

C6225177

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5715**

* Includes 1 in chamber.



Small
in

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

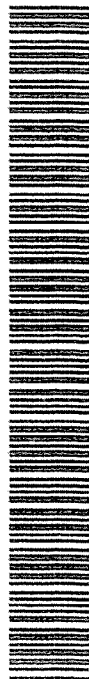


MODEL 700TM H24

SERIAL NO.
C6225177

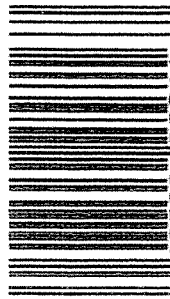
ORDER NO.
5716

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



5716 C6225177

LPC



0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225177

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock	9 12	8 8	RW
600	Proof	9 19	8 8	RW
607	Check Headspace	9 19	8 8	RW
610	Dis-assemble Gun	9 19	8 8	RW
612	Magnaflux Barrel Action		9-22-88	RW
	Magnaflux Bolt		9-22-88	RW
615	Rollmark Caliber		10-12-88	G.S.
617	Drill and Tap Sight Holes		10-23-88	F-8
618	Polish Barrel		10-24-88	WJT
620	Apply Coatings (Barrel Action)		10-31-88	TJA
	Apply Coating (Bolt)		10-31-88	TJA
625	Final Assembly A) Clean inside of Bolt Assembly		11/12/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/12/89	RW
	C) Inspect Ejector Hole for Chamfer		11/12/89	RW
	D) Oil Firing Pin Ass'y		11/12/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11/12/89	RW

op. #	OP. NAME	READINGS			DATE	INITIAL
625 cont.	F) Safety On Force	5	5	5	11 Jan 89	JS
	G) Safety Off Force	3	3	3	11 Jan 89	JS
	H) Trigger Pull Test & Retainability				11 Jan 89	JS
	I) Firing Pin Indent	.0215	.0215	.0215	11 Jan 89	JS
	J) Assemble Stock				1/12/89	RW
	K) Assemble Swivel Studs				31 Jan 89	JS
	L) Attach Front and Rear Sight Assemblies				1/12/89	RW
	M) Iron Sight Alignment				1/12/89	RW
	N) Detach Front & Rear Sights & place in numbered container				1/12/89	RW
	O) Attach Scope to Rifle				15 Jan 89	JS
	P) Detach & Attach Scope 20 Times				13 Jan 89	JS
640	Gallery Target & Test	63 R	91L		1/25/89	DH
	A) Time				1/25/89	DH
	B) Malfunctions				1/25/89	DH
	C) Pierced Primers				1/25/89	DH
	D) Optical Clarity of Scope				1/25/89	DH
645	Inspect for Live Ammo				1/25/89	DH
655	Final Inspection					
	A) Headspace				31 Jan 89	JS
	B) Trigger Pull	2.57	2.69	2.49	31 Jan 89	JS
	C) Function				31 Jan 89	JS
660	Pack				23 Jan 89	JS

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 6225177

DATE 4-3-90

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.43	2.37	2.33	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.38	2.30	2.28	
PULL #3	2.37	2.37	2.28	
PULL #4	2.37	2.36	2.31	
PULL #5	2.40	2.41	2.25	
TOTAL	11.95	11.81	11.45	
AVG.	2.39	2.362	2.29	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.37	3.28	
PULL #2	3.35	3.26	
PULL #3	3.28	3.30	
PULL #4	3.30	3.35	
PULL #5	3.30	3.51	
TOTAL	16.60	16.70	
AVG.	3.322	3.34	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.60	4.31		
PULL #2	4.33	4.33		
PULL #3	4.27	4.40		
PULL #4	4.31	4.51		
PULL #5	4.28	4.31		
TOTAL	21.79	21.86		
AVG.	4.358	4.372		

CENTROIDAL DISTANCES

0 TO	1	.232106
1 TO	2	.134134
1 TO	3	.503627
1 TO	4	.173833
1 TO	5	.278147

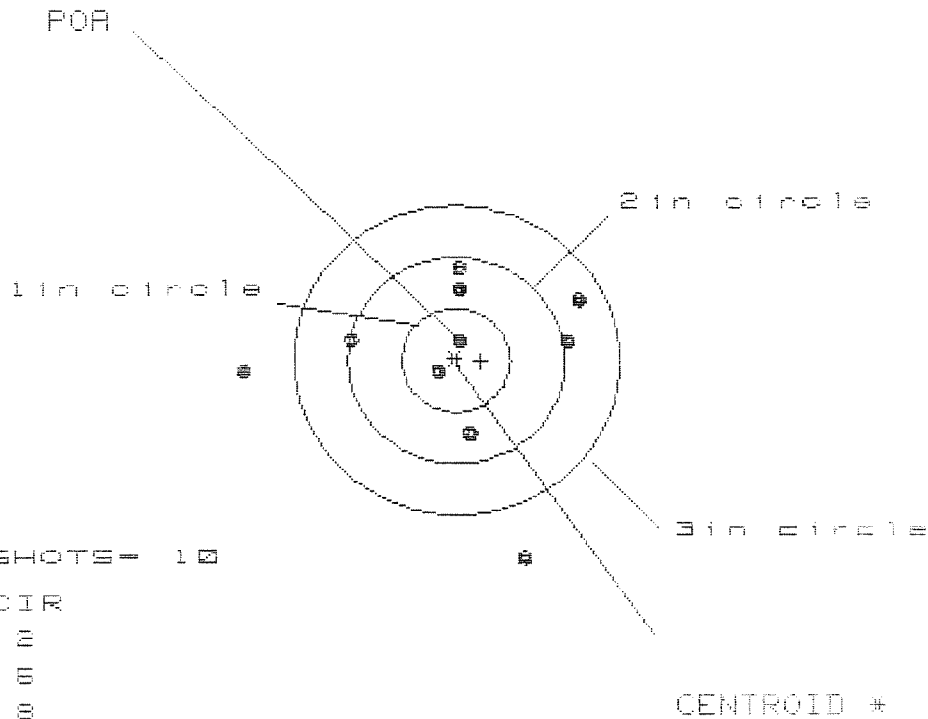
$\frac{5}{4}a_3$ <----POA

THE AMR FOR THIS RIFLE IS: 1.052

25 Jan 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6225177

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 8

HS = 3.086

VS = 2.805

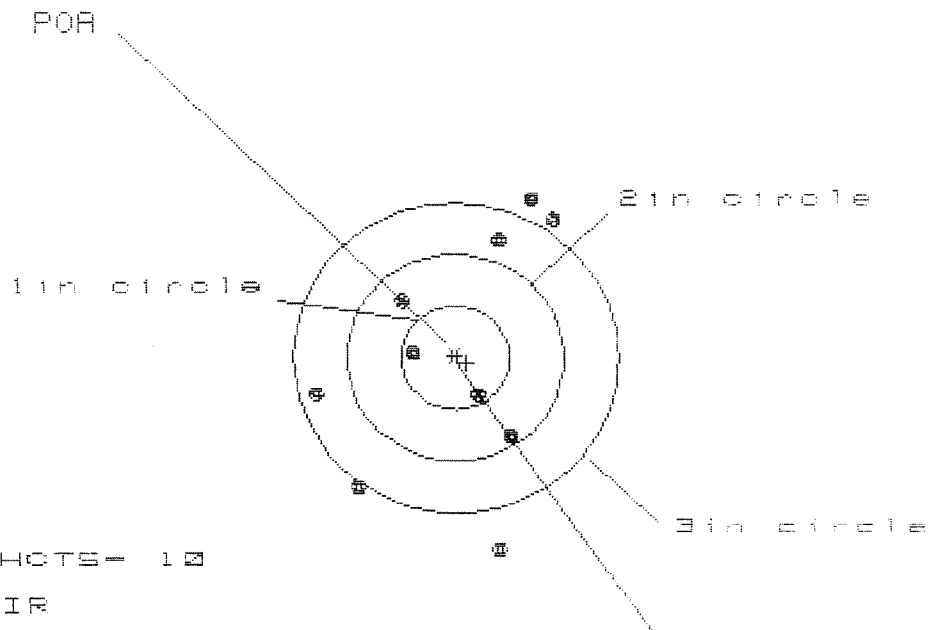
GS = 3.227

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.112	1.187	.950
MINIMUM X	:	-1.974	-1.899	-1.104
MAXIMUM Y	:	.903	.692	.658
MINIMUM Y	:	-1.901	-.947	-.981
CENTROID X	:	-.232	-.307	-.070
CENTROID Y	:	.007	.218	.252
POA TO CENTROID in.	:	.232	.377	.262
MIN RADIUS	:	.166	.139	.111
MEAN RADIUS	:	1.000	.864	.712
MAX RADIUS	:	2.019	1.919	1.108
HORIZONTAL SPREAD	:	3.086	3.086	2.854
VERTICAL SPREAD	:	2.805	1.639	1.639
EXTREME SPREAD	:	3.227	3.162	2.109
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			8	

26 Jan 1989

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 6

HS= 2.203

VS= 3.419

GS= 3.434

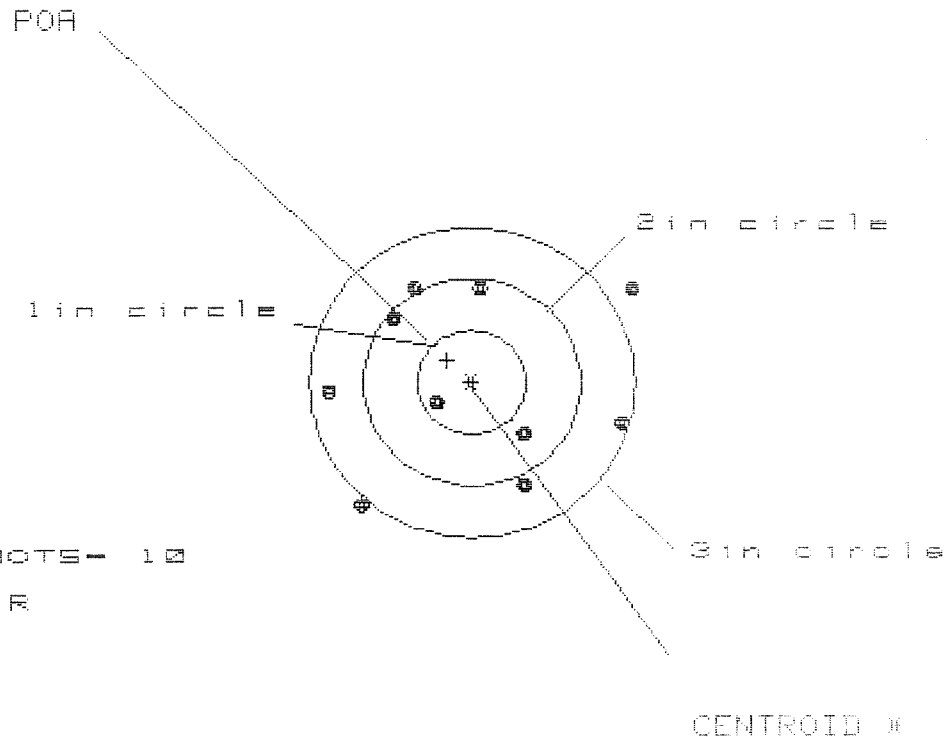
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.917	.959	1.051
MINIMUM X	:	-1.286	-1.244	-1.152
MAXIMUM Y	:	1.556	1.349	1.321
MINIMUM Y	:	-1.863	-1.453	-1.285
CENTROID X	:	-.106	-.148	-.240
CENTROID Y	:	.053	.260	.092
POA TO CENTROID in.	:	.119	.299	.257
MIN RADIUS	:	.361	.424	.293
MEAN RADIUS	:	1.172	1.084	.998
MAX RADIUS	:	1.901	1.675	1.689
HORIZONTAL SPREAD	:	2.203	2.203	2.203
VERTICAL SPREAD	:	3.419	2.802	2.606
EXTREME SPREAD	:	3.434	3.214	3.163
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	

25 Jan 1989

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS= 2.827

VS= 2.159

GS= 3.221

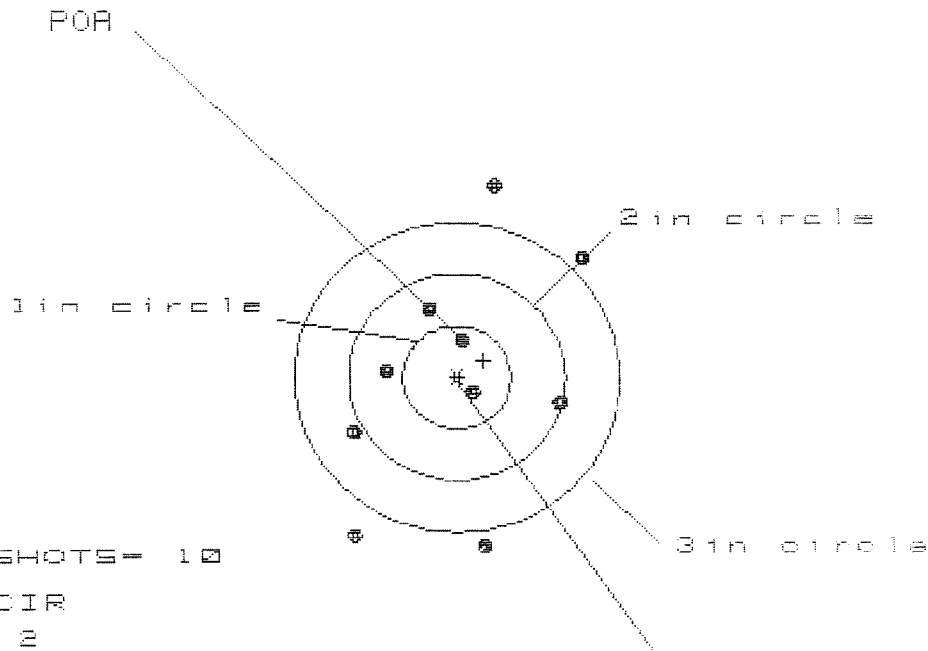
PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.480
MINIMUM X	-1.347
MAXIMUM Y	.942
MINIMUM Y	-1.217
CENTROID X	.222
CENTROID Y	-.211
POA TO CENTROID in.	.306
MIN RADIUS	.335
MEAN RADIUS	1.107
MAX RADIUS	1.713
HORIZONTAL SPREAD	2.827
VERTICAL SPREAD	2.159
EXTREME SPREAD	3.221
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	8

25 Jan 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C8225177

CENTERFIRE PATTERNS

4



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 4

3 in = 6

HS= 2.099

VS= 3.520

GS= 3.677

PATTERN # :

4

SHOTS (BEST OF) :

10

9

8

MAXIMUM X :

1.123

1.165

1.048

MINIMUM X :

-.976

-.934

-1.042

MAXIMUM Y :

1.873

1.416

1.249

MINIMUM Y :

-1.647

-1.439

-1.606

CENTROID X :

-.249

-.291

-.174

CENTROID Y :

-.166

-.374

-.207

POA TO CENTROID in.:

.299

.474

.271

MIN RADIUS :

.152

.181

.075

MEAN RADIUS :

1.096

1.018

.904

MAX RADIUS :

1.912

1.834

1.631

HORIZONTAL SPREAD :

2.099

2.099

2.090

VERTICAL SPREAD :

3.520

2.855

2.855

EXTREME SPREAD :

3.677

3.461

2.981

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

4

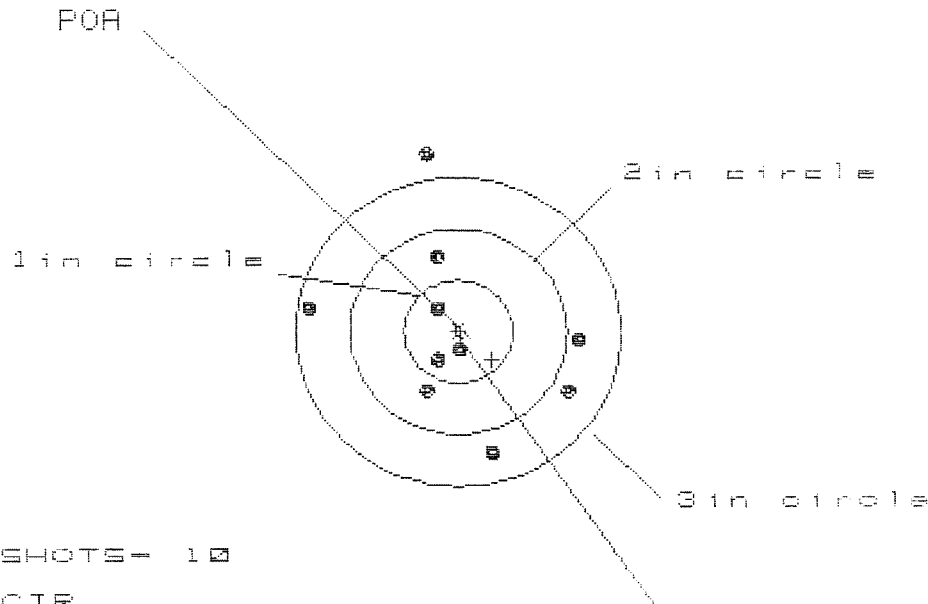
NUMBER IN THREE INCH CIRCLE =

6

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FILE:/PATTERNING/CENTERFIRE_PATT/C6225177

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 5

3 in = 9

HS= 2.471

VS= 2.859

GS= 2.915

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.104	1.073	.899
MINIMUM X	-1.367	-1.398	-.457
MAXIMUM Y	1.730	.903	.955
MINIMUM Y	-1.129	-.936	-.884
CENTROID X	-.313	-.282	-.107
CENTROID Y	.271	.078	.026
POA TO CENTROID in.	.414	.293	.111
MIN RADIUS	.193	.025	.162
MEAN RADIUS	.886	.754	.689
MAX RADIUS	1.752	1.459	1.040
HORIZONTAL SPREAD	2.471	2.471	1.356
VERTICAL SPREAD	2.859	1.839	1.839
EXTREME SPREAD	2.915	2.532	1.966
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	