

C6523480

MODEL 700TM #24

Model **SMS** TM

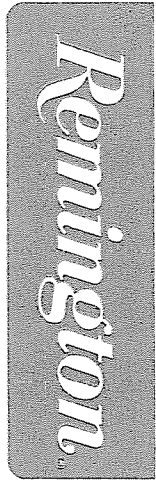
Action

Barrel Length

Capacity

Order No. **5716**

* Includes 1 in chamber.






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

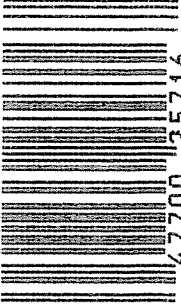
MODEL 700™ H24

SERIAL NO.
C6523480

ORDER NO.
5716

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

UPC



0 47700 25716 7



5716 C6523480

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6523480

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/2/90	KJ
600	Proof		10/2/90	KJ
607	Check Headspace		10/2/90	KJ
610	Dis-assemble Gun		10/2/90	KJ
612	Magnaflux Barrel Action		10/5/90	KR
	Magnaflux Bolt		10/5/90	KR
615	Rollmark Caliber		10/5/90	GB
617	Drill and Tap Sight Holes		10/8/90	KB
618	Polish Barrel <i>KB</i>		10/9/90	KB
620	Apply Coatings (Barrel Action)		10-20-90	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/21/90	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/21/90	KS
	C) Inspect Ejector Hole for Chamfer		10/21/90	KA
	D) Oil Firing Pin Ass'y		10/21/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		10-24-90	DH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/2	5 1/2	5 1/2			10/25/90	WB
	G) Safety Off Force	2 1/4	2 1/4	2 1/4			10/25/90	WB
	H) Trigger Pull Test & Retainability						10-24-90	DH
	I) Firing Pin Indent	.022	.0215	.0215			10/25/90	WB
	J) Assemble Stock						10/25/90	KA
	K) Assemble Swivel Studs						2/18/90	JS
	L) Attach Front and Rear Sight Assemblies						10/25/90	KA
	M) Iron Sight Alignment						10/25/90	KA
	N) Detach Front & Rear Sights & place in numbered container						10/25/90	KA
	O) Attach Scope to Rifle						10/25/90	KA
	P) Detach & Attach Scope 20 Times						10/25/90	KA
640	Gallery Target & Test						10-26-90	KT
	A) Time						10-26-90	KT
	B) Malfunctions						10-26-90	KT
	C) Pierced Primers						10-26-90	KT
	D) Optical Clarity of Scope						10-26-90	KT
645	Inspect for Live Ammo						10-26-90	KT
655	Final Inspection						2/18/90	JS
	A) Headspace						2/18/90	JS
	B) Trigger Pull	280	290	298	283	292	2/18/90	JS
	C) Function						2/18/90	JS
660	Pack						12/18/90	JP

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C6523480

DATE 10-24-90

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.51	2.72	2.57	280	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.54	2.68	2.57	290	
PULL #3	2.49	2.89	2.76	298	
PULL #4	2.54	2.61	2.67	283	
PULL #5	2.55	3.00	2.87	292	
TOTAL	12.63	13.90	13.44		
AVG.	2.52	2.78	2.68		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.19	3.24		
PULL #2	3.02	3.25		
PULL #3	3.12	3.39		
PULL #4	3.03	3.19		
PULL #5	3.00	3.23		
TOTAL	15.36	16.30		
AVG.	3.07	3.22		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.45	4.63		4.39
PULL #2	4.50	4.55		4.35
PULL #3	4.53	4.40		4.30
PULL #4	4.44	4.37		4.21
PULL #5	4.43	4.42		4.42
TOTAL	22.35	22.37		21.67
AVG.	4.47	4.47		4.33

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523480
27 Oct 1990

CENTROIDAL DISTANCES

0 TO	1	.135506
1 TO	2	.241149
1 TO	3	.272077
1 TO	4	.370203
1 TO	5	.288647

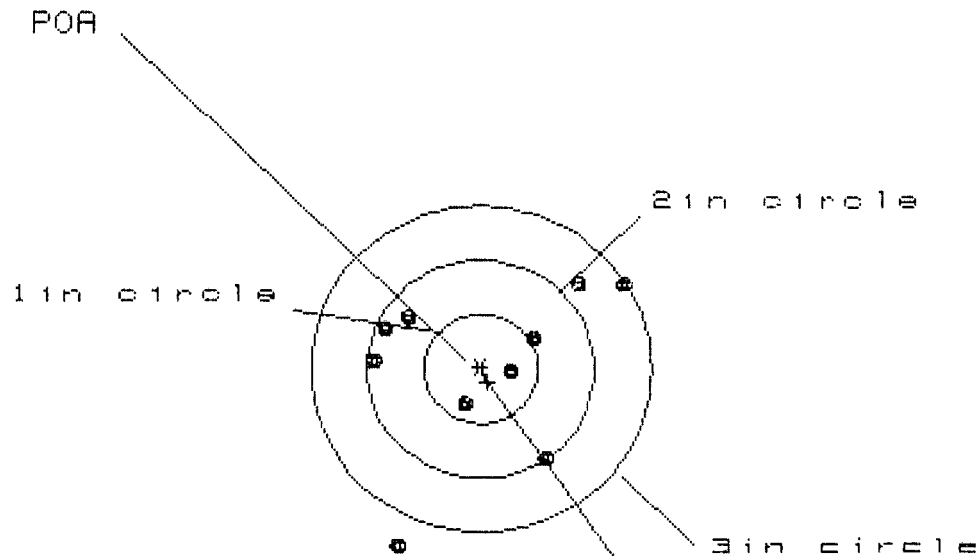
48 <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0342
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.091
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0972144
THE AMR FOR THIS RIFLE IS: .8524

26 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523480

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 8

HS= 2.219

VS= 2.343

GS= 3.060

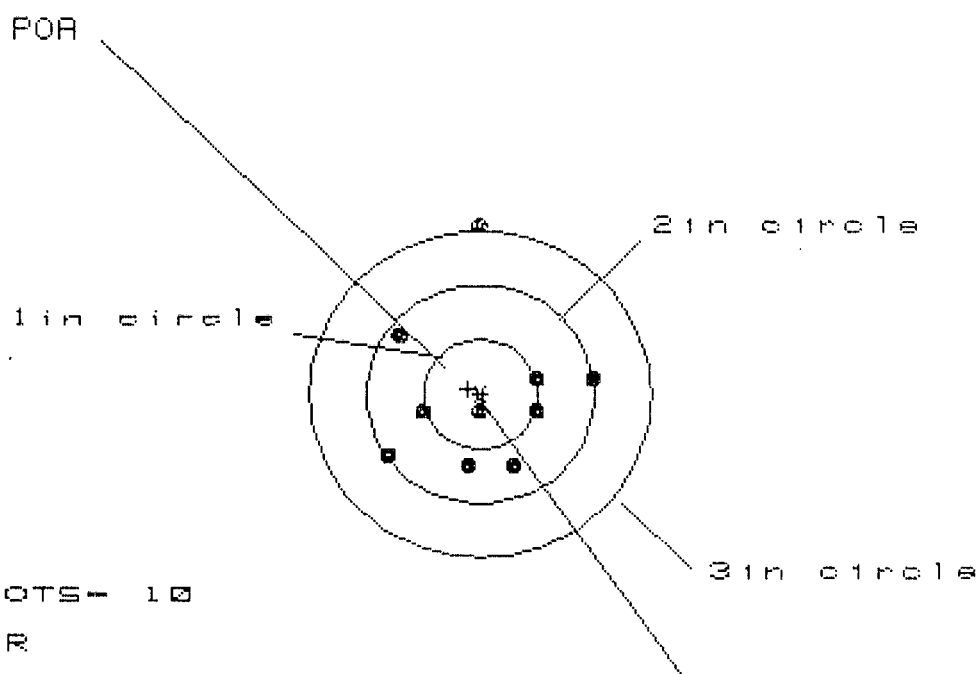
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.259	1.180	.895
MINIMUM X	-.960	-1.039	-.892
MAXIMUM Y	.766	.591	.658
MINIMUM Y	-1.577	-.981	-.908
CENTROID X	-.061	.018	-.129
CENTROID Y	.121	.296	.223
POA TO CENTROID in.	.136	.297	.257
MIN RADIUS	.302	.307	.394
MEAN RADIUS	.919	.820	.750
MAX RADIUS	1.730	1.319	1.111
HORIZONTAL SPREAD	2.219	2.219	1.787
VERTICAL SPREAD	2.343	1.572	1.566
EXTREME SPREAD	3.060	2.332	1.923
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 8

3in = 9

HS= 1.808

VS= 2.234

GS= 2.247

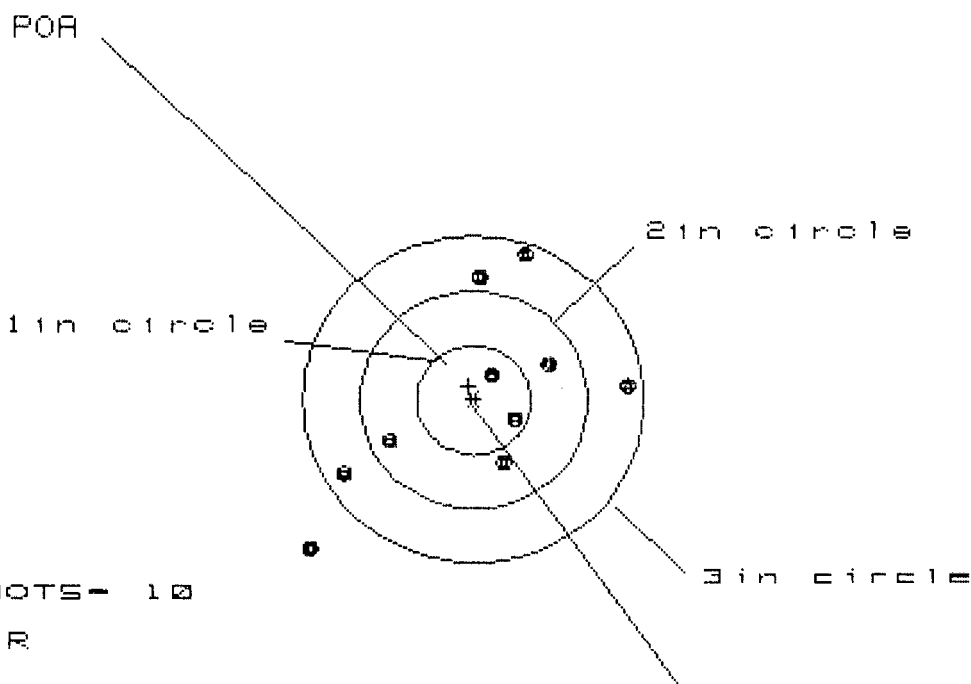
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.952	.950	.843
MINIMUM X	:	-.856	-.858	-.798
MAXIMUM Y	:	1.533	.690	.643
MINIMUM Y	:	-.701	-.531	-.578
CENTROID X	:	.112	.114	.221
CENTROID Y	:	-.047	-.217	-.170
POA TO CENTROID in.	:	.122	.245	.279
MIN RADIUS	:	.158	.024	.094
MEAN RADIUS	:	.746	.620	.575
MAX RADIUS	:	1.533	.993	1.025
HORIZONTAL SPREAD	:	1.808	1.808	1.641
VERTICAL SPREAD	:	2.234	1.221	1.221
EXTREME SPREAD	:	2.247	1.927	1.690
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 3

HS= 2.818

VS= 2.778

GS= 3.358

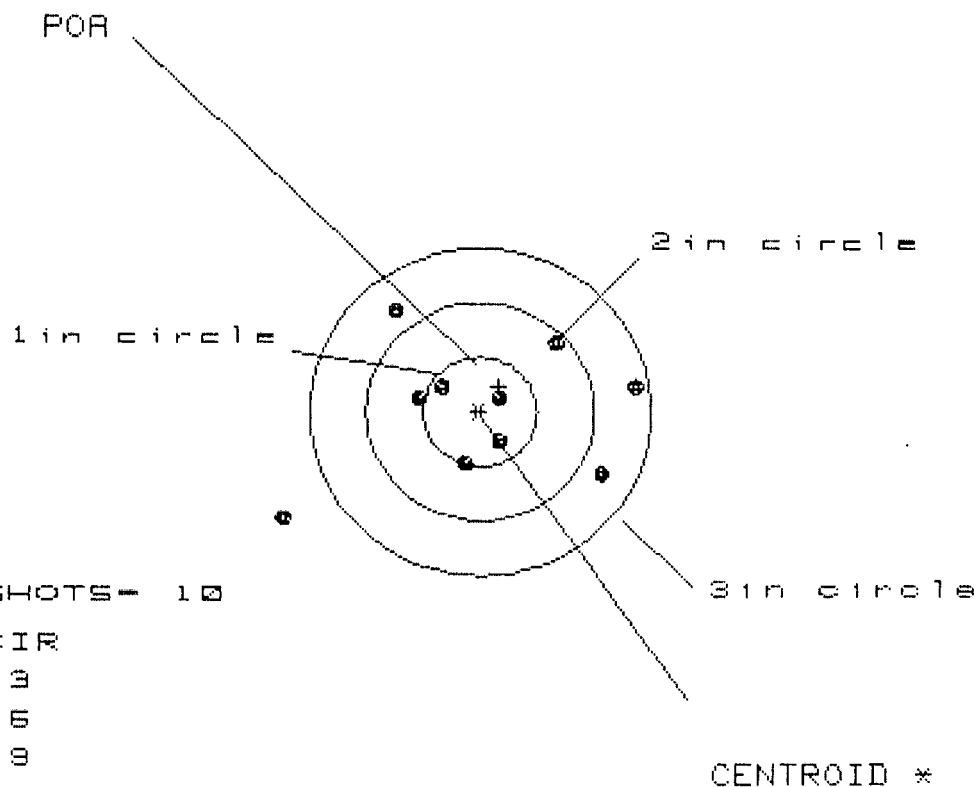
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.403	1.246	1.285
MINIMUM X	:	-1.415	-1.346	-1.307
MAXIMUM Y	:	1.377	1.221	1.079
MINIMUM Y	:	-1.401	-.777	-.624
CENTROID X	:	.044	.201	.162
CENTROID Y	:	-.130	.026	-.127
POA TO CENTROID in.	:	.137	.203	.206
MIN RADIUS	:	.318	.122	.277
MEAN RADIUS	:	1.013	.860	.813
MAX RADIUS	:	1.991	1.554	1.448
HORIZONTAL SPREAD	:	2.818	2.592	2.592
VERTICAL SPREAD	:	2.778	1.998	1.703
EXTREME SPREAD	:	3.358	2.687	2.687
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



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 5

3 in = 9

HS= 3.114

VS= 1.852

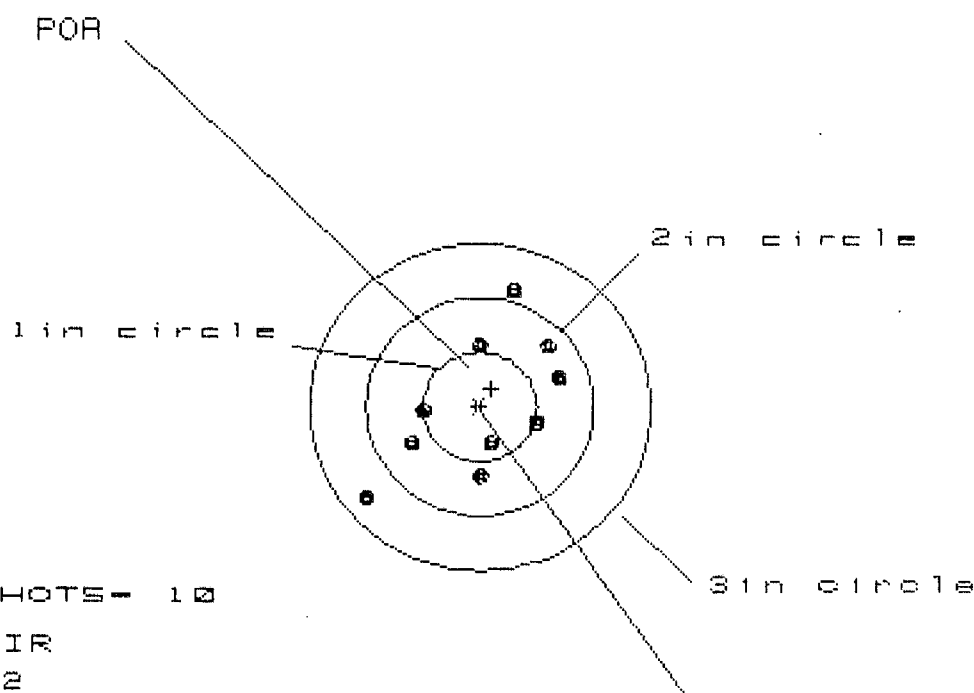
GS= 3.315

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.373	1.180	1.039
MINIMUM X	:	-1.741	-.948	-.801
MAXIMUM Y	:	.912	.807	.819
MINIMUM Y	:	-.940	-.643	-.632
CENTROID X	:	-.166	.027	-.120
CENTROID Y	:	-.234	-.129	-.140
POA TO CENTROID in.	:	.287	.132	.185
MIN RADIUS	:	.199	.021	.131
MEAN RADIUS	:	.869	.736	.666
MAX RADIUS	:	1.979	1.245	1.216
HORIZONTAL SPREAD	:	3.114	2.128	1.840
VERTICAL SPREAD	:	1.852	1.450	1.450
EXTREME SPREAD	:	3.315	2.343	2.343
NUMBER IN ONE INCH CIRCLE =	:		3	
NUMBER IN TWO INCH CIRCLE =	:		6	
NUMBER IN THREE INCH CIRCLE =	:		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 8

3 in = 10

HS= 1.775

VS= 1.877

GS= 2.332

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.729	.613	.641
MINIMUM X	:	-1.046	-.711	-.683
MAXIMUM Y	:	1.022	.927	.576
MINIMUM Y	:	-.855	-.721	-.605
CENTROID X	:	-.100	.016	-.012
CENTROID Y	:	-.165	-.070	-.186
POA TO CENTROID in.	:	.193	.072	.186
MIN RADIUS	:	.303	.391	.273
MEAN RADIUS	:	.715	.635	.581
MAX RADIUS	:	1.351	.953	.765
HORIZONTAL SPREAD	:	1.775	1.324	1.324
VERTICAL SPREAD	:	1.877	1.648	1.181
EXTREME SPREAD	:	2.332	1.692	1.461
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			10	