

C6611501

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	SERIAL NO. C6611501
	ORDER NO. 5716

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

46



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6611501**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/13/91	K.S.
600	Proof		3/13/91	K.S.
607	Check Headspace		3/13/91	K.S.
610	Dis-assemble Gun		3/13/91	K.S.
612	Magnaflux Barrel Action		3/27/91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		3/27/91	218
617	Drill and Tap Sight Holes	APR	3 1991	FB
618	Polish Barrel	APR	3 1991	WB
620	Apply Coatings (Barrel Action)		4-18-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/18/91	ICS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/18/91	ICS
	C) Inspect Ejector Hole for Chamfer		4/18/91	ICS
	D) Oil Firing Pin Ass'y		4/18/91	ICS
	E) Adjust Trigger Pull to Min Setting and Stake		4/19/91	JA

op. #	BARBER M24 0077899	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			4-22-91	D/H
	G) Safety Off Force	2 1/4	3	3			4-22-91	D/H
	H) Trigger Pull Test & Retainability						4/19/91	JS
	I) Firing Pin Indent	.022	.022	.022			4-22-91	D/H
	J) Assemble Stock						4/22/91	KS
	K) Assemble Swivel Studs						5-2-91	D/H
	L) Attach Front and Rear Sight Assemblies						4/22/91	KS
	M) Iron Sight Alignment						4/22/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/22/91	KS
	O) Attach Scope to Rifle						4/22/91	KS
	P) Detach & Attach Scope 20 Times						4/22/91	KS
640	Gallery Target & Test						4-23-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						4-23-91	NF
655	Final Inspection							
	A) Headspace						5-2-91	D/H
	B) Trigger Pull	2.65	2.68	2.70	2.70	2.69	4/26/91	JS
	C) Function						5-2-91	D/H
660	Pack						6-17-91	NF

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

SERIAL NO. C-6611501
DATE 4/19/91
TESTER [Signature]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.55	2.46	2.40	2.25	MIN. SETTING
PULL #2	2.51	2.53	2.36	2.68	NO AVG. OF 5
PULL #3	2.55	2.53	2.43	2.70	READINGS ACCEPT-
PULL #4	2.49	2.40	2.44	2.70	ABLE LESS THAN 2#
PULL #5	2.48	2.45	2.48	2.69	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES			COMMENTS
PULL #1	3.51	3.42			
PULL #2	3.23	3.18			
PULL #3	3.45	3.24			
PULL #4	3.52	3.23			
PULL #5	3.52	3.20			
TOTAL					
AVG.					

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.25	4.22		4.19
PULL #2	4.18	4.15		4.19
PULL #3	4.24	4.20		4.27
PULL #4	4.18	4.24		4.21
PULL #5	4.25	4.19		2.20
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611501
23 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.150333
1 TO	2	.070214
1 TO	3	.118431
1 TO	4	.168241
1 TO	5	.258652

#5 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1008
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.038
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .107725
THE AMR FOR THIS RIFLE IS: .9752

23 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611561

CENTERFIRE PATTERNS

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 0

2in = 2

3in = 8

HS = 1.871

VS = 3.354

GS = 3.407

CENTROID #

PATTERN #

1

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.875

.858

.912

MINIMUM X

-.996

-1.013

-.959

MAXIMUM Y

1.511

1.306

1.264

MINIMUM Y

-1.843

-1.433

-1.269

CENTROID X

.126

.143

.089

CENTROID Y

-.082

.123

-.041

POA TO CENTROID in.

.150

.188

.098

MIN RADIUS

.536

.722

.589

MEAN RADIUS

1.215

1.144

1.096

MAX RADIUS

1.849

1.441

1.369

HORIZONTAL SPREAD

1.871

1.871

1.871

VERTICAL SPREAD

3.354

2.739

2.533

EXTREME SPREAD

3.407

2.802

2.377

NUMBER IN ONE INCH CIRCLE =

0

NUMBER IN TWO INCH CIRCLE =

2

NUMBER IN THREE INCH CIRCLE =

8

23 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C861150J

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS = 2.352

VS = 2.663

GS = 2.918

CENTROID #

PATTERN #

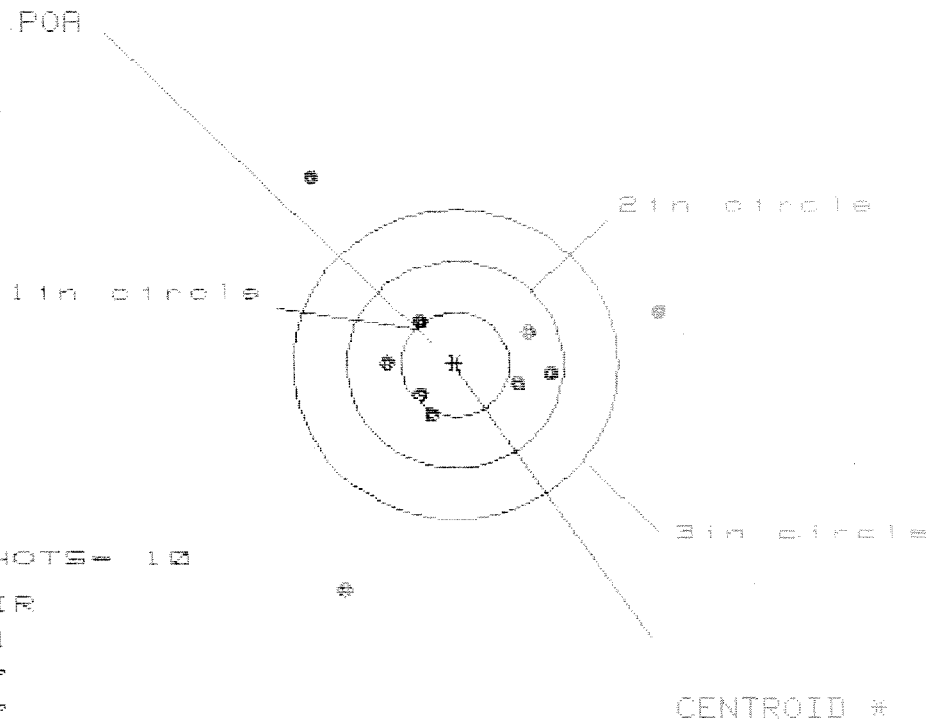
2

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.208	1.081	1.071
MINIMUM X	:	-1.144	-1.177	-1.187
MAXIMUM Y	:	1.564	1.442	.834
MINIMUM Y	:	-1.099	-1.068	-.888
CENTROID X	:	.057	.184	.194
CENTROID Y	:	-.069	.053	-.127
POA TO CENTROID in.	:	.089	.191	.231
MIN RADIUS	:	.315	.397	.288
MEAN RADIUS	:	.984	.919	.821
MAX RADIUS	:	1.586	1.444	1.213
HORIZONTAL SPREAD	:	2.352	2.258	2.256
VERTICAL SPREAD	:	2.663	2.510	1.722
EXTREME SPREAD	:	2.918	2.519	2.289
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

23 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611501

CENTERFIRE PATTERNS # 3

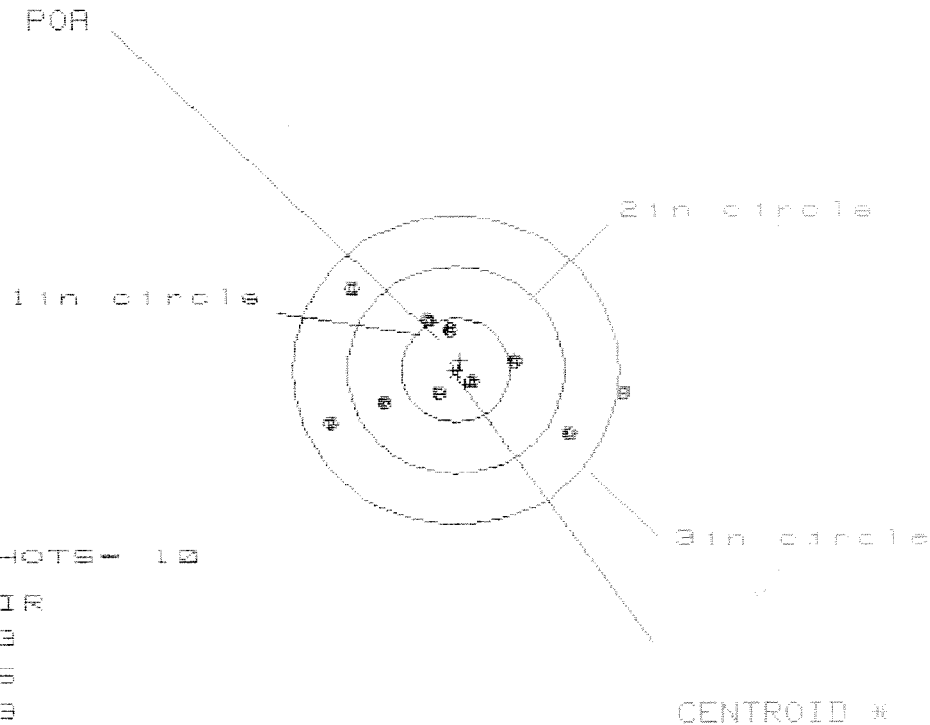


PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.832
MINIMUM X	-1.333
MAXIMUM Y	1.850
MINIMUM Y	-2.134
CENTROID X	.027
CENTROID Y	-.017
POA TO CENTROID in.	.032
MIN RADIUS	.433
MEAN RADIUS	1.101
MAX RADIUS	2.369
HORIZONTAL SPREAD	3.165
VERTICAL SPREAD	3.984
EXTREME SPREAD	3.996
NUMBER IN ONE INCH CIRCLE	1
NUMBER IN TWO INCH CIRCLE	7
NUMBER IN THREE INCH CIRCLE	7

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FILE:/PATTERNING/CENTERFIRE_PATT/C6611581

CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1in = 3

2in = 5

3in = 9

HS = 2.542

VS = 1.384

GS = 2.655

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.512

1.211

1.091

MINIMUM X

-1.130

-.962

-.868

MAXIMUM Y

.791

.768

.787

MINIMUM Y

-.593

-.616

-.677

CENTROID X

-.042

-.210

-.090

CENTROID Y

-.091

-.068

-.087

POA TO CENTROID in.

.100

.221

.090

MIN RADIUS

.153

.221

.238

MEAN RADIUS

.780

.690

.628

MAX RADIUS

1.526

1.359

1.284

HORIZONTAL SPREAD

2.642

2.173

1.959

VERTICAL SPREAD

1.384

1.384

1.384

EXTREME SPREAD

2.655

2.399

2.399

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

6

NUMBER IN THREE INCH CIRCLE =

9

23 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611501

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 3.010

VS= 1.372

GS= 3.101

CENTROID #

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.200

.999

.490

MINIMUM X

-1.810

-1.233

-1.108

MAXIMUM Y

.657

.615

.656

MINIMUM Y

-.715

-.757

-.716

CENTROID X

.366

.567

.442

CENTROID Y

.069

.111

.070

POA TO CENTROID in.

.372

.577

.447

MIN RADIUS

.329

.152

.254

MEAN RADIUS

.796

.615

.585

MAX RADIUS

1.848

1.447

1.319

HORIZONTAL SPREAD

3.010

2.202

1.598

VERTICAL SPREAD

1.372

1.372

1.372

EXTREME SPREAD

3.101

2.481

1.832

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

7

NUMBER IN THREE INCH CIRCLE =

9