

C6611578

MODEL 700™ M24

Model **SMS**™

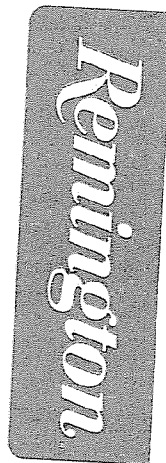
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



 		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700TM H24		SERIAL NO. C6611578
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		ORDER NO. 5716



5716 C6611578

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611578

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 28	91	RW
600	Proof	3 28	91	RW
607	Check Headspace	3 28	91	RW
610	Dis-assemble Gun	3 28	91	RW
612	Magnaflux Barrel Action	APR 2 1991		KR
	Magnaflux Bolt	APR 2 1991		"
615	Rollmark Caliber	APR 2 1991		YS
617	Drill and Tap Sight Holes	APR 5 1991		LB
618	Polish Barrel	APR 5 1991		WB
620	Apply Coatings (Barrel Action)		4/6/91	AS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/10/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/10/91	RW
	C) Inspect Ejector Hole for Chamfer		4/10/91	RW
	D) Oil Firing Pin Ass'y		4/10/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4/12/91	SL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6 1/2	6 1/2	6			4-15-91	D/H
	G) Safety Off Force	3 1/2	4	4			4-15-91	D/H
	H) Trigger Pull Test & Retainability						4/12/91	RM
	I) Firing Pin Indent	1.022	1.020	1.021			4-15-91	D/H
	J) Assemble Stock						4/16/91	RW
	K) Assemble Swivel Studs						5-2-91	D/H
	L) Attach Front and Rear Sight Assemblies						4/16/91	RW
	M) Iron Sight Alignment						4/16/91	RW
	N) Detach Front & Rear Sights & place in numbered container						4/16/91	RW
	O) Attach Scope to Rifle						4/16/91	RW
	P) Detach & Attach Scope 20 Times						4/16/91	RW
640	Gallery Target & Test						4/17/91	KS
	A) Time							KS
	B) Malfunctions							KS
	C) Pierced Primers							KS
	D) Optical Clarity of Scope							KS
645	Inspect for Live Ammo						4/17/91	KS
655	Final Inspection							
	A) Headspace						5-2-91	D/H
	B) Trigger Pull	2.26	2.20	2.23	2.24	2.26	4/26/91	RM
	C) Function						5-2-91	D/H
660	Pack						6-18-91	RF

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

SERIAL NO. C6611578DATE 4/12/91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.19	2.35	2.30	2.26	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.19	2.33	2.30	2.20	
PULL #3	2.25	2.32	2.36	2.23	
PULL #4	2.28	2.33	2.38	2.24	
PULL #5	2.27	2.32	2.30	2.26	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.52	3.48		
PULL #2	3.47	3.49		
PULL #3	3.44	3.46		
PULL #4	3.43	3.48		
PULL #5	3.48	3.48		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.28	4.32		4.28
PULL #2	4.28	4.27		4.27
PULL #3	4.19	4.22		4.33
PULL #4	4.27	4.20		4.31
PULL #5	4.26	4.25		4.28
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06611578
17 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.218323
1 TO	2	.486181
1 TO	3	.183883
1 TO	4	.550587
1 TO	5	.158095

45 + <----POB

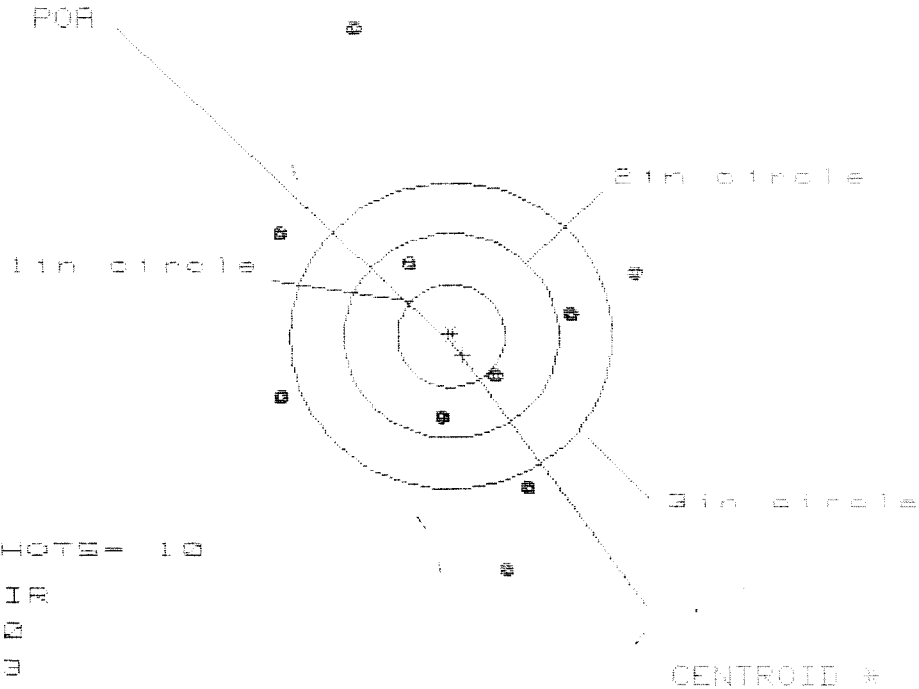
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0002
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0088
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0086021
THE AMR FOR THIS RIFLE IS: 1.243

Re target / Record

12 Apr 1981

FILE:/PATTERNING/CENTERFIRE_PATT/08811578

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 2

2in = 3

3in = 4

HS = 3.256

VS = 5.225

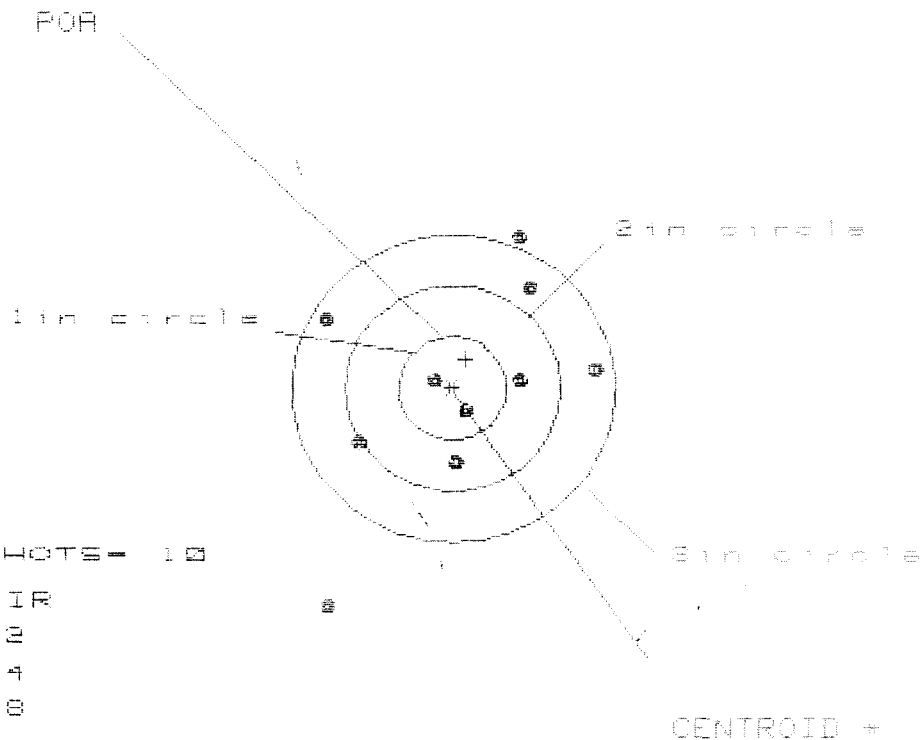
GS = 5.423

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.677	1.575	1.630
MINIMUM X	-1.579	-1.681	-1.626
MAXIMUM Y	2.965	1.353	1.111
MINIMUM Y	-2.260	-1.930	-1.352
CENTROID X	-1.111	-1.009	-1.064
CENTROID Y	.188	-1.142	.100
POR TO CENTROID in.	.218	.142	.118
MIN RADIUS	.602	.348	.509
MEAN RADIUS	1.581	1.350	1.284
MAX RADIUS	3.163	2.143	1.954
HORIZONTAL SPREAD	3.256	3.256	3.256
VERTICAL SPREAD	5.225	3.283	2.463
EXTREME SPREAD	5.423	3.896	3.487
NUMBER IN ONE INCH CIRCLE =	0	0	0
NUMBER IN TWO INCH CIRCLE =	0	3	3
NUMBER IN THREE INCH CIRCLE =	0	4	4

17 Apr 1991

FILE://PATTERNING/CENTERFIRE_PATT/C6511578

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

HS= 2.584

VS= 3.674

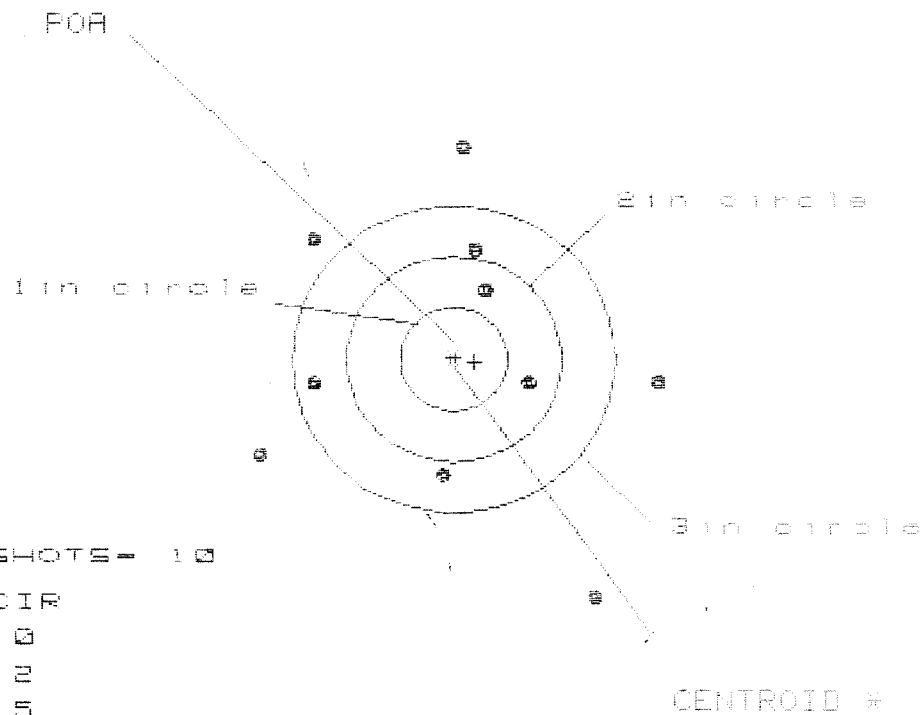
GS= 4.065

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.360	1.233	1.292
MINIMUM X	-1.224	-1.351	-1.292
MAXIMUM Y	1.516	1.276	.925
MINIMUM Y	-2.158	-1.973	-1.813
CENTROID X	-.124	.003	-.056
CENTROID Y	-.278	-.038	-.198
POA TO CENTROID in.	.305	.039	.206
MIN RADIUS	.153	.308	.201
MEAN RADIUS	1.088	.949	.859
MAX RADIUS	2.440	1.424	1.428
HORIZONTAL SPREAD	2.584	2.584	2.584
VERTICAL SPREAD	3.674	2.249	1.738
EXTREME SPREAD	4.065	2.628	2.628
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		8	

17 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CBB11578

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 0

2 in = 2

3 in = 5

IS = 3.692

VS = 4.430

GS = 4.573

PATTERN #	1	3	6
SHOTS (BEST OF)	10	9	6
MAXIMUM X	1.849	1.988	2.019
MINIMUM X	-1.849	-1.704	-1.673
MAXIMUM Y	2.113	1.856	1.138
MINIMUM Y	-2.317	-1.372	-1.140
CENTROID X	-1.198	-1.337	-1.368
CENTROID Y	.028	.283	.051
FOR TO CENTROID in.	.200	.440	.372
MIN RADIUS	.746	.617	.812
MEAN RADIUS	1.541	1.394	1.334
MAX RADIUS	2.631	2.063	2.040
HORIZONTAL SPREAD	3.692	3.692	3.692
VERTICAL SPREAD	4.430	3.228	2.278
EXTREME SPREAD	4.573	3.748	3.748
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	2	
NUMBER IN THREE INCH CIRCLE	=	5	

17 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06611570

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 6

H0 = 3.9000

V0 = 2.9550

G0 = 4.2000

PATTERN #

:

4

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

2.023

2.045

1.638

MINIMUM X

:

-1.885

-1.661

-1.955

MAXIMUM Y

:

1.404

1.079

1.113

MINIMUM Y

:

-1.554

-1.398

-1.364

CENTROID X

:

.400

.176

.303

CENTROID Y

:

-.017

-.173

-.267

POA TO CENTROID in.

:

.401

.246

.436

MIN RADIUS

:

.225

.281

.177

MEAN RADIUS

:

1.169

1.005

.901

MAX RADIUS

:

2.462

2.047

1.838

HORIZONTAL SPREAD

:

3.908

3.706

2.793

VERTICAL SPREAD

:

2.958

2.477

2.477

EXTREME SPREAD

:

4.209

3.722

3.094

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

5

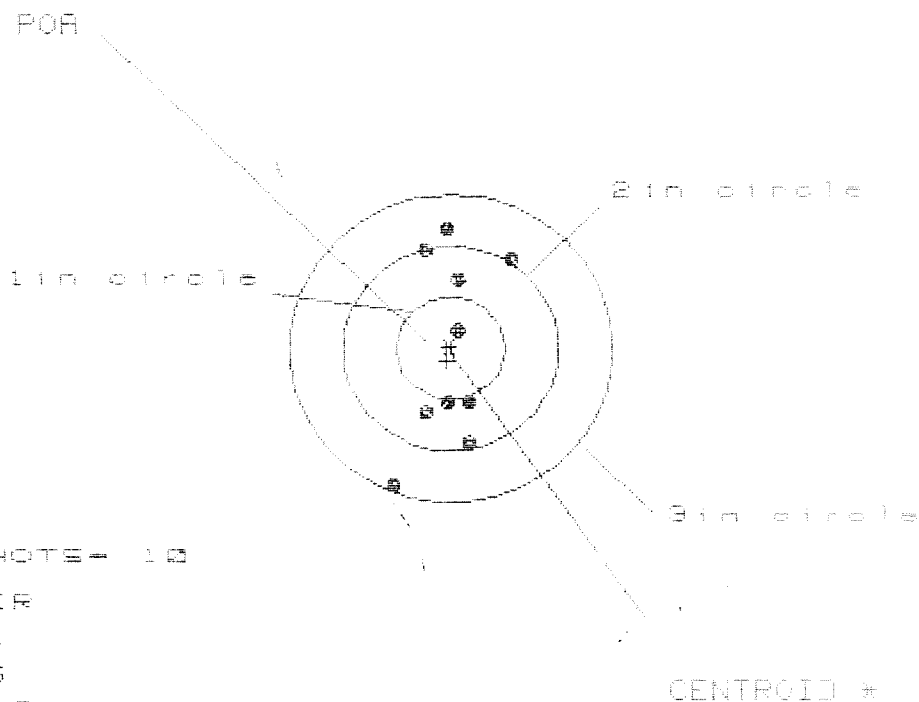
NUMBER IN THREE INCH CIRCLE =

6

17 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66115P8

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1in = 1

2in = 6

3in = 10

HS = 1.152

VS = 2.488

GS = 2.543

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.586	.523	.510
MINIMUM X	-.567	-.299	-.312
MAXIMUM Y	1.206	1.063	.968
MINIMUM Y	-1.282	-1.083	-.950
CENTROID X	.034	.097	.110
CENTROID Y	.125	.268	.135
POB TO CENTROID in.	.130	.285	.174
MIN RADIUS	.219	.073	.206
MEAN RADIUS	.836	.757	.716
MAX RADIUS	1.402	1.084	1.017
HORIZONTAL SPREAD	1.153	.822	.822
VERTICAL SPREAD	2.488	2.146	1.918
EXTREME SPREAD	2.543	2.152	1.950
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06611578
23 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.164924
1 TO	2	.212664
1 TO	3	.312128
1 TO	4	.308341
1 TO	5	.420171

548 4-11-91 POR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1836
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1442
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .233456
THE AMR FOR THIS RIFLE IS: .9166

23 Apr 1981

FILE:/PATTERNING/CENTERFIRE_PAT/06811578.1

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS = 3.185

VS = 2.169

GS = 3.337

CENTROID +

PATTERN #

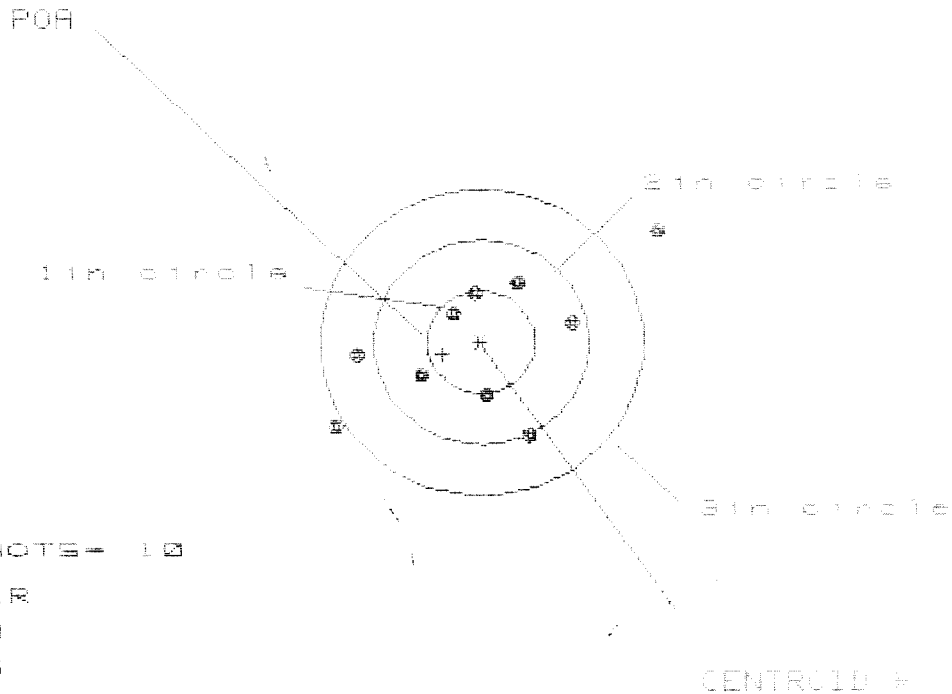
1

	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.943	1.651	1.162
MINIMUM X	-1.242	-1.026	-0.826
MAXIMUM Y	.879	.959	.929
MINIMUM Y	-1.298	-1.210	-1.240
CENTROID X	.160	-.056	-.262
CENTROID Y	.040	-.040	-.010
POA TO CENTROID in.	.165	.069	.262
MIN RADIUS	.336	.135	.092
MEAN RADIUS	1.095	.931	.789
MAX RADIUS	2.073	1.669	1.241
HORIZONTAL SPREAD	3.185	2.677	1.982
VERTICAL SPREAD	2.169	2.169	2.169
EXTREME SPREAD	3.337	2.678	2.196
NUMBER IN ONE INCH CIRCLE	=	1	
NUMBER IN TWO INCH CIRCLE	=	4	
NUMBER IN THREE INCH CIRCLE	=	9	

23 Apr 1981

FILE:/PATTERNING/CENTERFIRE_PATT/08611578.1

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 8

HS= 2.959

VS= 2.051

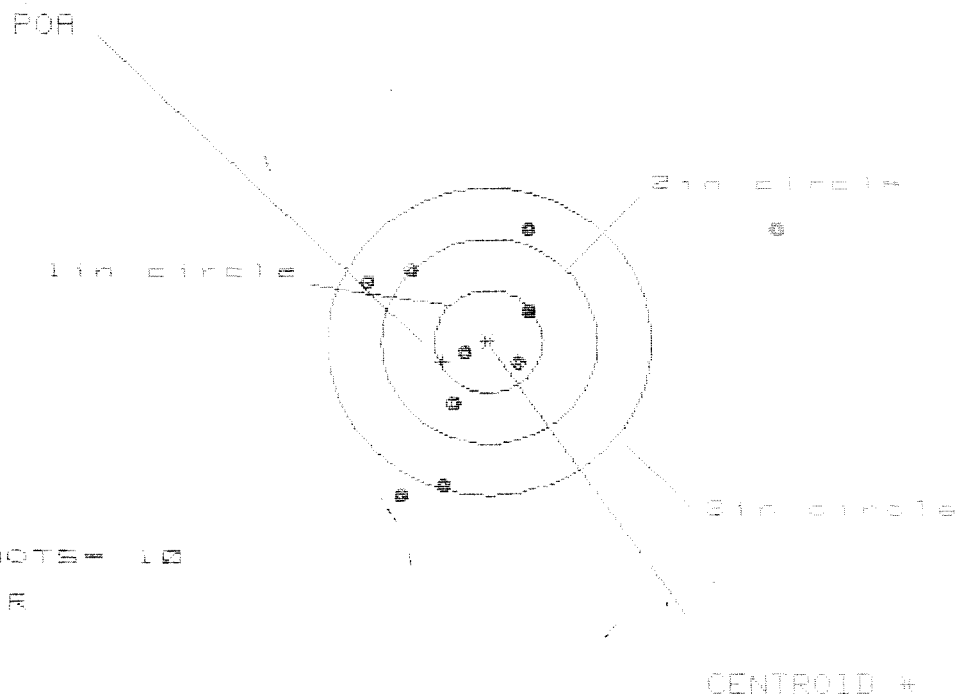
GS= 3.499

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.631	1.015	.872
MINIMUM X	-1.328	-1.147	-1.090
MAXIMUM Y	1.097	.738	.657
MINIMUM Y	-.954	-.832	-.913
CENTROID X	.359	.178	.321
CENTROID Y	.115	-.007	.074
POA TO CENTROID in.	.377	.178	.300
MIN RADIUS	.397	.386	.412
MEAN RADIUS	.915	.787	.707
MAX RADIUS	1.966	1.318	1.092
HORIZONTAL SPREAD	2.959	2.162	1.962
VERTICAL SPREAD	2.051	1.570	1.676
EXTREME SPREAD	3.499	2.352	1.980
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

23 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CAB11578.1

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 4

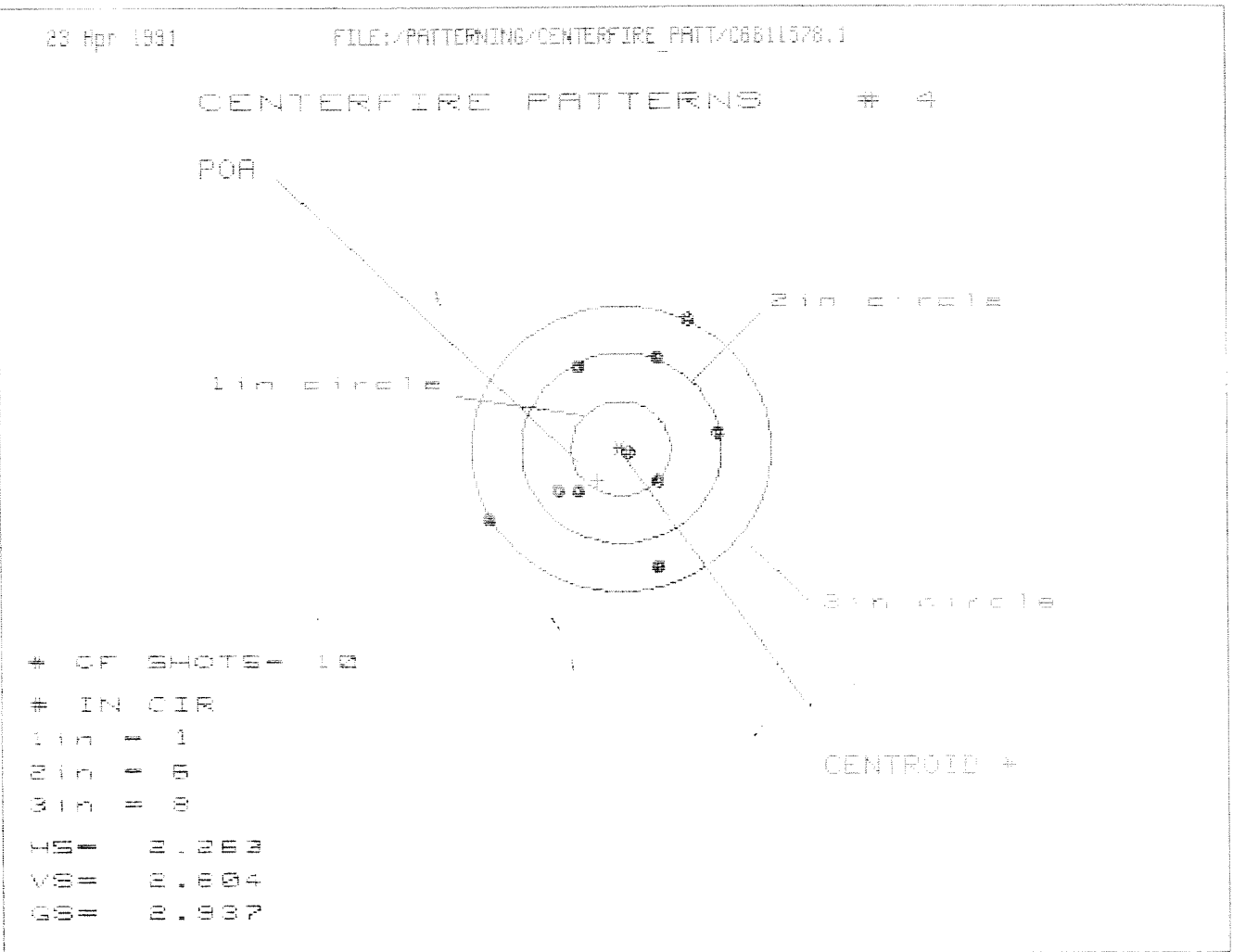
3 in = 3

HS = 3.850

VS = 2.553

GS = 4.400

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.710	.670	.599
MINIMUM X	-1.140	-.839	-.910
MAXIMUM Y	1.084	1.176	1.000
MINIMUM Y	-1.469	-1.349	-1.466
CENTROID X	.428	.127	.198
CENTROID Y	.200	.080	.240
POR TO CENTROID in.	.472	.150	.318
MIN RADIUS	.260	.070	.174
MEAN RADIUS	1.131	.903	.827
MAX RADIUS	2.919	1.465	1.474
HORIZONTAL SPREAD	3.850	1.509	1.509
VERTICAL SPREAD	2.553	2.525	2.473
EXTREME SPREAD	4.400	2.804	2.581
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		8	



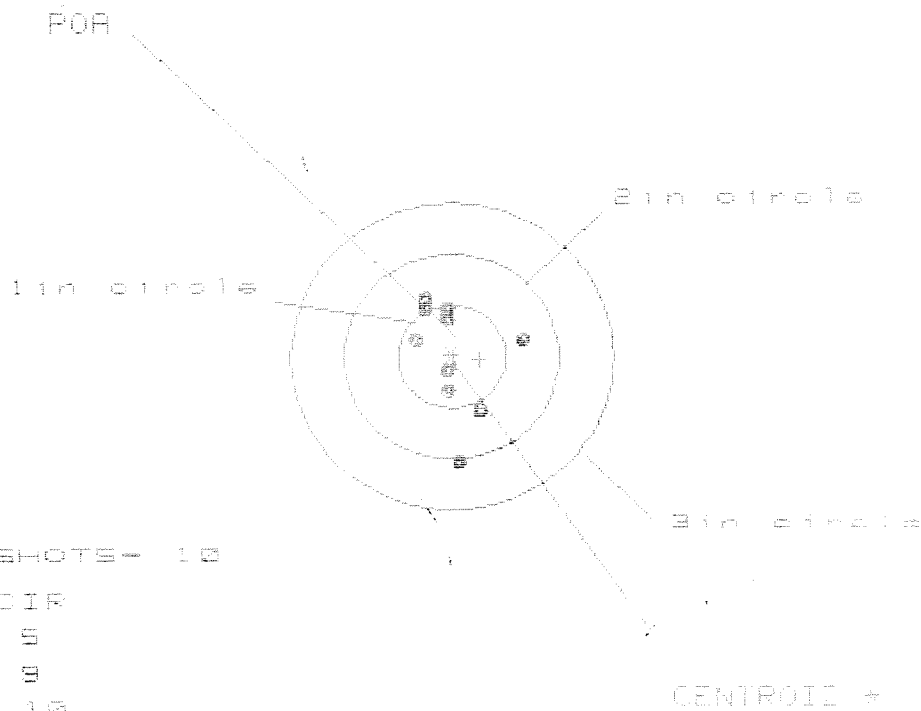
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.931	.783	.852
MINIMUM X	-1.332	-1.801	-1.732
MAXIMUM Y	1.338	1.252	1.030
MINIMUM Y	-1.266	-1.352	-1.196
CENTROID X	.231	.379	.310
CENTROID Y	.338	.424	.267
POA TO CENTROID IN.	.439	.569	.409
MIN RADIUS	.086	.127	.048
MEAN RADIUS	.928	.858	.764
MAX RADIUS	1.543	1.370	1.227
HORIZONTAL SPREAD	2.263	1.584	1.584
VERTICAL SPREAD	2.604	2.604	2.236
EXTREME SPREAD	2.937	2.627	2.263
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

23 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/0861(578.1)

CENTERFIRE PATTERNS

5



+ OF SHOTS- 10

IN CIR

1 in = 5

2 in = 8

3 in = 10

HM = 1.984

VM = 1.604

GM = 1.636

CENTROID +

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.648	.657	.328
MINIMUM X	:	-.836	-.327	-.245
MAXIMUM Y	:	.555	.439	.443
MINIMUM Y	:	-1.049	-.690	-.686
CENTROID X	:	-.260	-.269	-.351
CENTROID Y	:	.028	.144	.140
POA TO CENTROID in.	:	.262	.305	.378
MIN RADIUS	:	.121	.214	.215
MEAN RADIUS	:	.514	.437	.386
MAX RADIUS	:	1.952	.733	.761
HORIZONTAL SPREAD	:	.984	.984	.574
VERTICAL SPREAD	:	1.604	1.129	1.129
EXTREME SPREAD	:	1.636	1.228	1.228
NUMBER IN ONE INCH CIRCLE	=	5		
NUMBER IN TWO INCH CIRCLE	=	9		
NUMBER IN THREE INCH CIRCLE	=	10		