

C6611628

MODEL 700™ M24

Model **S&S**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Smead

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



REG. U.S. PAT. & TM. OFF.

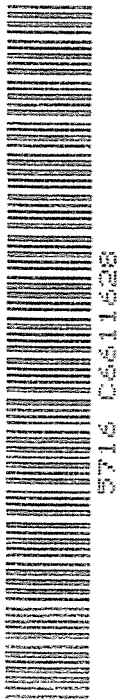
MODEL 700™ M24

SERIAL NO.
C6611628

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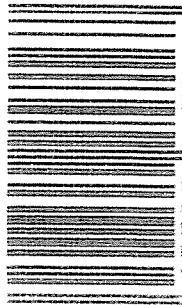
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada. Marque Deposee.

20



5716 C6611628

UPC



0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611628

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 16	91	RW
600	Proof	1 16	91	RW
607	Check Headspace	1 16	91	RW
610	Dis-assemble Gun	1 16	91	RW
612	Magnaflux Barrel Action	1 18	91	KR
	Magnaflux Bolt	1 18	91	KR
615	Rollmark Caliber			GS
617	Drill and Tap Sight Holes	1 24	91	LB
618	Polish Barrel	1 24	91	WB
620	Apply Coatings (Barrel Action)		2-15-91	TA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		2/19/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/19/91	RW
	C) Inspect Ejector Hole for Chamfer		2/19/91	RW
	D) Oil Firing Pin Ass'y		2/19/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		3/2/91	JS

op. #	BARBER - M24 0079823	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			3/4/91	JK
	G) Safety Off Force	3	3	3			3/4/91	JK
	H) Trigger Pull Test & Retainability						3/2/91	JK
	I) Firing Pin Indent	.022	.022	.022			3/4/91	JK
	J) Assemble Stock						3/5/91	RW
	K) Assemble Swivel Studs						3/5/91	RW
	L) Attach Front and Rear Sight Assemblies						3/5/91	RW
	M) Iron Sight Alignment						3/5/91	RW
	N) Detach Front & Rear Sights & place in numbered container						3/5/91	RW
	O) Attach Scope to Rifle						3/5/91	RW
	P) Detach & Attach Scope 20 Times						3/5/91	RW
640	Gallery Target & Test						3-5-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						3-5-91	NF
655	Final Inspection						3-8-91	DA
	A) Headspace							
	B) Trigger Pull	2.51	2.17	2.20	2.19	2.18	3/8/91	JK
	C) Function						3-8-91	DA
660	Pack						3-18-91	NF

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

SERIAL NO. C6611628DATE 3/2/91TESTER [Signature]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.25	2.36	2.25	MIN. SETTING,
PULL #2	2.35	2.22	2.20	NO AVG. OF 5
PULL #3	2.39	2.11	2.19	READINGS ACCEPT-
PULL #4	2.39	2.16	2.20	ABLE, LESS THAN 2#
PULL #5	2.33	2.19	2.20	
TOTAL				
AVG.				

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.42	3.57	
PULL #2	3.45	3.46	
PULL #3	3.39	3.45	
PULL #4	3.47	3.46	
PULL #5	3.43	3.53	
TOTAL			
AVG.			

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.48	4.37		4.34
PULL #2	4.35	4.47		4.35
PULL #3	4.34	4.31		4.41
PULL #4	4.31	4.39		4.45
PULL #5	4.34	4.35		4.42
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611628
6 Mar 1991

CENTROIDAL DISTANCES

0 TO	1	.0923472
1 TO	2	.268091
1 TO	3	.13132
1 TO	4	.117004
1 TO	5	.712973

5 <----POR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1456
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0868
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .16951

THE AME FOR THIS RIFLE IS: .9394

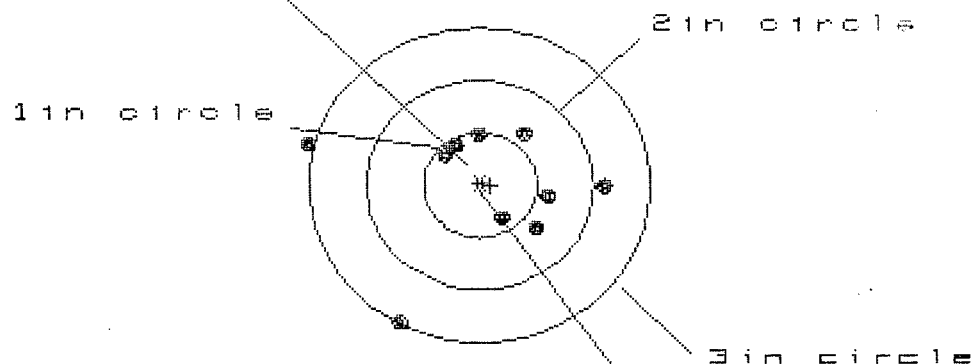
6 Mar 1991

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CENTERFIRE PATTERNS

1

POA



OF SHOTS- 10

IN CIR

1in - 3

2in - 7

3in = 8

HS- 2.563

VS= 1.797

GS= 2.592

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.098	.935	.831
MINIMUM X	-1.465	-.840	-.555
MAXIMUM Y	.518	.563	.409
MINIMUM Y	-1.279	-1.234	-.486
CENTROID X	-.092	.071	.176
CENTROID Y	.008	-.037	.117
POA TO CENTROID in.	.093	.080	.211
MIN RADIUS	.351	.259	.360
MEAN RADIUS	.751	.641	.514
MAX RADIUS	1.521	1.492	.835
HORIZONTAL SPREAD	2.563	1.775	1.386
VERTICAL SPREAD	1.797	1.797	.895
EXTREME SPREAD	2.592	2.201	1.413

6 Mar 1991

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CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 2

2in = 5

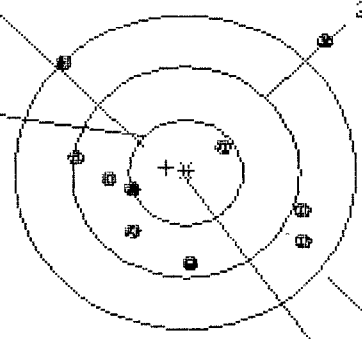
3in = 9

HS= 2.279

VS= 2.084

GS= 2.626

CENTROID *



PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.230	1.183	1.069
MINIMUM X	:	-1.049	-.913	-.991
MAXIMUM Y	:	1.269	1.137	.479
MINIMUM Y	:	-.815	-.674	-.532
CENTROID X	:	.171	.035	.149
CENTROID Y	:	-.044	-.185	-.327
POA TO CENTROID in.:	:	.177	.188	.359
MIN RADIUS	:	.368	.325	.459
MEAN RADIUS	:	.968	.841	.761
MAX RADIUS	:	1.767	1.458	1.097
HORIZONTAL SPREAD	:	2.279	2.096	2.060
VERTICAL SPREAD	:	2.084	1.811	1.011
EXTREME SPREAD	:	2.626	2.626	2.184
NUMBER IN ONE INCH CIRCLE =	:		2	
NUMBER IN TWO INCH CIRCLE =	:		5	
NUMBER IN THREE INCH CIRCLE =	:		9	

6 Mar 1991

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CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 10

HS= 1.936

VS= 1.933

GS= 2.271

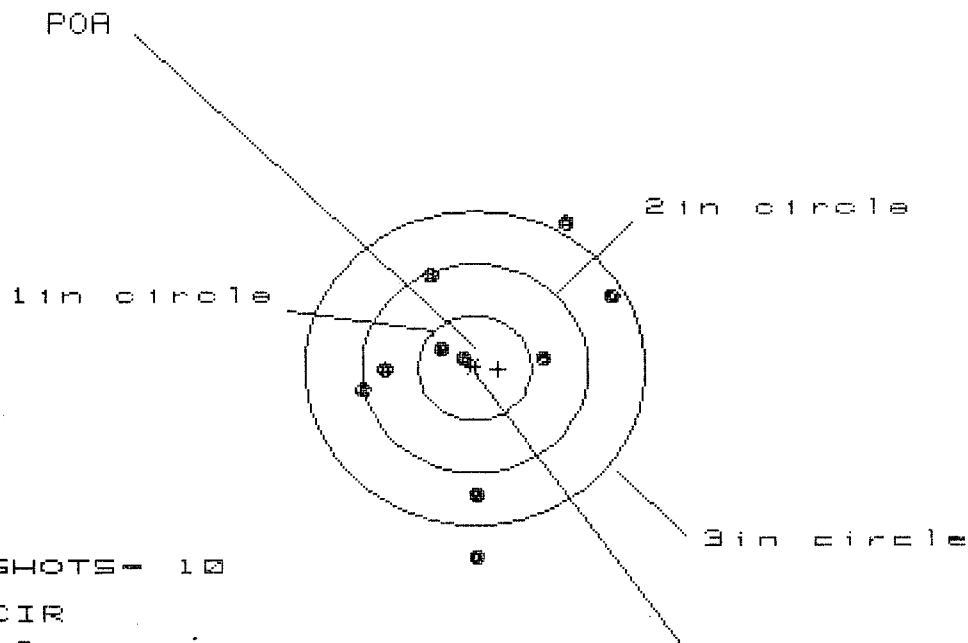
PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.962	.814	.868
MINIMUM X	-.974	-.868	-.814
MAXIMUM Y	.791	.718	.586
MINIMUM Y	-1.142	-1.054	-1.046
CENTROID X	.031	-.075	-.129
CENTROID Y	.054	-.034	.098
POA TO CENTROID in.	.063	.083	.162
MIN RADIUS	.363	.329	.201
MEAN RADIUS	.829	.767	.692
MAX RADIUS	1.245	1.138	1.081
HORIZONTAL SPREAD	1.936	1.682	1.682
VERTICAL SPREAD	1.933	1.772	1.632
EXTREME SPREAD	2.271	1.979	1.908
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

6 Mar 1991

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CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1 in - 2

2 in - 5

3 in - 8

HS- 2.271

VS= 3.160

GS= 3.258

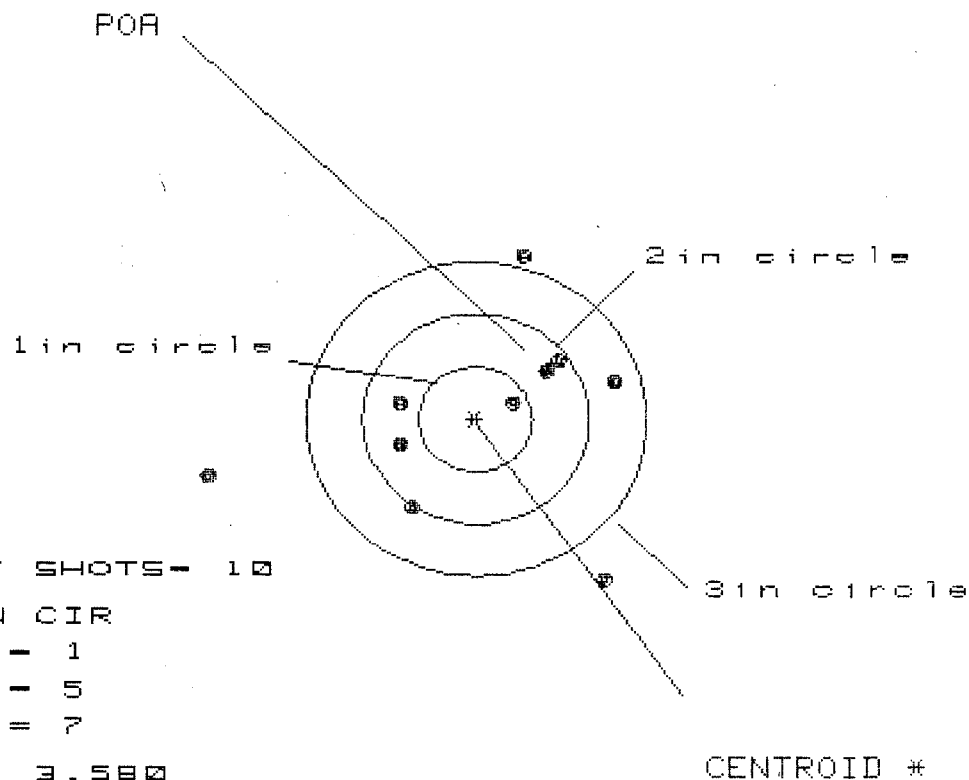
CENTROID *

PATTERN #	:	4
SHOTS (BEST OF)	:	10
MAXIMUM X	:	1.239
MINIMUM X	:	-1.032
MAXIMUM Y	:	1.355
MINIMUM Y	:	-1.805
CENTROID X	:	-.209
CENTROID Y	:	.009
POA TO CENTROID in.	:	.209
MIN RADIUS	:	.177
MEAN RADIUS	:	.997
MAX RADIUS	:	1.805
HORIZONTAL SPREAD	:	2.271
VERTICAL SPREAD	:	3.160
EXTREME SPREAD	:	3.258
NUMBER IN ONE INCH CIRCLE	=	2
NUMBER IN TWO INCH CIRCLE	=	5
NUMBER IN THREE INCH CIRCLE	=	8

6 Mar 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in - 1

2 in - 5

3 in - 7

HS - 3.580

VS - 3.035

GS - 3.683

CENTROID *

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.179	.912	1.022
MINIMUM X	-2.401	-.958	-.848
MAXIMUM Y	1.519	1.460	1.263
MINIMUM Y	-1.516	-1.575	-1.070
CENTROID X	-.629	-.362	-.472
CENTROID Y	-.461	-.402	-.205
POA TO CENTROID in.	.780	.541	.514
MIN RADIUS	.338	.127	.143
MEAN RADIUS	1.152	.960	.832
MAX RADIUS	2.461	1.805	1.303
HORIZONTAL SPREAD	3.580	1.870	1.870
VERTICAL SPREAD	3.035	3.035	2.333
EXTREME SPREAD	3.683	3.115	2.551
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		