

C6522321

MODEL 700TM M24

Model **SMS**TM

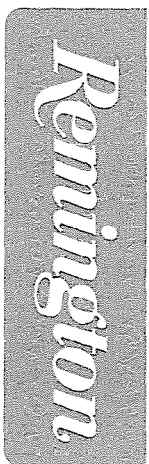
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6522321

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 29	90	RW
600	Proof	6 29	90	RW
607	Check Headspace	6 29	90	RW
610	Dis-assemble Gun	6 29	90	RW
612	Magnaflux Barrel Action		7-12-90	K.R.
	Magnaflux Bolt		7-12-90	K.R.
615	Rollmark Caliber		7-12-90	K.R.
617	Drill and Tap Sight Holes		7/13/90	FB
618	Polish Barrel RB		7/16/90	WB
620	Apply Coatings (Barrel Action)		7-13-90	AX
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		7/25/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/25/90	RW
	C) Inspect Ejector Hole for Chamfer		7/25/90	RW
	D) Oil Firing Pin Ass'y		7/25/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9-6-90	90

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			7/30/90	SL
	G) Safety Off Force	3	3	3			7/30/90	SL
	H) Trigger Pull Test & Retainability						7-5-90	SL
	I) Firing Pin Indent	.023	.0225	.0225			7/30/90	SL
	J) Assemble Stock						8/10/90	RW
	K) Assemble Swivel Studs						9/6/90	SL
	L) Attach Front and Rear Sight Assemblies						8/10/90	RW
	M) Iron Sight Alignment						8/10/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/10/90	RW
	O) Attach Scope to Rifle						8/10/90	RW
	P) Detach & Attach Scope 20 Times						8/10/90	RW
640	Gallery Target & Test						8/10/90	DH
	A) Time						8-10-90	DH
	B) Malfunctions						8-10-90	DH
	C) Pierced Primers						8-10-90	DH
	D) Optical Clarity of Scope						8-10-90	DH
645	Inspect for Live Ammo						8-10-90	DH
655	Final Inspection							
	A) Headspace						9/6/90	SL
	B) Trigger Pull	2.15	2.22	2.25	2.29	2.26	9-6-90	SL
	C) Function						9/6/90	SL
660	Pack						9/20/90	AF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 06522321

DATE 9-6-90

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.34	2.32	2.14	2.15	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.49	2.38	2.20	2.22	
PULL #3	2.49	2.29	2.15	2.25	
PULL #4	2.44	2.25	2.21	2.29	
PULL #5	2.39	2.27	2.13	2.26	
TOTAL	12.15	11.51	10.82	11.17	
AVG.	2.43	2.302	2.164	2.234	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.38	3.27		
PULL #2	3.43	3.36		
PULL #3	3.43	3.36		
PULL #4	3.36	3.35		
PULL #5	3.37	3.33		
TOTAL	16.97	16.67		
AVG.	3.394	3.334		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.29	4.31		4.22
PULL #2	4.33	4.33		4.20
PULL #3	4.34	4.31		4.24
PULL #4	4.29	4.33		4.26
PULL #5	4.29	4.23		4.17
TOTAL	21.54	21.51		21.09
AVG.	4.308	4.302		4.218

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522321
10 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.555325
1 TO	2	.271737
1 TO	3	.458225
1 TO	4	1.11753
1 TO	5	1.327

+⁵_{f3} <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .6162
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0072
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .616242
THE AMR FOR THIS RIFLE IS: .9512

18 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06522321

CENTERFIRE PATTERNS # 1

POR

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 8

HS= 2.791

VS= 2.304

GS= 3.417

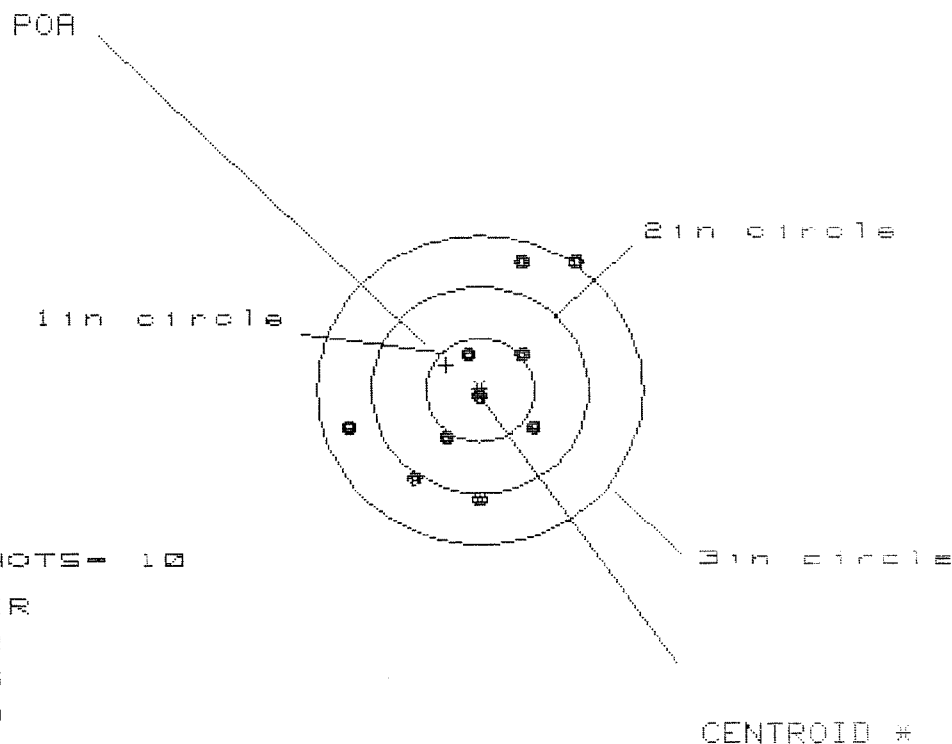
CENTROID *

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.696	.949	.836
MINIMUM X	:	-1.095	-.907	-.564
MAXIMUM Y	:	1.047	1.144	1.018
MINIMUM Y	:	-1.257	-1.160	-1.285
CENTROID X	:	.231	.043	.156
CENTROID Y	:	-.505	-.602	-.477
POR TO CENTROID in.	:	.556	.604	.501
MIN RADIUS	:	.280	.254	.315
MEAN RADIUS	:	1.071	.962	.904
MAX RADIUS	:	1.907	1.353	1.310
HORIZONTAL SPREAD	:	2.791	1.856	1.400
VERTICAL SPREAD	:	2.304	2.304	2.304
EXTREME SPREAD	:	3.417	2.552	2.384
NUMBER IN ONE INCH CIRCLE =	:	1		
NUMBER IN TWO INCH CIRCLE =	:	4		
NUMBER IN THREE INCH CIRCLE =	:	8		

18 Aug 1998

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 2.139

VS= 2.317

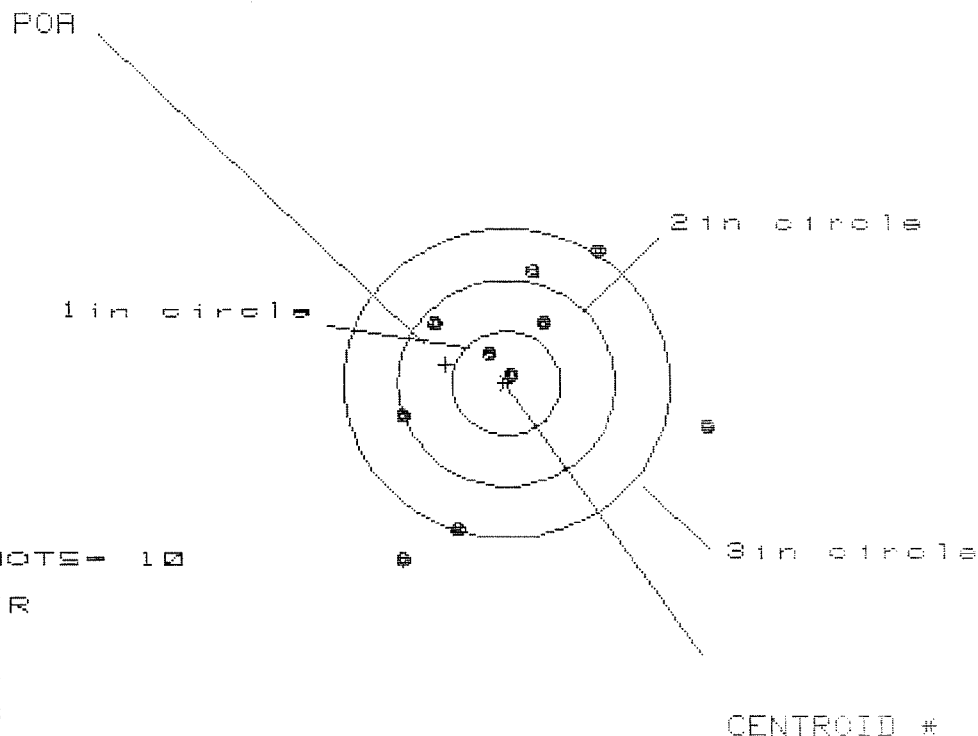
GS= 2.683

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.914	.633	.698
MINIMUM X	:	-1.225	-1.124	-1.059
MAXIMUM Y	:	1.272	1.389	.650
MINIMUM Y	:	-1.045	-.904	-.730
CENTROID X	:	.310	.209	.144
CENTROID Y	:	-.245	-.386	-.560
POA TO CENTROID in.	:	.395	.439	.578
MIN RADIUS	:	.103	.135	.188
MEAN RADIUS	:	.843	.750	.649
MAX RADIUS	:	1.566	1.482	1.060
HORIZONTAL SPREAD	:	2.139	1.757	1.757
VERTICAL SPREAD	:	2.317	2.293	1.380
EXTREME SPREAD	:	2.683	2.336	1.771
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 4

3 in = 6

HS= 2.824

VS= 3.011

GS= 3.485

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.817	1.715	.950
MINIMUM X	:	-1.007	-1.109	-.895
MAXIMUM Y	:	1.269	1.076	.995
MINIMUM Y	:	-1.742	-1.642	-1.722
CENTROID X	:	.558	.660	.446
CENTROID Y	:	-.184	.009	.089
POR TO CENTROID in.	:	.588	.660	.455
MIN RADIUS	:	.122	.114	.006
MEAN RADIUS	:	1.104	.963	.809
MAX RADIUS	:	1.968	1.831	1.764
HORIZONTAL SPREAD	:	2.824	2.824	1.845
VERTICAL SPREAD	:	3.011	2.718	2.718
EXTREME SPREAD	:	3.485	3.026	3.026
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			4	
NUMBER IN THREE INCH CIRCLE =			6	

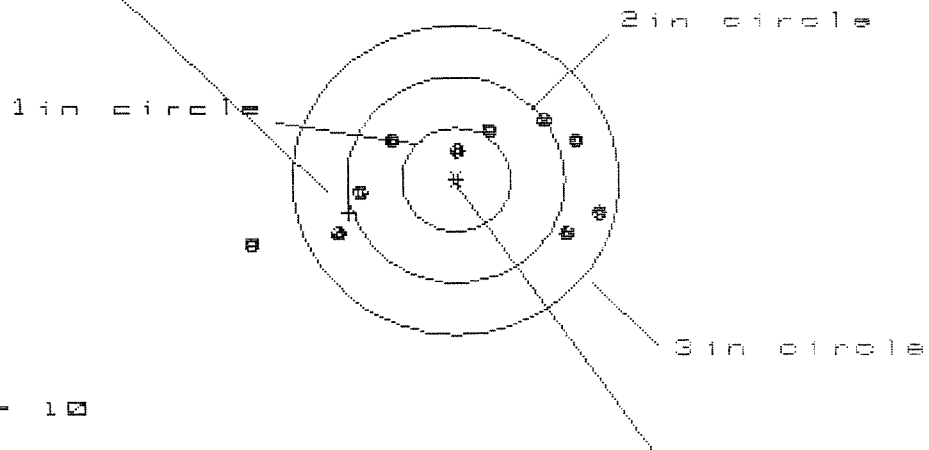
10 Aug 1998

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CENTERFIRE PATTERNS

4

POA



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 3.195

VS= 1.170

GS= 3.210

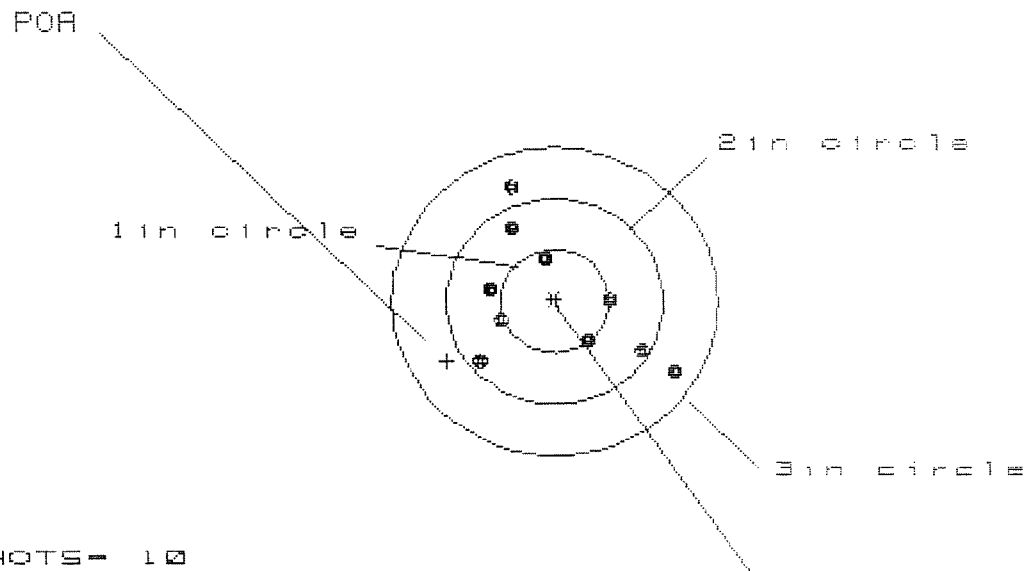
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.277	1.064	.988
MINIMUM X	:	-1.918	-1.271	-1.138
MAXIMUM Y	:	.572	.506	.461
MINIMUM Y	:	-.598	-.629	-.674
CENTROID X	:	.987	1.200	1.067
CENTROID Y	:	.318	.384	.429
POA TO CENTROID in.	:	1.037	1.260	1.150
MIN RADIUS	:	.246	.299	.171
MEAN RADIUS	:	1.027	.891	.842
MAX RADIUS	:	2.009	1.418	1.323
HORIZONTAL SPREAD	:	3.195	2.335	2.126
VERTICAL SPREAD	:	1.170	1.135	1.135
EXTREME SPREAD	:	3.210	2.351	2.332
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.787

VS= 1.783

GS= 2.349

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.118	.890	.854
MINIMUM X	:	-.669	-.544	-.580
MAXIMUM Y	:	1.089	1.011	.746
MINIMUM Y	:	-.694	-.653	-.526
CENTROID X	:	.995	.870	.906
CENTROID Y	:	.580	.658	.531
FOR TO CENTROID in.	:	1.152	1.091	1.050
MIN RADIUS	:	.405	.326	.448
MEAN RADIUS	:	.765	.689	.641
MAX RADIUS	:	1.316	1.051	.945
HORIZONTAL SPREAD	:	1.787	1.434	1.434
VERTICAL SPREAD	:	1.783	1.664	1.272
EXTREME SPREAD	:	2.349	1.940	1.647
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	




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

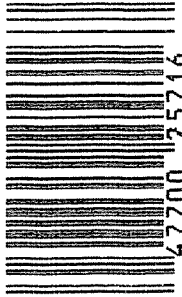
MODEL 700™ H24

SERIAL NO.
C6522321

ORDER NO.
5716

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

UPC



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5716 C6522321