

C6594498

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5715**

* Includes 1 in chamber.



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MODEL 700™ M24

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.

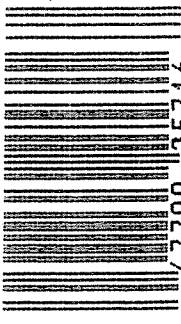
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

SERIAL NO. C6594498	ORDER NO. 5716
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5716 C6594498

UPC



0 47700 25716 7

OK - EJ-HOLE
O/L - SIGHTS

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6594498

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/31/90	KJ
600	Proof		10/31/90	KJ
607	Check Headspace		10/31/90	KJ
610	Dis-assemble Gun		10/31/90	KJ
612	Magnaflux Barrel Action		11/2/90	KCR
	Magnaflux Bolt		11/2/90	KCR
615	Rollmark Caliber		11/2/90	GS
617	Drill and Tap Sight Holes		11/5/90	FB
618	Polish Barrel RB		11/6/90	WB
620	Apply Coatings (Barrel Action)		11/20/90	JA
	Apply Coating (Bolt)			JA
625	Final Assembly A) Clean inside of Bolt Assembly		12/7/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/7/90	KS
	C) Inspect Ejector Hole for Chamfer		12/7/90	KS
	D) Oil Firing Pin Ass'y		12/7/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		12/8/90	JB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			12/10/90	W.B
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			12/10/90	W.B
	H) Trigger Pull Test & Retainability						12/8/90	W
	I) Firing Pin Indent	0205	0205	0205			12/10/90	W.B
	J) Assemble Stock						12/10/90	KS
	K) Assemble Swivel Studs						12-12-90	KS
	L) Attach Front and Rear Sight Assemblies						12/10/90	KS
	M) Iron Sight Alignment						12/10/90	KS
	N) Detach Front & Rear Sights & place in numbered container						12/10/90	KS
	O) Attach Scope to Rifle						12/10/90	KS
	P) Detach & Attach Scope 20 Times						12/10/90	KS
640	Gallery Target & Test						12/11/90	KS
	A) Time							KS
	B) Malfunctions							KS
	C) Pierced Primers							KS
	D) Optical Clarity of Scope							KS
645	Inspect for Live Ammo						12/11/90	KS
655	Final Inspection						12-12-90	KS
	A) Headspace						12-12-90	KS
	B) Trigger Pull	244	262	253	243	258	12-12-90	KS
	C) Function						12/12-90	KS
660	Pack						12/14/90	W

Safe hits stock

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06594498
11 Dec 1990

CENTROIDAL DISTANCES

0 TO	1	.065521
1 TO	2	.478657
1 TO	3	.0556058
1 TO	4	.320506
1 TO	5	.0850941

$\frac{1}{4}$ ² <----POA

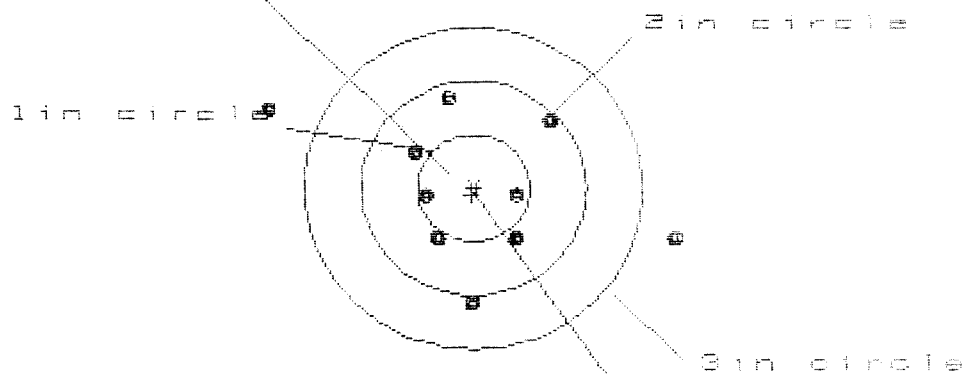
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0986
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0488
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .110015
THE AMR FOR THIS RIFLE IS: .9752

11 Dec 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08594488

CENTERFIRE PATTERNS # 1

POA



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 8

HS= 3.607

VS= 1.991

GS= 3.792

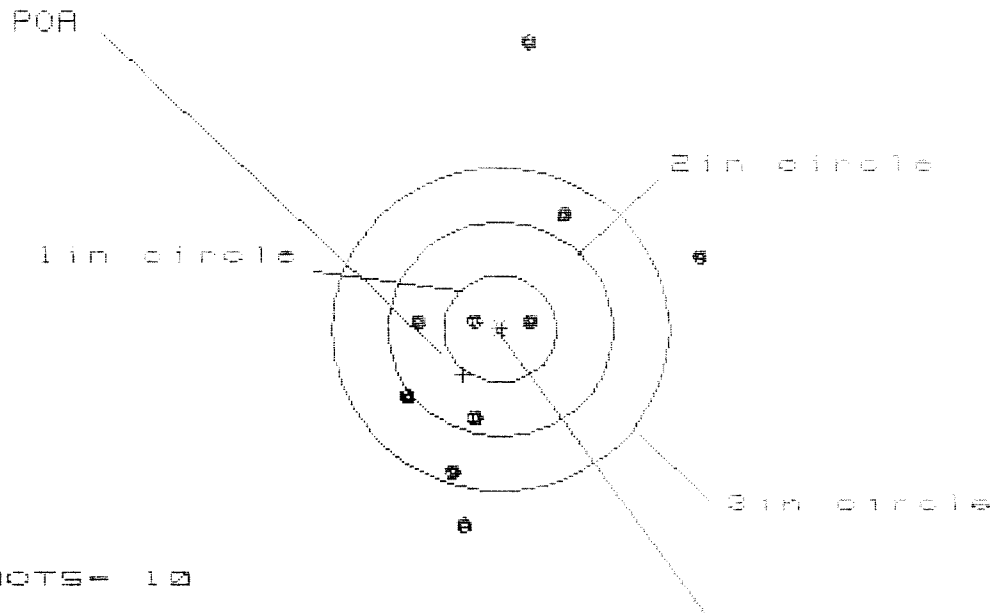
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.754	1.548	.658
MINIMUM X	:	-1.853	-.686	-.492
MAXIMUM Y	:	.882	.966	.923
MINIMUM Y	:	-1.109	-1.025	-1.068
CENTROID X	:	.018	.224	.080
CENTROID Y	:	.063	-.021	.021
POA TO CENTROID in.	:	.065	.225	.037
MIN RADIUS	:	.416	.209	.405
MEAN RADIUS	:	.931	.800	.685
MAX RADIUS	:	1.999	1.585	1.068
HORIZONTAL SPREAD	:	3.607	2.234	1.150
VERTICAL SPREAD	:	1.991	1.991	1.991
EXTREME SPREAD	:	3.792	2.353	2.001
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

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FILE:/PATTERNING/CENTERFIRE_PATT/08534498

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 4

3 in = 7

HS = 2.516

VS = 4.499

GS = 4.546

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.739	1.770	.846
MINIMUM X	:	-.877	-.846	-.624
MAXIMUM Y	:	2.696	1.352	1.477
MINIMUM Y	:	-1.803	-1.503	-1.378
CENTROID X	:	.330	.300	.078
CENTROID Y	:	.426	.126	.001
POA TO CENTROID in.	:	.539	.325	.078
MIN RADIUS	:	.232	.428	.427
MEAN RADIUS	:	1.223	1.036	.872
MAX RADIUS	:	2.711	2.033	1.702
HORIZONTAL SPREAD	:	2.516	2.516	1.470
VERTICAL SPREAD	:	4.499	2.855	2.855
EXTREME SPREAD	:	4.546	3.277	3.015
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 1

2in = 9

3in = 9

HS = 2.479

VS = 1.456

GS = 2.513

CENTROID *

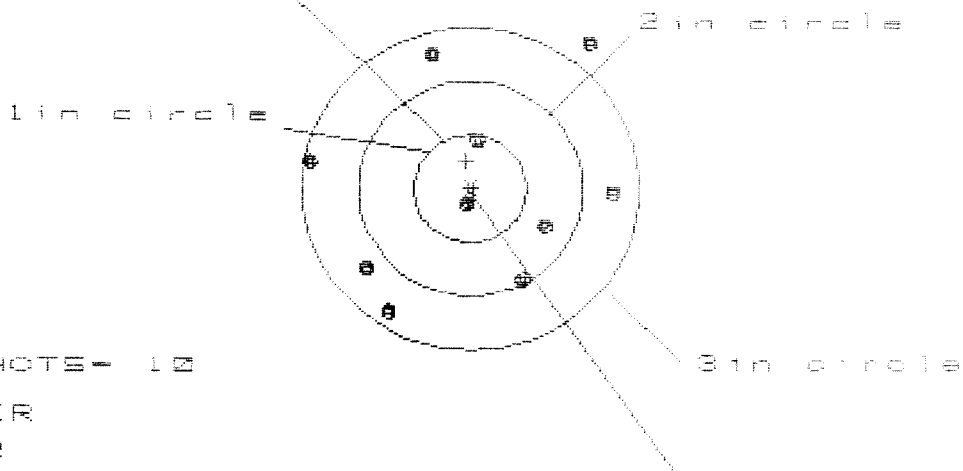
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.592	.776	.688
MINIMUM X	:	-.887	-.710	-.535
MAXIMUM Y	:	.796	.818	.794
MINIMUM Y	:	-.660	-.638	-.662
CENTROID X	:	.062	-.115	-.027
CENTROID Y	:	.029	.007	.031
POA TO CENTROID in.	:	.068	.115	.041
MIN RADIUS	:	.350	.471	.395
MEAN RADIUS	:	.761	.647	.633
MAX RADIUS	:	1.605	.869	.796
HORIZONTAL SPREAD	:	2.479	1.486	1.222
VERTICAL SPREAD	:	1.456	1.456	1.456
EXTREME SPREAD	:	2.513	1.596	1.477
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4

POB



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

HS= 2.557

VS= 2.557

GS= 3.116

CENTROID *

PATTERN # : 4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.276	1.390	1.227
MINIMUM X	-1.421	-1.307	-1.994
MAXIMUM Y	1.371	1.436	1.483
MINIMUM Y	-1.186	-1.034	-1.987
CENTROID X	.036	-.078	.085
CENTROID Y	-.257	-.489	-.456
POB TO CENTROID in.	.259	.416	.463
MIN RADIUS	.145	.104	.081
MEAN RADIUS	1.065	.982	.908
MAX RADIUS	1.714	1.454	1.534
HORIZONTAL SPREAD	2.697	2.697	2.221
VERTICAL SPREAD	2.557	2.470	2.470
EXTREME SPREAD	3.116	2.714	2.503
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		9	

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FILE:/PATTERNING/CENTERFIRE_PATT/C8594498

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 1.850

VS= 2.700

GS= 3.060

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.841
MINIMUM X	-1.009
MAXIMUM Y	1.309
MINIMUM Y	-1.391
CENTROID X	.047
CENTROID Y	-.017
POA TO CENTROID in.	.050
MIN RADIUS	.479
MEAN RADIUS	.896
MAX RADIUS	1.556
HORIZONTAL SPREAD	1.850
VERTICAL SPREAD	2.700
EXTREME SPREAD	3.060
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	8

SWS TRIGGER PULL TEST

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

SERIAL NO. C6594498
DATE 12/8/90
TESTER [Signature]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.32	2.41	2.42	2.44	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.28	2.37	2.38	2.62	
PULL #3	2.28	2.36	2.39	2.53	
PULL #4	2.33	2.43	2.38	2.43	
PULL #5	2.35	2.40	2.35	2.58	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.37	3.31		
PULL #2	3.32	3.37		
PULL #3	3.35	3.36		
PULL #4	3.38	3.41		
PULL #5	3.34	3.36		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.39	4.26		4.24
PULL #2	4.20	4.23		4.24
PULL #3	4.11	4.22		4.20
PULL #4	4.34	4.12		4.16
PULL #5	4.33	4.20		4.16
TOTAL				
AVG.				