

C6587711

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.






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

MODEL 700TM H24

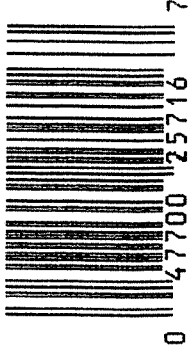
SERIAL NO.
C6587711

ORDER NO.
5716

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

01

LPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6587711

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/18/90	KA
600	Proof		10/18/90	KA
607	Check Headspace		10/18/90	KA
610	Dis-assemble Gun		10/18/90	KA
612	Magnaflux Barrel Action		10/22/90	KR
	Magnaflux Bolt		10/22/90	KR
615	Rollmark Caliber		10/22/90	JB
617	Drill and Tap Sight Holes		10/23/90	FB
618	Polish Barrel <i>RB</i>		10/24/90	WB
620	Apply Coatings (Barrel Action)		11/6/90	JA
	Apply Coating (Bolt)		11/6/90	JA
625	Final Assembly A) Clean inside of Bolt Assembly		11-6-90	K.S.
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11-6-90	K.S.
	C) Inspect Ejector Hole for Chamfer		11-6-90	K.S.
	D) Oil Firing Pin Ass'y		11-6-90	K.S.
	E) Adjust Trigger Pull to Min Setting and Stake		11/12/90	G.S.

op. #	OP. NAME	READINGS			DATE	INIT
625 cont.	F) Safety On Force	4. 1/2	4.0	4.0	11-7-90	KJ
	G) Safety Off Force	2. 1/4	2. 1/4	2. 1/4	11-7-90	KJ
	H) Trigger Pull Test & Retainability					
	I) Firing Pin Indent	.020	.021	.020	11-7-90	KJ
	J) Assemble Stock				11/12/90	KJ
	K) Assemble Swivel Studs				11/19/90	QJ8
	L) Attach Front and Rear Sight Assemblies				11/12/90	KJ
	M) Iron Sight Alignment				11/12/90	KJ
	N) Detach Front & Rear Sights & place in numbered container				11/12/90	KJ
	O) Attach Scope to Rifle				11/12/90	KJ
	P) Detach & Attach Scope 20 Times				11/12/90	KJ
640	Gallery Target & Test				11-13-90	AC
	A) Time				11-13-90	AC
	B) Malfunctions				11-13-90	AC
	C) Pierced Primers				11-13-90	AC
	D) Optical Clarity of Scope				11-13-90	AC
645	Inspect for Live Ammo				11-13-90	AC
655	Final Inspection					
	A) Headspace				11/19/90	QJ8
	B) Trigger Pull	290	251	242 244 241	11/19/90	QJ8
	C) Function				11/19/90	QJ8
660	Pack				12-17-90	DH

SWS TRIGGER PULL TEST

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

SERIAL NO. C658711
DATE 12/20/90
TESTER gss

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	255	237	210	290	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	386	241	220	251	
PULL #3	241	239	222	242	
PULL #4	234	239	223	244	
PULL #5	217	243	225	241	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	286	305		
PULL #2	303	303		
PULL #3	306	298		
PULL #4	303	299		
PULL #5	303	304		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	383	377		397
PULL #2	378	375		394
PULL #3	378	378		392
PULL #4	386	378		392
PULL #5	379	374		396
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587711
13 Nov 1998

CENTROIDAL DISTANCES

0 TO	1	.250505
1 TO	2	.492
1 TO	3	.284113
1 TO	4	.531361
1 TO	5	.523924

4.5 <----FOR
4

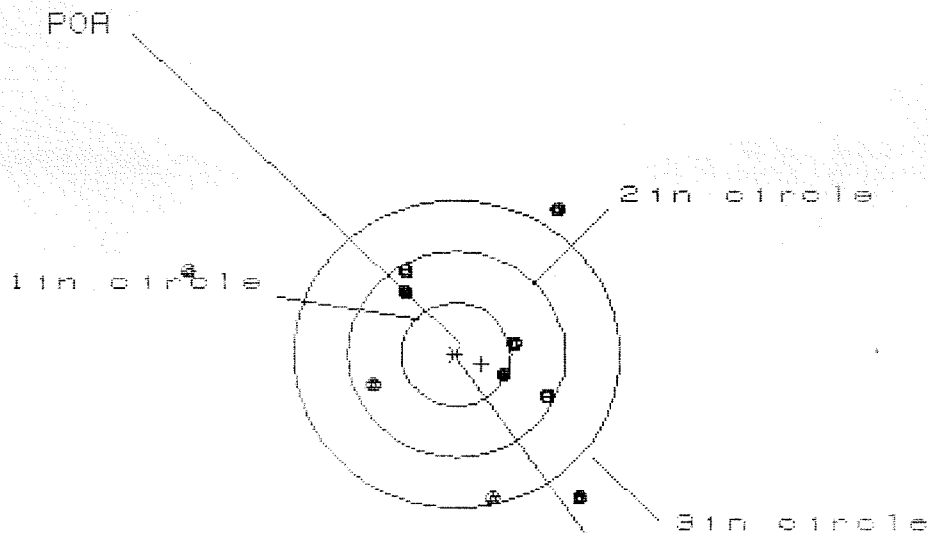
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0978
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0044
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0978989

THE AMR FOR THIS RIFLE IS: .9556

13 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06587711

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 7

HS= 3.611

VS= 2.829

GS= 4.213

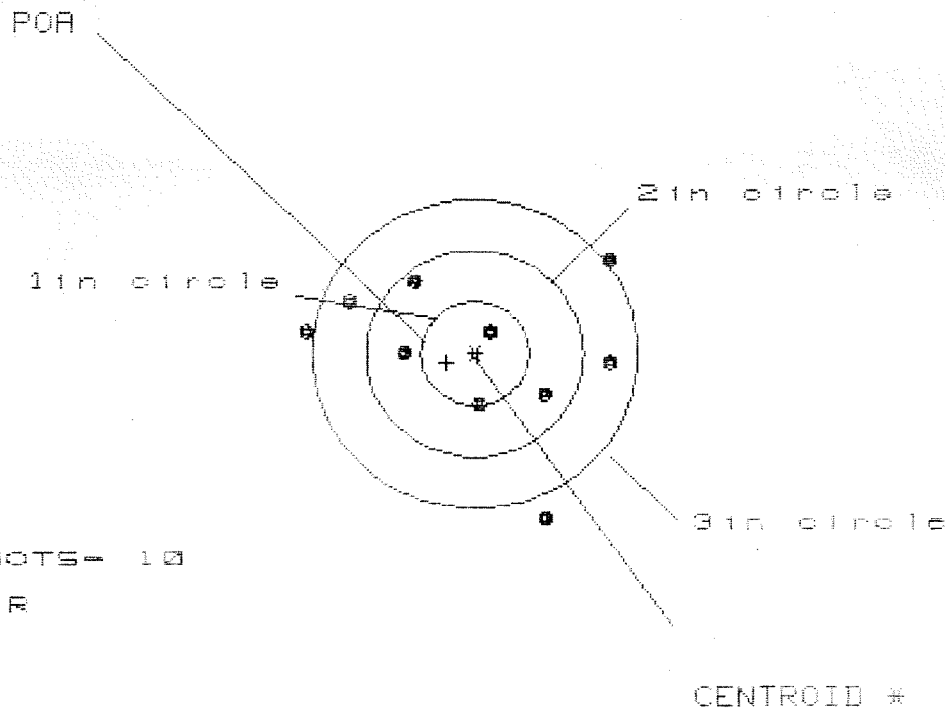
CENTROID *

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.141	.866	.793
MINIMUM X	:	-2.470	-1.037	-.928
MAXIMUM Y	:	1.394	1.481	1.319
MINIMUM Y	:	-1.435	-1.348	-1.510
CENTROID X	:	-.233	.042	-.067
CENTROID Y	:	.092	.005	.167
POA TO CENTROID in.	:	.250	.042	.180
MIN RADIUS	:	.487	.211	.352
MEAN RADIUS	:	1.208	1.001	.939
MAX RADIUS	:	2.592	1.632	1.539
HORIZONTAL SPREAD	:	3.611	1.903	1.721
VERTICAL SPREAD	:	2.829	2.829	2.829
EXTREME SPREAD	:	4.213	2.900	2.900
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	7		

13 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6587711

CENTERFIRE PATTERNS # 2



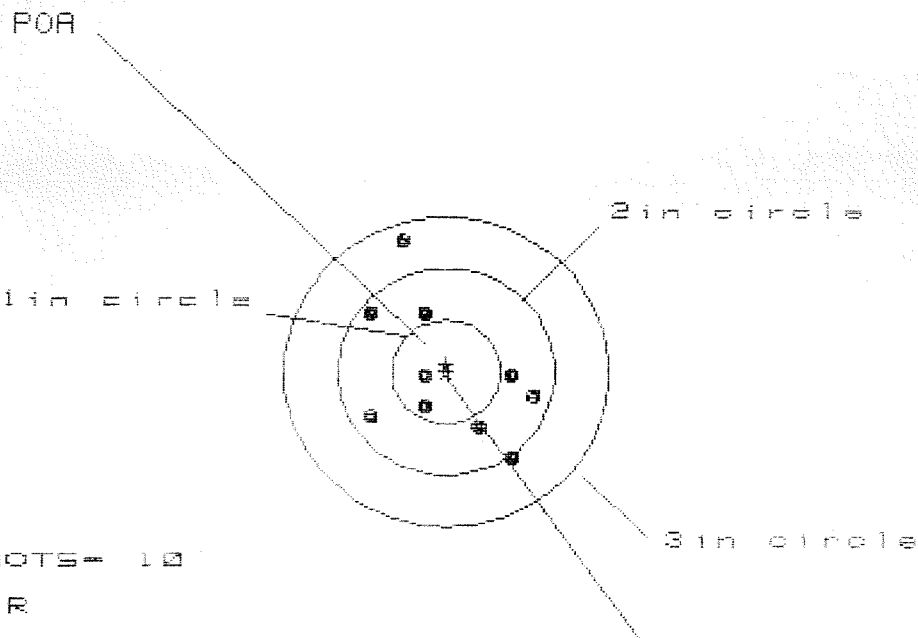
OF SHOTS- 10
IN CIR
1in = 2
2in = 5
3in = 7
HS= 2.794
VS= 2.510
GS= 2.836

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.266	1.337	1.154
MINIMUM X	:	-1.528	-1.457	-1.253
MAXIMUM Y	:	.897	.718	.719
MINIMUM Y	:	-1.613	-.627	-.626
CENTROID X	:	.259	.188	.371
CENTROID Y	:	.092	.271	.270
POA TO CENTROID in.	:	.275	.330	.458
MIN RADIUS	:	.255	.175	.061
MEAN RADIUS	:	1.027	.935	.859
MAX RADIUS	:	1.733	1.475	1.320
HORIZONTAL SPREAD	:	2.794	2.794	2.407
VERTICAL SPREAD	:	2.510	1.345	1.345
EXTREME SPREAD	:	2.836	2.836	2.482
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

13 Nov 1998

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 2

2in = 8

3in = 10

HS= 1.492

VS= 2.150

GS= 2.373

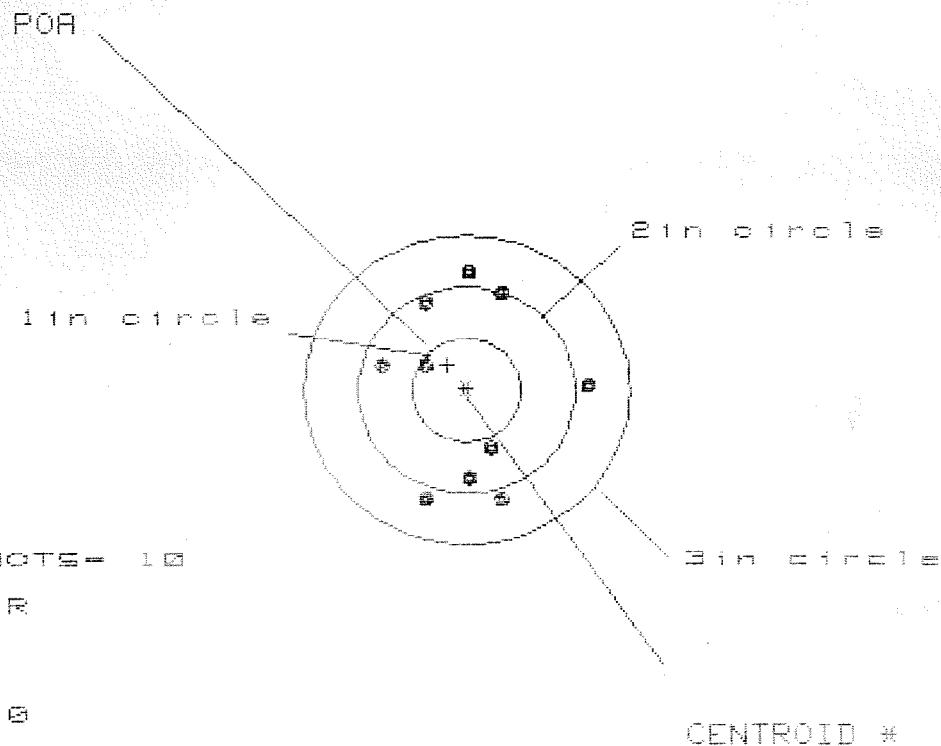
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.820	.779	.852
MINIMUM X	:	-.672	-.713	-.640
MAXIMUM Y	:	1.303	.762	.674
MINIMUM Y	:	-.847	-.702	-.498
CENTROID X	:	-.001	.040	-.033
CENTROID Y	:	-.072	-.217	-.129
POA TO CENTROID in.	:	.072	.221	.133
MIN RADIUS	:	.229	.293	.205
MEAN RADIUS	:	.739	.654	.613
MAX RADIUS	:	1.356	.994	.880
HORIZONTAL SPREAD	:	1.492	1.492	1.492
VERTICAL SPREAD	:	2.150	1.464	1.172
EXTREME SPREAD	:	2.373	1.907	1.702
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

13 Nov 1990

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 1.913

VS= 2.172

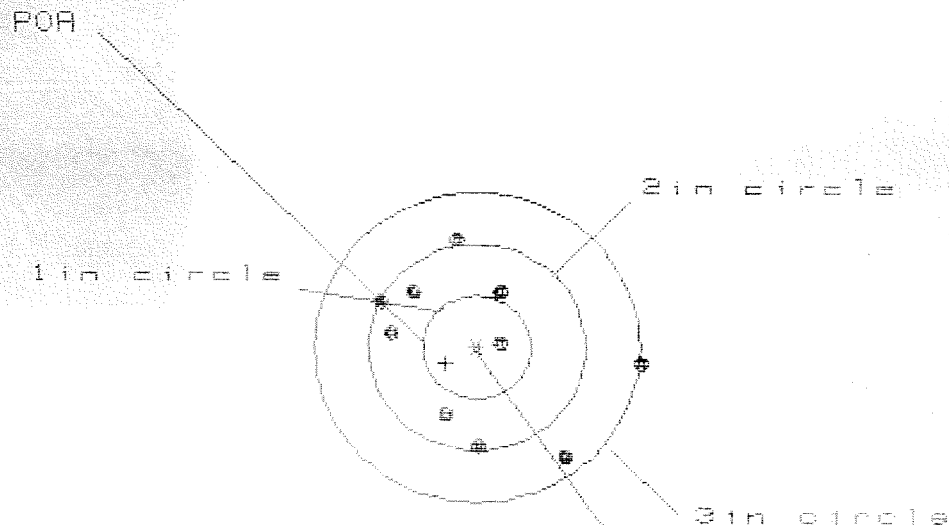
GS= 2.206

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.119	1.117	1.067
MINIMUM X	:	-.794	-.796	-.846
MAXIMUM Y	:	1.125	1.045	.929
MINIMUM Y	:	-1.046	-.921	-1.031
CENTROID X	:	.177	.179	.229
CENTROID Y	:	-.246	-.372	-.256
POA TO CENTROID in.	:	.304	.412	.344
MIN RADIUS	:	.453	.500	.500
MEAN RADIUS	:	.903	.869	.850
MAX RADIUS	:	1.126	1.126	1.067
HORIZONTAL SPREAD	:	1.913	1.913	1.913
VERTICAL SPREAD	:	2.172	1.966	1.960
EXTREME SPREAD	:	2.206	2.086	1.977
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

13 Nov 1998

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10
 # IN CIR
 1 in = 1
 2 in = 6
 3 in = 9
 HS= 2.418
 VS= 2.168
 GS= 2.500

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.523	.936	.495
MINIMUM X	:	-.894	-.725	-.608
MAXIMUM Y	:	1.082	1.064	.927
MINIMUM Y	:	-1.078	-1.096	-1.091
CENTROID X	:	.287	.118	.081
CENTROID Y	:	.156	.174	.311
POA TO CENTROID in.	:	.327	.211	.311
MIN RADIUS	:	.202	.369	.460
MEAN RADIUS	:	.901	.816	.711
MAX RADIUS	:	1.532	1.441	1.142
HORIZONTAL SPREAD	:	2.418	1.661	1.103
VERTICAL SPREAD	:	2.168	2.168	2.018
EXTREME SPREAD	:	2.500	2.374	2.036
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	