

C6648990

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.

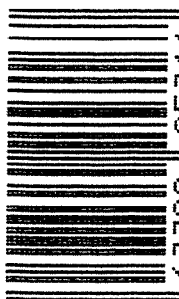
SERIAL NO.
C6648990

ORDER NO.
5716



5716 C6648990

LPC



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6648990

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		7/24/91	KL
600	Proof		7/24/91	KL
607	Check Headspace		7/24/91	KL
610	Dis-assemble Gun		7/24/91	KL
612	Magnaflux Barrel Action		AUG 7 1991	KR
	Magnaflux Bolt		AUG 7 1991	KR
615	Rollmark Caliber		AUG 7 1991	LS
617	Drill and Tap Sight Holes		AUG 7 1991	LB
618	Polish Barrel		AUG 13 1991	WB
620	Apply Coatings (Barrel Action)		8-27-91	DA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		9/4/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/4/91	KL
	C) Inspect Ejector Hole for Chamfer		9/4/91	KL
	D) Oil Firing Pin Ass'y		9/4/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		9/7/91	KL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			9/7/91	SL
	G) Safety Off Force	3	3	3			9/7/91	SL
	H) Trigger Pull Test & Retainability						9/7/91	SL
	I) Firing Pin Indent	.0205	.0205	.021			9/7/91	SL
	J) Assemble Stock						9/10/91	KL
	K) Assemble Swivel Studs						9-12-91	D/H
	L) Attach Front and Rear Sight Assemblies						9/10/91	KL
	M) Iron Sight Alignment						9/10/91	KL
	N) Detach Front & Rear Sights & place in numbered container						9/10/91	KL
	O) Attach Scope to Rifle						9/10/91	KL
	P) Detach & Attach Scope 20 Times						9/10/91	KL
640	Gallery Target & Test						9-11-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						9-11-91	NF
655	Final Inspection							
	A) Headspace						9-12-91	D/H
	B) Trigger Pull	2.20	2.18	2.18	2.22	2.25	9-12-91	SL
	C) Function						9-12-91	D/H
660	Pack						9-17-91	D/H

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C-6648990

DATE 9-7-91

TESTER JM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.36	2.25	2.20	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.26	2.28	2.33	2.18	
PULL #3	2.36	2.31	2.44	2.18	
PULL #4	2.38	2.43	2.30	2.22	
PULL #5	2.31	2.30	2.30	2.25	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.66	3.33		
PULL #2	3.61	3.51		
PULL #3	3.44	3.31		
PULL #4	3.44	3.52		
PULL #5	3.45	3.49		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.32		4.37
PULL #2	4.51	4.29		4.27
PULL #3	4.21	4.23		4.31
PULL #4	4.40	4.28		4.26
PULL #5	4.28	4.30		4.33
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6648990
12 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.194487
1 TO	2	.234002
1 TO	3	.209268
1 TO	4	.31939
1 TO	5	.0584637

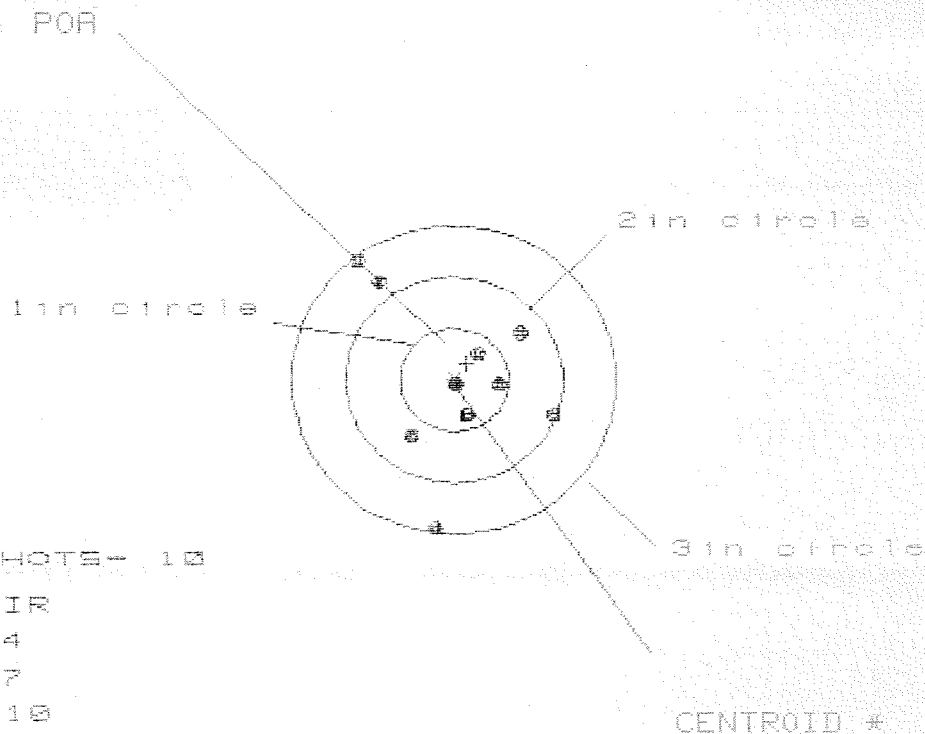
←----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1264
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0098
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .126779
THE AVERAGE POI RADIUS FOR THIS RIFLE IS: .9766

11 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8540390

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 10

HS= 1.774

VS= 2.583

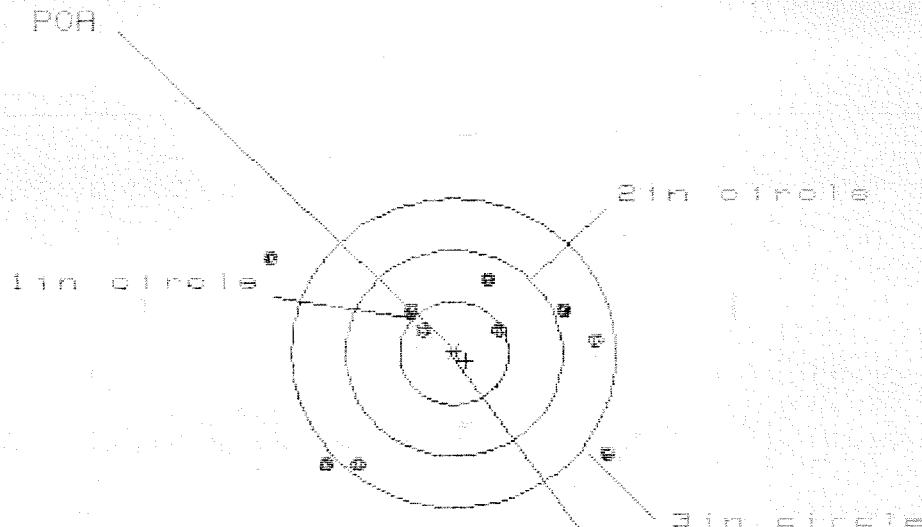
GS= 2.670

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.869	.769	.728
MINIMUM X	:	-.905	-.747	-.788
MAXIMUM Y	:	1.162	1.132	.971
MINIMUM Y	:	-1.421	-1.292	-.617
CENTROID X	:	-.112	-.012	.029
CENTROID Y	:	-.159	-.288	-.127
POR TO CENTROID in.	:	.195	.288	.130
MIN RADIUS	:	.056	.138	.180
MEAN RADIUS	:	.759	.657	.563
MAX RADIUS	:	1.473	1.356	1.250
HORIZONTAL SPREAD	:	1.774	1.516	1.516
VERTICAL SPREAD	:	2.583	2.424	1.588
EXTREME SPREAD	:	2.670	2.460	2.021
NUMBER IN ONE INCH CIRCLE	=	4		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	10		

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FILE:/PATTERNING/CENTERFIRE_PATT/C6848990

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 7

HS= 3.065

VS= 2.035

GS= 3.647

CENTROID *

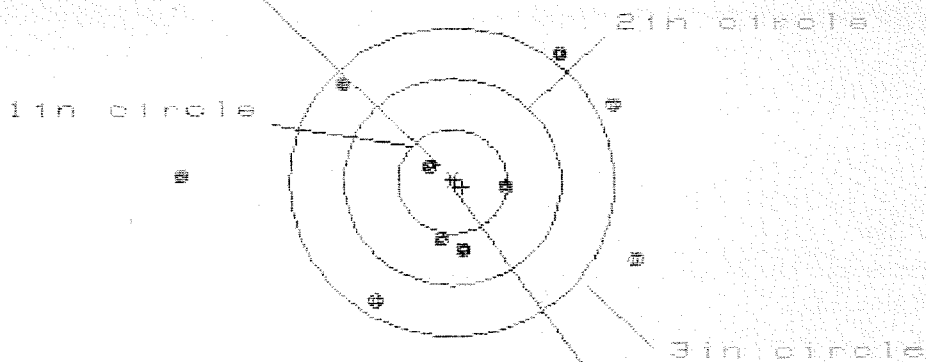
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.388	1.202	1.241
MINIMUM X	:	-1.677	-1.353	-1.203
MAXIMUM Y	:	.967	.880	.767
MINIMUM Y	:	-1.068	-.961	-1.074
CENTROID X	:	-.111	.075	-.075
CENTROID Y	:	.075	-.032	.081
POA TO CENTROID in.	:	.134	.082	.110
MIN RADIUS	:	.339	.349	.365
MEAN RADIUS	:	1.119	1.033	.940
MAX RADIUS	:	1.936	1.660	1.613
HORIZONTAL SPREAD	:	3.065	2.555	2.444
VERTICAL SPREAD	:	2.035	1.841	1.841
EXTREME SPREAD	:	3.647	2.714	2.714
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 3

POR



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 6

HS= 4.123

VS= 2.387

GS= 4.199

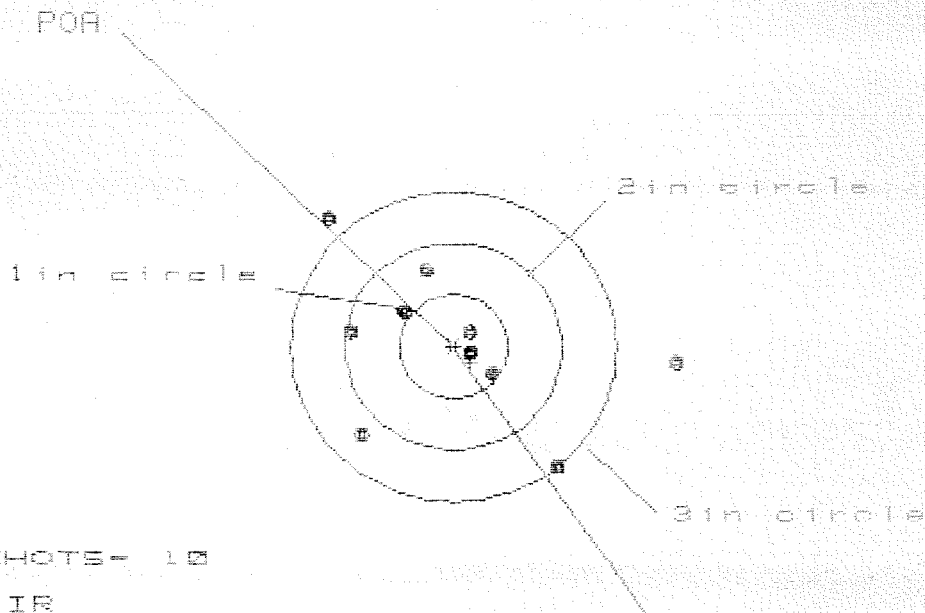
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.642	1.366	1.351
MINIMUM X	:	-2.481	-1.294	-1.123
MAXIMUM Y	:	1.254	1.257	1.162
MINIMUM Y	:	-1.133	-1.130	-1.225
CENTROID X	:	-.089	.187	.016
CENTROID Y	:	.049	.046	.141
POR TO CENTROID in.	:	.162	.193	.142
MIN RADIUS	:	.293	.219	.363
MEAN RADIUS	:	1.222	1.068	1.001
MAX RADIUS	:	2.482	1.587	1.516
HORIZONTAL SPREAD	:	4.123	2.660	2.474
VERTICAL SPREAD	:	2.387	2.387	2.387
EXTREME SPREAD	:	4.199	3.146	2.943
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 7

HS= 3.163

VS= 2.417

GS= 3.457

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.044	1.148	1.037
MINIMUM X	:	-1.119	-.892	-.806
MAXIMUM Y	:	1.231	1.213	.888
MINIMUM Y	:	-1.186	-1.204	-1.052
CENTROID X	:	-.151	-.378	-.267
CENTROID Y	:	.158	.176	.024
POA TO CENTROID in.	:	.218	.417	.268
MIN RADIUS	:	.148	.356	.226
MEAN RADIUS	:	.947	.829	.737
MAX RADIUS	:	2.051	1.664	1.477
HORIZONTAL SPREAD	:	3.163	2.040	1.843
VERTICAL SPREAD	:	2.417	2.417	1.940
EXTREME SPREAD	:	3.457	3.163	2.260
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 1.654

VS= 2.572

GS= 2.617

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.006

1.061

1.191

MINIMUM X

-.648

-.593

-.463

MAXIMUM Y

.019

.625

.602

MINIMUM Y

-1.753

-.687

-.609

CENTROID X

-.169

-.224

-.354

CENTROID Y

-.172

.022

-.056

POA TO CENTROID in.

.241

.225

.358

MIN RADIUS

.289

.308

.242

MEAN RADIUS

.836

.783

.686

MAX RADIUS

1.822

1.208

1.195

HORIZONTAL SPREAD

1.654

1.654

1.654

VERTICAL SPREAD

2.572

1.312

1.211

EXTREME SPREAD

2.617

1.891

1.730

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

7

NUMBER IN THREE INCH CIRCLE =

9