

C6587548

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.




REG. U.S. PAT. & TM. OFF.

MODEL 700™ H24

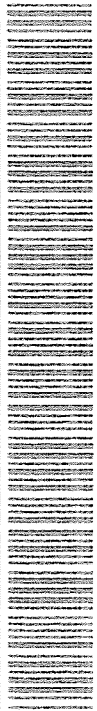
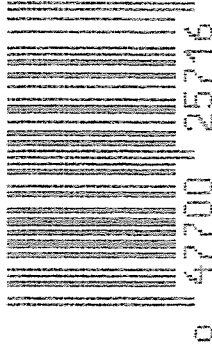
20

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

SERIAL NO.
C6587548

ORDER NO.
5716

UPC



5716 C6587548

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587548

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		"	LS
617	Drill and Tap Sight Holes	1 10	91	LB
618	Polish Barrel	1 10	91	LB
620	Apply Coatings (Barrel Action)		1-26-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		1/28/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/28/91	RW
	C) Inspect Ejector Hole for Chamfer		1/28/91	RW
	D) Oil Firing Pin Ass'y		1/28/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2/11/91	JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			2/13/91	WB
	G) Safety Off Force	2	2	2			2/13/91	WB
	H) Trigger Pull Test & Retainability						2/11/91	YU
	I) Firing Pin Indent	.022	.023	.0225			2/13/91	WB
	J) Assemble Stock						2/13/91	RW
	K) Assemble Swivel Studs						2-22-91	AC
	L) Attach Front and Rear Sight Assemblies						2/13/91	RW
	M) Iron Sight Alignment						2/13/91	RW
	N) Detach Front & Rear Sights & place in numbered container						2/13/91	RW
	O) Attach Scope to Rifle						2/13/91	RW
	P) Detach & Attach Scope 20 Times						2/13/91	RW
640	Gallery Target & Test						2-13-91	EH
	A) Time						2-13-91	DH
	B) Malfunctions						2-13-91	DH
	C) Pierced Primers						2-13-91	DH
	D) Optical Clarity of Scope						2-13-91	DH
645	Inspect for Live Ammo						2-13-91	DH
655	Final Inspection							
	A) Headspace						2-22-91	K
	B) Trigger Pull	2.34	2.34	2.34	2.34	2.30	2/19/91	WB
	C) Function						2-22-91	A
660	Pack						3-19-91	NF

SWS TRIGGER PULL TEST

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

SERIAL NO C6587548
DATE 2/1/91
TESTER JPH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.51	2.38	2.33	2.34	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.33	2.39	2.35	2.34	
PULL #3	2.43	2.36	2.38	2.34	
PULL #4	2.40	2.34	2.40	2.34	
PULL #5	2.44	2.34	2.34	2.30	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.51	3.31		
PULL #2	3.45	3.19		
PULL #3	3.36	3.23		
PULL #4	3.33	3.46		
PULL #5	3.33	3.41		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.28	4.32		4.19
PULL #2	4.36	4.30		4.24
PULL #3	4.33	4.16		4.18
PULL #4	4.20	4.30		4.18
PULL #5	4.37	4.47		4.20
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06587548
14 Feb 1991

CENTROIDAL DISTANCES

0 TO 1	.241267
1 TO 2	.443208
1 TO 3	.806068
1 TO 4	.400839
1 TO 5	.39584

3
3.1 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1372
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0934
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .165974
THE AMR FOR THIS RIFLE IS: .9558

13 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8587548

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 3

2 in = 5

3 in = 8

HS= 2.9330

VS= 2.420

GS= 2.968

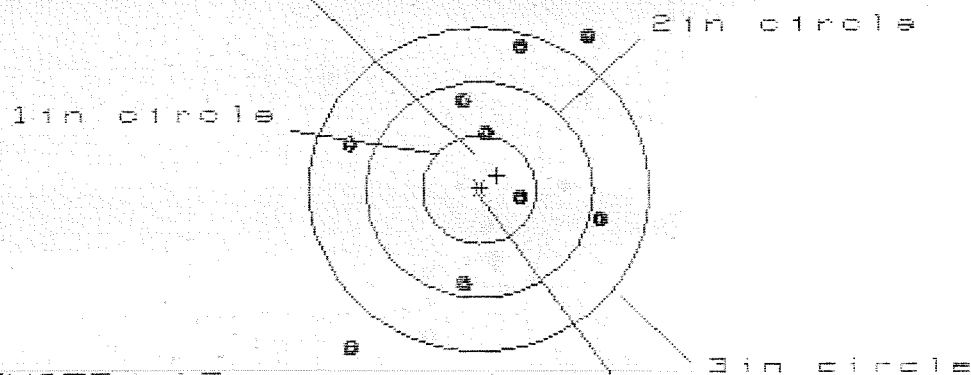
PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.888	1.224	1.281
MINIMUM X	:	-1.042	-.832	-.775
MAXIMUM Y	:	.866	.953	.770
MINIMUM Y	:	-1.554	-1.467	-.613
CENTROID X	:	.211	.001	-.056
CENTROID Y	:	.117	.030	.213
POA TO CENTROID in.	:	.241	.030	.221
MIN RADIUS	:	.270	.076	.187
MEAN RADIUS	:	.921	.726	.632
MAX RADIUS	:	2.045	1.535	1.283
HORIZONTAL SPREAD	:	2.930	2.056	2.056
VERTICAL SPREAD	:	2.420	2.420	1.383
EXTREME SPREAD	:	2.968	2.740	2.168
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	8		

13 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8587548

CENTERFIRE PATTERNS # 2

POA



OF SHOTS = 10

IN CIR

1in = 1

2in = 4

3in = 7

HS = 2.222

VS = 3.305

GS = 3.568

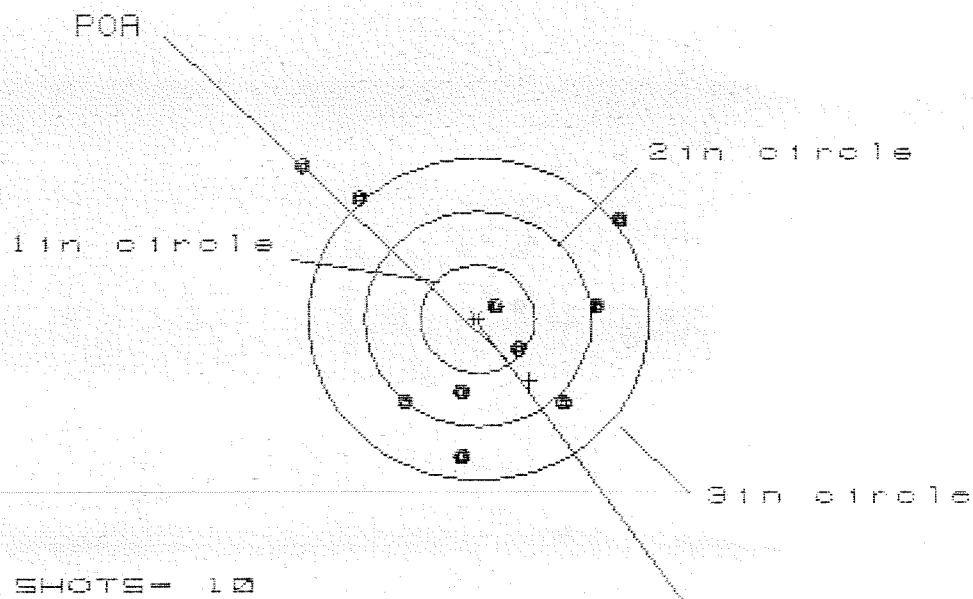
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.069	1.048	.906
MINIMUM X	:	-1.153	-1.174	-1.316
MAXIMUM Y	:	1.426	1.218	1.005
MINIMUM Y	:	-1.879	-1.697	-1.335
CENTROID X	:	-.157	-.136	.006
CENTROID Y	:	-.130	.078	.291
POA TO CENTROID in.	:	.204	.157	.291
MIN RADIUS	:	.396	.357	.192
MEAN RADIUS	:	1.194	1.082	.916
MAX RADIUS	:	1.888	2.043	1.378
HORIZONTAL SPREAD	:	2.222	2.222	2.222
VERTICAL SPREAD	:	3.305	2.915	2.340
EXTREME SPREAD	:	3.568	3.568	2.594
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

13 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06587548

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 2

2in = 3

3in = 7

HE= 2.780

VS= 2.651

GS= 3.187

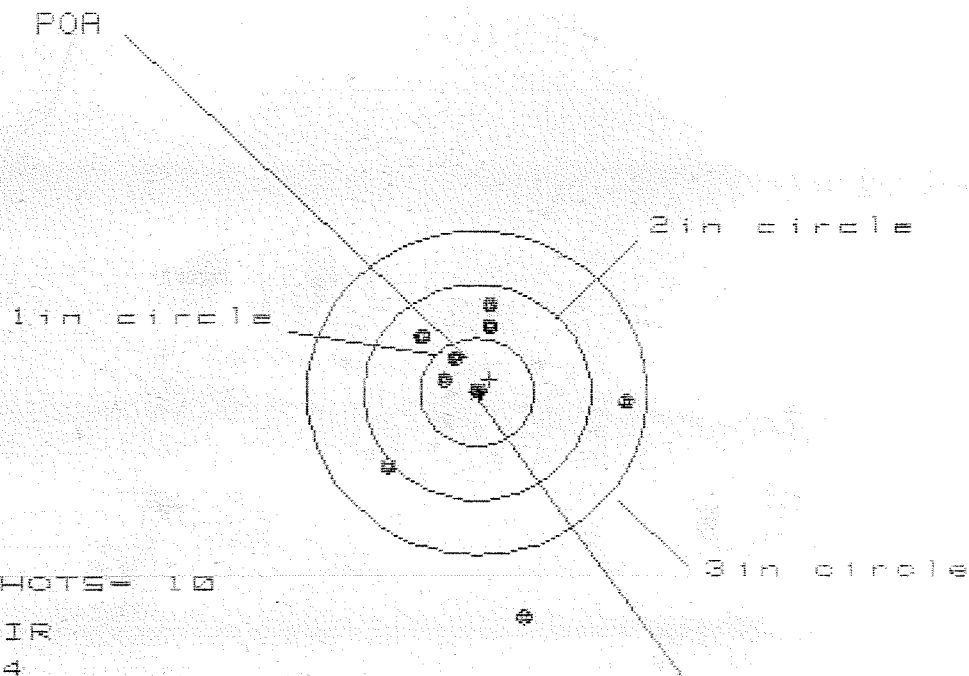
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.238	1.069	.917
MINIMUM X	:	-1.522	-1.219	-.975
MAXIMUM Y	:	1.417	1.321	1.225
MINIMUM Y	:	-1.234	-1.076	-.911
CENTROID X	:	-.453	-.284	-.132
CENTROID Y	:	.574	.416	.251
POA TO CENTROID in.	:	.731	.504	.284
MIN RADIUS	:	.241	.205	.063
MEAN RADIUS	:	1.098	.932	.789
MAX RADIUS	:	2.079	1.797	1.530
HORIZONTAL SPREAD	:	2.760	2.288	1.892
VERTICAL SPREAD	:	2.651	2.397	2.136
EXTREME SPREAD	:	3.187	2.675	2.563
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		7	

13 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06587548

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 4

2 in = 7

3 in = 9

HS = 2.091

VS = 2.843

GS = 2.864

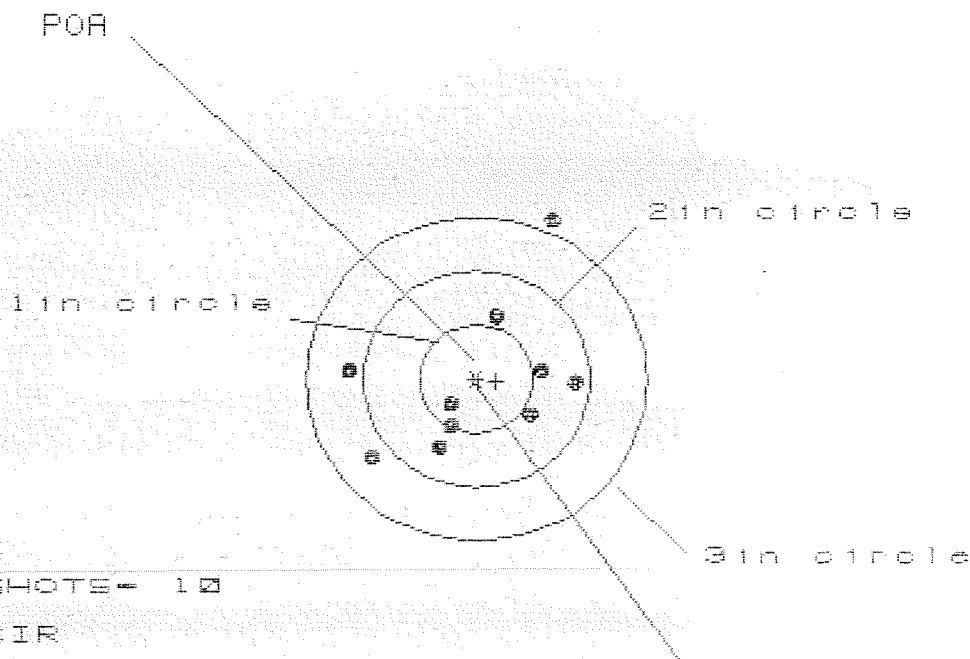
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.308	1.357	.319
MINIMUM X	:	-.783	-.734	-.564
MAXIMUM Y	:	.812	.586	.545
MINIMUM Y	:	-2.031	-.882	-.923
CENTROID X	:	-.113	-.162	-.332
CENTROID Y	:	-.119	.107	.148
POA TO CENTROID in.	:	.164	.194	.363
MIN RADIUS	:	.047	.159	.120
MEAN RADIUS	:	.771	.542	.406
MAX RADIUS	:	2.079	1.397	1.082
HORIZONTAL SPREAD	:	2.091	2.091	.983
VERTICAL SPREAD	:	2.843	1.468	1.468
EXTREME SPREAD	:	2.864	2.162	1.713
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

13 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6587548

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 9

HS = 1.977

VS = 2.204

GS = 2.730

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.877	.955	.851
MINIMUM X	-1.099	-1.022	-1.126
MAXIMUM Y	1.443	.767	.692
MINIMUM Y	-.761	-.601	-.504
CENTROID X	-.174	-.252	-.148
CENTROID Y	.025	-.136	-.061
POA TO CENTROID in.	.176	.287	.160
MIN RADIUS	.266	.113	.237
MEAN RADIUS	.795	.669	.631
MAX RADIUS	1.604	1.054	1.141
HORIZONTAL SPREAD	1.977	1.977	1.977
VERTICAL SPREAD	2.204	1.368	1.196
EXTREME SPREAD	2.730	1.979	1.979
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		