

C66361B2

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.





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

MODEL 700TM M24

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

20

SERIAL NO. C6636182
ORDER NO. 5716



5716 C6636182



Stock
Refused

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636182

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 30 91		Rw
600	Proof	4 30 91		Rw
607	Check Headspace	4 30 91		Rw
610	Dis-assemble Gun	4 30 91		Rw
612	Magnaflux Barrel Action	5 6 91		Kcd
	Magnaflux Bolt	5 6 91		Kcd
615	Rollmark Caliber	5 6 91		GB
617	Drill and Tap Sight Holes	5 10 91		FB
618	Polish Barrel	5 10 91		WB
620	Apply Coatings (Barrel Action)		5/30/91	FB
	Apply Coating (Bolt)		5/30/91	FB
625	Final Assembly A) Clean inside of Bolt Assembly		5/30/91	Rw
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/91	Rw
	C) Inspect Ejector Hole for Chamfer		5/30/91	Rw
	D) Oil Firing Pin Ass'y		5/30/91	Rw
	E) Adjust Trigger Pull to Min Setting and Stake		6-10-91	YH

op. #	BARBER - M24 0038647	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			6-10-91	JU
	G) Safety Off Force	4	4	4			6-10-91	JU
	H) Trigger Pull Test & Retainability						6-10-91	JU
	I) Firing Pin Indent	.0215	.0215	.0215			6-10-91	JU
	J) Assemble Stock						6/10/91	RW
	K) Assemble Swivel Studs						6-12-91	K
	L) Attach Front and Rear Sight Assemblies						6/10/91	RW
	M) Iron Sight Alignment						6/10/91	RW
	N) Detach Front & Rear Sights & place in numbered container						6/10/91	RW
	O) Attach Scope to Rifle						6/10/91	RW
	P) Detach & Attach Scope 20 Times						6/10/91	RW
640	Gallery Target & Test						6-10-91	NE
	A) Time						"	NE
	B) Malfunctions						"	NE
	C) Pierced Primers						"	NE
	D) Optical Clarity of Scope						"	NE
645	Inspect for Live Ammo						6-10-91	NE
655	Final Inspection							
	A) Headspace						6-12-91	K
	B) Trigger Pull	2.34	2.43	2.27	2.43	2.47	6-12-91	JU
	C) Function						6-12-91	AC
660	Pack						6-20-91	NE

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6636182

DATE 6-10-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.27	2.51	2.49	2.34	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.39	2.49	2.53	2.43	
PULL #3	2.36	2.53	2.38	2.22	
PULL #4	2.45	2.41	2.35	2.43	
PULL #5	2.49	2.38	2.29	2.42	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.39	3.27		
PULL #2	3.38	3.37		
PULL #3	3.47	3.41		
PULL #4	3.42	3.41		
PULL #5	3.38	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	4.31	4.31		4.37
PULL #2	4.21	4.33		4.39
PULL #3	4.42	4.44		4.39
PULL #4	4.26	4.40		4.38
PULL #5	4.35	4.39		4.39
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636182
11 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.321624
1 TO	2	.288007
1 TO	3	.129356
1 TO	4	.426691
1 TO	5	.0891067

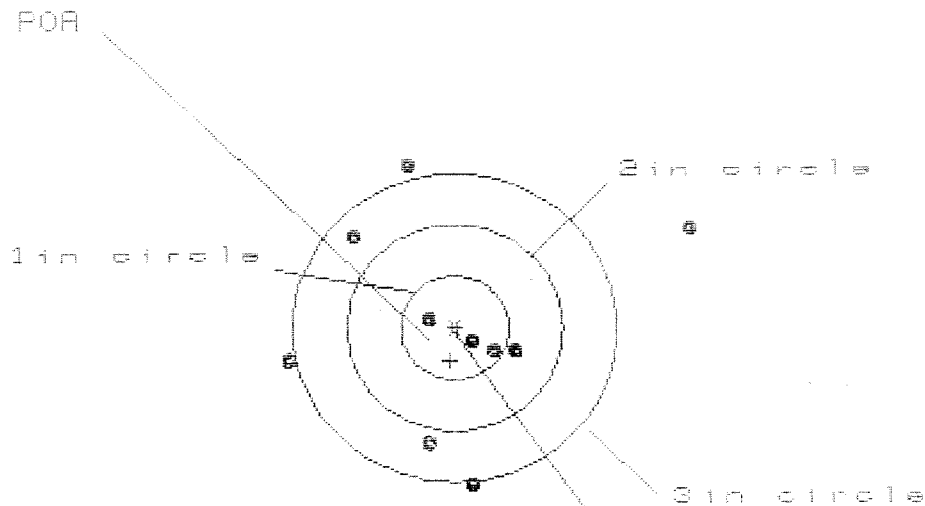
-----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .08
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1504
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .170353
THE AMR FOR THIS RIFLE IS: .9442

10 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/066361B2

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 3

2in = 4

3in = 6

HS= 3.710

VS= 3.151

GS= 3.952

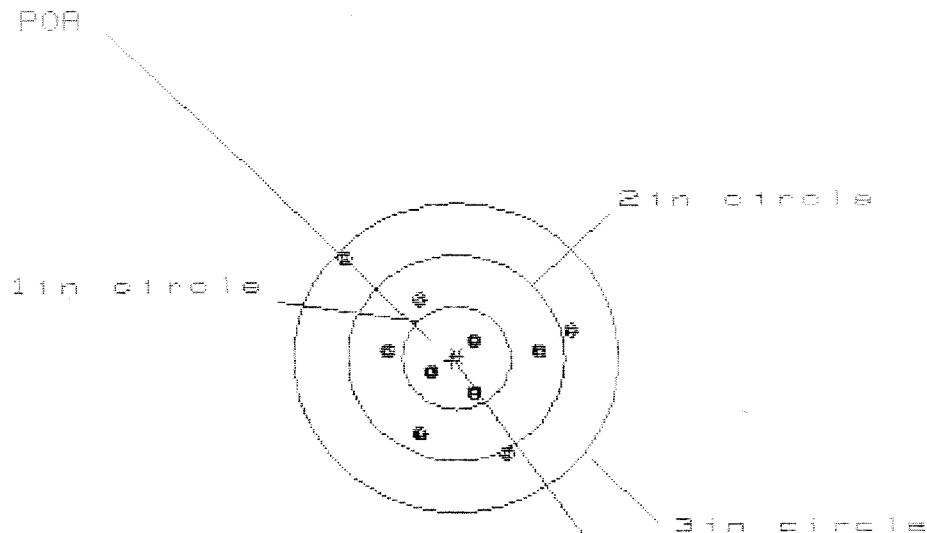
CENTROID #

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.195	.785	.755
MINIMUM X	-1.515	-1.271	-1.301
MAXIMUM Y	1.607	1.719	1.178
MINIMUM Y	-1.544	-1.432	-1.217
CENTROID X	.041	-.203	-.173
CENTROID Y	.319	.207	-.008
POA TO CENTROID in.	.321	.290	.173
MIN RADIUS	.152	.205	.396
MEAN RADIUS	1.100	.966	.864
MAX RADIUS	2.415	1.736	1.398
HORIZONTAL SPREAD	3.710	2.056	2.056
VERTICAL SPREAD	3.151	3.151	2.395
EXTREME SPREAD	3.952	3.214	2.644
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	6		

18 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/066361B2

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 2.091

VS= 1.907

GS= 2.413

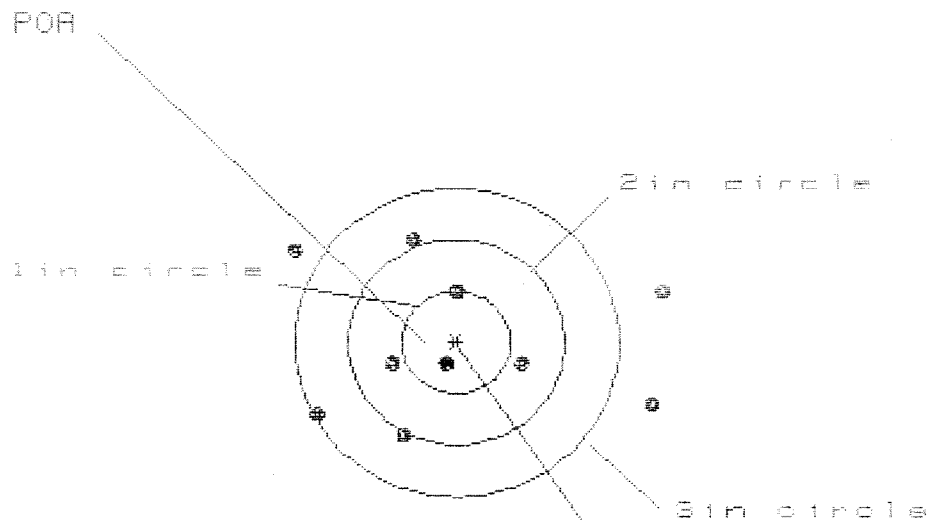
CENTROID #

PATTERN #	2		
SHOTS (BEST OF)	10	9	9
MAXIMUM X	1.045	.929	.805
MINIMUM X	-1.046	-.788	-.672
MAXIMUM Y	.943	.699	.746
MINIMUM Y	-.964	-.859	-.812
CENTROID X	.039	.155	.039
CENTROID Y	.031	-.074	-.121
POR TO CENTROID in.	.049	.172	.127
MIN RADIUS	.230	.281	.288
MEAN RADIUS	.744	.663	.608
MAX RADIUS	1.408	1.003	.920
HORIZONTAL SPREAD	2.091	1.717	1.477
VERTICAL SPREAD	1.907	1.558	1.558
EXTREME SPREAD	2.413	1.730	1.730
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

18 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6869102

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 7

HS= 3.437

VS= 1.930

GS= 3.655

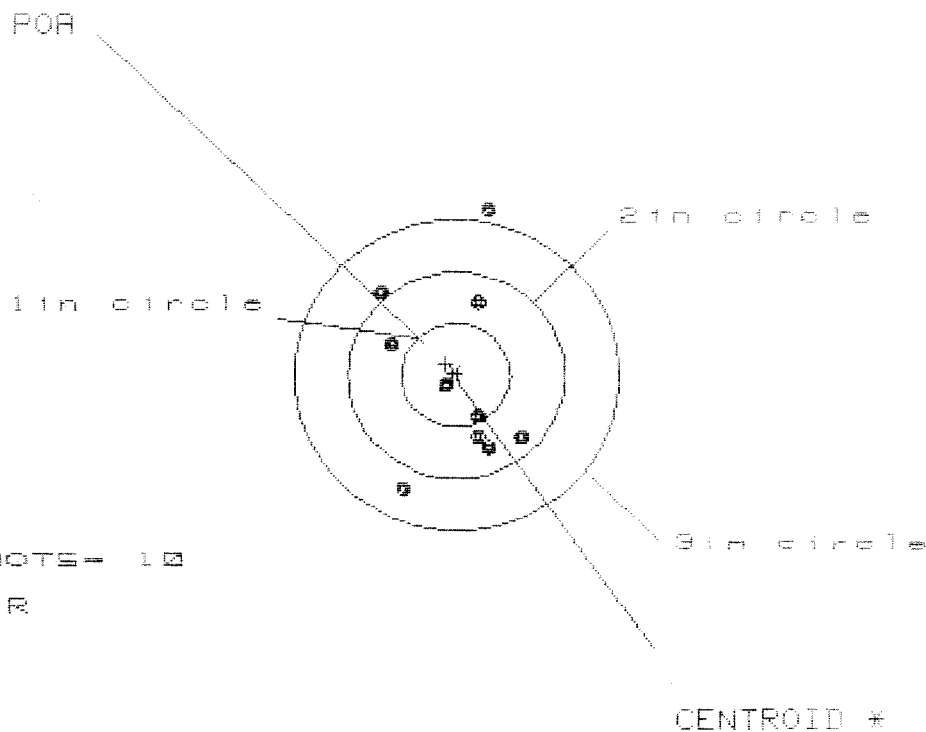
CENTROID *

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.951	2.058	1.076
MINIMUM X	-1.486	-1.269	-1.012
MAXIMUM Y	1.004	1.057	.989
MINIMUM Y	-.926	-.873	-.942
CENTROID X	.094	-.123	-.380
CENTROID Y	.201	.148	.217
POA TO CENTROID in.	.222	.193	.438
MIN RADIUS	.262	.193	.273
MEAN RADIUS	1.130	.998	.852
MAX RADIUS	2.009	2.129	1.352
HORIZONTAL SPREAD	3.437	3.327	2.088
VERTICAL SPREAD	1.930	1.930	1.930
EXTREME SPREAD	3.655	3.655	2.384
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		7	

10 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636182

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 9

HS = 1.262

VS = 2.668

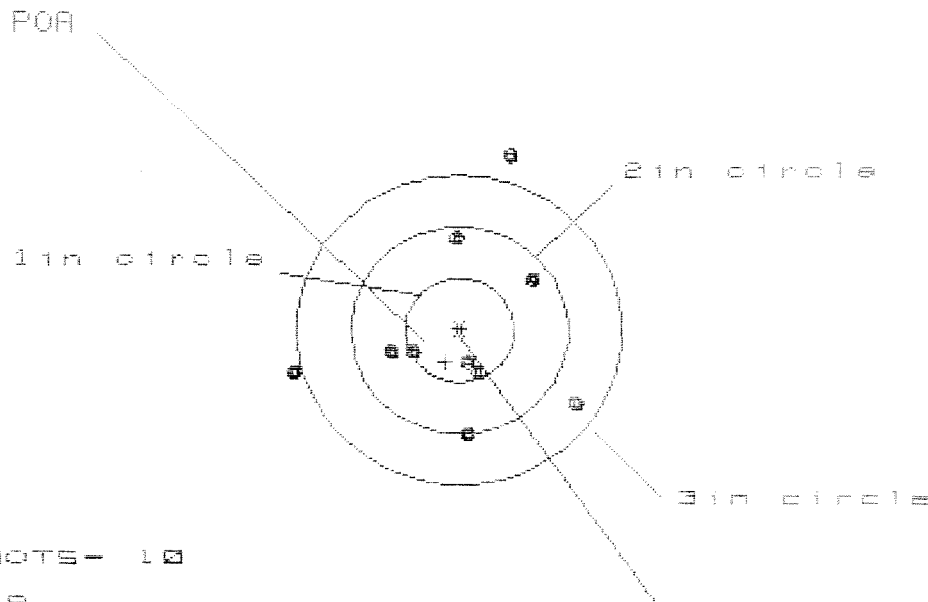
GS = 2.772

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.558	.591	.538
MINIMUM X	:	-.704	-.671	-.724
MAXIMUM Y	:	1.600	.999	.888
MINIMUM Y	:	-1.068	-.890	-.656
CENTROID X	:	.097	.064	.117
CENTROID Y	:	-.104	-.282	-.171
POA TO CENTROID in.	:	.142	.289	.207
MIN RADIUS	:	.129	.113	.119
MEAN RADIUS	:	.802	.677	.641
MAX RADIUS	:	1.627	1.203	1.146
HORIZONTAL SPREAD	:	1.262	1.262	1.262
VERTICAL SPREAD	:	2.668	1.889	1.544
EXTREME SPREAD	:	2.772	1.905	1.879
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			9	

18 Jun 1981

FILE:/PATTERNING/CENTERFIRE_PATT/CAB36162

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 8

HS= 2.554

VS= 2.665

GS= 2.918

CENTROID #

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.062	1.116	.936
MINIMUM X	-1.492	-1.438	-.798
MAXIMUM Y	1.690	1.127	1.094
MINIMUM Y	-.975	-.787	-.820
CENTROID X	.129	.075	.255
CENTROID Y	.305	.117	.150
POA TO CENTROID in.	.331	.139	.295
MIN RADIUS	.204	.185	.104
MEAN RADIUS	.915	.782	.685
MAX RADIUS	1.760	1.462	1.100
HORIZONTAL SPREAD	2.554	2.554	1.734
VERTICAL SPREAD	2.665	1.914	1.914
EXTREME SPREAD	2.918	2.563	1.923
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	