

C6611636

MODEL 700™ M24

Model 5145™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.



Smead

 		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700TM H24		SERIAL NO. C6611636
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		ORDER NO. 5716



5716 C6611636



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611636

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	2 1 91	Rw
600	Proof		2 1 91	Rw
607	Check Headspace		2 1 91	Rw
610	Dis-assemble Gun		2 1 91	Rw
612	Magnaflux Barrel Action		2 1 91	WCB
	Magnaflux Bolt		2 1 91	WCB
615	Rollmark Caliber		2 1 91	GS
617	Drill and Tap Sight Holes		2 1 91	FB
618	Polish Barrel <i>ABB</i>		2 1 91	WB
620	Apply Coatings (Barrel Action)		3 12 91	DA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		3/25/91	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		3/25/91	WB
	C) Inspect Ejector Hole for Chamfer		3/25/91	WB
	D) Oil Firing Pin Ass'y		3/25/91	WB
	E) Adjust Trigger Pull to Min Setting and Stake		4/8/91	JA

op. #	BARBER - M24 0079945 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	6	5			4/9/91	SL
	G) Safety Off Force	3	3	3			4/9/91	SL
	H) Trigger Pull Test & Retainability						4/8/91	SL
	I) Firing Pin Indent	.023	.023	.023			4/6/91	SL
	J) Assemble Stock						4/9/91	RW
	K) Assemble Swivel Studs						4-16-91	AC
	L) Attach Front and Rear Sight Assemblies						4/9/91	RW
	M) Iron Sight Alignment						4/9/91	RW
	N) Detach Front & Rear Sights & place in numbered container						4/9/91	RW
	O) Attach Scope to Rifle						4/9/91	RW
	P) Detach & Attach Scope 20 Times						4/9/91	RW
640	Gallery Target & Test						4-9-91	AC
	A) Time						4-9-91	AC
	B) Malfunctions						4-9-91	AC
	C) Pierced Primers						4-9-91	AC
	D) Optical Clarity of Scope						4-9-91	AC
645	Inspect for Live Ammo						4-9-91	AC
655	Final Inspection							
	A) Headspace						4-16-91	AC
	B) Trigger Pull	2.38	2.47	2.51	2.51	2.49	4/16/91	SL
	C) Function						4-16-91	AC
660	Pack						6-18-91	SL

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

SERIAL NO. C 6611636DATE 4/8/94TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.50	2.38	2.50	2.38	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.45	2.33	2.43	2.47	
PULL #3	2.51	2.50	2.40	2.51	
PULL #4	2.56	2.47	2.43	2.51	
PULL #5	2.16	2.53	2.45	2.49	
TOTAL -					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.41	3.53		
PULL #2	3.43	3.22		
PULL #3	3.44	3.33		
PULL #4	3.37	3.31		
PULL #5	3.42	3.30		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.23	4.33		4.44
PULL #2	4.13	4.34		4.43
PULL #3	4.18	4.34		4.23
PULL #4	4.38	4.31		4.44
PULL #5	4.41	4.33		4.45
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611636
9 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.275786
1 TO	2	.172609
1 TO	3	.633242
1 TO	4	.317191
1 TO	5	.112539

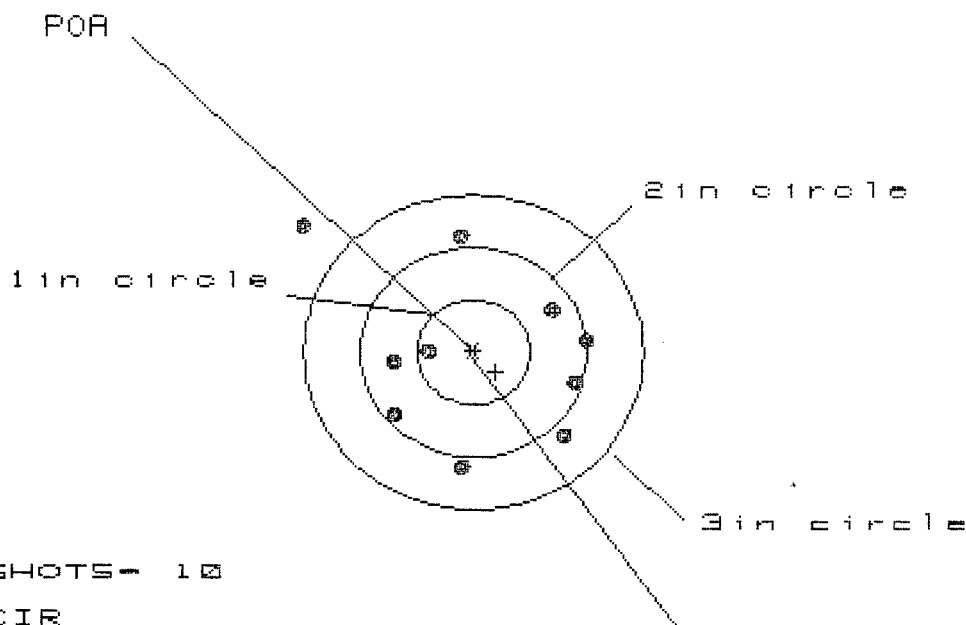
4⁵₂₊₃ <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1664
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1378
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .21605
THE AMP FOR THIS RIFLE IS: .8266

9 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611636

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 6

3 in = 9

HS = 2.457

VS = 2.300

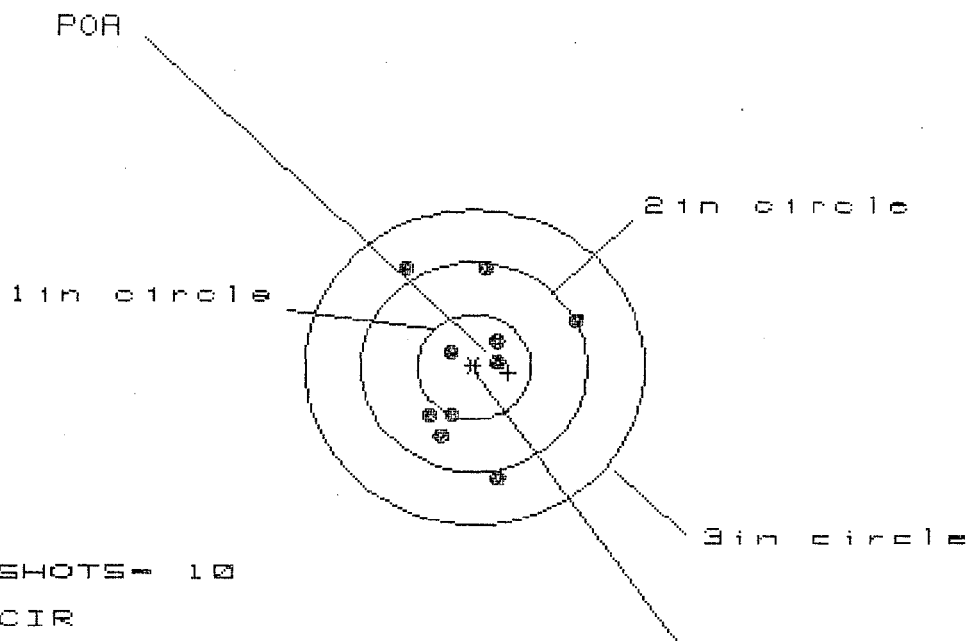
GS = 3.050

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.990	.827	.909
MINIMUM X	:	-1.467	-.849	-.767
MAXIMUM Y	:	1.211	1.221	1.137
MINIMUM Y	:	-1.089	-.954	-1.038
CENTROID X	:	-.197	-.034	-.116
CENTROID Y	:	.193	.058	.142
POA TO CENTROID in.	:	.275	.067	.183
MIN RADIUS	:	.422	.610	.510
MEAN RADIUS	:	1.005	.892	.876
MAX RADIUS	:	1.903	1.245	1.149
HORIZONTAL SPREAD	:	2.457	1.676	1.676
VERTICAL SPREAD	:	2.300	2.175	2.175
EXTREME SPREAD	:	3.050	2.176	2.176
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	9		

9 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611636

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 4

2 in = 7

3 in = 10

HS = 1.559

VS = 1.970

GS = 2.113

CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.933	.864	.879
MINIMUM X	:	-.626	-.494	-.479
MAXIMUM Y	:	.924	1.024	.906
MINIMUM Y	:	-1.046	-.946	-.700
CENTROID X	:	-.302	-.233	-.248
CENTROID Y	:	.056	-.044	.074
POA TO CENTROID in.	:	.307	.237	.259
MIN RADIUS	:	.191	.172	.135
MEAN RADIUS	:	.668	.618	.563
MAX RADIUS	:	1.097	1.047	.999
HORIZONTAL SPREAD	:	1.559	1.358	1.358
VERTICAL SPREAD	:	1.970	1.970	1.606
EXTREME SPREAD	:	2.113	1.971	1.691
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

9 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611636

CENTERFIRE PATTERNS

3

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 8

HS= 3.735

VS= 1.546

GS= 3.802

CENTROID *

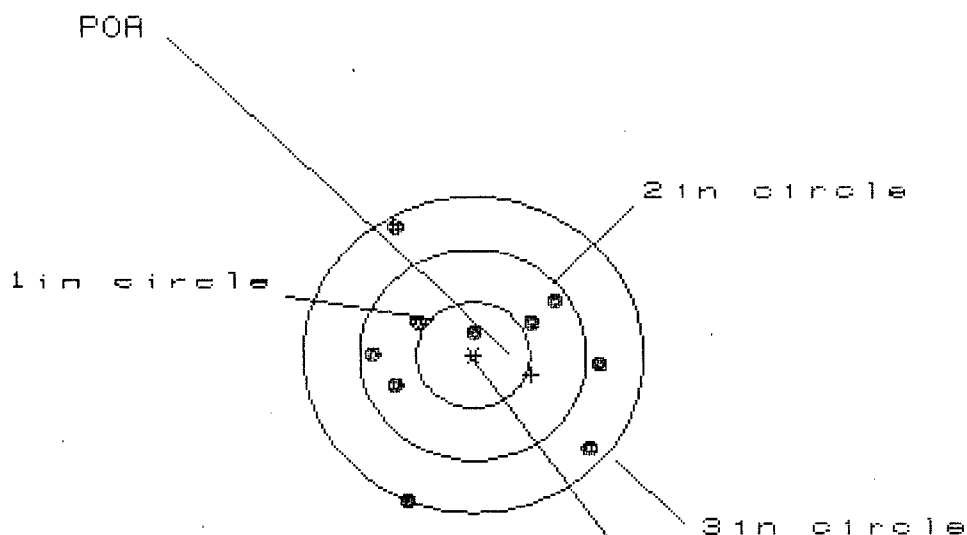
PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.752	1.532	.983
MINIMUM X	:	-1.983	-.977	-.786
MAXIMUM Y	:	.834	.834	.745
MINIMUM Y	:	-.712	-.712	-.751
CENTROID X	:	.389	.609	.418
CENTROID Y	:	-.047	-.047	.042
POA TO CENTROID in.	:	.392	.611	.420
MIN RADIUS	:	.320	.524	.316
MEAN RADIUS	:	.954	.854	.701
MAX RADIUS	:	1.983	1.689	1.015
HORIZONTAL SPREAD	:	3.735	2.509	1.769
VERTICAL SPREAD	:	1.546	1.546	1.496
EXTREME SPREAD	:	3.802	2.554	1.859
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	8		

9 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611636

CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 6

3 in = 10

HS= 2.037

VS= 2.613

GS= 2.676

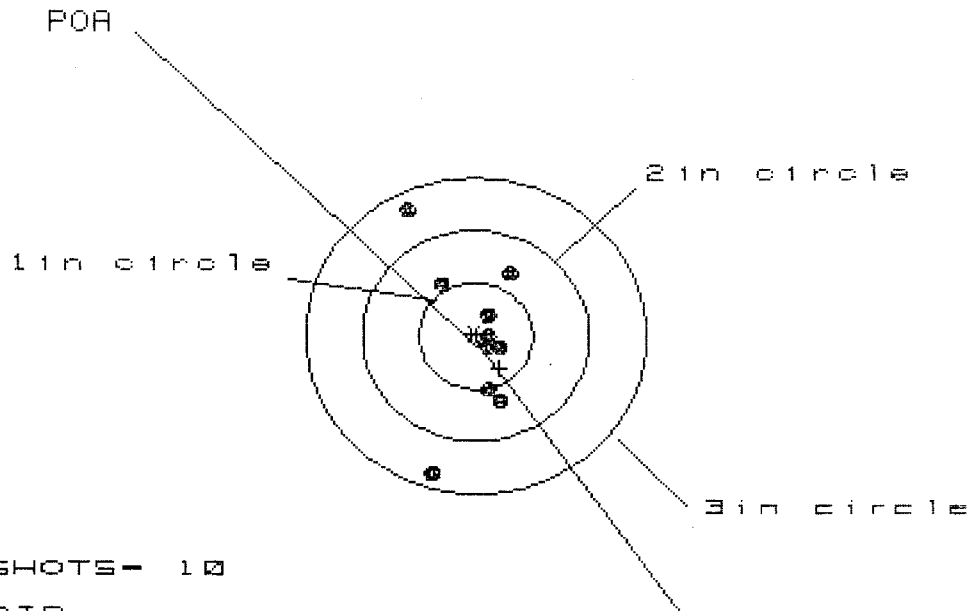
CENTROID #

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.151	1.082	.992
MINIMUM X	-.886	-.955	-1.045
MAXIMUM Y	1.250	1.098	.453
MINIMUM Y	-1.363	-1.027	-.890
CENTROID X	-.514	-.445	-.354
CENTROID Y	.182	.334	.197
POA TO CENTROID in.	.546	.557	.405
MIN RADIUS	.271	.115	.272
MEAN RADIUS	.923	.826	.779
MAX RADIUS	1.498	1.366	1.203
HORIZONTAL SPREAD	2.037	2.037	2.037
VERTICAL SPREAD	2.613	2.125	1.343
EXTREME SPREAD	2.676	2.676	2.060
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

9 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611636

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in - 5

2in - 8

3in = 10

HS- .920

VS= 2.475

GS= 2.483

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.347	.306	.229
MINIMUM X	-.573	-.614	-.411
MAXIMUM Y	1.194	1.052	.589
MINIMUM Y	-1.281	-.731	-.599
CENTROID X	-.208	-.167	-.090
CENTROID Y	.305	.447	.316
POA TO CENTROID in.	.369	.477	.328
MIN RADIUS	.125	.077	.011
MEAN RADIUS	.583	.496	.36
MAX RADIUS	1.333	1.218	.672
HORIZONTAL SPREAD	.920	.920	.640
VERTICAL SPREAD	2.475	1.783	1.188
EXTREME SPREAD	2.483	1.960	1.252
NUMBER IN ONE INCH CIRCLE =	5		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		