

C6523423

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

* Includes 1 in chamber.





MODEL 700™
M24



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

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

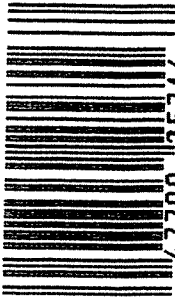
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

SERIAL NO.	C6523423
ORDER NO.	5716



5716 C6523423

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523423

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/1/90	KJ
600	Proof		10/1/90	KJ
607	Check Headspace		10/1/90	KJ
610	Dis-assemble Gun		10/1/90	KJ
612	Magnaflux Barrel Action		10/3/90	KR
	Magnaflux Bolt		10/3/90	KR
615	Rollmark Caliber		10/3/90	LS
617	Drill and Tap Sight Holes		10/4/90	FB
618	Polish Barrel <i>RB</i>		10/5/90	WB
620	Apply Coatings (Barrel Action)		10-20-90	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/21/90	KJ
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/21/90	KJ
	C) Inspect Ejector Hole for Chamfer		10/21/90	KJ
	D) Oil Firing Pin Ass'y		10/21/90	KJ
	E) Adjust Trigger Pull to Min Setting and Stake		11/2/90	JJ

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			11/2/90	RW
	G) Safety Off Force	2.5	2.5	2.5			11/2/90	RW
	H) Trigger Pull Test & Retainability						11/2/90	QPL
	I) Firing Pin Indent	.021	.022	.021			11/2/90	RW
	J) Assemble Stock						11/2/90	KH
	K) Assemble Swivel Studs						11-19-90	DH
	L) Attach Front and Rear Sight Assemblies						11/2/90	KH
	M) Iron Sight Alignment						11/2/90	KH
	N) Detach Front & Rear Sights & place in numbered container						11/2/90	KH
	O) Attach Scope to Rifle						11/2/90	KH
	P) Detach & Attach Scope 20 Times						11/2/90	KH
640	Gallery Target & Test						11-6-90	AC
	A) Time						11-6-90	AC
	B) Malfunctions						11-6-90	AC
	C) Pierced Primers						11-6-90	AC
	D) Optical Clarity of Scope						11-6-90	AC
645	Inspect for Live Ammo						11-6-90	AC
655	Final Inspection							
	A) Headspace						11-19-90	DH
	B) Trigger Pull	225	222	228	224	223	11-19-90	DH
	C) Function						11-19-90	DH
660	Pack						12-8-90	DH

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523423
6 Nov 1990

CENTROIDAL DISTANCES

0 TO	1	.0877097
1 TO	2	.109567
1 TO	3	.265887
1 TO	4	.0284253
1 TO	5	.223573

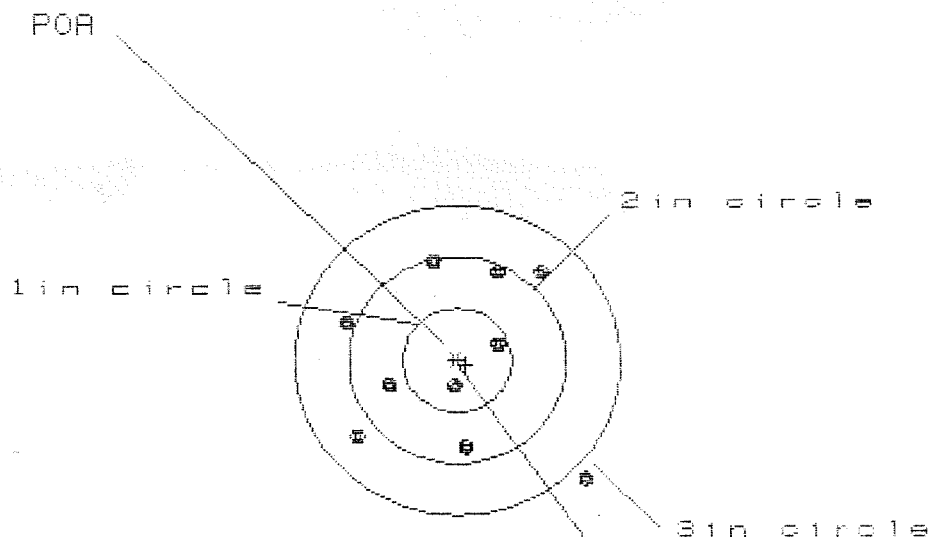
5. (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0542
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0228
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0598003
THE AMR FOR THIS RIFLE IS: .821

6 Nov 1990

FILE:/PATTERNING/CENTERFIRE_PATT/06523423

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS= 2.157

VS= 2.127

GS= 2.653

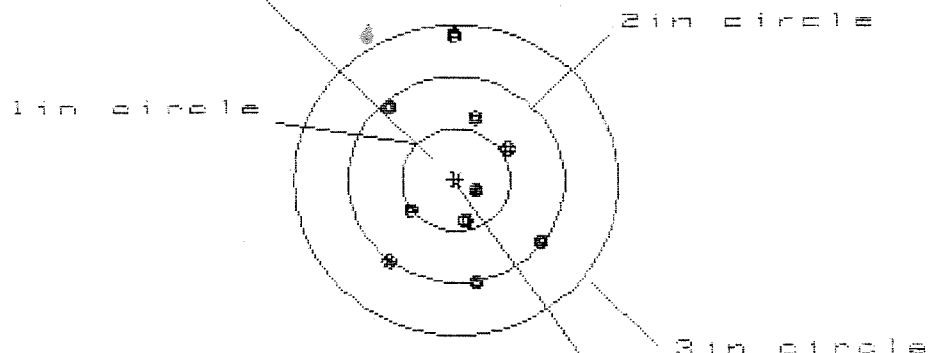
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.137	.935	.616
MINIMUM X	-1.020	-.894	-.777
MAXIMUM Y	.968	.839	.931
MINIMUM Y	-1.159	-.999	-.907
CENTROID X	-.077	-.203	-.320
CENTROID Y	.042	.171	.079
POA TO CENTROID in.	.088	.266	.330
MIN RADIUS	.235	.386	.367
MEAN RADIUS	.922	.843	.788
MAX RADIUS	1.624	1.189	1.048
HORIZONTAL SPREAD	2.157	1.829	1.393
VERTICAL SPREAD	2.127	1.838	1.838
EXTREME SPREAD	2.653	2.340	2.058
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

6 Nov 1990

FILE:/PATTERNING/CENTERFIRE_PATT/G6523423

CENTERFIRE PATTERNS # 2

FOR



OF SHOTS- 10

IN CIR

1in = 2

2in = 8

3in = 10

CENTROID #

HS= 1.420

VS= 2.365

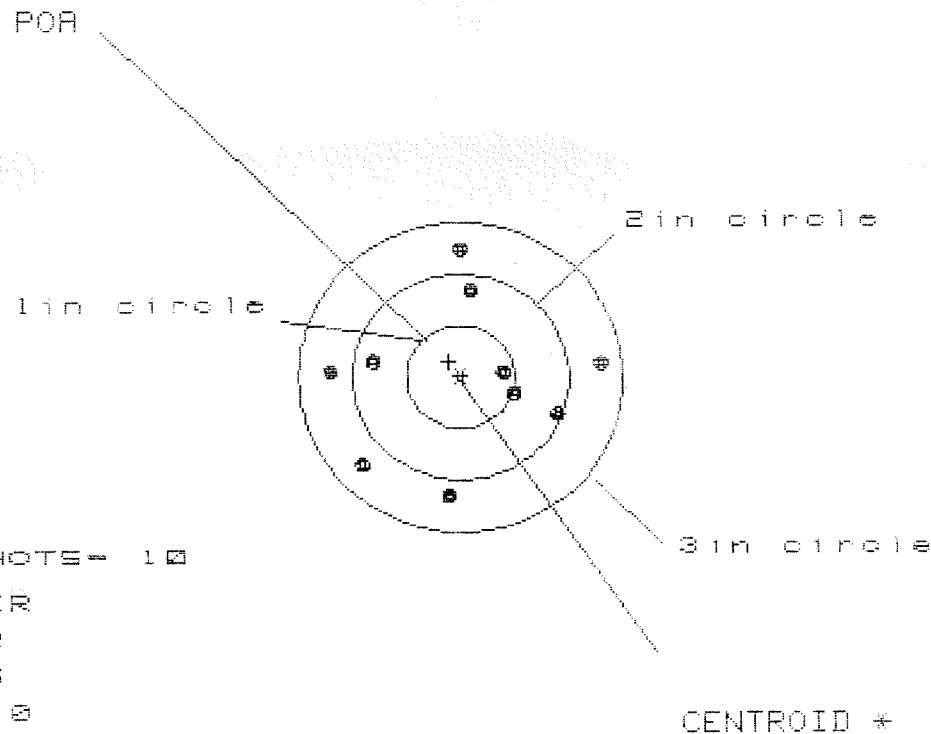
GS= 2.374

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.759	.754	.671
MINIMUM X	:	-.661	-.666	-.749
MAXIMUM Y	:	1.411	.898	.818
MINIMUM Y	:	-.954	-.797	-.877
CENTROID X	:	.021	.026	.109
CENTROID Y	:	-.007	-.164	-.084
FOR TO CENTROID in.	:	.022	.166	.138
MIN RADIUS	:	.186	.208	.098
MEAN RADIUS	:	.774	.683	.641
MAX RADIUS	:	1.412	1.118	1.109
HORIZONTAL SPREAD	:	1.420	1.420	1.420
VERTICAL SPREAD	:	2.365	1.695	1.695
EXTREME SPREAD	:	2.374	1.979	1.979
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

6 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06523423

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 10

HS = 2.503

VS = 2.429

GS = 2.503

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.252	1.146	.921
MINIMUM X	:	-1.251	-1.357	-1.214
MAXIMUM Y	:	1.257	1.165	1.168
MINIMUM Y	:	-1.172	-1.264	-1.261
CENTROID X	:	.109	.215	.072
CENTROID Y	:	-.148	-.056	-.059
POA TO CENTROID in.	:	.184	.223	.093
MIN RADIUS	:	.394	.284	.426
MEAN RADIUS	:	.970	.914	.898
MAX RADIUS	:	1.262	1.357	1.262
HORIZONTAL SPREAD	:	2.503	2.503	2.135
VERTICAL SPREAD	:	2.429	2.429	2.429
EXTREME SPREAD	:	2.503	2.503	2.430
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

5 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08523423

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 3

2 in = 8

3 in = 9

HS= 1.674

VS= 2.296

GS= 2.461

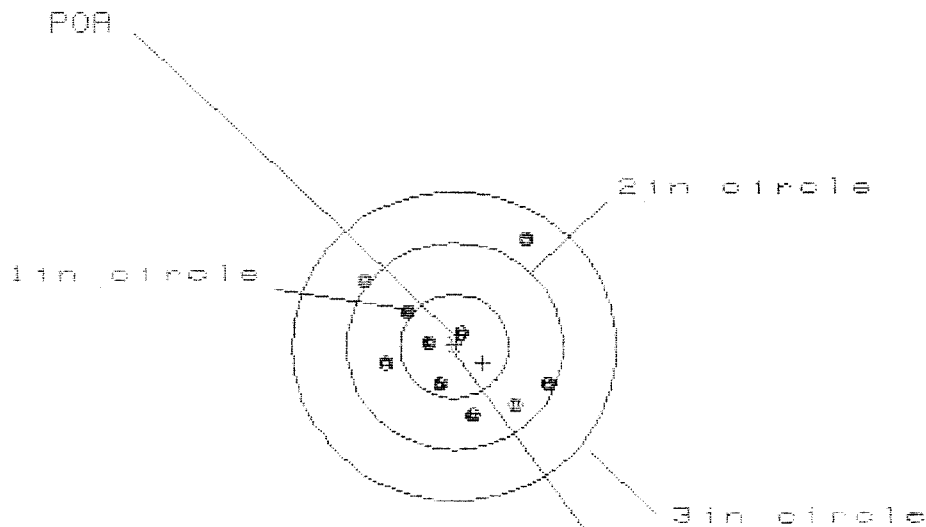
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.901	.959	1.074
MINIMUM X	:	-.773	-.715	-.680
MAXIMUM Y	:	1.495	.524	.470
MINIMUM Y	:	-.801	-.635	-.689
CENTROID X	:	-.059	-.117	-.232
CENTROID Y	:	.064	-.102	-.048
POA TO CENTROID in.	:	.088	.155	.237
MIN RADIUS	:	.260	.264	.145
MEAN RADIUS	:	.780	.683	.611
MAX RADIUS	:	1.583	1.011	1.080
HORIZONTAL SPREAD	:	1.674	1.674	1.674
VERTICAL SPREAD	:	2.296	1.159	1.159
EXTREME SPREAD	:	2.461	1.768	1.714
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

6 Nov 1998

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CENTERFIRE PATTERNS # 5



OF SHOTS- 12

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.687

VS= 1.692

GS= 1.924

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.892	.960	.869
MINIMUM X	:	-.795	-.727	-.687
MAXIMUM Y	:	1.016	.725	.523
MINIMUM Y	:	-.676	-.563	-.472
CENTROID X	:	-.265	-.333	-.242
CENTROID Y	:	.163	.050	-.041
POA TO CENTROID in.	:	.311	.337	.246
MIN RADIUS	:	.147	.203	.258
MEAN RADIUS	:	.659	.587	.533
MAX RADIUS	:	1.188	1.026	.876
HORIZONTAL SPREAD	:	1.687	1.687	1.556
VERTICAL SPREAD	:	1.692	1.288	.995
EXTREME SPREAD	:	1.924	1.924	1.561
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

SWS TRIGGER PULL TEST

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

SERIAL NO. C6523423
DATE 11/2/90
TESTER [Signature]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.42	2.40	225	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.23	2.33	2.43	222	
PULL #3	2.30	2.31	2.30	228	
PULL #4	2.26	2.42	2.45	224	
PULL #5	2.24	2.44	2.43	223	
TOTAL	11.49	11.92	12.01		
AVG.	2.298	2.384	2.402		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.47	3.32		
PULL #2	3.50	3.14		
PULL #3	3.26	3.25		
PULL #4	3.26	3.29		
PULL #5	3.12	3.16		
TOTAL	16.61	16.16		
AVG.	3.322	3.232		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.16	4.38		4.41
PULL #2	4.10	4.42		4.03
PULL #3	4.36	4.40		4.40
PULL #4	4.39	4.22		4.39
PULL #5	4.35	4.38		4.44
TOTAL	21.36	21.80		21.67
AVG.	4.272	4.36		4.334