

C6348727

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348727

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10-9	89	RW
600	Proof	10-9	89	RW
607	Check Headspace	10-9	89	RW
610	Dis-assemble Gun	10-9	89	RW
612	Magnaflux Barrel Action	REJECTED	11/2/89	KCR
	Magnaflux Bolt		11/2/89	KCR
615	Rollmark Caliber			
7	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake			

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

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348727

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	11-8	89	RW
600	Proof	11-8	89	RW
607	Check Headspace	11-8	89	RW
610	Dis-assemble Gun	11-8	89	RW
612	Magnaflux Barrel Action	11-9-89		KCR
	Magnaflux Bolt	11-9-89		KCR
615	Rollmark Caliber			
617	Drill and Tap Sight Holes	11 9	89	FB
618	Polish Barrel RB	11 9	89	BT
620	Apply Coatings (Barrel Action)		11-11-89	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/27/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/27/89	RW
	C) Inspect Ejector Hole for Chamfer		11/27/89	RW
	D) Oil Firing Pin Ass'y		11/27/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5 Dec 89	JS

BARBER - M24 0062459

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5 Dec 89	928
	G) Safety Off Force	3	3	3			5 Dec 89	928
	H) Trigger Pull Test & Retainability						5 Dec 89	928
	I) Firing Pin Indent	.0225	.0225	.0225			5 Dec 89	928
	J) Assemble Stock						12/8/89	RW
	K) Assemble Swivel Studs						8 Dec 89	928
	L) Attach Front and Rear Sight Assemblies						12/8/89	RW
	M) Iron Sight Alignment						12/8/89	RW
	N) Detach Front & Rear Sights & place in numbered container						12/8/89	RW
	O) Attach Scope to Rifle						8 Dec 89	928
	P) Detach & Attach Scope 20 Times						8 Dec 89	928
640	Gallery Target & Test						12-8-89	A
	A) Time						12-8-89	A
	B) Malfunctions						12-8-89	A
	C) Pierced Primers						12-8-89	A
	D) Optical Clarity of Scope						12-8-89	A
645	Inspect for Live Ammo						12-8-89	A
655	Final Inspection						8 Dec 89	928
	A) Headspace						8 Dec 89	928
	B) Trigger Pull	250	244	246	243	245	8 Dec 89	928
	C) Function						8 Dec 89	928
660	Pack						15 Dec 89	928

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. CG348727

DATE 13 Mar 90

TESTER QSS

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.47	2.32		2.21	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.46	2.40		2.41	
PULL #3	2.36	2.41		2.32	
PULL #4	2.46	2.41		2.39	
PULL #5	2.43	2.36		2.31	
TOTAL	12.18	11.90			
AVG.	2.436	2.38			

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	2.83	2.96		
PULL #2	2.95	2.97		
PULL #3	2.99	2.90		
PULL #4	2.96	2.93		
PULL #5	3.04	2.96		
TOTAL	14.77	14.72		
AVG.	2.954	2.944		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.00	3.86		
PULL #2	3.92	3.94		
PULL #3	3.94	3.86		
PULL #4	3.91	3.83		
PULL #5	3.92	3.85		
TOTAL	19.69	19.34		
AVG.	3.938	3.868		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348727
8 Dec 1989

CENTROIDAL DISTANCES

0 TO	1	.524023
1 TO	2	.386456
1 TO	3	.625374
1 TO	4	.646803
1 TO	5	.549102

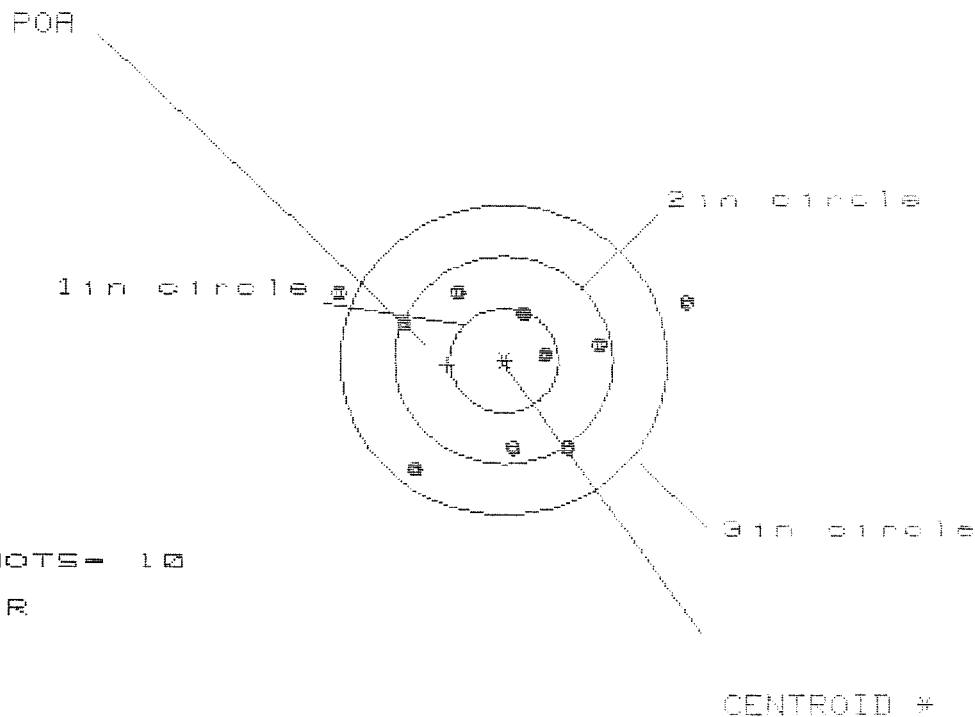
平均: (----)FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0914
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0918
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .129542
THE AMR FOR THIS RIFLE IS: .961

8 Dec 1989

FILE:/PATTERNING/CENTERFIRE_PATT/068348727

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 8

HS= 3.121

VS= 1.763

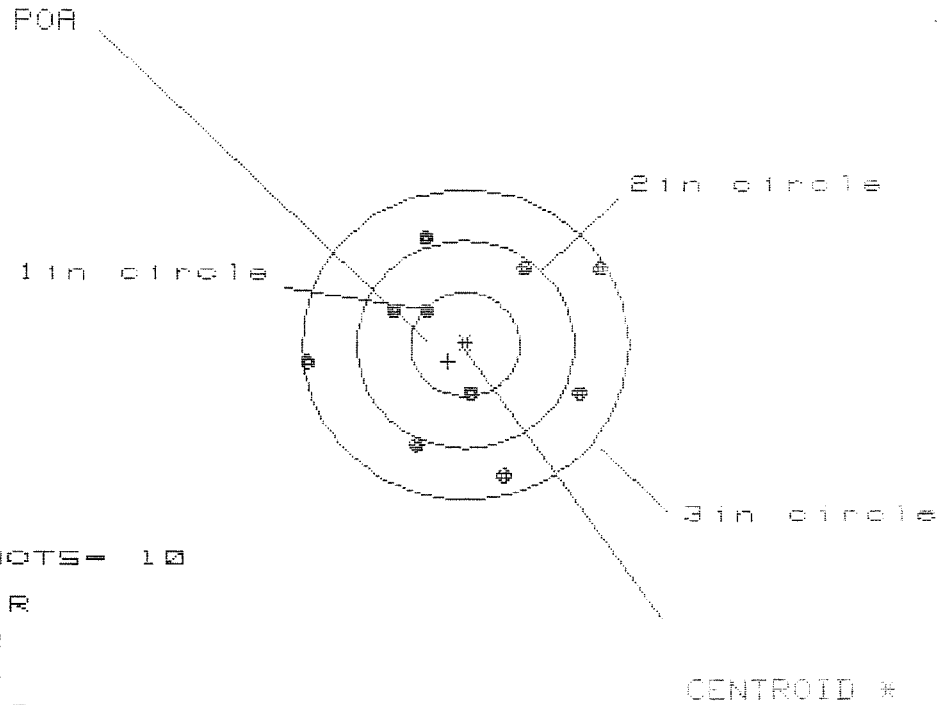
GS= 3.123

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.634	1.028	.865
MINIMUM X	:	-1.487	-1.306	-.862
MAXIMUM Y	:	.696	.757	.847
MINIMUM Y	:	-1.067	-1.006	-.916
CENTROID X	:	.522	.341	.504
CENTROID Y	:	.046	-.015	-.105
POA TO CENTROID in.	:	.525	.341	.515
MIN RADIUS	:	.395	.574	.445
MEAN RADIUS	:	1.001	.931	.837
MAX RADIUS	:	1.724	1.490	1.194
HORIZONTAL SPREAD	:	3.121	2.334	1.727
VERTICAL SPREAD	:	1.763	1.763	1.763
EXTREME SPREAD	:	3.123	2.523	2.024
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	8		

8 Dec 1989

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 10

HS= 2.685

VS= 2.216

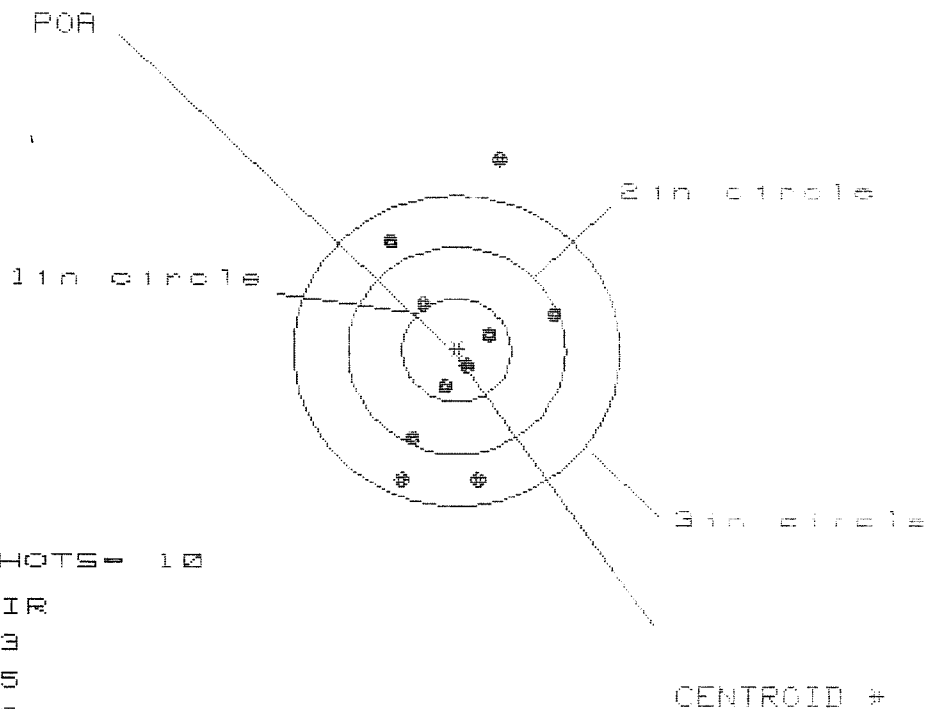
GS= 2.838

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.204	1.039	1.044
MINIMUM X	:	-1.481	-1.794	-1.664
MAXIMUM Y	:	.990	.970	1.060
MINIMUM Y	:	-1.226	-1.246	-1.156
CENTROID X	:	.154	.319	.189
CENTROID Y	:	.164	.184	.094
POA TO CENTROID in.	:	.225	.368	.211
MIN RADIUS	:	.446	.490	.377
MEAN RADIUS	:	1.003	.952	.892
MAX RADIUS	:	1.492	1.266	1.209
HORIZONTAL SPREAD	:	2.685	1.833	1.708
VERTICAL SPREAD	:	2.216	2.216	2.216
EXTREME SPREAD	:	2.838	2.368	2.329
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			4	
NUMBER IN THREE INCH CIRCLE =			10	

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 5

3 in = 9

HS= 1.519

VS= 3.141

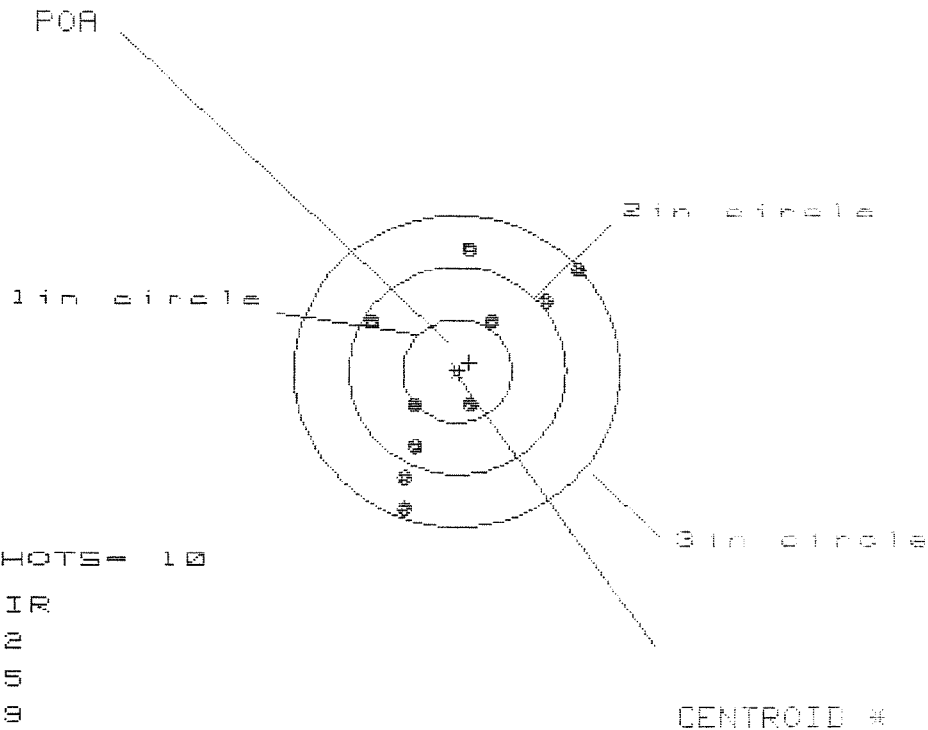
GS= 3.233

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.933	.982	.923
MINIMUM X	:	-.586	-.537	-.596
MAXIMUM Y	:	1.848	1.253	1.123
MINIMUM Y	:	-1.293	-1.088	-1.218
CENTROID X	:	-.095	-.144	-.086
CENTROID Y	:	.148	-.058	.072
POA TO CENTROID in.	:	.175	.155	.112
MIN RADIUS	:	.158	.144	.092
MEAN RADIUS	:	.915	.783	.729
MAX RADIUS	:	1.900	1.363	1.271
HORIZONTAL SPREAD	:	1.519	1.519	1.519
VERTICAL SPREAD	:	3.141	2.341	2.341
EXTREME SPREAD	:	3.233	2.456	2.456
NUMBER IN ONE INCH CIRCLE =	:	3		
NUMBER IN TWO INCH CIRCLE =	:	5		
NUMBER IN THREE INCH CIRCLE =	:	9		

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS= 1.934

VS= 2.453

GS= 2.860

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.147	.933	.885
MINIMUM X	:	-.787	-.659	-.707
MAXIMUM Y	:	1.131	1.243	1.092
MINIMUM Y	:	-1.322	-1.210	-1.038
CENTROID X	:	-.113	-.241	-.194
CENTROID Y	:	-.077	-.189	-.033
POA TO CENTROID in.	:	.137	.306	.197
MIN RADIUS	:	.377	.294	.437
MEAN RADIUS	:	.946	.855	.813
MAX RADIUS	:	1.529	1.274	1.116
HORIZONTAL SPREAD	:	1.934	1.592	1.592
VERTICAL SPREAD	:	2.453	2.453	2.130
EXTREME SPREAD	:	2.860	2.540	2.223
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 9

IN CIR

1 in = 0

2 in = 7

3 in = 8

HS= 2.491

VS= 1.916

GS= 2.628

CENTROID #

PATTERN #	:	5	8	7
SHOTS (BEST OF)	:	9	8	7
MAXIMUM X	:	1.349	1.055	.916
MINIMUM X	:	-1.142	-.974	-.849
MAXIMUM Y	:	1.013	.595	.673
MINIMUM Y	:	-.903	-.776	-.691
CENTROID X	:	-.011	-.179	-.040
CENTROID Y	:	.178	.051	-.034
POA TO CENTROID in.	:	.178	.187	.053
MIN RADIUS	:	.530	.405	.537
MEAN RADIUS	:	.940	.820	.766
MAX RADIUS	:	1.687	1.141	.975
HORIZONTAL SPREAD	:	2.491	2.029	1.765
VERTICAL SPREAD	:	1.916	1.371	1.364
EXTREME SPREAD	:	2.628	2.114	1.808
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	8		




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

MODEL 700™ M24

SERIAL NO.
C6348727

ORDER NO.
5716

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

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5716 C6348727

UPC



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