

C6523438

MODEL 700TM M24

Model **SMS**TM

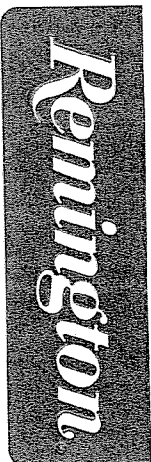
Action

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

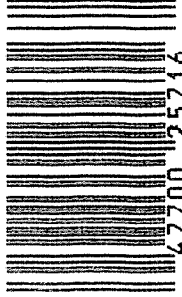
MADE IN LION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off; Marca Registrada. Marque Deposee.

SERIAL NO.
C6523438

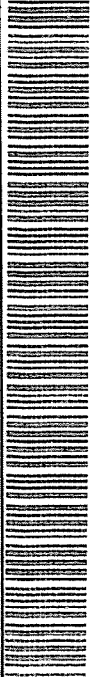
ORDER NO.
5716

Ø1

UPC



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5716 C6523438

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523438

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 25	90	RW
600	Proof	9 25	90	RW
607	Check Headspace	9 25	90	RW
610	Dis-assemble Gun	9 25	90	RW
612	Magnaflux Barrel Action		9/26/90	KR
	Magnaflux Bolt		9/26/90	KR
615	Rollmark Caliber		9/26/90	L.S.
617	Drill and Tap Sight Holes		9/28/90	WB
618	Polish Barrel RB		10/1/90	WB
620	Apply Coatings (Barrel Action)		10/5/90	TA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/8/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/8/90	RW
	C) Inspect Ejector Hole for Chamfer		10/8/90	RW
	D) Oil Firing Pin Ass'y		10/8/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/9/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2			10/9/90	WB
	G) Safety Off Force	2 1/4	2 1/4	2 1/4			10/9/90	WB
	H) Trigger Pull Test & Retainability						10/9/90	WB
	I) Firing Pin Indent	.022	.022	.022			10/9/90	WB
	J) Assemble Stock						10/22/90	RW
	K) Assemble Swivel Studs						2/16/90	JS
	L) Attach Front and Rear Sight Assemblies						10/22/90	RW
	M) Iron Sight Alignment						10/22/90	RW
	N) Detach Front & Rear Sights & place in numbered container						10/24/90	RW
	O) Attach Scope to Rifle						10/24/90	RW
	P) Detach & Attach Scope 20 Times						10/24/90	RW
640	Gallery Target & Test						10-26-90	AC
	A) Time						10-26-90	AC
	B) Malfunctions						10-26-90	AC
	C) Pierced Primers						10-26-90	AC
	D) Optical Clarity of Scope						10-26-90	AC
645	Inspect for Live Ammo						10-26-90	AC
655	Final Inspection						2/16/90	JS
	A) Headspace						2/16/90	JS
	B) Trigger Pull	2.79	2.92	2.84	2.64	2.77	2/16/90	JS
	C) Function						2/16/90	JS
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. C6523438
DATE 10/9/80
TESTER W3

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.39	2.28	2.17	2.79	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.39	2.25	2.22	2.97	
PULL #3	2.43	2.26	2.20	2.84	
PULL #4	2.42	2.17	2.17	2.64	
PULL #5	2.27	2.27	2.16	2.77	
TOTAL	11.90	11.23	10.92		
AVG.	2.38	2.24	2.18		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.25		
PULL #2	3.43	3.31		
PULL #3	3.34	3.26		
PULL #4	3.40	3.39		
PULL #5	3.46	3.22		
TOTAL	16.99	16.43		
AVG.	3.40	3.29		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.09	4.09		4.08
PULL #2	4.10	4.11		4.17
PULL #3	4.05	4.16		4.12
PULL #4	4.05	4.14		4.10
PULL #5	4.02	4.13		4.09
TOTAL	20.31	20.63		20.56
AVG.	4.06	4.12		4.11

0113

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523438
26 Oct 1990

CENTROIDAL DISTANCES

0	TO	1	.552313
1	TO	2	.947562
1	TO	3	.421233
1	TO	4	.60324
1	TO	5	.574582

μ_1 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0484
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0056
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0487229
THE AMR FOR THIS RIFLE IS: .884

26 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523438

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 2.384

VS= 2.295

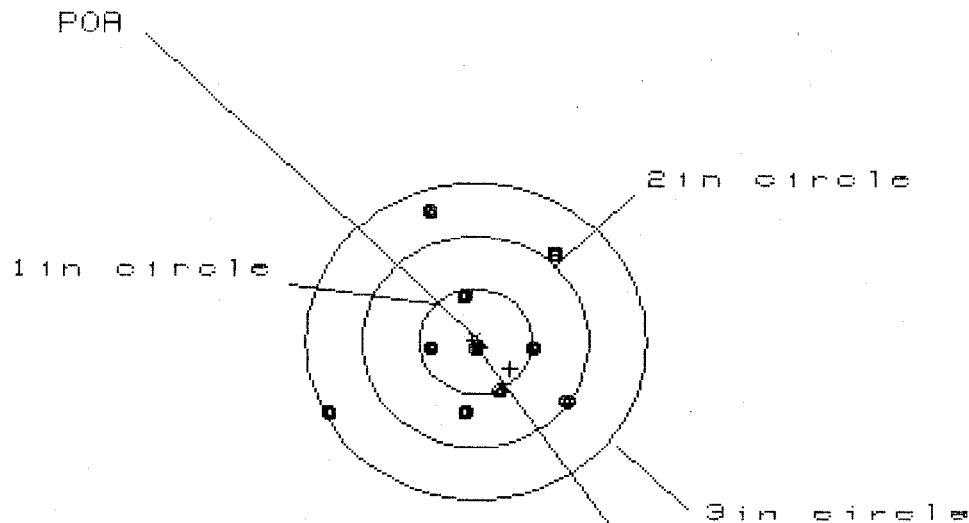
GS= 2.418

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.244	1.222	1.099
MINIMUM X	:	-1.140	-1.162	-1.285
MAXIMUM Y	:	1.380	.619	.524
MINIMUM Y	:	-.915	-.762	-.780
CENTROID X	:	.495	.517	.640
CENTROID Y	:	-.245	-.398	-.303
POA TO CENTROID in.	:	.552	.653	.708
MIN RADIUS	:	.416	.412	.530
MEAN RADIUS	:	.945	.899	.846
MAX RADIUS	:	1.394	1.245	1.287
HORIZONTAL SPREAD	:	2.384	2.384	2.384
VERTICAL SPREAD	:	2.295	1.381	1.304
EXTREME SPREAD	:	2.418	2.385	2.385
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 4

2in = 6

3in = 10

HS= 2.107

VS= 1.925

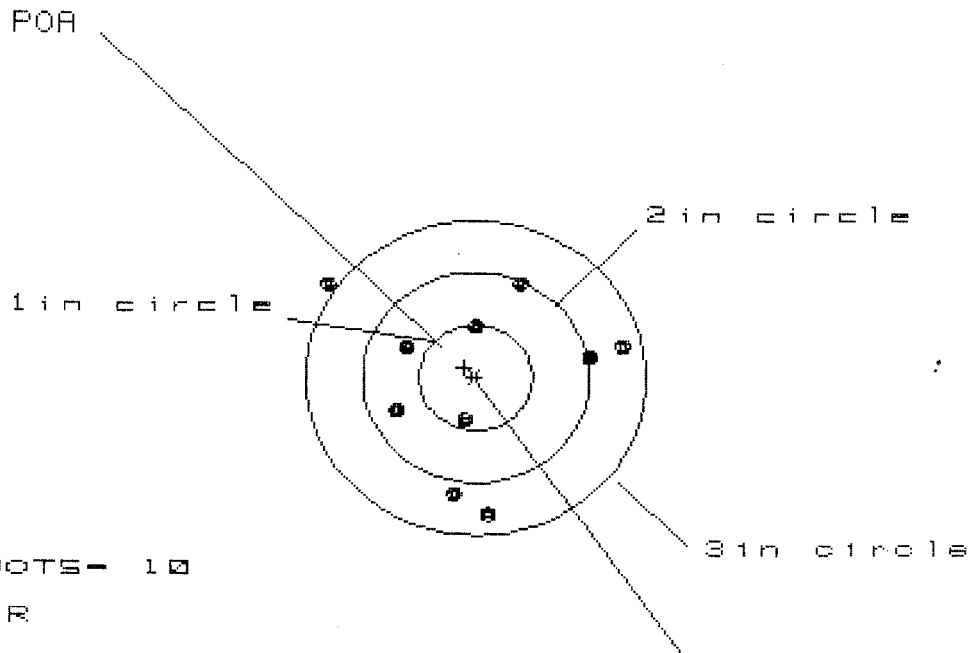
GS= 2.441

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.843	.702	.632
MINIMUM X	:	-1.264	-.564	-.557
MAXIMUM Y	:	1.233	1.164	.898
MINIMUM Y	:	-.692	-.761	-.615
CENTROID X	:	-.305	-.164	-.094
CENTROID Y	:	.263	.332	.186
POA TO CENTROID in.	:	.403	.370	.208
MIN RADIUS	:	.046	.191	.227
MEAN RADIUS	:	.736	.669	.571
MAX RADIUS	:	1.406	1.294	1.027
HORIZONTAL SPREAD	:	2.107	1.266	1.189
VERTICAL SPREAD	:	1.925	1.925	1.513
EXTREME SPREAD	:	2.441	2.180	1.734
NUMBER IN ONE INCH CIRCLE =		4		
NUMBER IN TWO INCH CIRCLE =		6		
NUMBER IN THREE INCH CIRCLE =		10		

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS= 2.541

VS= 2.179

GS= 2.606

CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.265	1.124	.971
MINIMUM X	:	-1.276	-.825	-.685
MAXIMUM Y	:	.890	.947	.998
MINIMUM Y	:	-1.289	-1.190	-1.139
CENTROID X	:	.101	.242	.102
CENTROID Y	:	-.096	-.195	-.246
POA TO CENTROID in.	:	.139	.311	.266
MIN RADIUS	:	.415	.382	.270
MEAN RADIUS	:	.949	.884	.821
MAX RADIUS	:	1.555	1.197	1.145
HORIZONTAL SPREAD	:	2.541	1.949	1.656
VERTICAL SPREAD	:	2.179	2.137	2.137
EXTREME SPREAD	:	2.606	2.155	2.155
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 8

3 in = 9

HS= 1.620

VS= 2.192

GS= 2.596

CENTROID #

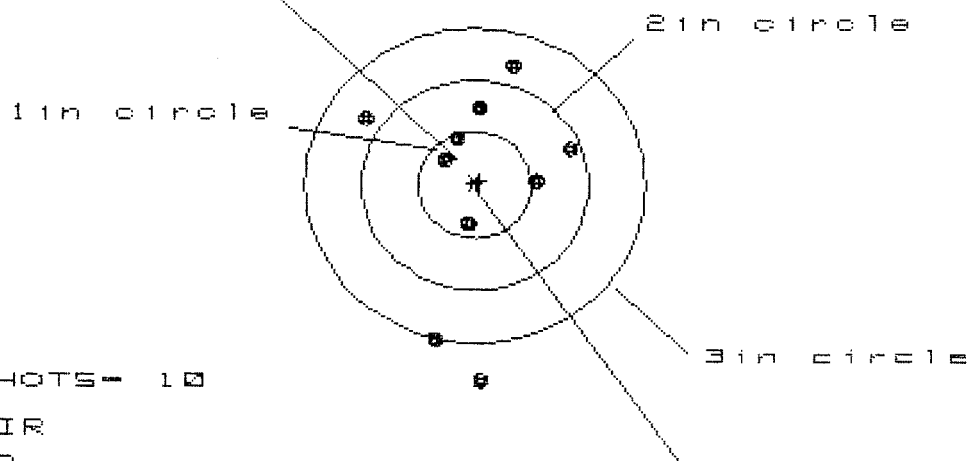
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.728	.802	.701
MINIMUM X	:	-.892	-.811	-.912
MAXIMUM Y	:	.746	.585	.639
MINIMUM Y	:	-1.446	-.887	-.833
CENTROID X	:	-.008	-.089	.012
CENTROID Y	:	.088	.249	.195
POA TO CENTROID in.	:	.088	.264	.196
MIN RADIUS	:	.423	.536	.423
MEAN RADIUS	:	.880	.783	.752
MAX RADIUS	:	1.619	1.037	1.050
HORIZONTAL SPREAD	:	1.620	1.613	1.613
VERTICAL SPREAD	:	2.192	1.472	1.472
EXTREME SPREAD	:	2.596	1.939	1.939
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5

POA



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS = 1.824

VS = 3.055

GS = 3.075

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.862	.866	.824
MINIMUM X	:	-.962	-.958	-1.000
MAXIMUM Y	:	1.161	.950	.746
MINIMUM Y	:	-1.895	-1.632	-.747
CENTROID X	:	-.041	-.045	-.003
CENTROID Y	:	-.038	.172	.376
POA TO CENTROID in.	:	.056	.178	.376
MIN RADIUS	:	.341	.255	.195
MEAN RADIUS	:	.910	.756	.615
MAX RADIUS	:	1.895	1.667	1.037
HORIZONTAL SPREAD	:	1.824	1.824	1.824
VERTICAL SPREAD	:	3.055	2.582	1.493
EXTREME SPREAD	:	3.075	2.684	1.855
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			9	