

C6522304

MODEL 700™ M24

Model **SMS**™

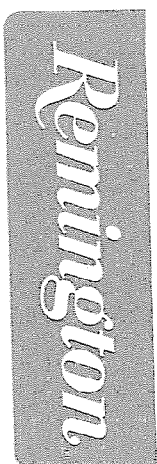
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6522304

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		7/10/90	KL
600	Proof		7/10/90	KL
607	Check Headspace		7/10/90	KL
610	Dis-assemble Gun		7/10/90	KL
612	Magnaflux Barrel Action		7/17/90	KR
	Magnaflux Bolt		7/17/90	KR
615	Rollmark Caliber		7/17/90	L.S.
617	Drill and Tap Sight Holes		7/23/90	FB
618	Polish Barrel RB		7/24/90	WB
620	Apply Coatings (Barrel Action)		7/26/90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/16/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/16/90	KS
	C) Inspect Ejector Hole for Chamfer		8/16/90	KS
	D) Oil Firing Pin Ass'y		8/16/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		8/21/90	RL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			8/17/90 8/20/90	SL
	G) Safety Off Force	3	3	3			8/17/90 8/20/90	SL
	H) Trigger Pull Test & Retainability						8/21/90	SL
	I) Firing Pin Indent	.0205	.021	.0215			8/20/90	SL
	J) Assemble Stock						8/17/90	KS
	K) Assemble Swivel Studs						8/17/90 8/20/90	SL
	L) Attach Front and Rear Sight Assemblies						8/17/90	KS
	M) Iron Sight Alignment						8/17/90	KS
	N) Detach Front & Rear Sights & place in numbered container						8/17/90	KS
	O) Attach Scope to Rifle						8/17/90	KS
	P) Detach & Attach Scope 20 Times						8/17/90	KS
640	Gallery Target & Test						8/20/90	NE
	A) Time						8/20/90	NE
	B) Malfunctions						8/20/90	NE
	C) Pierced Primers						8/20/90	NE
	D) Optical Clarity of Scope						8/20/90	NE
645	Inspect for Live Ammo						8/20/90	NE
655	Final Inspection							
	A) Headspace						8/29/90	SL
	B) Trigger Pull	2.37	2.39	2.40	2.40	2.43	8/21/90	SL
	C) Function						8/29/90	SL
660	Pack						9/20/90	NE

SWS TRIGGER PULL TEST

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

SERIAL NO. C6522304

DATE 8/21/90

TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.21	2.24	2.42	2.37	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.18	2.23	2.37	2.39	
PULL #3	2.19	2.24	2.43	2.40	
PULL #4	2.20	2.24	2.39	2.40	
PULL #5	2.19	2.28	2.40	2.43	
TOTAL	10.97	11.23	12.01	11.99	
AVG.	2.194	2.246	2.402	2.398	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.19	3.21		
PULL #2	3.22	3.27		
PULL #3	3.25	3.24		
PULL #4	3.24	3.31		
PULL #5	3.25	3.32		
TOTAL	16.15	16.35		
AVG.	3.23	3.27		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.48	4.44		4.47
PULL #2	4.43	4.43		4.50
PULL #3	4.35	4.40		4.43
PULL #4	4.37	4.43		4.45
PULL #5	4.37	4.42		4.44
TOTAL	22.00	22.12		22.29
AVG.	4.4	4.424		4.458

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C522304
21 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.229009
1 TO	2	.200562
1 TO	3	.471985
1 TO	4	.317328
1 TO	5	.355857

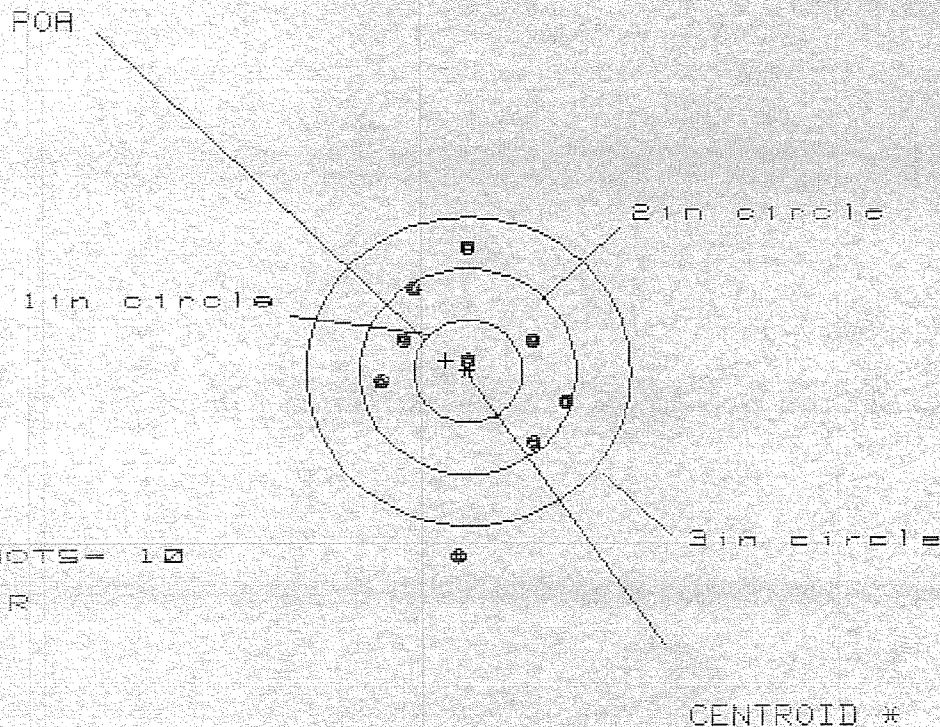
POI <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0548
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0754
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0932105
THE AMR FOR THIS RIFLE IS: .7844

20 Aug 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6522304

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 2

2in = 8

3in = 9

HS = 1.747

VS = 2.971

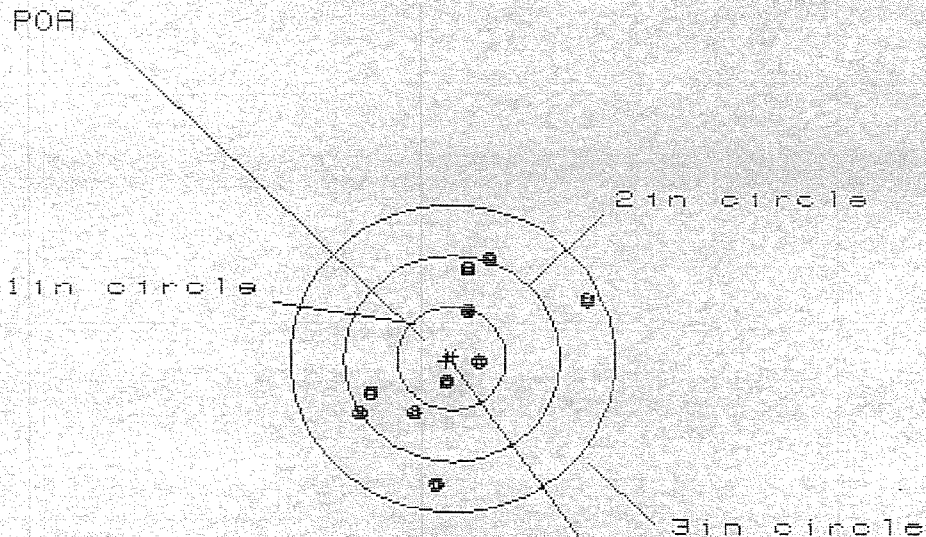
GS = 2.973

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.897	.884	.883
MINIMUM X	:	-.850	-.863	-.864
MAXIMUM Y	:	1.182	.983	.684
MINIMUM Y	:	-1.789	-.874	-.751
CENTROID X	:	.203	.216	.217
CENTROID Y	:	-.106	.093	-.030
POA TO CENTROID in.	:	.229	.235	.219
MIN RADIUS	:	.109	.062	.037
MEAN RADIUS	:	.819	.678	.630
MAX RADIUS	:	1.793	1.027	.940
HORIZONTAL SPREAD	:	1.747	1.747	1.747
VERTICAL SPREAD	:	2.971	1.857	1.435
EXTREME SPREAD	:	2.973	1.937	1.789
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

28 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522384

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 10

HS= 2.140

VS= 2.177

CS= 2.403

CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.248	.502	.503
MINIMUM X	:	-.892	-.753	-.752
MAXIMUM Y	:	1.000	1.060	.921
MINIMUM Y	:	-1.177	-1.117	-.631
CENTROID X	:	.052	-.087	-.088
CENTROID Y	:	.026	-.034	.105
POA TO CENTROID in.	:	.058	.093	.137
MIN RADIUS	:	.214	.243	.371
MEAN RADIUS	:	.798	.727	.686
MAX RADIUS	:	1.361	1.173	1.049
HORIZONTAL SPREAD	:	2.140	1.255	1.255
VERTICAL SPREAD	:	2.177	2.177	1.552
EXTREME SPREAD	:	2.403	2.231	1.996
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

28 Aug 1998

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CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 6

2in = 9

3in = 10

HS = 2.391

VS = 1.088

CS = 2.395

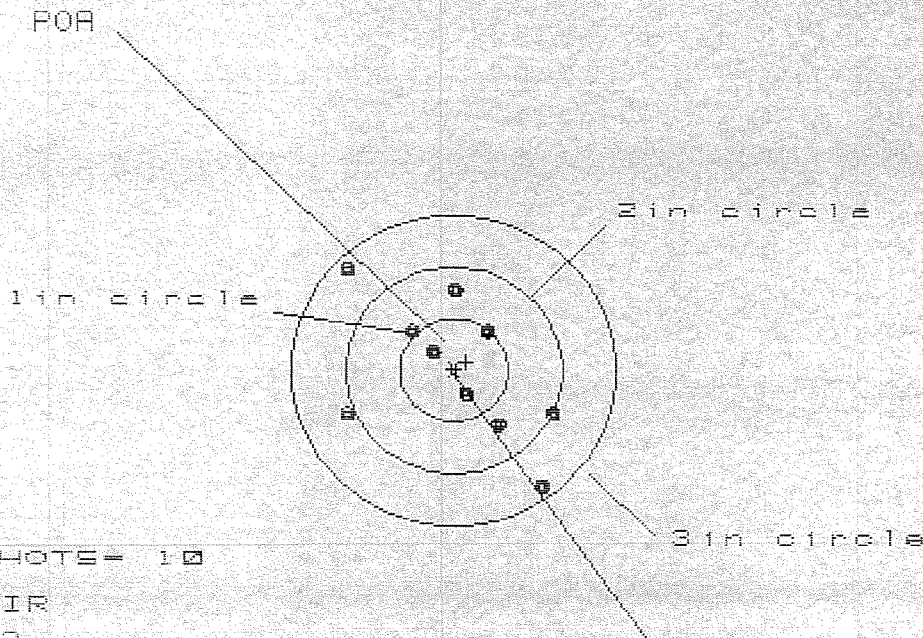
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.958	.799	.365
MINIMUM X	:	-1.433	-.871	-.771
MAXIMUM Y	:	.678	.671	.647
MINIMUM Y	:	-.410	-.417	-.441
CENTROID X	:	-.266	-.107	-.207
CENTROID Y	:	-.159	-.152	-.128
POA TO CENTROID in.	:	.310	.186	.243
MIN RADIUS	:	.113	.075	.151
MEAN RADIUS	:	.578	.447	.412
MAX RADIUS	:	1.434	.874	.778
HORIZONTAL SPREAD	:	2.391	1.670	1.136
VERTICAL SPREAD	:	1.088	1.088	1.088
EXTREME SPREAD	:	2.395	1.674	1.206
NUMBER IN ONE INCH CIRCLE	=		6	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

20 Aug 1980

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CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS = 1.886

VS = 2.125

GS = 2.792

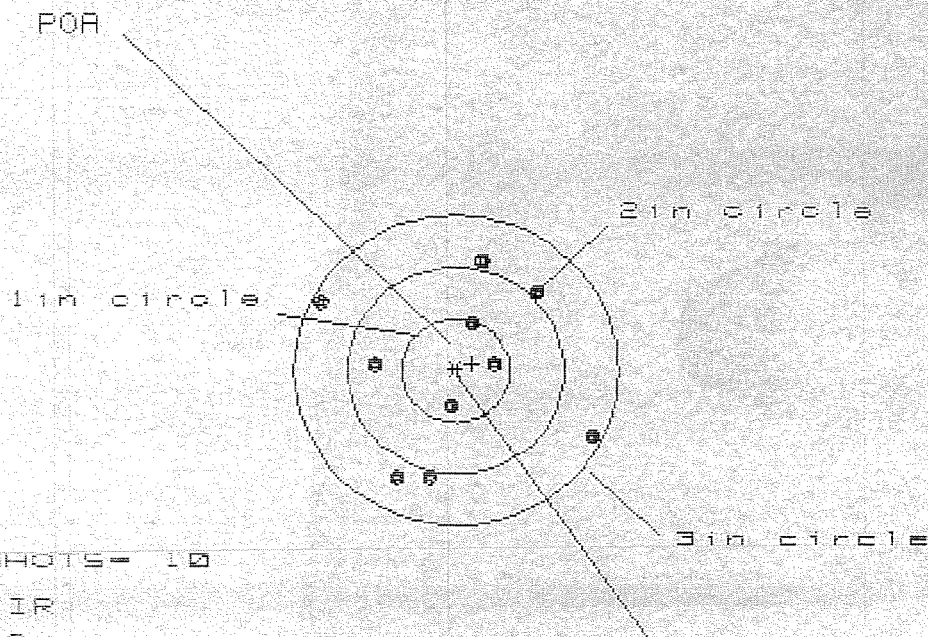
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.871	.966	.859
MINIMUM X	:	-1.015	-.920	-1.027
MAXIMUM Y	:	1.004	.879	.767
MINIMUM Y	:	-1.121	-.677	-.567
CENTROID X	:	-.113	-.208	-.100
CENTROID Y	:	-.077	.048	-.062
POA TO CENTROID in.	:	.137	.213	.118
MIN RADIUS	:	.231	.082	.232
MEAN RADIUS	:	.796	.709	.645
MAX RADIUS	:	1.410	1.230	1.131
HORIZONTAL SPREAD	:	1.886	1.886	1.886
VERTICAL SPREAD	:	2.125	1.556	1.334
EXTREME SPREAD	:	2.792	2.297	1.887
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

20 Aug 1990

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 10

HS= 2.487

VS= 2.148

GS= 2.887

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.273	.932	.798
MINIMUM X	:	-1.214	-1.072	-.730
MAXIMUM Y	:	1.187	1.033	1.103
MINIMUM Y	:	-1.041	-1.115	-1.045
CENTROID X	:	-.150	-.292	-.158
CENTROID Y	:	-.061	.013	-.057
POA TO CENTROID in.	:	.162	.292	.168
MIN RADIUS	:	.348	.475	.354
MEAN RADIUS	:	.931	.875	.813
MAX RADIUS	:	1.439	1.209	1.177
HORIZONTAL SPREAD	:	2.487	2.004	1.528
VERTICAL SPREAD	:	2.148	2.148	2.148
EXTREME SPREAD	:	2.887	2.284	2.284
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	



MODEL 700™ **H24**

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

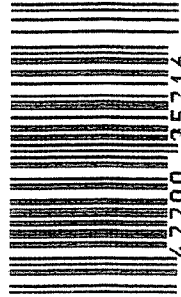


REG. U.S. PAT. & T.M. OFF.

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

SERIAL NO.	C6522304
ORDER NO.	5716

UPC



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5716 C6522304