

C6636150

MODEL 700TM M24

Model **SMS** TM

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. C6636150
ORDER NO. 5716



Stock
Repaired

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636150

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		5/1/91	KS
600	Proof		5/1/91	KS
607	Check Headspace		5/1/91	KS
610	Dis-assemble Gun		5/1/91	KS
612	Magnaflux Barrel Action	5	8 9 1	KCK
	Magnaflux Bolt	5 8	9 1	Kcd
615	Rollmark Caliber	5	8 9 1	GB
617	Drill and Tap Sight Holes	5	15	9 FB
618	Polish Barrel	5	15 9 1	WB
620	Apply Coatings (Barrel Action)		5-31-91	DA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		6-6-91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6-6-91	KS
	C) Inspect Ejector Hole for Chamfer		6-6-91	KS
	D) Oil Firing Pin Ass'y		6-6-91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		6-10-91	

op. #	BARBER - M24 0038283	READINGS					DATE	INIT
625 cont.	F) Safety On Force	8	8	8			6-10-91	JH
	G) Safety Off Force	6	6	6			6-10-91	JH
	H) Trigger Pull Test & Retainability						6-10-91	JH
	I) Firing Pin Indent	.023	.023	.023			6-10-91	JH
	J) Assemble Stock						6-10-91	KS
	K) Assemble Swivel Studs						6-12-91	KS
	L) Attach Front and Rear Sight Assemblies						4/10/91	KS
	M) Iron Sight Alignment						4/10/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/10/91	KS
	O) Attach Scope to Rifle						6/10/91	KS
	P) Detach & Attach Scope 20 Times						4/10/91	KS
640	Gallery Target & Test						6-11-91	AC
	A) Time						6-11-91	AC
	B) Malfunctions						6-11-91	AC
	C) Pierced Primers						6-11-91	AC
	D) Optical Clarity of Scope						6-11-91	AC
645	Inspect for Live Ammo						6-11-91	AC
655	Final Inspection							
	A) Headspace						6-12-91	KS
	B) Trigger Pull	269	267	263	260	268	6-12-91	JH
	C) Function						6-12-91	AC
660	Pack						6-20-91	VF

SWS TRIGGER PULL TEST

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

SERIAL NO. C 6636150DATE 6-10-91TESTER [Signature]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.67	2.57	2.50	2.69	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.51	2.67	2.55	2.67	
PULL #3	2.58	2.40	2.53	2.63	
PULL #4	2.62	2.49	2.48	2.66	
PULL #5	2.68	2.50	2.48	2.68	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.66	3.15		
PULL #2	3.41	3.61		
PULL #3	3.60	3.40		
PULL #4	3.37	3.58		
PULL #5	3.53	3.40		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.28		4.35
PULL #2	4.25	4.29		4.45
PULL #3	4.19	2.26		4.33
PULL #4	4.15	4.33		4.53
PULL #5	4.16	4.14		4.63
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636150
11 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.126194
1 TO	2	.168885
1 TO	3	.197408
1 TO	4	.247421
1 TO	5	.140293

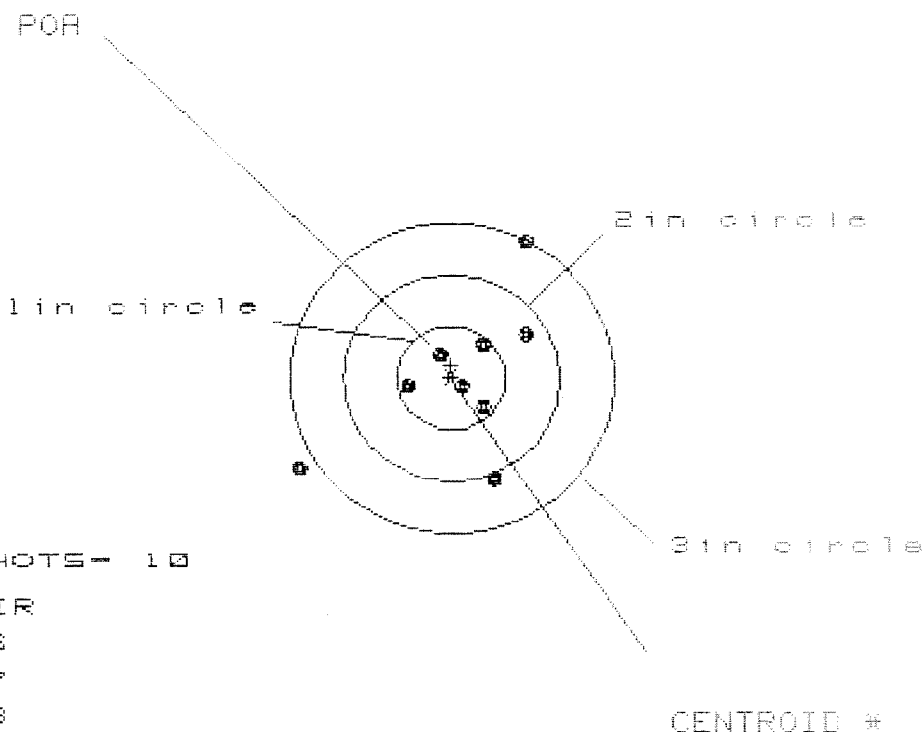
중 (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0634
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0938
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .113217
THE AMR FOR THIS RIFLE IS: .8752

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FILE:/PATTERNING/CENTERFIRE_PATT/06636150

CENTERFIRE PATTERNS # 1

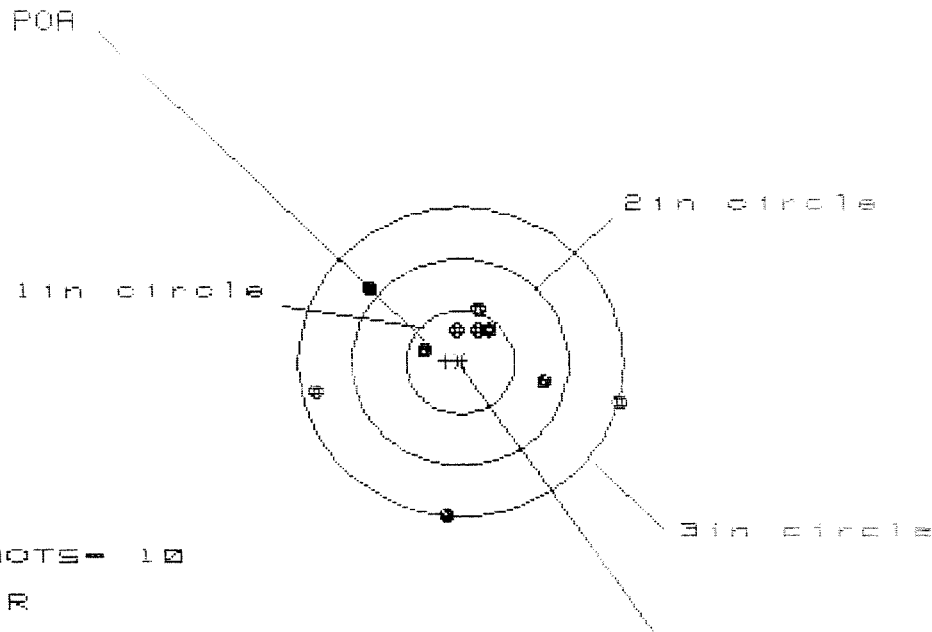


PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.693	.532	.594
MINIMUM X	-1.447	-.532	-.478
MAXIMUM Y	1.361	1.268	.482
MINIMUM Y	-.974	-1.067	-.988
CENTROID X	.007	.168	.106
CENTROID Y	-.126	-.032	-.191
POA TO CENTROID in.	.126	.171	.218
MIN RADIUS	.121	.215	.047
MEAN RADIUS	.694	.594	.468
MAX RADIUS	1.673	1.363	.946
HORIZONTAL SPREAD	2.139	1.064	1.064
VERTICAL SPREAD	2.335	2.335	1.390
EXTREME SPREAD	3.048	2.354	1.429
NUMBER IN ONE INCH CIRCLE =	6		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 4

2in = 6

3in = 9

HS= 2.763

VS= 2.247

GS= 2.767

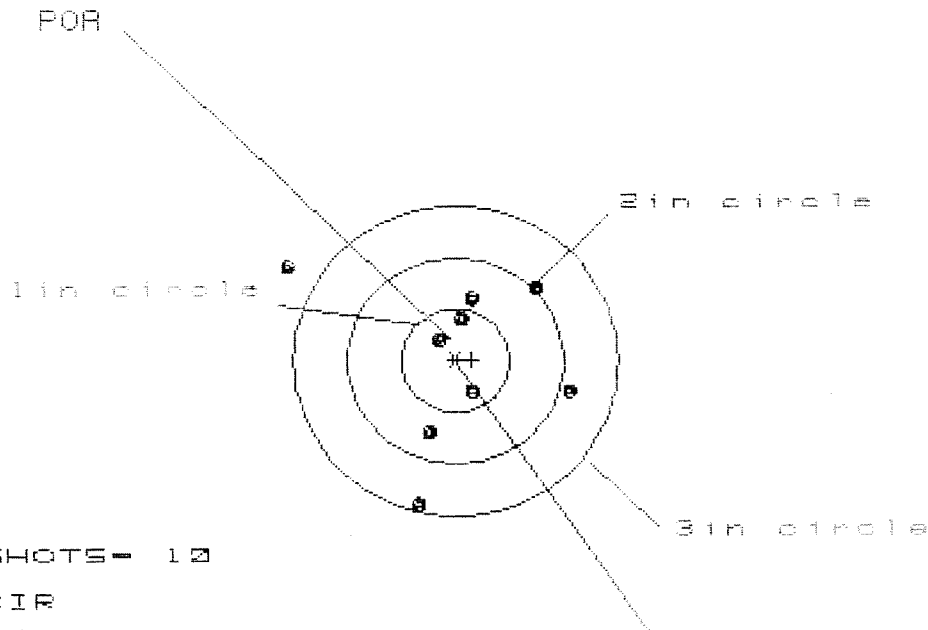
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.422	1.409	.946
MINIMUM X	:	-1.341	-1.354	-1.178
MAXIMUM Y	:	.716	.546	.473
MINIMUM Y	:	-1.531	-1.580	-1.586
CENTROID X	:	.136	.149	-.027
CENTROID Y	:	-.017	.153	.226
POA TO CENTROID in.	:	.137	.214	.227
MIN RADIUS	:	.323	.172	.128
MEAN RADIUS	:	.826	.684	.573
MAX RADIUS	:	1.536	1.523	1.282
HORIZONTAL SPREAD	:	2.763	2.763	2.124
VERTICAL SPREAD	:	2.247	1.126	.979
EXTREME SPREAD	:	2.767	2.767	2.128
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS - 12

IN CIR

1 in = 4

2 in = 6

3 in = 9

CENTROID #

HS = 2.568

VS = 2.319

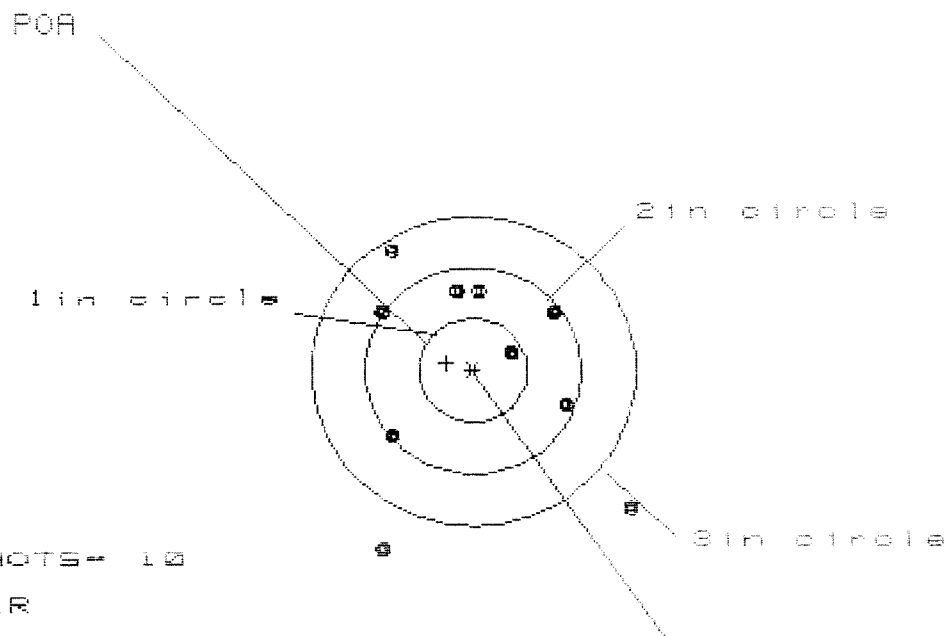
GS = 2.856

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.042
MINIMUM X	-1.526
MAXIMUM Y	.933
MINIMUM Y	-1.386
CENTROID X	-.152
CENTROID Y	-.009
POR TO CENTROID in.	.152
MIN RADIUS	.259
MEAN RADIUS	.793
MAX RADIUS	1.789
HORIZONTAL SPREAD	2.568
VERTICAL SPREAD	2.319
EXTREME SPREAD	2.856
NUMBER IN ONE INCH CIRCLE =	4
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	9

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 6

3 in = 8

HS= 2.281

VS= 2.921

GS= 3.285

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.407	1.310	.888
MINIMUM X	:	-.874	-.938	-.774
MAXIMUM Y	:	1.159	.963	.778
MINIMUM Y	:	-1.762	-1.482	-1.043
CENTROID X	:	.248	.345	.161
CENTROID Y	:	-.070	.126	.311
POA TO CENTROID in.	:	.258	.367	.368
MIN RADIUS	:	.424	.292	.374
MEAN RADIUS	:	1.108	.958	.795
MAX RADIUS	:	1.967	1.978	1.244
HORIZONTAL SPREAD	:	2.281	2.248	1.662
VERTICAL SPREAD	:	2.921	2.445	1.821
EXTREME SPREAD	:	3.285	3.285	2.188
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 10

HS= 2.730

VS= 2.000

GS= 2.900

PATTERN #	:	5
SHOTS (BEST OF)	:	10
MAXIMUM X	:	1.391
MINIMUM X	:	-1.339
MAXIMUM Y	:	1.256
MINIMUM Y	:	-1.752
CENTROID X	:	.078
CENTROID Y	:	-.247
POA TO CENTROID in.	:	.259
MIN RADIUS	:	.460
MEAN RADIUS	:	.955
MAX RADIUS	:	1.477
HORIZONTAL SPREAD	:	2.730
VERTICAL SPREAD	:	2.000
EXTREME SPREAD	:	2.900
NUMBER IN ONE INCH CIRCLE	=	1
NUMBER IN TWO INCH CIRCLE	=	6
NUMBER IN THREE INCH CIRCLE	=	10