

C6587725

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.






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

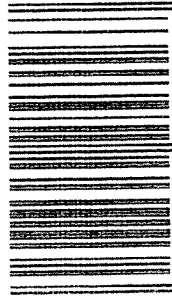
MODEL 700™ M24

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

SERIAL NO.
C6587725

ORDER NO.
5716

LPC



0 47700 25716 2



5716 C6587725

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6587725

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	GL
617	Drill and Tap Sight Holes		10/23/90	FB
618	Polish Barrel <i>FB</i>		10/24/90	WB
620	Apply Coatings (Barrel Action)		11-6-90	TS
	Apply Coating (Bolt)		11-6-90	TS
625	Final Assembly A) Clean inside of Bolt Assembly		11-6-90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11-6-90	KS
	C) Inspect Ejector Hole for Chamfer		11-6-90	KS
	D) Oil Firing Pin Ass'y		11-6-90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		1-24-91	JS

Op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			1/25/91	WB
	G) Safety Off Force	2	2	2			1/25/91	WB
	H) Trigger Pull Test & Retainability						1-24-91	GM
	I) Firing Pin Indent	.0207	.0205	.0205			1/25/91	WB
	J) Assemble Stock						1/25/91	KS
	K) Assemble Swivel Studs						2-4-91	KS
	L) Attach Front and Rear Sight Assemblies						1/25/91	KS
	M) Iron Sight Alignment						1/25/91	KS
	N) Detach Front & Rear Sights & place in numbered container						1/25/91	KS
	O) Attach Scope to Rifle						1/25/91	KS
	P) Detach & Attach Scope 20 Times						1/25/91	KS
640	Gallery Target & Test						1/28/91	K2
	A) Time						()	K2
	B) Malfunctions						()	K2
	C) Pierced Primers						()	K2
	D) Optical Clarity of Scope						()	K2
645	Inspect for Live Ammo						1/28/91	K2
655	Final Inspection							
	A) Headspace						2-4-91	KS
	B) Trigger Pull	2.28	2.31	2.24	2.27	2.39	2-1-91	GM
	C) Function						2-4-91	KS
660	Pack						3-19-91	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6587725

DATE 1/24/91

TESTER J.P.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.27	2.40	2.22	2.28	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.26	2.33	2.26	2.31	
PULL #3	2.50	2.37	2.22	2.24	
PULL #4	2.46	2.44	2.24	2.27	
PULL #5	2.39	2.16	2.12	2.39	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.40	3.41		
PULL #2	3.44	3.44		
PULL #3	3.48	3.47		
PULL #4	3.50	3.46		
PULL #5	3.53	3.46		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.36	4.50		4.42
PULL #2	4.42	4.43		4.17
PULL #3	4.39	4.37		4.35
PULL #4	4.41	4.47		4.23
PULL #5	4.48	4.50		4.30
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587725
29 Jan 1991

CENTROIDAL DISTANCES

0 TO	1	.466087
1 TO	2	.455887
1 TO	3	.29144
1 TO	4	.318823
1 TO	5	.35165

* <----POA

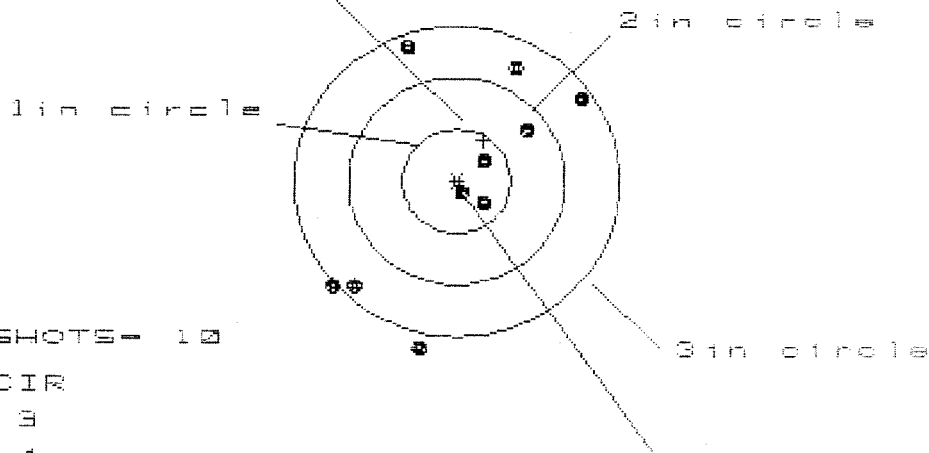
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1726
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1252
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .213227
THE AMR FOR THIS RIFLE IS: 1.094

29 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8587725

CENTERFIRE PATTERNS # 1

POA



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 4

3 in = 3

HS= 2.372

VS= 2.875

GS= 3.013

CENTROID #

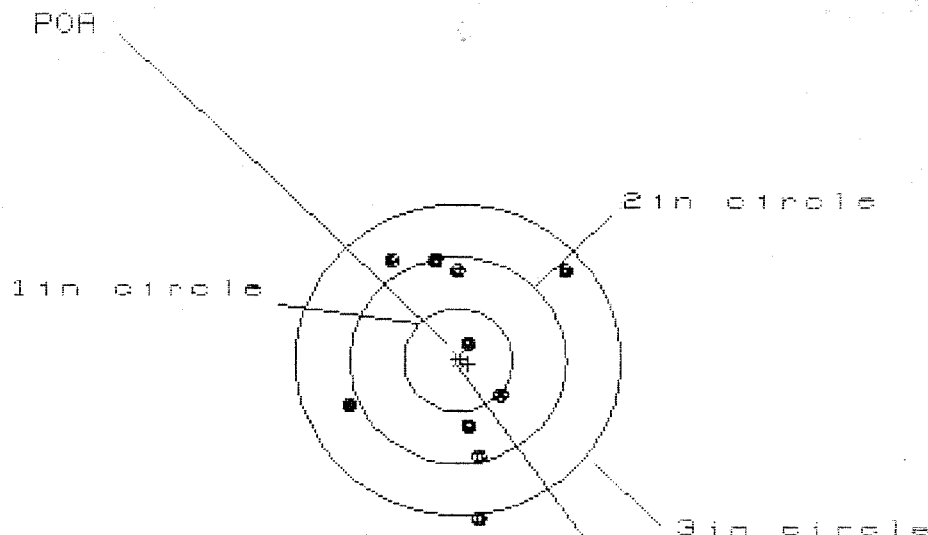
PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.188	1.151	.999
MINIMUM X	:	-1.184	-1.221	-1.154
MAXIMUM Y	:	1.301	1.126	.975
MINIMUM Y	:	-1.574	-1.205	-1.351
CENTROID X	:	-.249	-.212	-.068
CENTROID Y	:	-.394	-.219	-.068
POA TO CENTROID in.	:	.466	.305	.091
MIN RADIUS	:	.114	.182	.117
MEAN RADIUS	:	1.025	.946	.818
MAX RADIUS	:	1.609	1.715	1.777
HORIZONTAL SPREAD	:	2.372	2.372	2.153
VERTICAL SPREAD	:	2.875	2.331	2.326
EXTREME SPREAD	:	3.013	3.013	2.841
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	8		

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CENTERFIRE PATTERNS

2



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 1.910

VS= 2.572

GS= 2.659

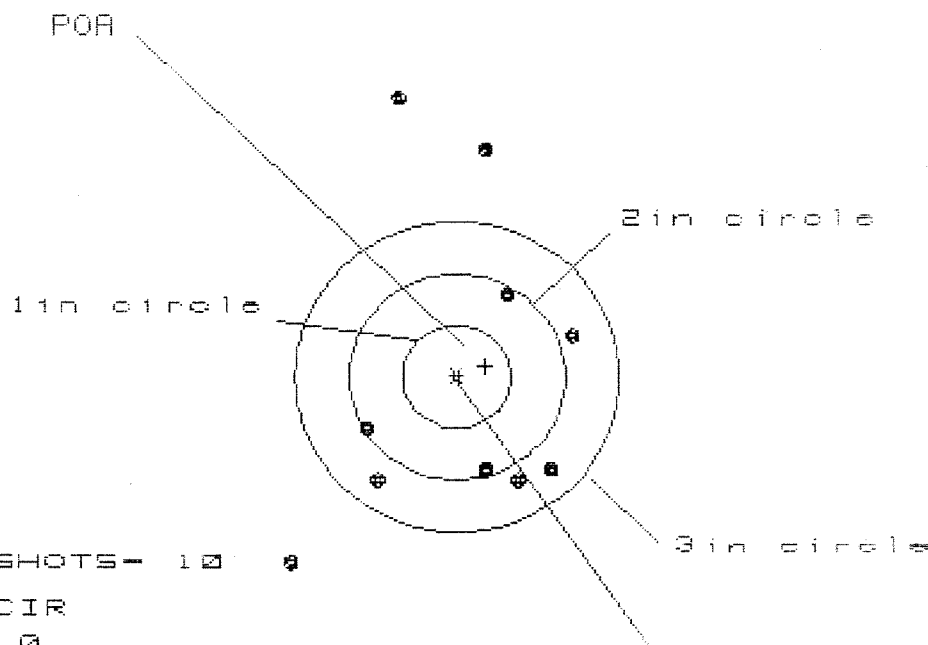
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.950	.970	.486
MINIMUM X	:	-.960	-.940	-.819
MAXIMUM Y	:	.999	.825	.907
MINIMUM Y	:	-1.573	-1.082	-1.000
CENTROID X	:	-.092	-.112	-.233
CENTROID Y	:	.034	.208	.126
POA TO CENTROID in.	:	.090	.236	.265
MIN RADIUS	:	.217	.080	.226
MEAN RADIUS	:	.925	.833	.799
MAX RADIUS	:	1.583	1.175	1.046
HORIZONTAL SPREAD	:	1.910	1.910	1.305
VERTICAL SPREAD	:	2.572	1.907	1.907
EXTREME SPREAD	:	2.659	2.289	2.027
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in - 0

2in - 3

3in - 7

HS= 2.611

VS= 4.481

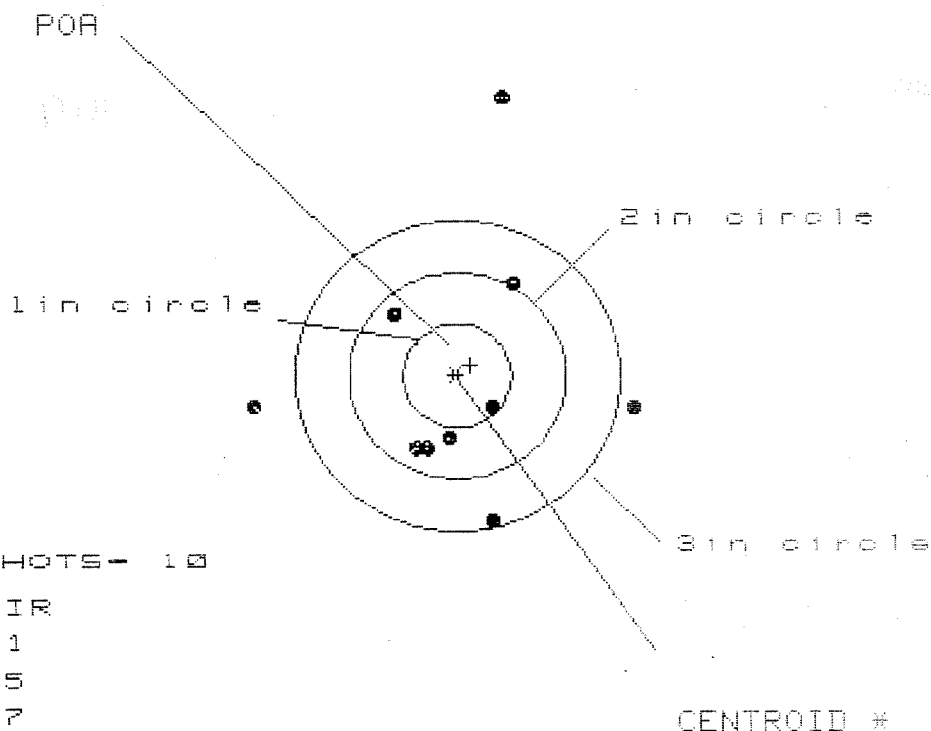
GS= 4.589

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.111
MINIMUM X	-1.500
MAXIMUM Y	2.722
MINIMUM Y	-1.759
CENTROID X	-0.265
CENTROID Y	-0.103
POA TO CENTROID in.	0.284
MIN RADIUS	0.862
MEAN RADIUS	1.493
MAX RADIUS	2.770
HORIZONTAL SPREAD	2.611
VERTICAL SPREAD	4.481
EXTREME SPREAD	4.589
NUMBER IN ONE INCH CIRCLE	0
NUMBER IN TWO INCH CIRCLE	3
NUMBER IN THREE INCH CIRCLE	7

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1in = 1

2in = 5

3in = 7

HS = 3.537

VS = 4.057

GS = 4.058

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	-1.622	1.667	1.433
MINIMUM X	:	-1.915	-1.870	-1.790
MAXIMUM Y	:	2.701	1.224	1.226
MINIMUM Y	:	-1.356	-1.056	-1.054
CENTROID X	:	-.121	-.166	.068
CENTROID Y	:	-.102	-.402	-.404
POA TO CENTROID in.	:	.158	.435	.410
MIN RADIUS	:	.486	.287	.164
MEAN RADIUS	:	1.223	.969	.849
MAX RADIUS	:	2.732	1.870	1.434
HORIZONTAL SPREAD	:	3.537	3.537	2.224
VERTICAL SPREAD	:	4.057	2.280	2.280
EXTREME SPREAD	:	4.058	3.537	2.425
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

CID

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 2.872

VS= 1.884

GS= 2.948

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.420	.852	.691
MINIMUM X	:	-1.452	-1.294	-.467
MAXIMUM Y	:	.974	1.080	1.131
MINIMUM Y	:	-.910	-.804	-.753
CENTROID X	:	-.136	-.294	-.133
CENTROID Y	:	-.061	-.168	-.219
POA TO CENTROID in.	:	.150	.339	.256
MIN RADIUS	:	.021	.180	.137
MEAN RADIUS	:	.805	.699	.587
MAX RADIUS	:	1.716	1.355	1.224
HORIZONTAL SPREAD	:	2.872	2.146	1.158
VERTICAL SPREAD	:	1.884	1.884	1.884
EXTREME SPREAD	:	2.948	2.185	1.966
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	

NUMBER IN THREE INCH CIRCLE =

9