

C6594562

MODEL 700™ M24

Model **SMS**™

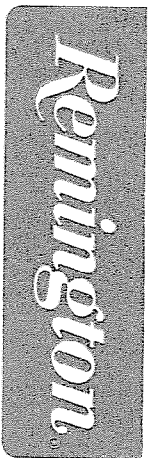
Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.






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

MODEL 700™

W24

SERIAL NO.
06594560

ORDER NO.
5716

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

LPC

0 4700 25716

5716 06594560

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6594560

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1228	90	RW
600	Proof	1228	90	RW
607	Check Headspace	1228	90	RW
610	Dis-assemble Gun	1228	90	RW
612	Magnaflux Barrel Action		1-7-91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	GL
617	Drill and Tap Sight Holes	1	1091	LB
618	Polish Barrel	1	1091	WB
620	Apply Coatings (Barrel Action)		1-13-91	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		1/19/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/19/91	RW
	C) Inspect Ejector Hole for Chamfer		1/19/91	RW
	D) Oil Firing Pin Ass'y		1/19/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		1-25-91	RU

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			1/25/91	WB
	G) Safety Off Force	2 1/4	2 1/4	2 1/4			1/25/91	WB
	H) Trigger Pull Test & Retainability						1-25-91	JV
	I) Firing Pin Indent	.0205	.0205	.0205			1/25/91	WB
	J) Assemble Stock						1/28/91	RW
	K) Assemble Swivel Studs						2-4-91	AC
	L) Attach Front and Rear Sight Assemblies						1/28/91	RW
	M) Iron Sight Alignment						1/28/91	RW
	N) Detach Front & Rear Sights & place in numbered container						1/28/91	RW
	O) Attach Scope to Rifle						1/28/91	RW
	P) Detach & Attach Scope 20 Times						1/28/91	RW
640	Gallery Target & Test						1-28-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						1-28-91	NF
655	Final Inspection							
	A) Headspace						2-4-91	AC
	B) Trigger Pull	2.36	2.36	2.36	2.37	2.20	2-1-91	JV
	C) Function						2-4-91	AC
660	Pack						3-18-91	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6594560

DATE 1-25-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.25	2.26	2.50	2.36	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.18	2.37	2.41	2.36	
PULL #3	2.21	2.45	2.40	2.36	
PULL #4	2.34	2.42	2.51	2.37	
PULL #5	2.20	2.49	2.50	2.20	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.22		
PULL #2	3.27	3.18		
PULL #3	3.13	3.20		
PULL #4	3.23	3.16		
PULL #5	3.34	3.22		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.29	4.38		4.25
PULL #2	4.26	4.31		4.14
PULL #3	4.28	4.38		4.15
PULL #4	4.31	4.32		4.26
PULL #5	4.29	4.36		4.20
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594560
29 Jan 1991

CENTROIDAL DISTANCES

0	TO	1	.303908
1	TO	2	.437919
1	TO	3	.253513
1	TO	4	.342965
1	TO	5	.430048

5
31 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.04
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0248
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0470642

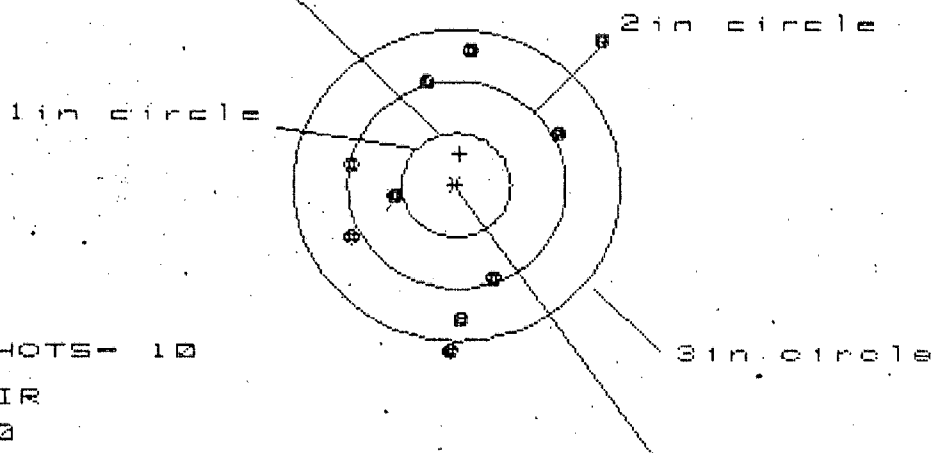
THE AMR FOR THIS RIFLE IS: .8926

29 Jan 1991

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CENTERFIRE PATTERNS # 1

POA



OF SHOTS - 10

IN CIR

1in = 0

2in = 3

3in = 7

HS = 2.256

VS = 3.025

GS = 3.306

CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.314	1.080	1.096
MINIMUM X	:	-.942	-.796	-.780
MAXIMUM Y	:	1.390	1.464	1.279
MINIMUM Y	:	-1.635	-1.480	-1.333
CENTROID X	:	-.034	-.180	-.196
CENTROID Y	:	-.302	-.457	-.272
POA TO CENTROID in.	:	.304	.491	.335
MIN RADIUS	:	.621	.470	.469
MEAN RADIUS	:	1.192	1.078	1.017
MAX RADIUS	:	1.913	1.494	1.354
HORIZONTAL SPREAD	:	2.256	1.876	1.876
VERTICAL SPREAD	:	3.025	2.944	2.612
EXTREME SPREAD	:	3.306	2.949	2.613
NUMBER IN ONE INCH CIRCLE =			0	
NUMBER IN TWO INCH CIRCLE =			3	

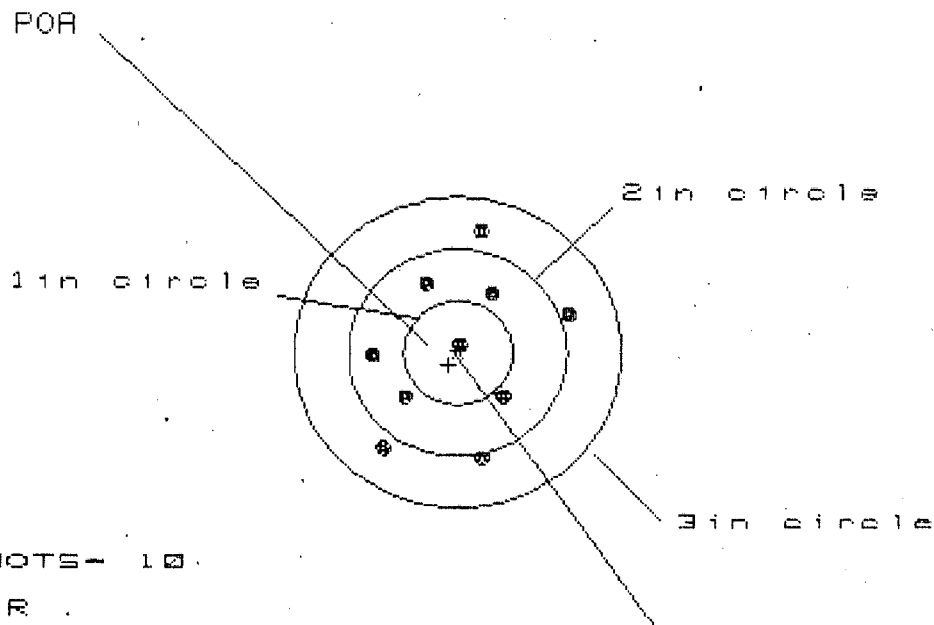
NUMBER IN THREE INCH CIRCLE =

8

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 1.849

VS= 2.217

GS= 2.218

CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.026	1.047	.969
MINIMUM X	:	-.823	-.802	-.880
MAXIMUM Y	:	1.168	.822	.729
MINIMUM Y	:	-1.049	-.919	-1.012
CENTROID X	:	.083	.062	.140
CENTROID Y	:	.120	-.010	.083
POA TO CENTROID in.	:	.146	.063	.163
MIN RADIUS	:	.114	.243	.138
MEAN RADIUS	:	.801	.761	.719
MAX RADIUS	:	1.183	1.152	1.044
HORIZONTAL SPREAD	:	1.849	1.849	1.849
VERTICAL SPREAD	:	2.217	1.741	1.741
EXTREME SPREAD	:	2.218	2.070	1.896
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 8

3 in = 8

HS= 1.564

VS= 3.806

GS= 3.940

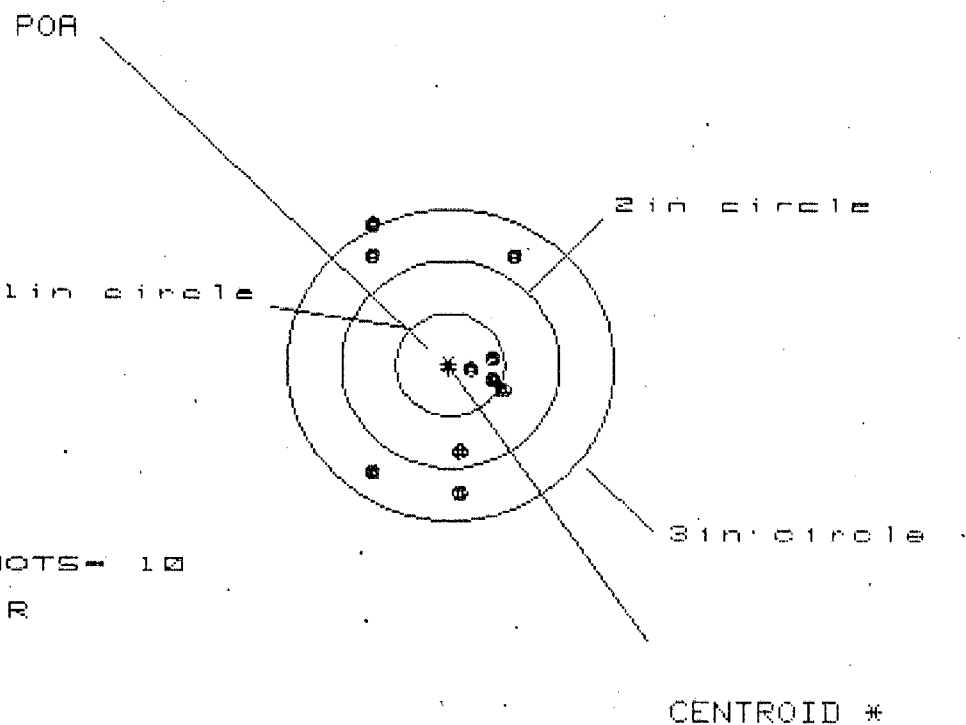
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.697	.750	.690
MINIMUM X	:	-.867	-.814	-.874
MAXIMUM Y	:	2.055	.890	.699
MINIMUM Y	:	-1.751	-1.522	-.658
CENTROID X	:	-.198	-.251	-.191
CENTROID Y	:	-.107	-.336	-.145
POA TO CENTROID in.	:	.225	.419	.240
MIN RADIUS	:	.127	.204	.159
MEAN RADIUS	:	.885	.758	.615
MAX RADIUS	:	2.111	1.597	.881
HORIZONTAL SPREAD	:	1.564	1.564	1.564
VERTICAL SPREAD	:	3.806	2.412	1.357
EXTREME SPREAD	:	3.940	2.450	1.567
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 5

3 in = 8

HS= 1.268

VS= 2.606

GS= 2.712

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.569	.491	.396
MINIMUM X	:	-.699	-.761	-.839
MAXIMUM Y	:	1.411	1.193	1.083
MINIMUM Y	:	-1.196	-1.039	-1.149
CENTROID X	:	.011	.089	.184
CENTROID Y	:	.038	-.118	-.008
POA TO CENTROID in.	:	.040	.148	.184
MIN RADIUS	:	.180	.126	.022
MEAN RADIUS	:	.874	.749	.661
MAX RADIUS	:	1.574	1.406	1.370
HORIZONTAL SPREAD	:	1.268	1.252	1.235
VERTICAL SPREAD	:	2.606	2.232	2.232
EXTREME SPREAD	:	2.712	2.417	2.344
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			5	

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR .

1in = 3

2in = 7

3in = 10

HS= 1.215

VS= 2.039

GS= 2.280

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.602	.660	.605
MINIMUM X	:	-.613	-.555	-.473
MAXIMUM Y	:	1.129	.709	.614
MINIMUM Y	:	-.910	-.785	-.880
CENTROID X	:	-.064	-.122	-.204
CENTROID Y	:	.127	.002	.097
POA TO CENTROID in.	:	.142	.122	.226
MIN RADIUS	:	.247	.371	.267
MEAN RADIUS	:	.711	.662	.595
MAX RADIUS	:	1.241	1.011	.953
HORIZONTAL SPREAD	:	1.215	1.215	1.078
VERTICAL SPREAD	:	2.039	1.494	1.494
EXTREME SPREAD	:	2.280	1.782	1.782
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			10	