

C6636205

MODEL 700TM M24

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 700TM M24

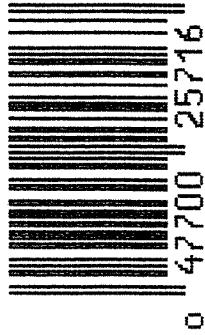
SERIAL NO.
C6636205

ORDER NO.
5716

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



UPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636205

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	5 2	9 1	RW
600	Proof	5 2	9 1	RW
607	Check Headspace	5 2	9 1	RW
610	Dis-assemble Gun	5 2	9 1	RW
612	Magnaflux Barrel Action	5	8 9 1	Kcd
	Magnaflux Bolt	5	8 9 1	Kcd
615	Rollmark Caliber	5	8 9 1	GB
617	Drill and Tap Sight Holes	5	15 9 1	KB
618	Polish Barrel	5	15 9 1	WB
620	Apply Coatings (Barrel Action)		5/29/91	DA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/30/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/91	RW
	C) Inspect Ejector Hole for Chamfer		5/30/91	RW
	D) Oil Firing Pin Ass'y		5/30/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/30/91	RW

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7	7 ³ / ₄	8			5-30-91	DH
	G) Safety Off Force	3	3	3			5-30-91	DH
	H) Trigger Pull Test & Retainability						5/30/91	JL
	I) Firing Pin Indent	.020	.021	.020			5-30-91	DH
	J) Assemble Stock						5/31/91	Rev
	K) Assemble Swivel Studs						6-3-91	DH
	L) Attach Front and Rear Sight Assemblies						5/31/91	Rev
	M) Iron Sight Alignment						5/31/91	Rev
	N) Detach Front & Rear Sights & place in numbered container						5/31/91	Rev
	O) Attach Scope to Rifle						5/31/91	Rev
	P) Detach & Attach Scope 20 Times						5/31/91	Rev
640	Gallery Target & Test						6-1-91	DH
	A) Time						6-1-91	DH
	B) Malfunctions						6-1-91	DH
	C) Pierced Primers						6-1-91	DH
	D) Optical Clarity of Scope						6-1-91	DH
645	Inspect for Live Ammo						6-1-91	DH
655	Final Inspection A) Headspace						6-3-91	DH
	B) Trigger Pull	2.48	2.44	2.48	2.52	2.33	6/3/91	JL
	C) Function						6-3-91	DH
660	Pack						6-20-91	RF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6636205
DATE 6/30/91
TESTER JK

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.39	2.51	2.38	2.48	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.42	2.50	2.40	2.44	
PULL #3	2.44	2.52	2.46	2.48	
PULL #4	2.44	2.49	2.42	2.52	
PULL #5	2.47	2.26	2.48	2.33	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.59	3.64		
PULL #2	3.60	3.61		
PULL #3	3.54	3.59		
PULL #4	3.55	3.61		
PULL #5	3.55	3.64		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.59	4.54		4.29
PULL #2	4.52	4.55		4.51
PULL #3	4.48	4.20		4.58
PULL #4	4.51	4.56		4.25
PULL #5	4.52	4.56		4.43
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # D6636205
1 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.204088
1 TO	2	.159906
1 TO	3	.351241
1 TO	4	.508847
1 TO	5	.301761

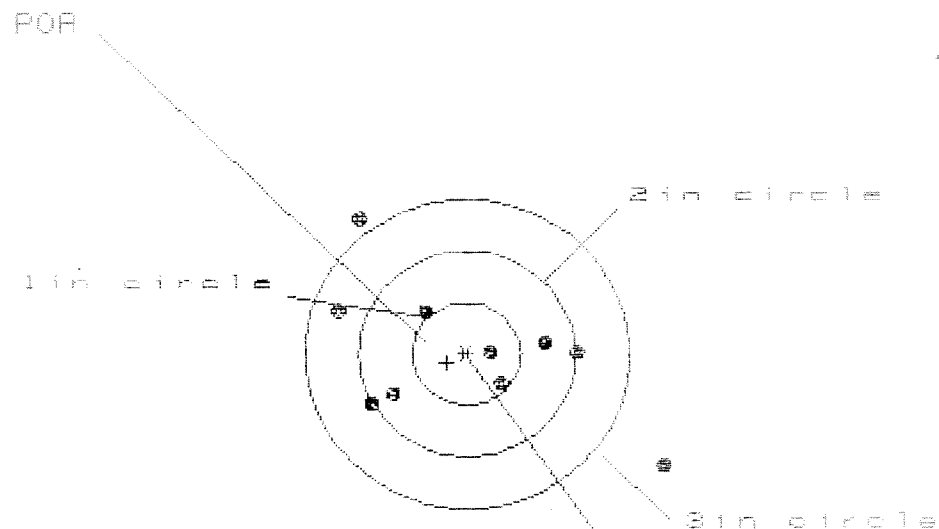
$\frac{5}{36}$ 4 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0826
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0424
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0928468
THE AMR FOR THIS RIFLE IS: .9

1 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08638285

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 3.946

VS= 2.364

GS= 3.614

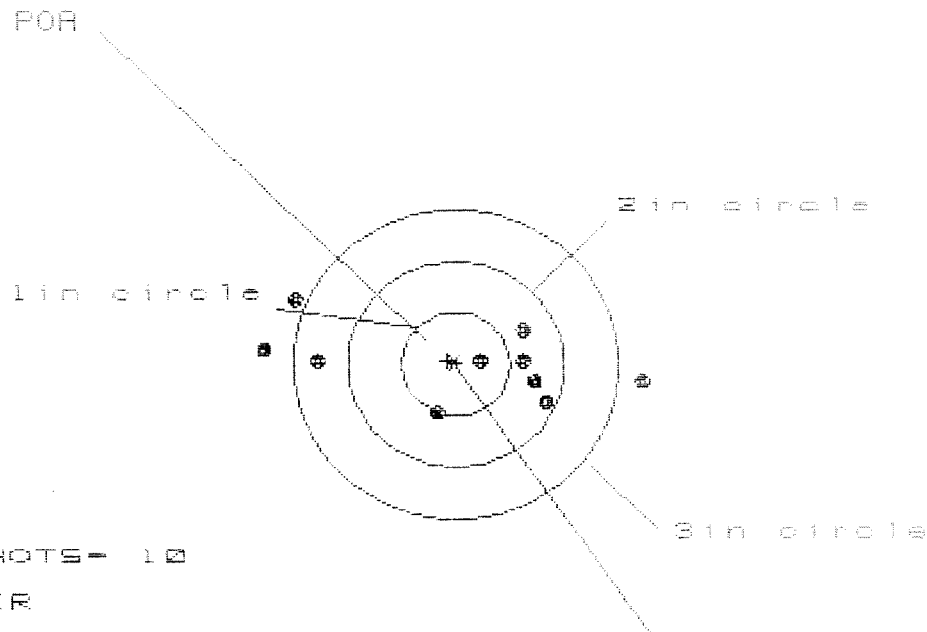
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.768	1.259	1.163
MINIMUM X	-1.178	-0.981	-1.077
MAXIMUM Y	1.290	1.171	.423
MINIMUM Y	-1.074	-0.553	-0.407
CENTROID X	.186	-0.011	.085
CENTROID Y	.084	.203	.057
POA TO CENTROID in.	.204	.204	.103
MIN RADIUS	.172	.323	.271
MEAN RADIUS	.955	.832	.738
MAX RADIUS	2.069	1.400	1.163
HORIZONTAL SPREAD	2.946	2.240	2.240
VERTICAL SPREAD	2.364	1.724	.830
EXTREME SPREAD	3.614	2.394	2.272
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

1 Jun 1981

FILE:/PATTERNING/CENTERFIRE_PATT/06030205

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 7

HS= 3.487

VS= 1.088

CS= 3.500

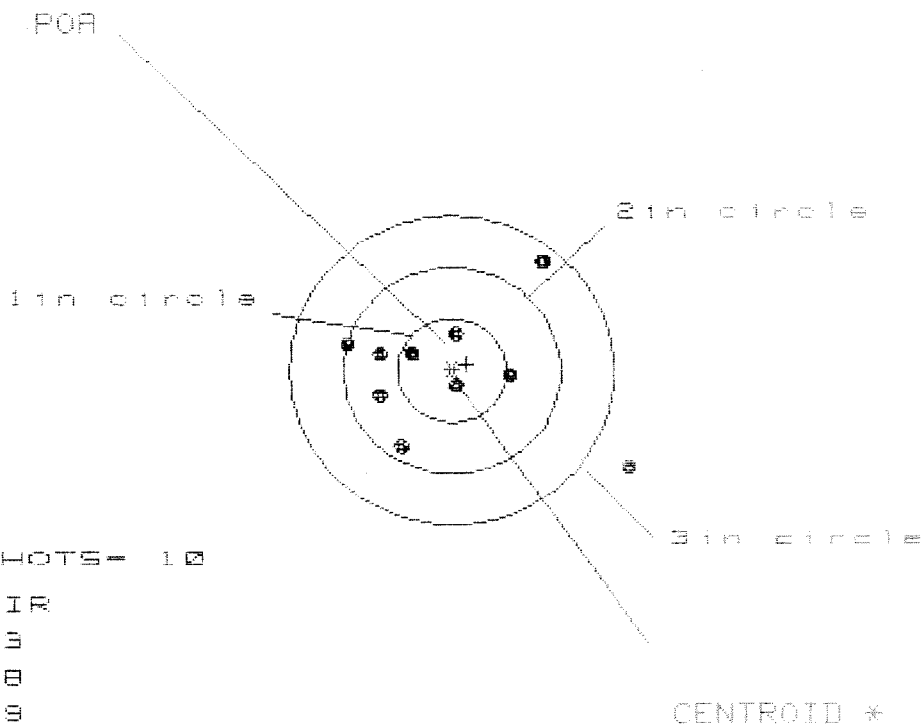
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.738	1.543	.784
MINIMUM X	-1.749	-1.636	-1.443
MAXIMUM Y	.597	.616	.601
MINIMUM Y	-.491	-.472	-.487
CENTROID X	.077	.272	.079
CENTROID Y	-.033	-.052	-.037
POA TO CENTROID in.	.084	.277	.087
MIN RADIUS	.246	.097	.246
MEAN RADIUS	1.003	.853	.815
MAX RADIUS	1.757	1.748	1.563
HORIZONTAL SPREAD	3.487	3.179	2.227
VERTICAL SPREAD	1.088	1.088	1.088
EXTREME SPREAD	3.500	3.262	2.440
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		7	

1 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636205

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 3

2in = 8

3in = 9

HS= 2.589

VS= 1.968

GS= 2.821

CENTROID *

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.616
MINIMUM X	-.973
MAXIMUM Y	1.072
MINIMUM Y	-.896
CENTROID X	-.133
CENTROID Y	-.063
POR TO CENTROID in.	.147
MIN RADIUS	.169
MEAN RADIUS	.801
MAX RADIUS	1.848
HORIZONTAL SPREAD	2.589
VERTICAL SPREAD	1.968
EXTREME SPREAD	2.821
NUMBER IN ONE INCH CIRCLE	3
NUMBER IN TWO INCH CIRCLE	8
NUMBER IN THREE INCH CIRCLE	9

1 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08638285

CENTERFIRE PATTERNS # 4

POB

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 6

3 in = 10

HS = 2.237

VS = 2.063

GS = 2.580

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.153

1.032

.894

MINIMUM X

-1.084

-.958

-.829

MAXIMUM Y

.848

.918

.875

MINIMUM Y

-1.215

-1.121

-1.164

CENTROID X

.381

.562

.373

CENTROID Y

-.386

-.480

-.437

POB TO CENTROID in.

.543

.694

.575

MIN RADIUS

.483

.332

.467

MEAN RADIUS

.899

.846

.801

MAX RADIUS

1.376

1.121

1.172

HORIZONTAL SPREAD

2.237

1.990

1.723

VERTICAL SPREAD

2.063

2.039

2.039

EXTREME SPREAD

2.580

2.039

2.039

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

6

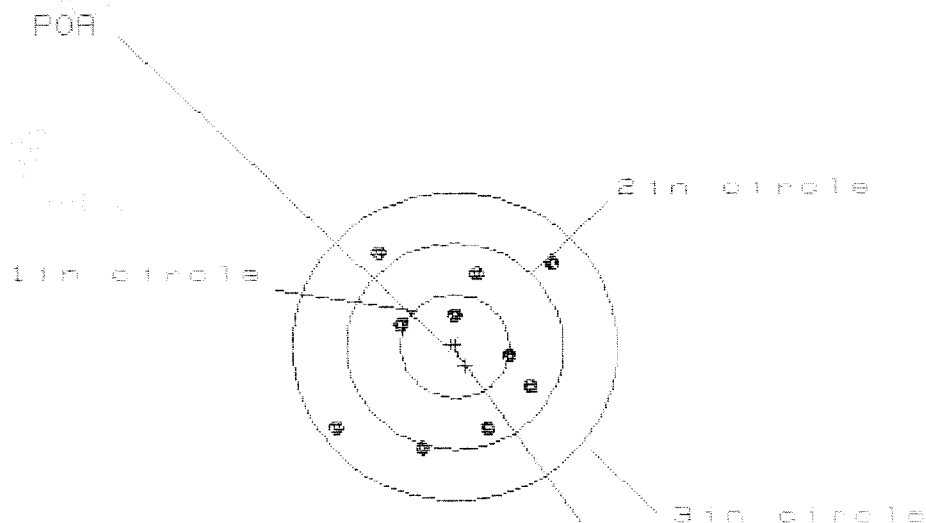
NUMBER IN THREE INCH CIRCLE =

10

1 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66362B5

CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1in = 1

2in = 6

3in = 10

HS = 2.025

VS = 1.841

GS = 2.624

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.927	.885	.628
MINIMUM X	-1.098	-.798	-.698
MAXIMUM Y	.868	.777	.872
MINIMUM Y	-.973	-1.064	-.969
CENTROID X	-.098	.024	-.076
CENTROID Y	.186	.277	.182
POA TO CENTROID in.	.210	.278	.197
MIN RADIUS	.301	.241	.386
MEAN RADIUS	.842	.764	.723
MAX RADIUS	1.368	1.158	1.117
HORIZONTAL SPREAD	2.025	1.603	1.326
VERTICAL SPREAD	1.841	1.841	1.841
EXTREME SPREAD	2.624	2.219	1.876
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		