

C6648967

MODEL 700TM M24

Model **SMS** TM

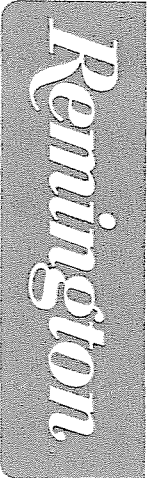
Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

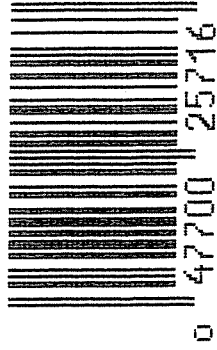





VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700™ H24 MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.	SERIAL NO. C6648967	ORDER NO. 5716
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UPC



GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6648967

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 2	9 1	RW
600	Proof	7 2	9 1	RW
607	Check Headspace	7 2	9 1	RW
610	Dis-assemble Gun	7 2	9 1	RW
612	Magnaflux Barrel Action		JUL 22 1991	YS
	Magnaflux Bolt		JUL 22 1991	YS
615	Rollmark Caliber		JUL 22 1991	YS
617	Drill and Tap Sight Holes		JUL 22 1991	LB
618	Polish Barrel		7/28/91	WB
620	Apply Coatings (Barrel Action)		8-22-91	LB
	Apply Coating (Bolt)		8-22-91	LB
625	Final Assembly			
	A) Clean inside of Bolt Assembly		8/29/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/29/91	RW
	C) Inspect Ejector Hole for Chamfer		8/29/91	RW
	D) Oil Firing Pin Ass'y		8/29/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9/11/91	AL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			9/11/91	SH
	G) Safety Off Force	3	3	3			9/11/91	SH
	H) Trigger Pull Test & Retainability						9/11/91	SH
	I) Firing Pin Indent	.022	.022	.022			9/11/91	SH
	J) Assemble Stock						9/12/91	Rev
	K) Assemble Swivel Studs						9-13-91	D/H
	L) Attach Front and Rear Sight Assemblies						9/12/91	Rev
	M) Iron Sight Alignment						9/10/91	Rev
	N) Detach Front & Rear Sights & place in numbered container						9/12/91	Rev
	O) Attach Scope to Rifle						9/12/91	Rev
	P) Detach & Attach Scope 20 Times						9/12/91	Rev
640	Gallery Target & Test						9-13-91	AC
	A) Time						9-13-91	AC
	B) Malfunctions						9-13-91	AC
	C) Pierced Primers						9-13-91	AC
	D) Optical Clarity of Scope						9-13-91	AC
645	Inspect for Live Ammo						9-13-91	AC
655	Final Inspection						9-13-91	DH
	A) Headspace						9-13-91	SH
	B) Trigger Pull	2.39	2.41	2.43	2.43	2.37	9-13-91	SH
	C) Function						9-13-91	D/H
660	Pack						9-14-91	VF

SWS TRIGGER PULL TEST

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

SERIAL NO. 06648967

DATE 9-11-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.42	2.27	2.50	2.39	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.47	2.50	2.52	2.41	
PULL #3	2.44	2.45	2.48	2.43	
PULL #4	2.27	2.48	2.44	2.43	
PULL #5	2.38	2.48	2.38	2.37	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.63	3.57		
PULL #2	3.57	3.65		
PULL #3	3.64	3.57		
PULL #4	3.59	3.55		
PULL #5	3.60	3.61		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.21	4.35		4.46
PULL #2	4.48	4.45		4.40
PULL #3	4.47	4.43		4.39
PULL #4	4.47	4.42		4.32
PULL #5	4.32	4.38		4.42
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6648967
13 Sep 1991

CENTROIDAL DISTANCES

0 TO 1	.126921
1 TO 2	.383725
1 TO 3	.265859
1 TO 4	.496864
1 TO 5	.484084

$\begin{matrix} +^a \\ +^b \end{matrix}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1622
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.091
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .185983
THE AMR FOR THIS RIFLE IS: 1.066

13 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6546967

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 2.887

VS= 2.589

GS= 2.987

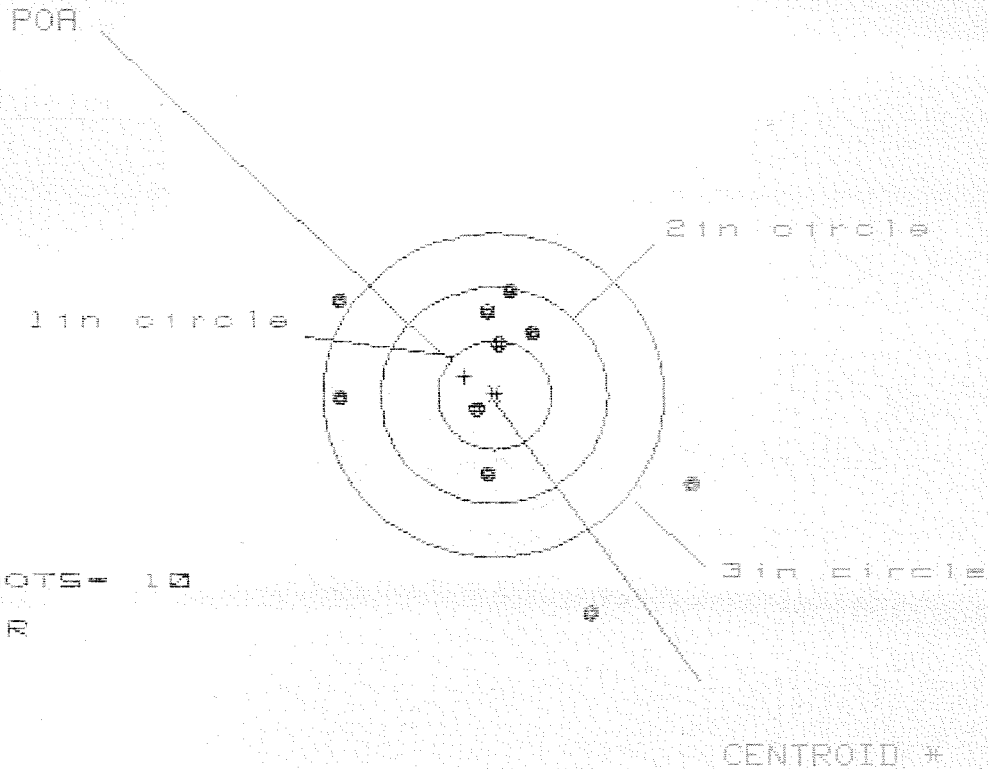
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.286	1.168	.704
MINIMUM X	-1.601	-1.021	-.882
MAXIMUM Y	1.221	1.213	1.298
MINIMUM Y	-1.368	-1.376	-1.292
CENTROID X	.022	.200	.061
CENTROID Y	.125	.133	.048
POA TO CENTROID in.	.127	.240	.078
MIN RADIUS	.333	.253	.376
MEAN RADIUS	.951	.864	.801
MAX RADIUS	1.603	1.409	1.400
HORIZONTAL SPREAD	2.887	2.129	1.586
VERTICAL SPREAD	2.589	2.589	2.589
EXTREME SPREAD	2.987	2.678	2.678
NUMBER IN ONE INCH CIRCLE	= 1		
NUMBER IN TWO INCH CIRCLE	= 6		
NUMBER IN THREE INCH CIRCLE	= 9		

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FILE:/PATTERNING/CENTERFIRE_PATT/C6B4B967

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 7

HS= 3.084

VS= 2.974

GS= 3.574

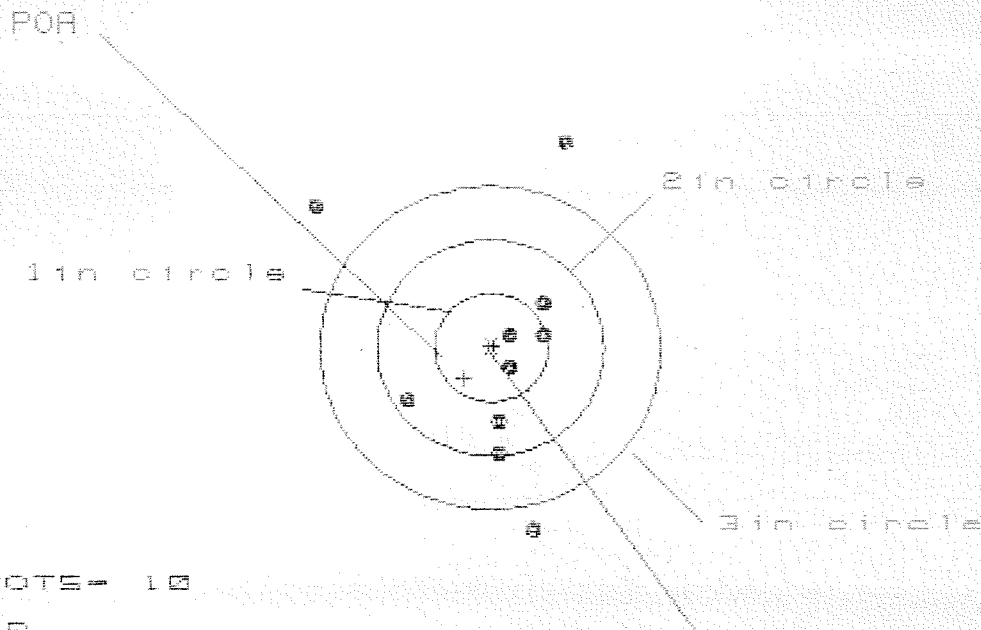
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.704	1.799	.617
MINIMUM X	:	-1.380	-1.285	-1.061
MAXIMUM Y	:	.988	.767	.635
MINIMUM Y	:	-1.986	-1.057	-1.035
CENTROID X	:	.260	.165	-.059
CENTROID Y	:	-.176	.045	.177
FOR TO CENTROID in.	:	.314	.171	.186
MIN RADIUS	:	.210	.295	.398
MEAN RADIUS	:	1.080	.912	.764
MAX RADIUS	:	2.161	2.086	1.121
HORIZONTAL SPREAD	:	3.084	3.084	1.678
VERTICAL SPREAD	:	2.974	1.824	1.670
EXTREME SPREAD	:	3.574	3.464	1.974
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 7

HS= 2.159

VS= 3.548

GS= 3.561

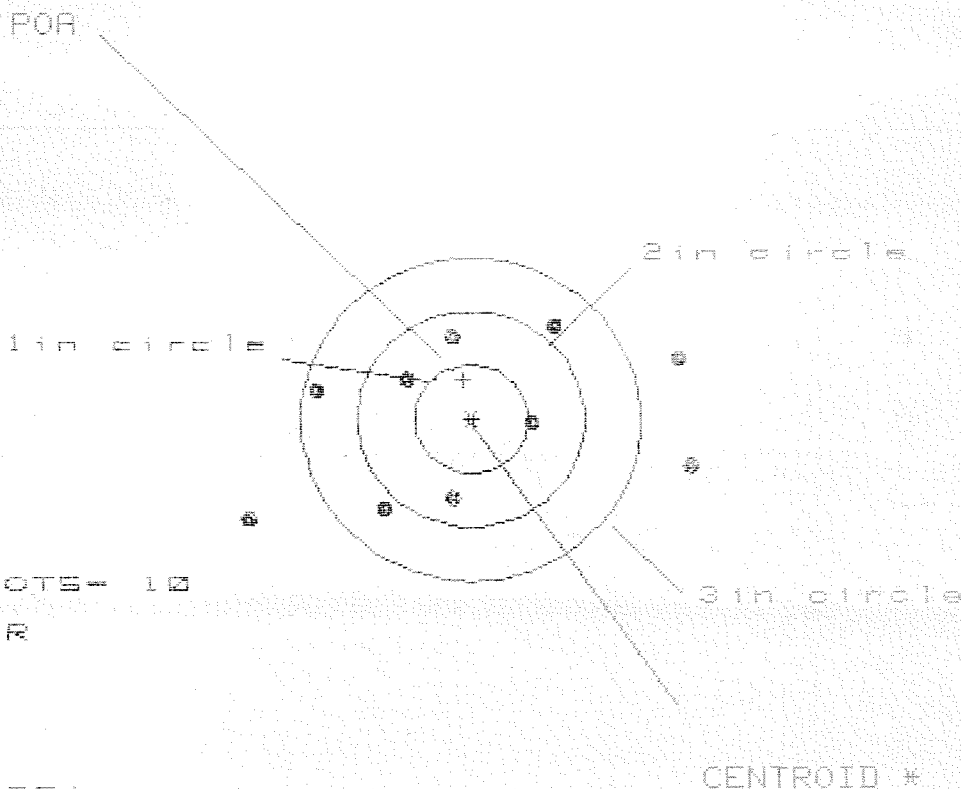
CENTROID +

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.623	.452	.375
MINIMUM X	:	-1.536	-.954	-.897
MAXIMUM Y	:	1.898	2.043	.849
MINIMUM Y	:	-1.650	-1.505	-1.250
CENTROID X	:	.238	.409	.352
CENTROID Y	:	.280	.135	-.128
POA TO CENTROID in.	:	.368	.431	.372
MIN RADIUS	:	.204	.006	.266
MEAN RADIUS	:	.979	.812	.668
MAX RADIUS	:	2.016	2.092	1.267
HORIZONTAL SPREAD	:	2.159	1.406	1.272
VERTICAL SPREAD	:	3.548	3.548	2.099
EXTREME SPREAD	:	3.561	3.561	2.186
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 0

2in = 4

3in = 7

HS= 3.904

VS= 1.768

GS= 4.105

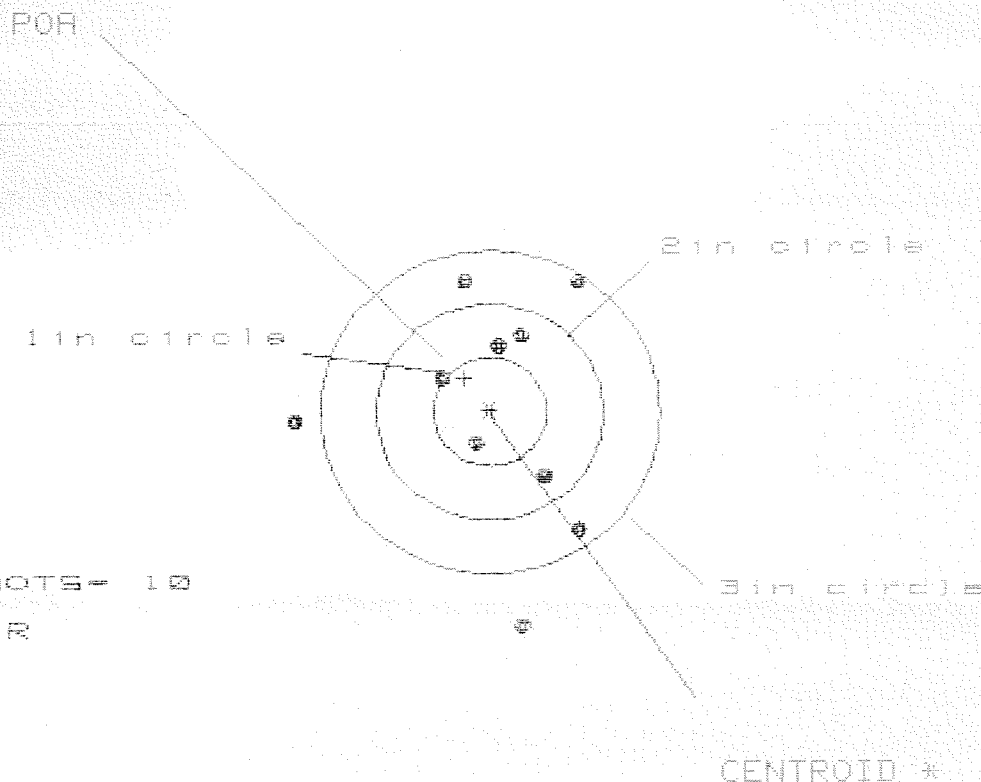
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.892	1.669	1.795
MINIMUM X	:	-2.012	-1.565	-1.357
MAXIMUM Y	:	.884	.786	.715
MINIMUM Y	:	-.884	-.901	-.972
CENTROID X	:	.065	.288	.080
CENTROID Y	:	-.370	-.272	-.201
POA TO CENTROID in.	:	.376	.396	.216
MIN RADIUS	:	.532	.332	.552
MEAN RADIUS	:	1.246	1.129	1.027
MAX RADIUS	:	2.197	1.762	1.849
HORIZONTAL SPREAD	:	3.904	3.234	3.152
VERTICAL SPREAD	:	1.768	1.687	1.687
EXTREME SPREAD	:	4.105	3.328	3.166
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 8

HS = 2.449

VS = 3.245

GS = 3.282

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.765	.792	.585
MINIMUM X	:	-1.684	-1.657	-.598
MAXIMUM Y	:	1.232	1.008	.968
MINIMUM Y	:	-2.013	-1.311	-1.351
CENTROID X	:	.226	.199	.406
CENTROID Y	:	-.314	-.090	-.050
POR TO CENTROID in.	:	.386	.219	.409
MIN RADIUS	:	.340	.404	.393
MEAN RADIUS	:	1.074	.933	.834
MAX RADIUS	:	2.028	1.688	1.472
HORIZONTAL SPREAD	:	2.449	2.449	1.183
VERTICAL SPREAD	:	3.245	2.319	2.319
EXTREME SPREAD	:	3.282	2.758	2.485
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	