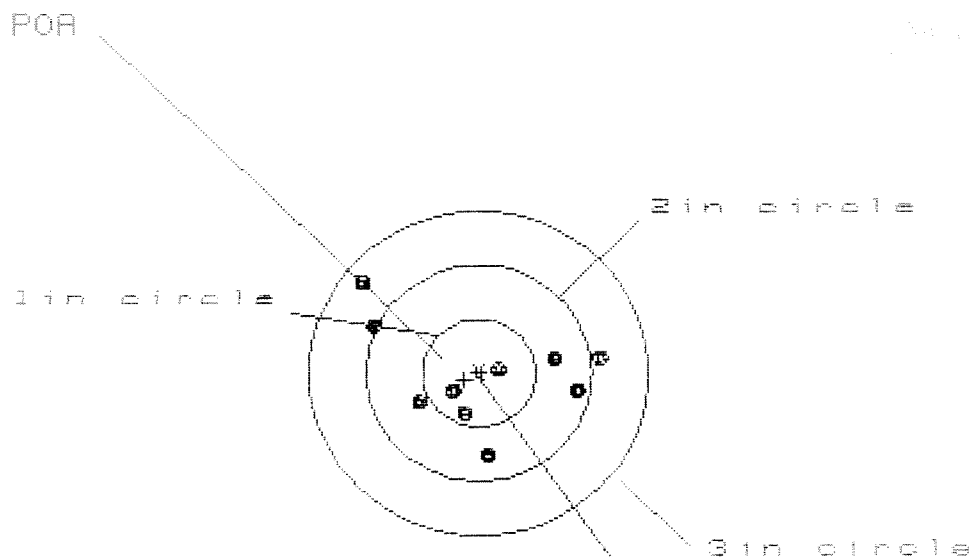
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.013	.879	.731
MINIMUM X	:	-1.204	-1.183	-.700
MAXIMUM Y	:	.897	.979	1.041
MINIMUM Y	:	-.750	-.668	-.606
CENTROID X	:	-.046	.088	.236
CENTROID Y	:	-.279	-.361	-.423
POA TO CENTROID in.	:	.282	.371	.484
MIN RADIUS	:	.592	.471	.400
MEAN RADIUS	:	.920	.839	.755
MAX RADIUS	:	1.413	1.282	1.046
HORIZONTAL SPREAD	:	2.217	2.062	1.431
VERTICAL SPREAD	:	1.647	1.647	1.647
EXTREME SPREAD	:	2.336	2.071	1.818
NUMBER IN ONE INCH CIRCLE	=		0	
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 = 8

3in = 10

HS= 2.060

VS= 1.526

GS= 2.160

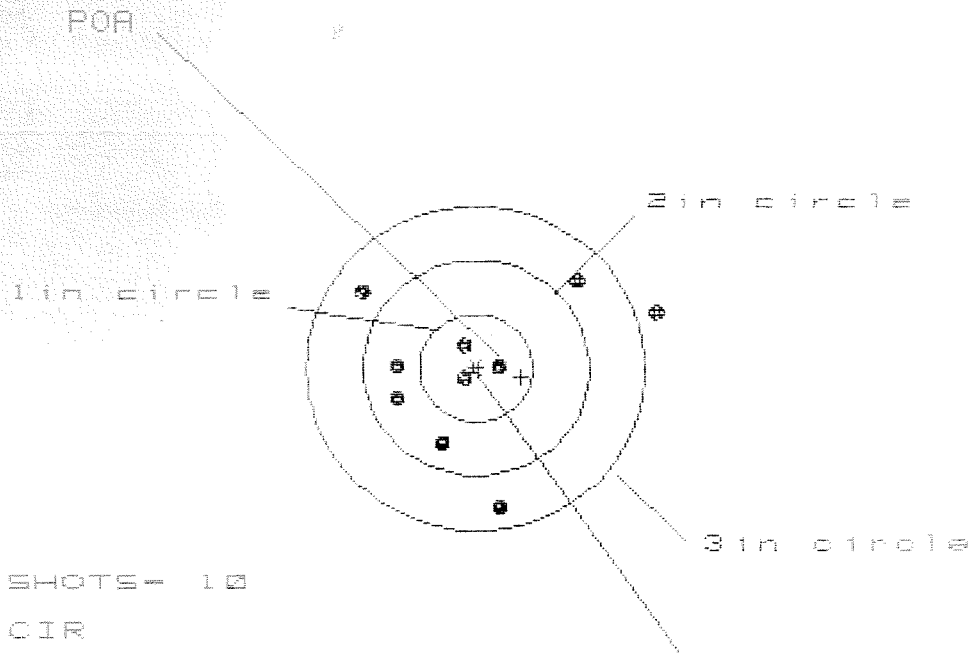
CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.056	.945	.831
MINIMUM X	-1.004	-1.005	-.887
MAXIMUM Y	.810	.484	.516
MINIMUM Y	-.716	-.626	-.595
CENTROID X	.129	.240	.122
CENTROID Y	.061	-.029	-.061
POA TO CENTROID in.	.142	.242	.136
MIN RADIUS	.207	.141	.252
MEAN RADIUS	.698	.616	.557
MAX RADIUS	1.290	1.116	1.026
HORIZONTAL SPREAD	2.060	1.950	1.718
VERTICAL SPREAD	1.526	1.110	1.110
EXTREME SPREAD	2.160	1.964	1.798
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS = 2.537

VS = 2.033

GS = 2.544

CENTROID #

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.552	1.100	1.149
MINIMUM X	-.985	-.813	-.764
MAXIMUM Y	.793	.853	.706
MINIMUM Y	-1.240	-1.180	-.792
CENTROID X	-.397	-.569	-.618
CENTROID Y	.085	.025	.172
POA TO CENTROID in.	.406	.569	.642
MIN RADIUS	.171	.084	.190
MEAN RADIUS	.812	.692	.626
MAX RADIUS	1.644	1.392	1.349
HORIZONTAL SPREAD	2.537	1.913	1.913
VERTICAL SPREAD	2.033	2.033	1.498
EXTREME SPREAD	2.544	2.309	1.943
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	