

C6522240

MODEL 700™ M24

Model **SMS**™

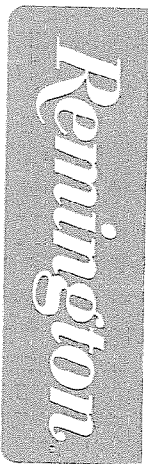
Action

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

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

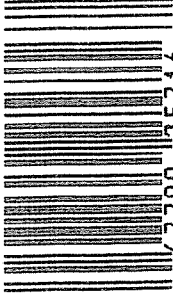
SERIAL NO.
06522240

ORDER NO.
5716

Q1



UPC



0 47700 25716 7

5716 06522240

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522240
21 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	1.07244
1 TO	2	.673886
1 TO	3	.516609
1 TO	4	.348001
1 TO	5	.405011

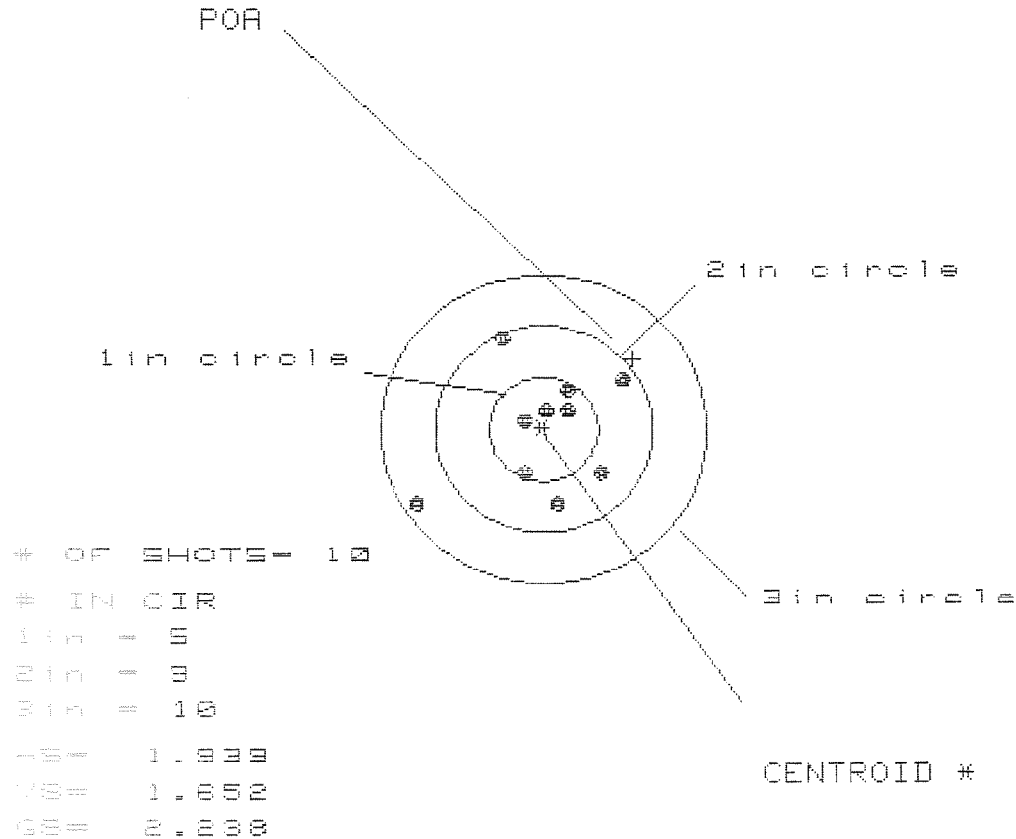
$\begin{matrix} 4 \\ 1 \end{matrix} \begin{matrix} 3 \\ 2 \end{matrix} +$ <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.6586
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.4438
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .794174
THE AVERAGE POI RADIUS FOR THIS RIFLE IS: .7332

21 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522240

CENTERFIRE PATTERNS # 1



PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.754	.622	.561
MINIMUM X	-1.185	-.490	-.399
MAXIMUM Y	.909	.834	.475
MINIMUM Y	-.743	-.818	-.714
CENTROID X	-.826	-.694	-.633
CENTROID Y	-.684	-.609	-.714
POA TO CENTROID in.	1.073	.924	.954
MIN RADIUS	.225	.175	.223
MEAN RADIUS	.640	.537	.495
MAX RADIUS	1.363	.967	.735
HORIZONTAL SPREAD	1.939	1.112	.960
VERTICAL SPREAD	1.652	1.652	1.188
EXTREME SPREAD	2.238	1.723	1.341
MURDER IN ONE INCH CIRCLE	= 5		
MURDER IN TWO INCH CIRCLE	= 9		
MURDER IN THREE INCH CIRCLE	= 10		

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CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS = 1.443

VS = 2.831

GS = 2.881

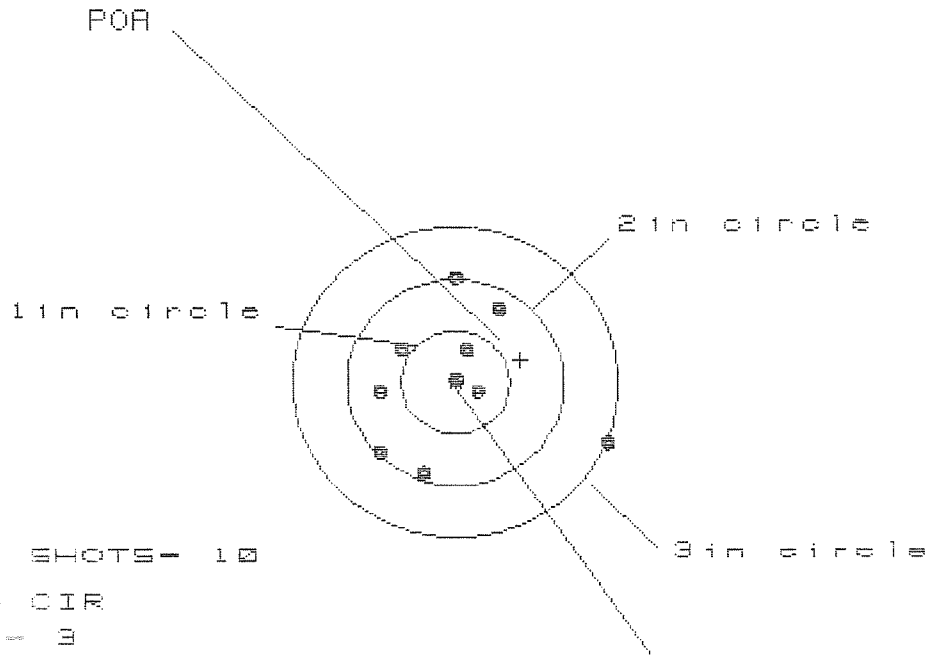
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.786	.714	.689
MINIMUM X	:	-.656	-.581	-.606
MAXIMUM Y	:	1.460	.966	.815
MINIMUM Y	:	-1.371	-1.209	-1.006
CENTROID X	:	-.157	-.084	-.059
CENTROID Y	:	-.603	-.765	-.614
POA TO CENTROID in.	:	.623	.770	.617
MIN RADIUS	:	.182	.100	.105
MEAN RADIUS	:	.814	.719	.639
MAX RADIUS	:	1.601	1.224	1.016
HORIZONTAL SPREAD	:	1.443	1.295	1.295
VERTICAL SPREAD	:	2.831	2.175	1.821
EXTREME SPREAD	:	2.881	2.209	1.892
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 9

3in = 9

HSE= 2.0000

VSE= 1.8000

GSE= 2.137

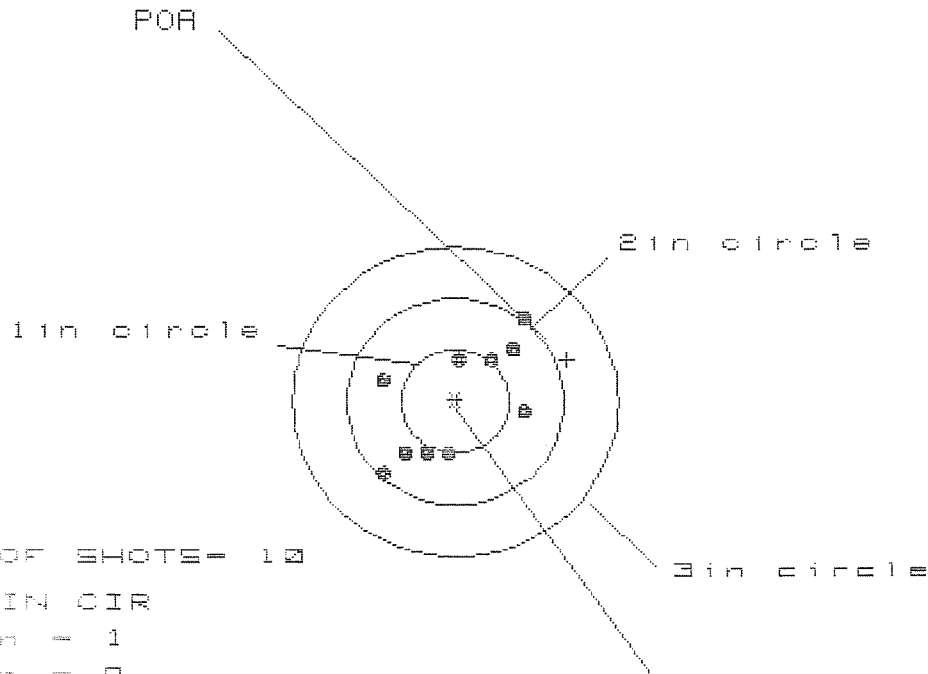
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.418	.528	.554
MINIMUM X	:	-.651	-.493	-.467
MAXIMUM Y	:	.972	.902	.749
MINIMUM Y	:	-.832	-.901	-.788
CENTROID X	:	-.603	-.761	-.787
CENTROID Y	:	-.218	-.149	-.262
POA TO CENTROID in.	:	.642	.775	.830
MIN RADIUS	:	.058	.143	.195
MEAN RADIUS	:	.694	.593	.555
MAX RADIUS	:	1.548	.927	.932
HORIZONTAL SPREAD	:	2.069	1.021	1.021
VERTICAL SPREAD	:	1.803	1.803	1.537
EXTREME SPREAD	:	2.137	1.843	1.722
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 1

2in = 9

3in = 10

HS= 1.341

VS= 1.420

GS= 1.951

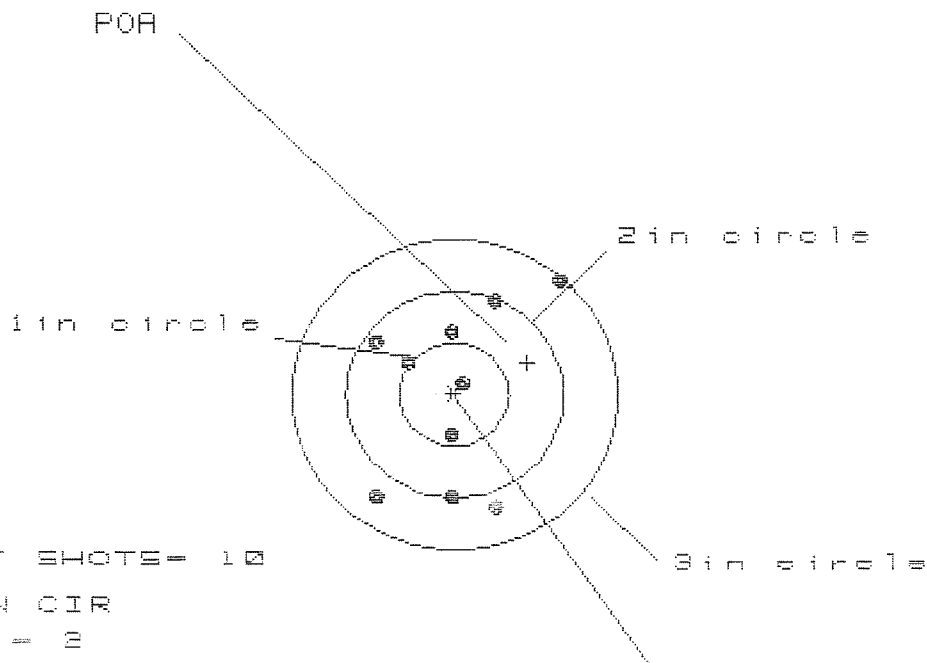
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.650	.662	.585
MINIMUM X	:	-.691	-.619	-.696
MAXIMUM Y	:	.760	.600	.528
MINIMUM Y	:	-.660	-.575	-.524
CENTROID X	:	-1.034	-1.106	-1.029
CENTROID Y	:	-.405	-.490	-.418
FOR TO CENTROID in.	:	1.111	1.210	1.111
MIN RADIUS	:	.410	.425	.423
MEAN RADIUS	:	.670	.624	.593
MAX RADIUS	:	1.000	.882	.776
HORIZONTAL SPREAD	:	1.341	1.281	1.281
VERTICAL SPREAD	:	1.420	1.175	1.052
EXTREME SPREAD	:	1.951	1.724	1.429
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1in = 2

2in = 6

3in = 10

HS = 1.707

VS = 2.191

GS = 2.696

CENTROID #

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.012	.521	.448
MINIMUM X	-.695	-.582	-.649
MAXIMUM Y	1.070	1.004	.892
MINIMUM Y	-1.122	-1.003	-1.115
CENTROID X	-.673	-.786	-.713
CENTROID Y	-.309	-.428	-.316
POP TO CENTROID in.	.741	.895	.780
MIN RADIUS	.137	.271	.165
MEAN RADIUS	.848	.778	.722
MAX RADIUS	1.473	1.131	1.198
HORIZONTAL SPREAD	1.707	1.103	1.097
VERTICAL SPREAD	2.191	2.007	2.007
EXTREME SPREAD	2.696	2.200	2.007
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

SWS TRIGGER PULL TEST

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

SERIAL NO C6522240

DATE 9-16-90

TESTER JF

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.31	2.23	2.41	2.23	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.23	2.25	2.19	2.25	
PULL #3	2.21	2.23	2.40	2.38	
PULL #4	2.21	2.20	2.20	2.31	
PULL #5	2.23	2.49	2.20	2.34	
TOTAL	11.08	11.40	11.40	11.43	
AVG.	2.216	2.28	2.28	2.286	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.20	3.12		
PULL #2	3.21	3.20		
PULL #3	3.26	3.23		
PULL #4	3.05	3.21		
PULL #5	3.18	3.18		
TOTAL	15.90	15.94		
AVG.	3.18	3.188		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.15		4.32
PULL #2	4.34	4.36		4.30
PULL #3	4.28	4.30		4.30
PULL #4	4.33	4.29		4.27
PULL #5	4.33	4.22		4.34
TOTAL	21.50	21.32		21.53
AVG.	4.3	4.264		4.306

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	4	4			8/19/90	928
	G) Safety Off Force	3	3	3			8/19/90	928
	H) Trigger Pull Test & Retainability						9-16-90	921
	I) Firing Pin Indent	.022	.022	.022			8/19/90	928
	J) Assemble Stock						8/20/90	KS
	K) Assemble Swivel Studs						9/16/90	928
	L) Attach Front and Rear Sight Assemblies						8/20/90	KS
	M) Iron Sight Alignment						8/24/90	KS
	N) Detach Front & Rear Sights & place in numbered container						8/20/90	KS
	O) Attach Scope to Rifle						8/20/90	KS
	P) Detach & Attach Scope 20 Times						8/20/90	KS
640	Gallery Target & Test						8-21-90	A
	A) Time						11	A
	B) Malfunctions						11	A
	C) Pierced Primers						11	A
	D) Optical Clarity of Scope						11	A
645	Inspect for Live Ammo						8-21-90	A
655	Final Inspection							
	A) Headspace						9/16/90	928
	B) Trigger Pull	2.23	2.25	2.30	2.31	2.34	9-16-90	928
	C) Function						9/16/90	928
660	Pack						9/19/90	1F

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6522240

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/24/90	KA
600	Proof		6/24/90	KA
607	Check Headspace		6/24/90	KA
610	Dis-assemble Gun		6/24/90	KA
612	Magnaflux Barrel Action		7/10/90	K.R.
	Magnaflux Bolt		7/10/90	K.R.
615	Rollmark Caliber		7/10/90	G.L.
617	Drill and Tap Sight Holes		7/11/90	LB
618	Polish Barrel RB		7/13/90	WB
620	Apply Coatings (Barrel Action)		7-23-90	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/17/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/17/90	KS
	C) Inspect Ejector Hole for Chamfer		8/17/90	KS
	D) Oil Firing Pin Ass'y		8/17/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		9-16-90	KA