

C6522195

MODEL 700TM M24

Model **SMS**TM

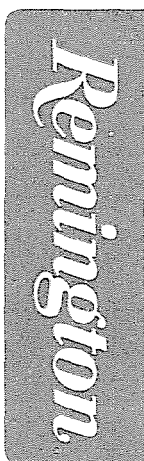
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.






MODEL 700™ H24

SERIAL NO. C8522195

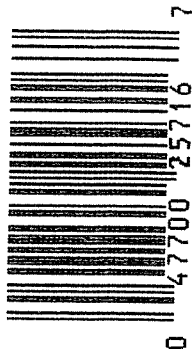
ORDER NO. 5716

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

Ø1

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

LPC



CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522195
29 Aug 1990

CENTROIDAL DISTANCES

Ø TO	1	.36711
1 TO	2	.912932
1 TO	3	.615565
1 TO	4	.602583
1 TO	5	.316443

$\bar{x}_1 +$ <----POA
 $+ \bar{x}_2$

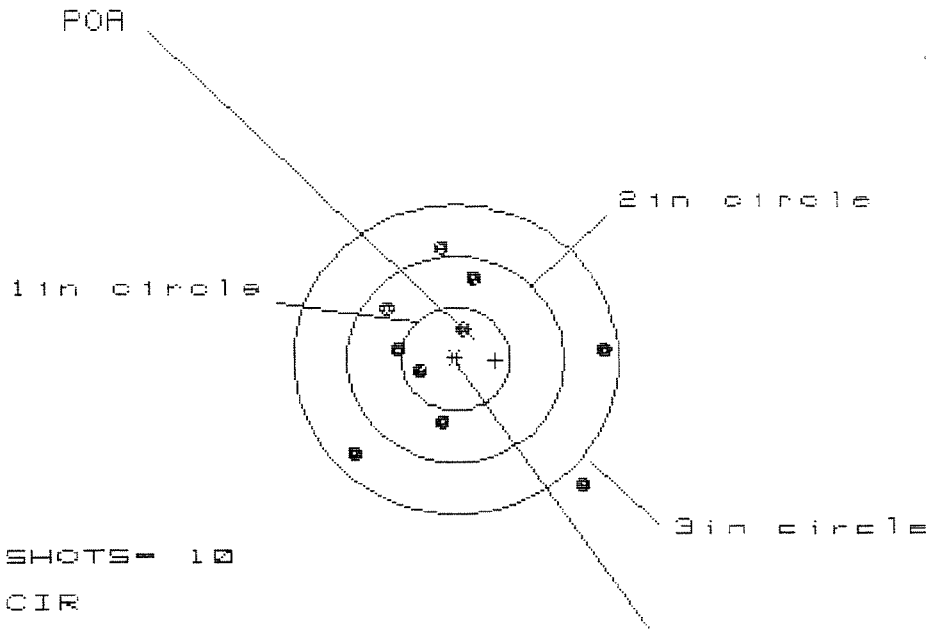
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.326
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.3374
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .469164
THE AMR FOR THIS RIFLE IS: .8326

29 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522195

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.226

VS= 2.321

GS= 2.641

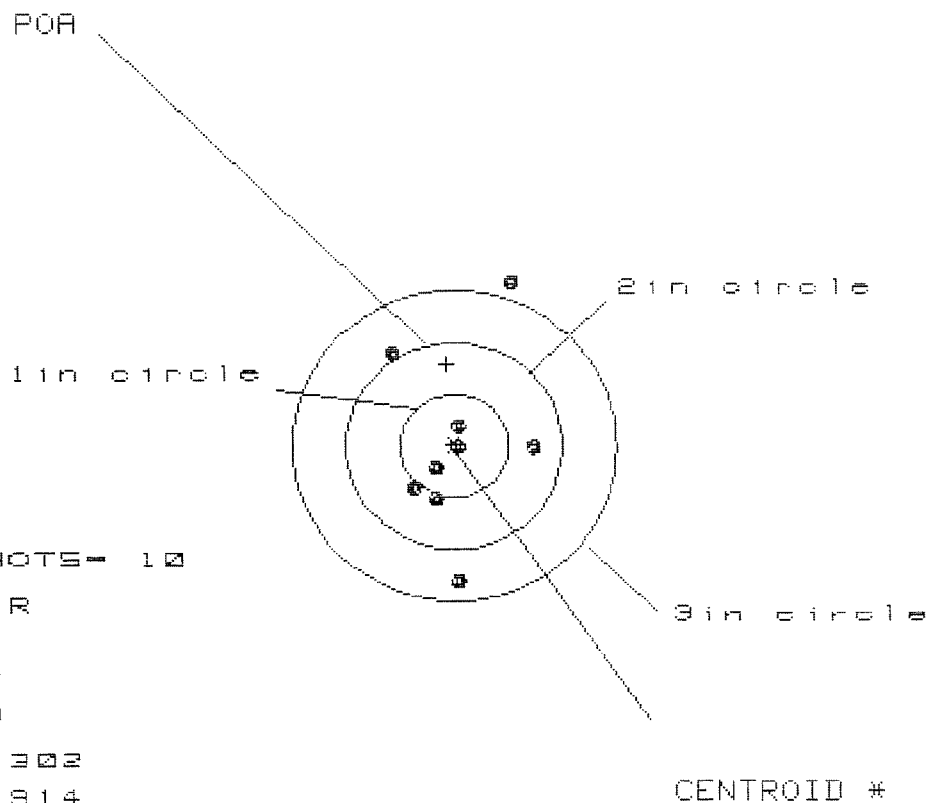
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.327	1.453	.439
MINIMUM X	-.899	-.773	-.591
MAXIMUM Y	1.084	.947	.941
MINIMUM Y	-1.237	-1.035	-1.041
CENTROID X	-.367	-.493	-.675
CENTROID Y	.009	.146	.152
POA TO CENTROID in.	.368	.514	.691
MIN RADIUS	.325	.258	.217
MEAN RADIUS	.880	.750	.634
MAX RADIUS	1.674	1.453	1.197
HORIZONTAL SPREAD	2.226	2.226	1.030
VERTICAL SPREAD	2.321	1.982	1.982
EXTREME SPREAD	2.641	2.438	2.125
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

29 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8522195

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 9

HS= 1.302

VS= 2.914

GS= 2.966

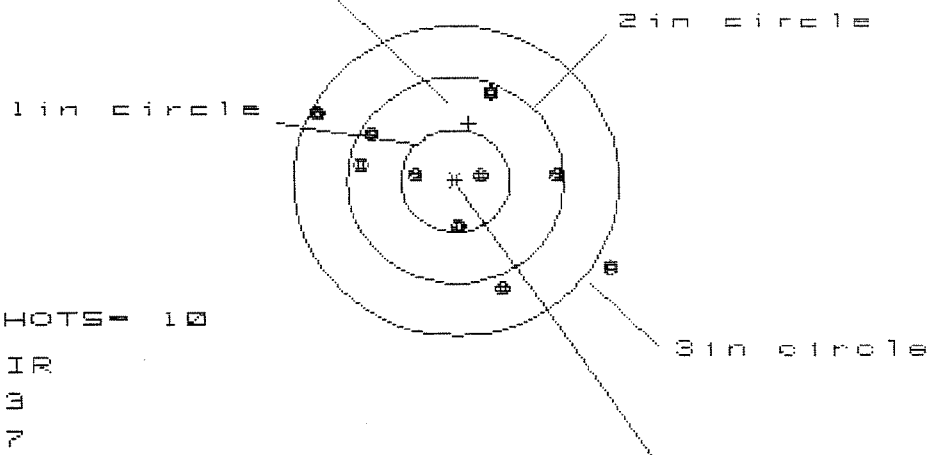
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.724	.786	.794
MINIMUM X	:	-.578	-.516	-.508
MAXIMUM Y	:	1.572	1.035	.889
MINIMUM Y	:	-1.342	-1.167	-.488
CENTROID X	:	.071	.009	.001
CENTROID Y	:	-.792	-.967	-.821
POA TO CENTROID in.:	:	.795	.967	.821
MIN RADIUS	:	.017	.060	.059
MEAN RADIUS	:	.644	.499	.421
MAX RADIUS	:	1.667	1.169	1.024
HORIZONTAL SPREAD	:	1.302	1.302	1.302
VERTICAL SPREAD	:	2.914	2.202	1.377
EXTREME SPREAD	:	2.966	2.277	1.571
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

29 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06522195

CENTERFIRE PATTERNS # 3

POA



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS = 2.654

VS = 1.888

GS = 3.071

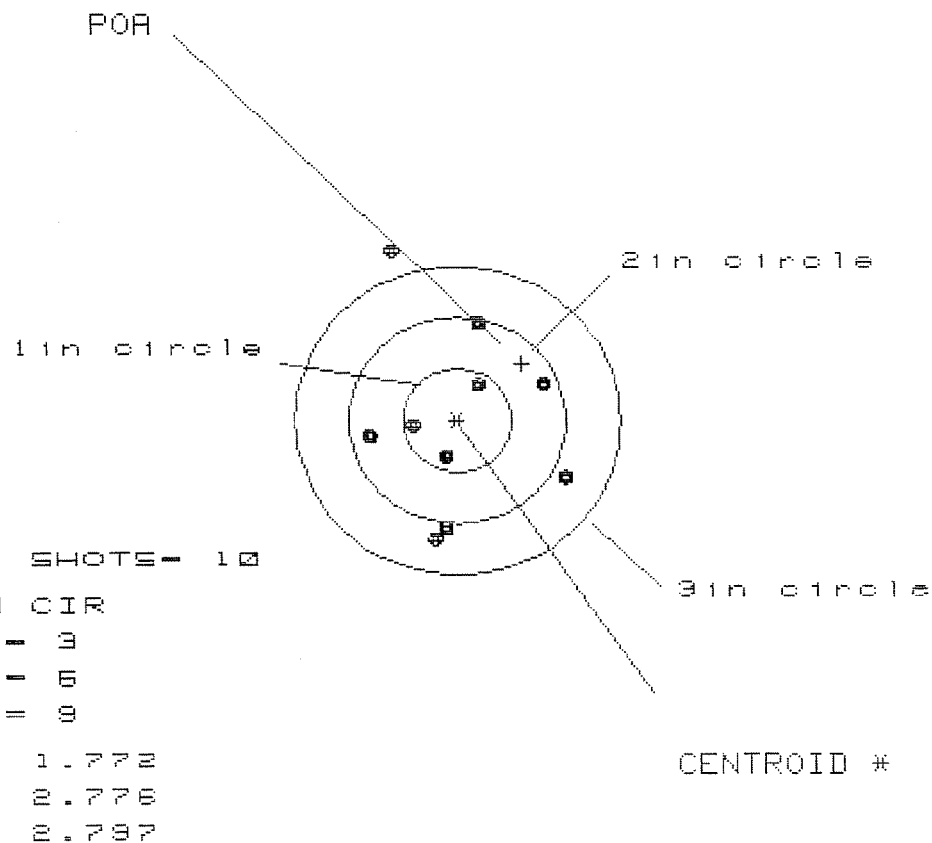
CENTROID *

PATTERN #	:	3
SHOTS (BEST OF)	:	10
MAXIMUM X	:	1.403
MINIMUM X	:	-1.251
MAXIMUM Y	:	.875
MINIMUM Y	:	-1.013
CENTROID X	:	-.125
CENTROID Y	:	-.557
POA TO CENTROID in.	:	.571
MIN RADIUS	:	.212
MEAN RADIUS	:	.892
MAX RADIUS	:	1.658
HORIZONTAL SPREAD	:	2.654
VERTICAL SPREAD	:	1.888
EXTREME SPREAD	:	3.071
NUMBER IN ONE INCH CIRCLE =	:	3
NUMBER IN TWO INCH CIRCLE =	:	7
NUMBER IN THREE INCH CIRCLE =	:	9

25 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522195

CENTERFIRE PATTERNS # 4

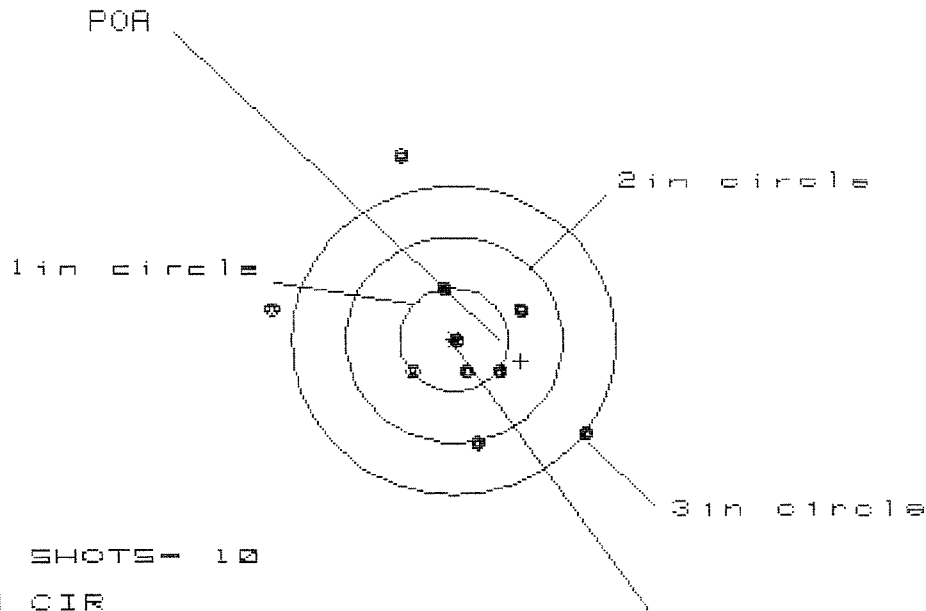


PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.982	.918	.880
MINIMUM X	:	-.790	-.854	-.892
MAXIMUM Y	:	1.635	1.151	1.031
MINIMUM Y	:	-1.141	-.959	-.983
CENTROID X	:	-.592	-.528	-.490
CENTROID Y	:	-.550	-.732	-.612
FOR TO CENTROID in.	:	.808	.902	.784
MIN RADIUS	:	.402	.250	.373
MEAN RADIUS	:	.897	.787	.758
MAX RADIUS	:	1.734	1.164	1.040
HORIZONTAL SPREAD	:	1.772	1.772	1.772
VERTICAL SPREAD	:	2.776	2.110	2.014
EXTREME SPREAD	:	2.797	2.164	2.044
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

29 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08522195

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 5

3 in = 7

HS= 2.871

VS= 2.767

GS= 3.212

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.204	1.146	.930
MINIMUM X	:	-1.667	-1.725	-.615
MAXIMUM Y	:	1.779	.650	.712
MINIMUM Y	:	-.988	-.791	-.729
CENTROID X	:	-.617	-.559	-.343
CENTROID Y	:	.203	.006	-.056
POA TO CENTROID in.	:	.650	.559	.348
MIN RADIUS	:	.062	.074	.141
MEAN RADIUS	:	.850	.707	.569
MAX RADIUS	:	1.855	1.795	1.145
HORIZONTAL SPREAD	:	2.871	2.871	1.545
VERTICAL SPREAD	:	2.767	1.441	1.441
EXTREME SPREAD	:	3.212	3.121	1.872
NUMBER IN ONE INCH CIRCLE =			4	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			7	

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO Q6522195

DATE 8/27/90

TESTER gcy

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.19	2.28	2.41	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.45	2.23	2.38	2.35	
PULL #3	2.51	2.18	2.26	2.03	
PULL #4	2.41	2.21	2.40	2.38	
PULL #5	2.28	2.18	2.26	2.13	
TOTAL	12.06	10.99	11.58	11.30	
AVG.	2.412	2.198	2.316	2.26	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.46	3.08		
PULL #2	3.14	3.16		
PULL #3	3.23	3.12		
PULL #4	3.12	3.27		
PULL #5	3.26	3.12		
TOTAL	16.21	15.75		
AVG.	3.242	3.15		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.30	4.08		4.04
PULL #2	4.07	4.39		4.23
PULL #3	4.23	4.15		4.43
PULL #4	4.04	4.36		4.23
PULL #5	4.07	4.04		4.20
TOTAL	20.71	20.92		21.13
AVG.	4.142	4.184		4.226

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522195

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	8/1/90	KS
600	Proof		8/1/90	KS
607	Check Headspace		8/1/90	KS
610	Dis-assemble Gun		8/1/90	KS
612	Magnaflux Barrel Action		8/6/90	KR
	Magnaflux Bolt		8/6/90	KR
615	Rollmark Caliber		8/6/90	JS
617	Drill and Tap Sight Holes		8/10/90	KB
618	Polish Barrel RB		8/14/90	WB
620	Apply Coatings (Barrel Action)		8/22/90	JS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/23/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/23/90	KS
	C) Inspect Ejector Hole for Chamfer		8/23/90	KS
	D) Oil Firing Pin Ass'y		8/23/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		8/27/90	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/4	4 1/4	4 1/4			8/24/90	WB
	G) Safety Off Force	2 1/4	2 1/4	2 1/4			8/24/90	WB
	H) Trigger Pull Test & Retainability						8/27/90	JS
	I) Firing Pin Indent	.0235	.0235	.0235			8/24/90	WB
	J) Assemble Stock						8/27/90	KS
	K) Assemble Swivel Studs						8/31/90	JS
	L) Attach Front and Rear Sight Assemblies						8/27/90	KS
	M) Iron Sight Alignment						8/27/90	KS
	N) Detach Front & Rear Sights & place in numbered container						8/27/90	KS
	O) Attach Scope to Rifle						8/27/90	KS
	P) Detach & Attach Scope 20 Times						8/27/90	KS
640	Gallery Target & Test						8-29-90	DH
	A) Time						8-29-90	DH
	B) Malfunctions						8-29-90	DH
	C) Pierced Primers						8-29-90	DH
	D) Optical Clarity of Scope						8-29-90	DH
645	Inspect for Live Ammo						8-29-90	DH
655	Final Inspection							
	A) Headspace						8/31/90	JS
	B) Trigger Pull	2.41	2.35	2.03	2.38	2.13	8/30/90	JS
	C) Function						8/31/90	JS
660	Pack						9/20/90	NE