

C5349082

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. C6349082
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		ORDER NO. 5716



5716 C6349082



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349082

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 12	90	RW
600	Proof	4 12	90	A
607	Check Headspace	4 12	90	A
610	Dis-assemble Gun	4 12	90	RW
612	Magnaflux Barrel Action	4-19-90		KCR
	Magnaflux Bolt	4-19-90		KCR
615	Rollmark Caliber	4-19-90		SL
617	Drill and Tap Sight Holes		4/23/90	LB
618	Polish Barrel RB		4/24/90	WB
620	Apply Coatings (Barrel Action)		4/30/90	TH
	Apply Coating (Bolt)			TH
625	Final Assembly			
	A) Clean inside of Bolt Assembly		5/1/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/1/90	RW
	C) Inspect Ejector Hole for Chamfer		5/1/90	RW
	D) Oil Firing Pin Ass'y		5/1/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/9/90	TH

BARBER - M24 0107410		READINGS					DATE	INIT
op. #	OP. NAME							
625 cont.	F) Safety On Force	5	5	5			5/9/90	gcl
	G) Safety Off Force	3	3	3			5/9/90	gcl
	H) Trigger Pull Test & Retainability						5/9/90	gcl
	I) Firing Pin Indent	.023	.022	.023			5/9/90	gcl
	J) Assemble Stock						5/15/90	RW
	K) Assemble Swivel Studs						5/17/90	WB
	L) Attach Front and Rear Sight Assemblies						5/15/90	RW
	M) Iron Sight Alignment						5/15/90	RW
	N) Detach Front & Rear Sights & place in numbered container						5/15/90	RW
	O) Attach Scope to Rifle						5/15/90	gcl
	P) Detach & Attach Scope 20 Times						5/15/90	gcl
640	Gallery Target & Test						5-15-90	AC
	A) Time						5-15-90	AC
	B) Malfunctions						5-15-90	AC
	C) Pierced Primers						5-15-90	AC
	D) Optical Clarity of Scope						5-15-90	AC
645	Inspect for Live Ammo						5-15-90	AC
655	Final Inspection						5/17/90	WB
	A) Headspace							
	B) Trigger Pull	2.43	2.50	2.48	2.50	2.54	5/17/90	WB
	C) Function						5/17/90	WB
660	Pack						9-19-90	DH

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

SERIAL NO. 06349082DATE 5/9/90TESTER gll

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.26	2.30	2.43	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.31	2.36	2.50	
PULL #3	2.43	2.31	2.40	2.48	
PULL #4	2.26	2.35	2.41	2.50	
PULL #5	2.19	2.36	2.36	2.54	
TOTAL	11.69	11.59	11.83		
AVG.	2.338	2.318	2.366		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.45	3.40		
PULL #2	3.31	3.42		
PULL #3	3.32	3.46		
PULL #4	3.35	3.33		
PULL #5	3.33	3.31		
TOTAL	16.76	16.92		
AVG.	3.352	3.384		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.20	4.45		4.35
PULL #2	4.24	4.43		4.39
PULL #3	4.22	4.40		4.45
PULL #4	4.35	4.41		4.37
PULL #5	4.40	4.42		4.44
TOTAL	21.41	22.11		22.00
AVG.	4.282	4.422		4.4

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06349082
16 May 1990

CENTROIDAL DISTANCES

0 TO	1	.0403113
1 TO	2	.456426
1 TO	3	.149201
1 TO	4	.0875957
1 TO	5	.396531

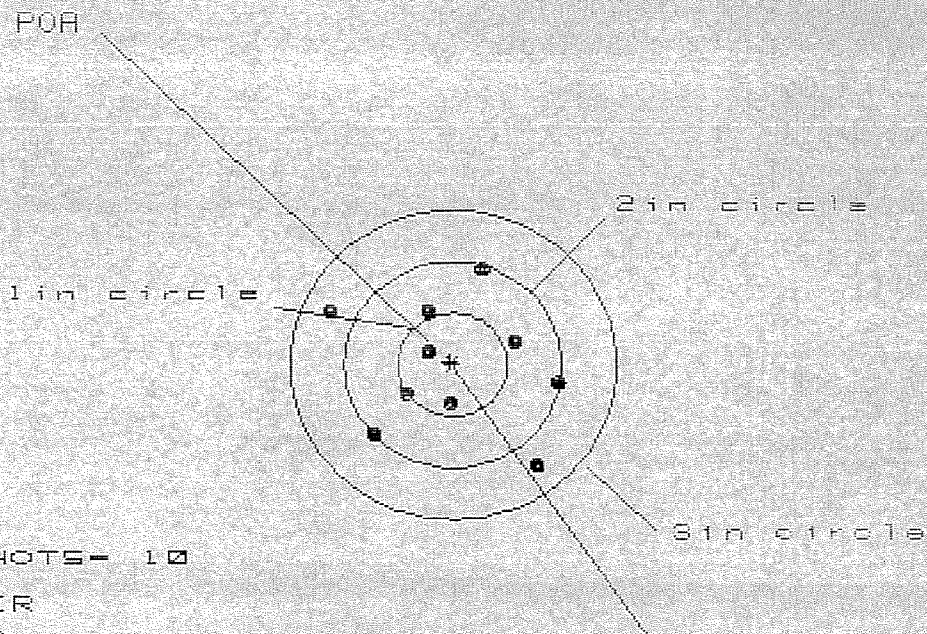
$\frac{4}{5}$ (----POA
2

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0622
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.092
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .111053
THE AMR FOR THIS RIFLE IS: .8606

15 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6349082

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 6

3 in = 10

HS= 2.107

VS= 1.862

GS= 2.397

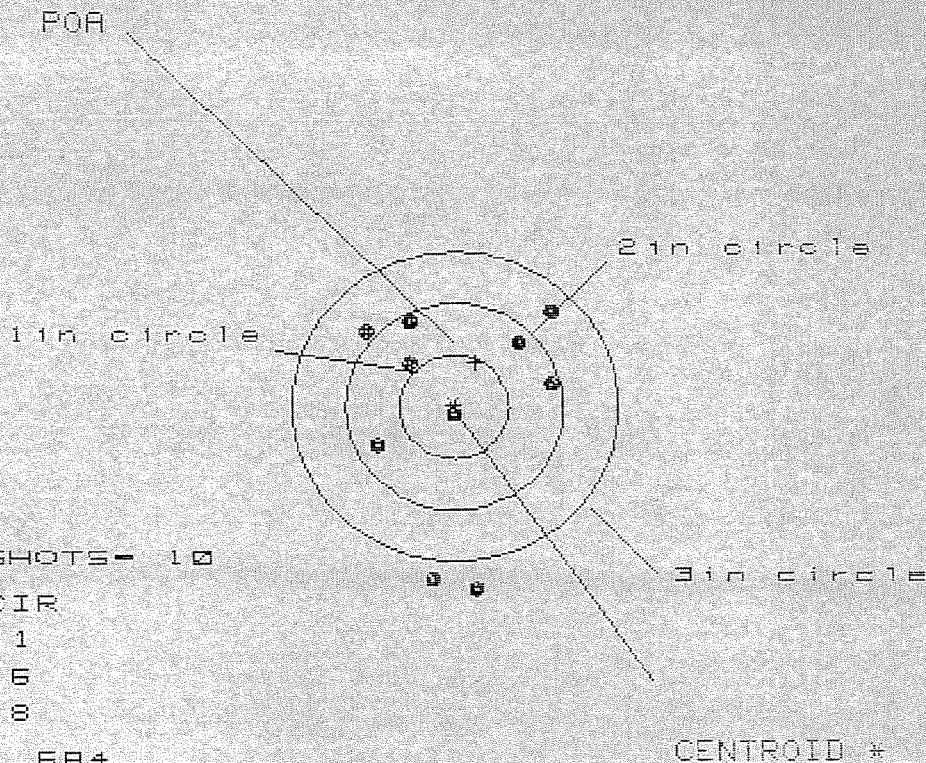
CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.009	1.099	.972
MINIMUM X	:	-1.098	-1.008	-.801
MAXIMUM Y	:	.932	.828	.882
MINIMUM Y	:	-.930	-.786	-.732
CENTROID X	:	.029	-.060	.067
CENTROID Y	:	-.028	.076	.022
POA TO CENTROID in.	:	.041	.096	.070
MIN RADIUS	:	.228	.105	.241
MEAN RADIUS	:	.775	.708	.666
MAX RADIUS	:	1.228	1.124	1.085
HORIZONTAL SPREAD	:	2.107	2.107	1.774
VERTICAL SPREAD	:	1.862	1.614	1.614
EXTREME SPREAD	:	2.397	2.210	1.931
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 6

3 in = 8

HS= 1.684

VS= 2.678

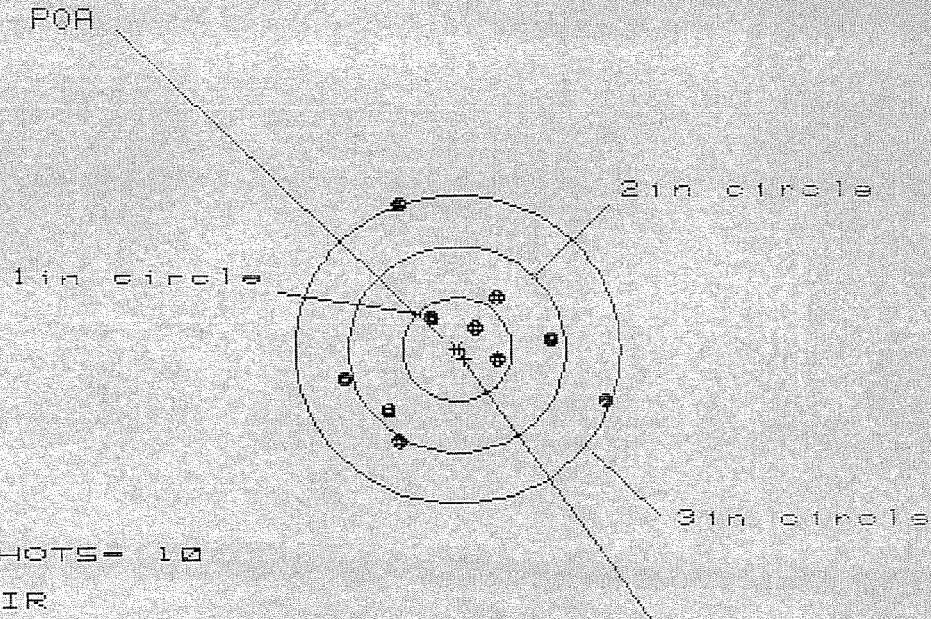
GS= 2.835

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.906	.931	.906
MINIMUM X	:	-.778	-.753	-.778
MAXIMUM Y	:	.953	.762	.532
MINIMUM Y	:	-1.725	-1.839	-.803
CENTROID X	:	-.189	-.214	-.189
CENTROID Y	:	-.429	-.238	-.008
POA TO CENTROID in.	:	.469	.320	.189
MIN RADIUS	:	.107	.288	.437
MEAN RADIUS	:	1.006	.898	.756
MAX RADIUS	:	1.739	1.850	1.080
HORIZONTAL SPREAD	:	1.684	1.684	1.684
VERTICAL SPREAD	:	2.678	2.601	1.335
EXTREME SPREAD	:	2.835	2.835	2.105
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 3

2in = 6

3in = 10

HS= 2.439

VS= 2.263

GS= 2.638

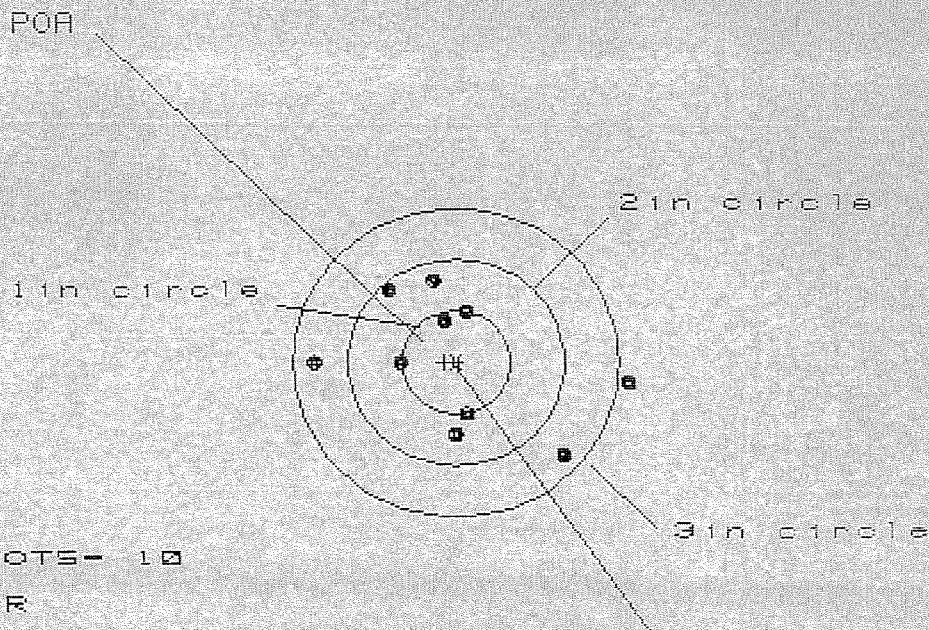
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.375	1.003	.961
MINIMUM X	:	-1.064	-.911	-.953
MAXIMUM Y	:	1.370	1.315	.624
MINIMUM Y	:	-.893	-.948	-.784
CENTROID X	:	-.061	-.214	-.172
CENTROID Y	:	.091	.146	-.018
POA TO CENTROID in.	:	.110	.259	.173
MIN RADIUS	:	.216	.256	.370
MEAN RADIUS	:	.844	.777	.705
MAX RADIUS	:	1.462	1.357	.982
HORIZONTAL SPREAD	:	2.439	1.914	1.914
VERTICAL SPREAD	:	2.263	2.263	1.408
EXTREME SPREAD	:	2.638	2.264	1.962
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 2.899

VS= 1.757

GS= 2.902

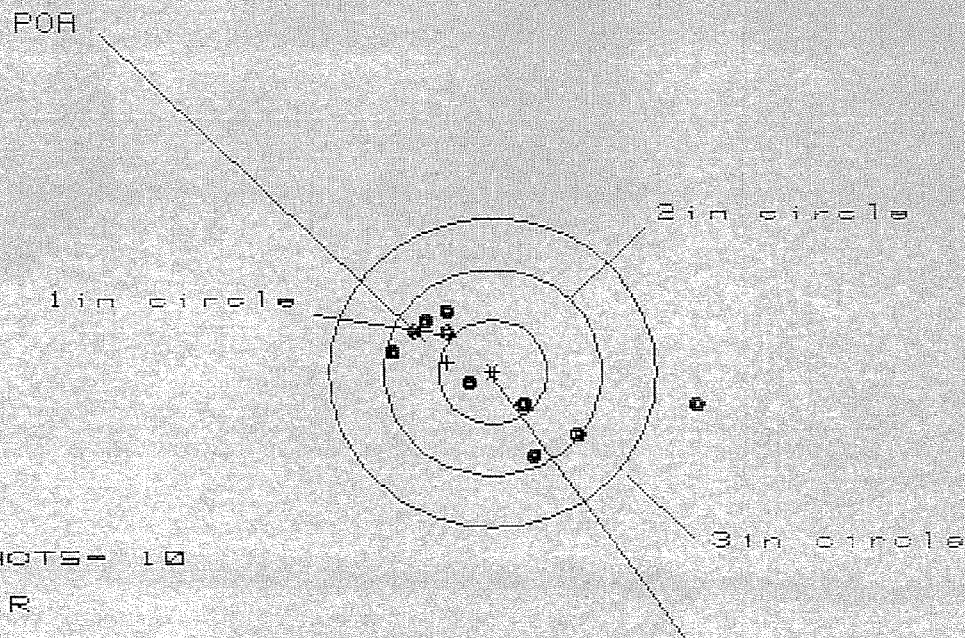
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.609	1.122	.449
MINIMUM X	:	-1.290	-1.111	-.971
MAXIMUM Y	:	.827	.808	.689
MINIMUM Y	:	-.930	-.949	-.865
CENTROID X	:	.112	-.067	-.207
CENTROID Y	:	.000	.019	.138
POA TO CENTROID in.	:	.112	.070	.249
MIN RADIUS	:	.378	.292	.233
MEAN RADIUS	:	.858	.745	.629
MAX RADIUS	:	1.618	1.470	.985
HORIZONTAL SPREAD	:	2.899	2.233	1.420
VERTICAL SPREAD	:	1.757	1.757	1.554
EXTREME SPREAD	:	2.902	2.407	1.560
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			9	

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 2

2in = 9

3in = 9

HS= 2.719

VS= 1.407

GS= 2.770

CENTROID #

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.839	.966	.739
MINIMUM X	-.880	-.676	-.555
MAXIMUM Y	.579	.543	.459
MINIMUM Y	-.828	-.864	-.948
CENTROID X	.420	.216	.095
CENTROID Y	-.094	-.058	.026
POA TO CENTROID in.	.431	.224	.099
MIN RADIUS	.210	.114	.237
MEAN RADIUS	.820	.652	.554
MAX RADIUS	1.867	1.175	1.202
HORIZONTAL SPREAD	2.719	1.642	1.294
VERTICAL SPREAD	1.407	1.407	1.407
EXTREME SPREAD	2.770	1.842	1.712
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		9	