

C6649075

MODEL 700TM M24

Model SMSTM

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.






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

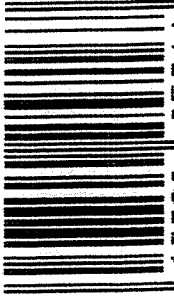
MODEL 700™ H24

SERIAL NO.
C6649075

ORDER NO.
5716

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

UPC



0 47700 25716 7



5716 C6649075

CONTRACT # DAAA21-87-C-0086

GFM

GUN SERIAL #

C6649075

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	K.R
	Magnaflux Bolt		AUG 7 1991	KR
615	Rollmark Caliber		AUG 7 1991	GB
617	Drill and Tap Sight Holes		AUG 7 1991	FB
618	Polish Barrel		AUG 3 1991	WB
620	Apply Coatings (Barrel Action)		8/27/91	KL
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/29/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/29/91	KL
	C) Inspect Ejector Hole for Chamfer		8/29/91	KL
	D) Oil Firing Pin Ass'y		8/29/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		9/14/91	KL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			9/4/91	JK
	G) Safety Off Force	4	4	4			9/4/91	JK
	H) Trigger Pull Test & Retainability						9/4/91	JK
	I) Firing Pin Indent	.0235	.0235	.0235			9/4/91	JK
	J) Assemble Stock						9/4/91	JK
	K) Assemble Swivel Studs						9-12-91	JK
	L) Attach Front and Rear Sight Assemblies						9/4/91	JK
	M) Iron Sight Alignment						9/4/91	JK
	N) Detach Front & Rear Sights & place in numbered container						9/4/91	JK
	O) Attach Scope to Rifle						9/4/91	JK
	P) Detach & Attach Scope 20 Times						9/4/91	JK
640	Gallery Target & Test						9/5/91	KT
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	KT
645	Inspect for Live Ammo						9/5/91	KT
655	Final Inspection							
	A) Headspace						9-12-91	DH
	B) Trigger Pull	263	260	255	254	257	9/6/91	JK
	C) Function						9-12-91	DH
660	Pack						9-12-91	N

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6649075

DATE 9/4/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.25	2.48	2.50	2.63	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.28	2.54	2.51	2.60	
PULL #3	2.48	2.52	2.53	2.55	
PULL #4	2.47	2.50	2.49	2.54	
PULL #5	2.49	2.52	2.51	2.57	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.30		
PULL #2	3.28	3.28		
PULL #3	3.27	3.31		
PULL #4	3.31	3.29		
PULL #5	3.31	3.30		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.43	4.42		4.36
PULL #2	4.46	4.23		4.46
PULL #3	4.28	4.43		4.46
PULL #4	4.43	4.45		4.39
PULL #5	4.30	4.45		4.46
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649075
5 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.366715
1 TO	2	.463199
1 TO	3	.462705
1 TO	4	.251002
1 TO	5	.229682

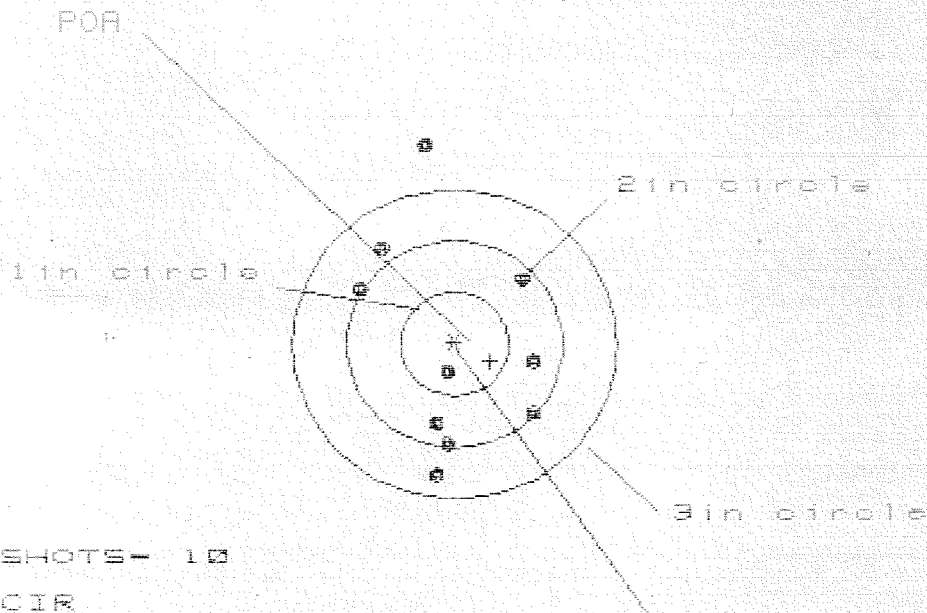
←----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1536
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.045
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .160056
THE AMP FOR THIS RIFLE IS: 1.03

Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649025

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 9

HE= 1.616

VS= 3.149

GS= 3.150

CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.773	.745	.723
MINIMUM X	:	-.843	-.871	-.893
MAXIMUM Y	:	1.927	1.122	.996
MINIMUM Y	:	-1.222	-1.008	-.862
CENTROID X	:	-.328	-.300	-.278
CENTROID Y	:	.164	-.050	.076
POA TO CENTROID in.	:	.367	.305	.288
MIN RADIUS	:	.267	.073	.193
MEAN RADIUS	:	.993	.831	.825
MAX RADIUS	:	1.942	1.308	1.215
HORIZONTAL SPREAD	:	1.616	1.616	1.616
VERTICAL SPREAD	:	3.149	2.130	1.858
EXTREME SPREAD	:	3.150	2.186	2.109
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

5 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CGB49075

CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 1.352

VS= 3.535

GS= 3.666

PATTERN #

2

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.681

.743

.698

MINIMUM X

-.671

-.609

-.654

MAXIMUM Y

1.428

1.194

.828

MINIMUM Y

-2.107

-1.177

-1.028

CENTROID X

.004

-.058

-.013

CENTROID Y

-.159

.075

-.074

POA TO CENTROID in.

.159

.095

.075

MIN RADIUS

.201

.286

.210

MEAN RADIUS

.880

.718

.637

MAX RADIUS

2.179

1.285

1.171

HORIZONTAL SPREAD

1.352

1.352

1.352

VERTICAL SPREAD

3.535

2.371

1.856

EXTREME SPREAD

3.666

2.376

1.900

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

7

NUMBER IN THREE INCH CIRCLE =

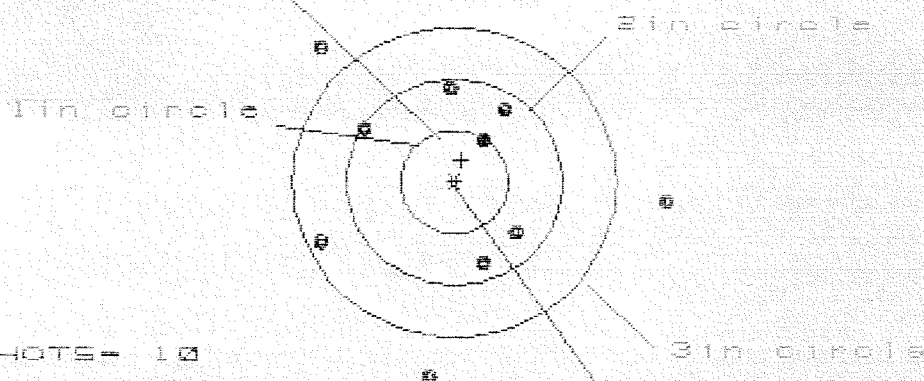
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5-Sep-1991

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CENTERFIRE PATTERNS # 3

POA



OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 3

HS= 3.254

VS= 3.157

GS= 3.516

CENTROID #

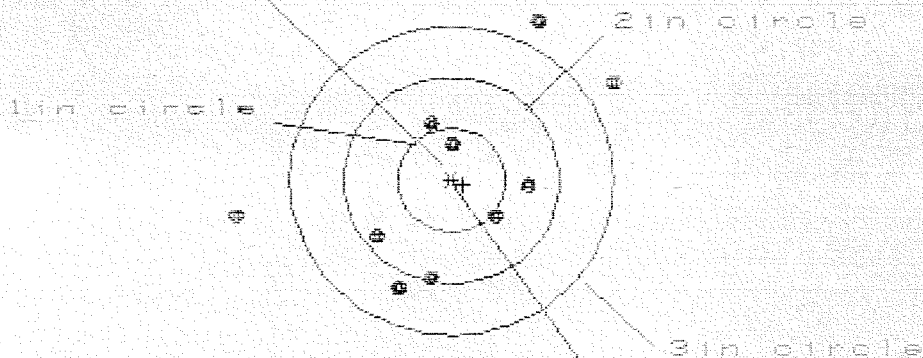
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.994	.778	.775
MINIMUM X	:	-1.260	-1.038	-1.041
MAXIMUM Y	:	1.286	1.264	1.027
MINIMUM Y	:	-1.871	-1.893	-1.064
CENTROID X	:	-.064	-.286	-.283
CENTROID Y	:	-.216	-.194	.043
POA TO CENTROID in.	:	.225	.345	.207
MIN RADIUS	:	.473	.593	.466
MEAN RADIUS	:	1.181	1.090	.948
MAX RADIUS	:	2.004	1.893	1.416
HORIZONTAL SPREAD	:	3.254	1.816	1.816
VERTICAL SPREAD	:	3.157	3.157	2.091
EXTREME SPREAD	:	3.516	3.298	2.568
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

5 Sep 1991

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CENTERFIRE PATTERNS # 4

POA



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 7

CENTROID #

HS= 3.543

VS= 2.632

GS= 3.767

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.510	1.284	1.366
MINIMUM X	:	-2.033	-.927	-.851
MAXIMUM Y	:	1.581	1.541	1.072
MINIMUM Y	:	-1.051	-1.091	-.898
CENTROID X	:	-.107	.119	.043
CENTROID Y	:	.045	.085	-.108
POA TO CENTROID in.	:	.116	.146	.116
MIN RADIUS	:	.344	.366	.320
MEAN RADIUS	:	1.084	.959	.854
MAX RADIUS	:	2.065	1.657	1.732
HORIZONTAL SPREAD	:	3.543	2.211	2.211
VERTICAL SPREAD	:	2.632	2.632	1.970
EXTREME SPREAD	:	3.767	2.943	2.802
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

VS 02p 1991

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 3.966

VS= 1.950

GS= 4.059

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.665	1.409	.847
MINIMUM X	-2.301	-1.764	-.580
MAXIMUM Y	.917	.802	.766
MINIMUM Y	-1.033	-.938	-.974
CENTROID X	-.273	-.017	-.193
CENTROID Y	-.059	.056	.092
POA TO CENTROID in.	.279	.059	.214
MIN RADIUS	.208	.420	.373
MEAN RADIUS	1.012	.856	.749
MAX RADIUS	2.522	1.438	1.170
HORIZONTAL SPREAD	3.966	2.173	1.435
VERTICAL SPREAD	1.950	1.740	1.740
EXTREME SPREAD	4.059	2.253	2.025
NUMBER IN ONE INCH CIRCLE	= 1		
NUMBER IN TWO INCH CIRCLE	= 5		
NUMBER IN THREE INCH CIRCLE	= 8		