

C6649066

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.






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

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

SERIAL NO.
C6649066

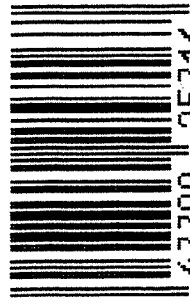
ORDER NO.
5716

MODEL 700™ H24

06

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

UPC



0 47700 25716 7



5716 C6649066

MOD. _____		GA. CAL. _____	GUN # <u>9066</u>
INSP. #	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st		
<i>NF</i>	<i>9/11</i>	<i>Bolt Handle Hit Stock</i>	<i>KS</i>
	2nd		
	<i>9/11</i>	<i>REP'D</i>	<i>KS</i>
	3rd		
	4th		
		FINAL INSPECTION	RD 6657 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6649066

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

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			9/7/91	JK
	G) Safety Off Force	3	3	3			9/7/91	JK
	H) Trigger Pull Test & Retainability						9-7-91	JK
	I) Firing Pin Indent	.021	.0225	.0225			9/7/91	JK
	J) Assemble Stock						9/10/91	JK
	K) Assemble Swivel Studs						9-13-91	D/H
	L) Attach Front and Rear Sight Assemblies						9/10/91	JK
	M) Iron Sight Alignment						9/10/91	JK
	N) Detach Front & Rear Sights & place in numbered container						9/10/91	JK
	O) Attach Scope to Rifle						9/10/91	JK
	P) Detach & Attach Scope 20 Times						9/10/91	JK
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						9-13-91	D/H
	B) Trigger Pull	2.14	2.24	2.37	2.38	2.46	9-12-191	JK
	C) Function						9-13-91	D/H
660	Pack						9-19-91	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C-6649066

DATE 9-7-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.52	2.57	2.48	2.14	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.49	2.55	2.44	2.24	
PULL #3	2.52	2.60	2.53	2.37	
PULL #4	2.65	2.66	2.50	2.38	
PULL #5	2.48	2.52	2.56	2.46	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.47	3.33		
PULL #2	3.29	3.40		
PULL #3	3.23	3.20		
PULL #4	3.20	3.19		
PULL #5	3.23	3.45		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.30	4.34		4.20
PULL #2	4.18	4.25		4.15
PULL #3	4.18	4.26		4.18
PULL #4	4.34	4.28		4.40
PULL #5	4.35	4.27		4.29
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649066
12 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.137004
1 TO	2	.213638
1 TO	3	.075452
1 TO	4	.200831
1 TO	5	.0247588

<----POA

AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0634
AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0298
AVERAGE POI RADIUS FOR THIS RIFLE IS: .070054
P.I. RIFLE IS: .9938

11 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649006

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 1.917

VS= 2.297

GS= 2.307

CENTROID *

PATTERN #

1

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.025

1.045

.955

MINIMUM X

-.892

-.872

-.962

MAXIMUM Y

.865

.786

.574

MINIMUM Y

-1.432

-1.057

-.679

CENTROID X

-.137

-.157

-.067

CENTROID Y

.001

.160

.292

POA TO CENTROID in.

.137

.224

.299

MIN RADIUS

.220

.184

.101

MEAN RADIUS

.876

.776

.684

MAX RADIUS

1.443

1.280

1.079

HORIZONTAL SPREAD

1.917

1.917

1.917

VERTICAL SPREAD

2.297

1.763

1.253

EXTREME SPREAD

2.307

2.270

2.047

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

7

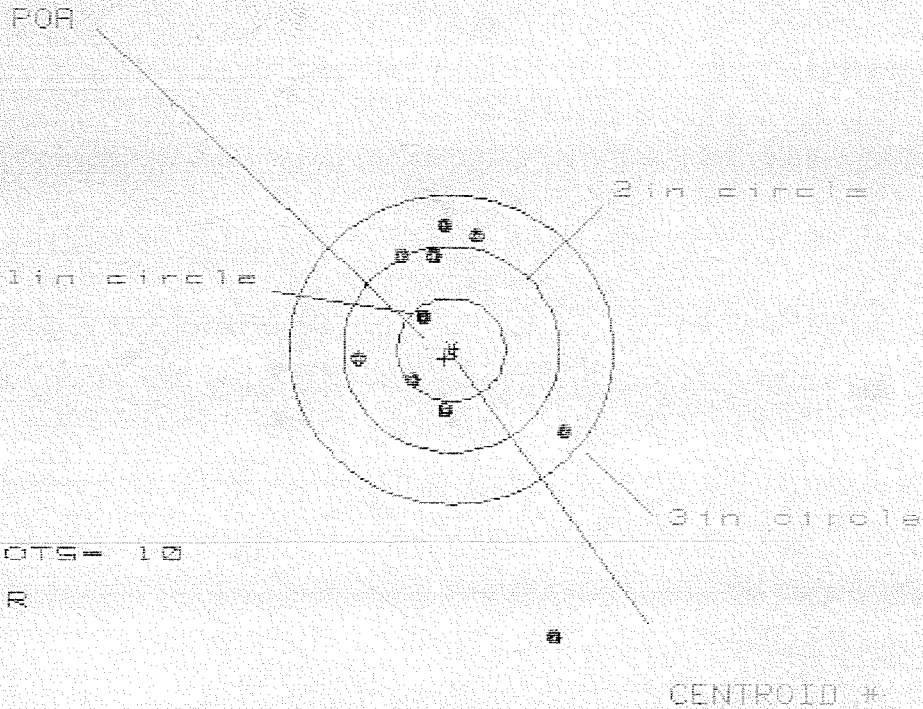
NUMBER IN THREE INCH CIRCLE =

10

11 Sep 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 1.941

VS= 4.030

GS= 4.137

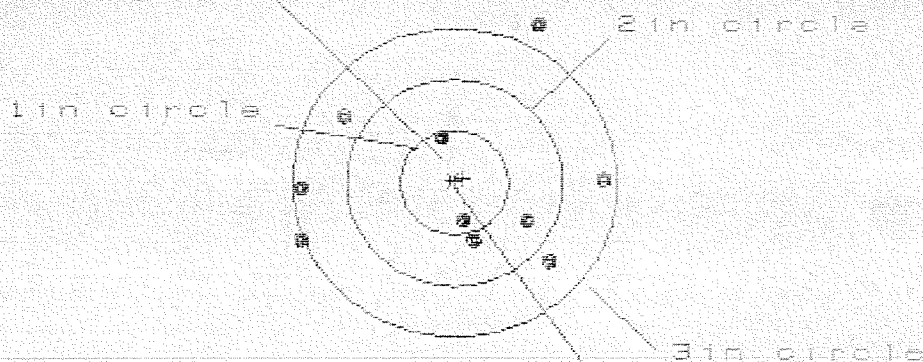
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.040	1.140	.525
MINIMUM X	:	-.901	-.801	-.658
MAXIMUM Y	:	1.200	.885	.752
MINIMUM Y	:	-2.830	-1.063	-1.017
CENTROID X	:	.059	-.041	-.184
CENTROID Y	:	.086	.401	.534
POA TO CENTROID in.	:	.105	.403	.564
MIN RADIUS	:	.417	.212	.111
MEAN RADIUS	:	1.097	.813	.676
MAX RADIUS	:	2.972	1.559	1.030
HORIZONTAL SPREAD	:	1.941	1.941	1.183
VERTICAL SPREAD	:	4.030	1.948	1.769
EXTREME SPREAD	:	4.137	2.256	1.770
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

(1 Sep 1991)

FILE:/PATTERNING/CENTERFIRE_PATT/06649066

CENTERFIRE PATTERNS # 3

POA



OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 2.028

VS= 2.226

GS= 3.018

CENTROID *

PATTERN #

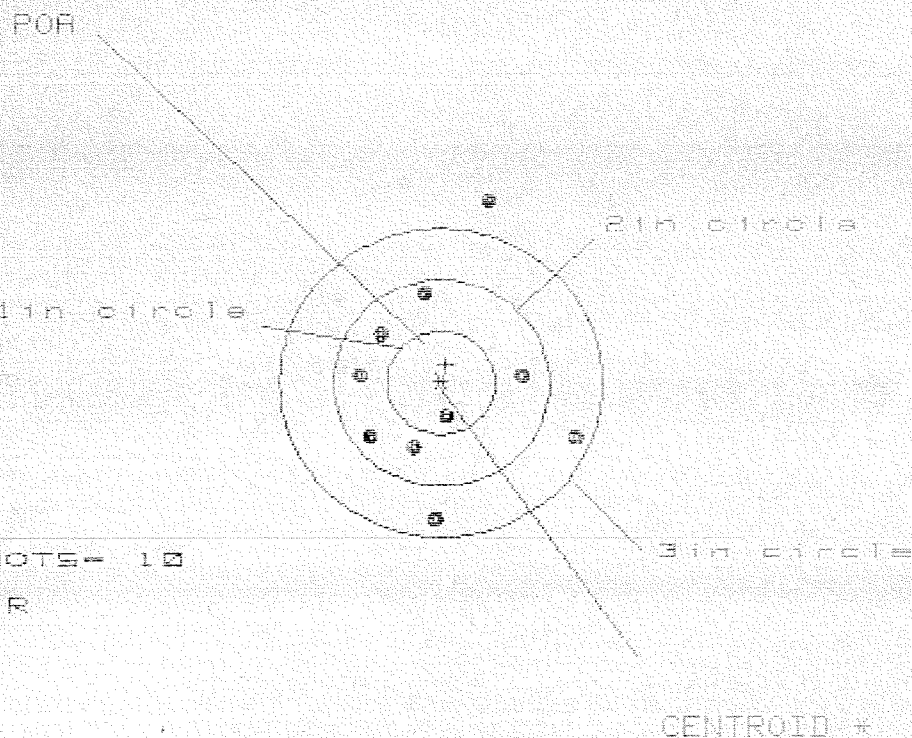
3

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.388	1.476	1.307
MINIMUM X	:	-1.441	-1.353	-1.474
MAXIMUM Y	:	1.514	.815	.770
MINIMUM Y	:	-.712	-.543	-.587
CENTROID X	:	-.075	-.163	.006
CENTROID Y	:	-.042	-.211	-.167
POA TO CENTROID in.	:	.006	.266	.167
MIN RADIUS	:	.344	.221	.218
MEAN RADIUS	:	1.046	.953	.871
MAX RADIUS	:	1.707	1.488	1.475
HORIZONTAL SPREAD	:	2.829	2.829	2.781
VERTICAL SPREAD	:	2.226	1.358	1.358
EXTREME SPREAD	:	3.018	2.890	2.782
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

11 Sep 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 9

HS= 2.056

VS= 3.125

GS= 3.167

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.288	1.335	.967
MINIMUM X	:	-.768	-.721	-.554
MAXIMUM Y	:	1.796	1.116	1.079
MINIMUM Y	:	-1.329	-1.129	-1.166
CENTROID X	:	-.044	-.092	-.259
CENTROID Y	:	-.177	-.377	-.340
POA TO CENTROID in.	:	.183	.388	.427
MIN RADIUS	:	.312	.193	.282
MEAN RADIUS	:	.953	.813	.728
MAX RADIUS	:	1.847	1.367	1.173
HORIZONTAL SPREAD	:	2.056	2.056	1.521
VERTICAL SPREAD	:	3.125	2.245	2.245
EXTREME SPREAD	:	3.167	2.246	2.246
NUMBER IN ONE INCH CIRCLE =	:		1	
NUMBER IN TWO INCH CIRCLE =	:		7	
NUMBER IN THREE INCH CIRCLE =	:		9	

01 Sep 1991

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CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

CENTROID *

HS= 2.323

VS= 2.818

GS= 2.984

PATTERN # : 5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.232	1.210	1.325
MINIMUM X	-1.091	-1.113	-1.998
MAXIMUM Y	1.637	.780	.662
MINIMUM Y	-1.181	-1.000	-1.117
CENTROID X	-.120	-.098	-.213
CENTROID Y	-.017	-.198	-.081
POA TO CENTROID in.	.121	.222	.228
MIN RADIUS	.218	.401	.291
MEAN RADIUS	.997	.920	.856
MAX RADIUS	1.648	1.359	1.358
HORIZONTAL SPREAD	2.323	2.323	2.323
VERTICAL SPREAD	2.818	1.780	1.780
EXTREME SPREAD	2.984	2.663	2.352
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		