

05636208

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.

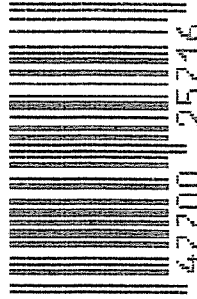
MODEL 700TM M24

SERIAL NO.
C6636208

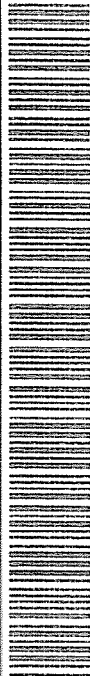
ORDER NO.
5716

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

UPC



0 47700 25716 7



5716 C6636208

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636208

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 30	91	Rw
600	Proof	4 30	91	Rw
607	Check Headspace	4 30	91	Rw
610	Dis-assemble Gun	4 30		Rw
612	Magnaflux Barrel Action	5 6	91	Rw
	Magnaflux Bolt	5 6	91	Rw
615	Rollmark Caliber	5 6	91	GB
617	Drill and Tap Sight Holes	5 10	91	FB
618	Polish Barrel	5 10	91	WB
620	Apply Coatings (Barrel Action)		5 30 91	FB
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		6/19/91	Rw
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6/19/91	Rw
	C) Inspect Ejector Hole for Chamfer		6/19/91	Rw
	D) Oil Firing Pin Ass'y		6/19/91	Rw
	E) Adjust Trigger Pull to Min Setting and Stake		7-22-91	Rw

op. #	OP. NAME	READINGS			DATE	INIT
625 cont.	F) Safety On Force	6	5	5	7-23-91	DH
	G) Safety Off Force	3	3	3	7-23-91	DH
	H) Trigger Pull Test & Retainability				7-22-91	SL
	I) Firing Pin Indent	.073	.022	.022	7-23-91	DH
	J) Assemble Stock				7/25/91	RW
	K) Assemble Swivel Studs				7-26-91	DH
	L) Attach Front and Rear Sight Assemblies				7/25/91	RW
	M) Iron Sight Alignment				7/25/91	RW
	N) Detach Front & Rear Sights & place in numbered container				7/25/91	RW
	O) Attach Scope to Rifle				7/25/91	RW
	P) Detach & Attach Scope 20 Times				7/25/91	RW
640	Gallery Target & Test				7/25/91	KT
	A) Time				"	KT
	B) Malfunctions				"	KT
	C) Pierced Primers				"	KT
	D) Optical Clarity of Scope				"	KT
645	Inspect for Live Ammo				7/25/91	KA
655	Final Inspection					
	A) Headspace				7-26-91	DH
	B) Trigger Pull	2.24	2.28	2.29	7-26-91	SL
	C) Function				7-26-91	DH
660	Pack				9-18-91	RF

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6636208
DATE 7-22-91
TESTER JY

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.61	2.55	2.24	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.37	2.54	2.40	2.28	
PULL #3	2.39	2.63	2.60	2.29	
PULL #4	2.45	2.60	2.63	2.28	
PULL #5	2.47	2.67	2.60	2.32	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.40	3.46		
PULL #2	3.46	3.48		
PULL #3	3.37	3.42		
PULL #4	3.44	3.40		
PULL #5	3.37	3.32		
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	4.29		4.24
PULL #2	4.28	4.44		4.43
PULL #3	4.24	4.23		4.50
PULL #4	4.22	4.20		4.44
PULL #5	4.24	4.28		4.44
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636208
25 Jul 1991

CENTROIDAL DISTANCES

0 TO	1	.059808
1 TO	2	.121499
1 TO	3	.0907855
1 TO	4	.33008
1 TO	5	.132004

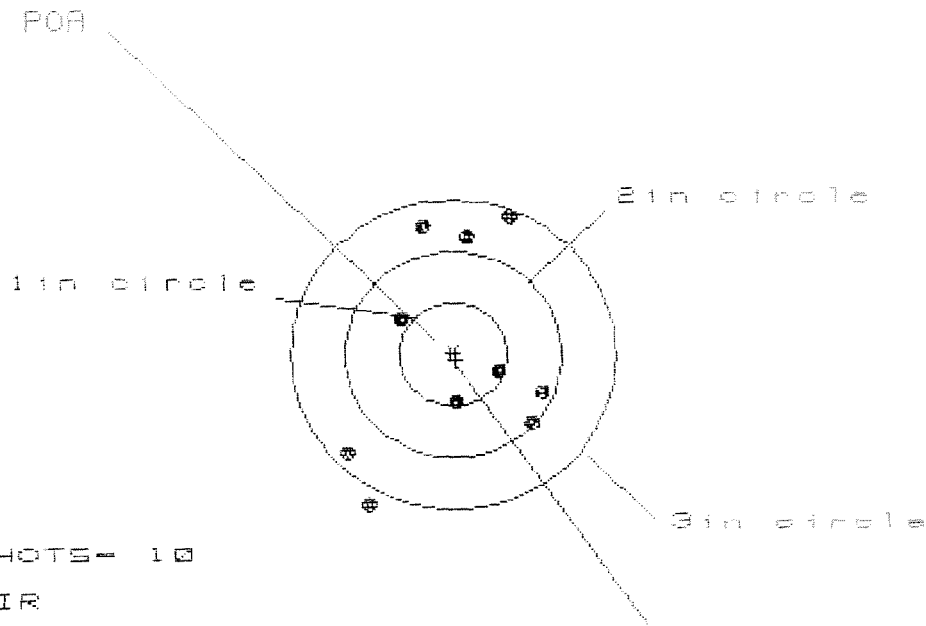
✱ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0202
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0092
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0221964
THE AMR FOR THIS RIFLE IS: .9622

25 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636208

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 1.768

VS= 2.761

CS= 3.054

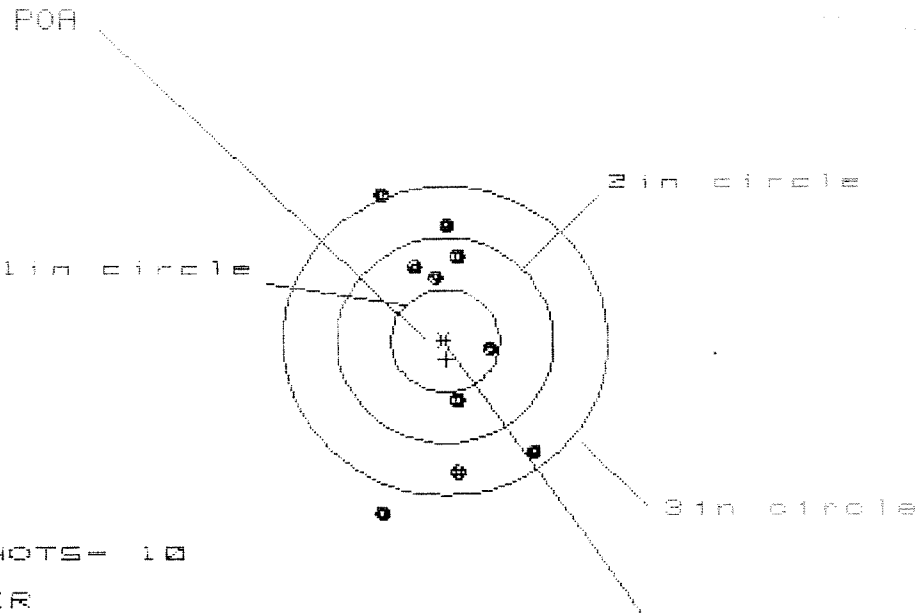
CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.773	.686	.740
MINIMUM X	:	-.995	-1.082	-1.028
MAXIMUM Y	:	1.315	1.154	1.260
MINIMUM Y	:	-1.446	-1.145	-1.088
CENTROID X	:	-.021	.066	.012
CENTROID Y	:	.056	.217	.072
POA TO CENTROID in.	:	.060	.227	.074
MIN RADIUS	:	.400	.404	.374
MEAN RADIUS	:	1.021	.945	.891
MAX RADIUS	:	1.645	1.576	1.435
HORIZONTAL SPREAD	:	1.768	1.768	1.768
VERTICAL SPREAD	:	2.761	2.299	2.261
EXTREME SPREAD	:	3.054	2.754	2.391
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	9		

25 Jul 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS= 1.451

VS= 3.098

GS= 3.098

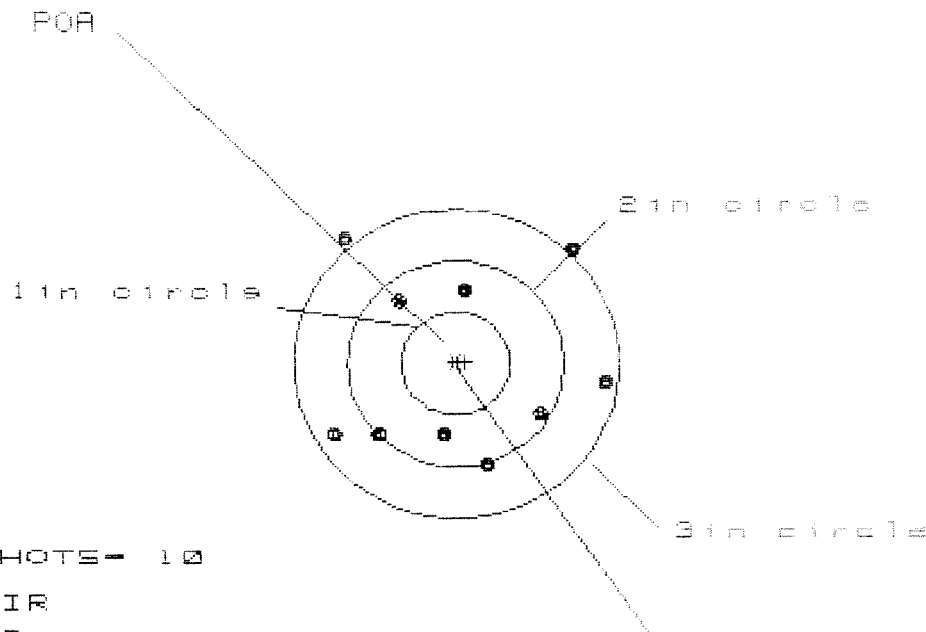
CENTROID *

PATTERN #	:	2
SHOTS (BEST OF)	:	10
MAXIMUM X	:	.841
MINIMUM X	:	-.610
MAXIMUM Y	:	1.377
MINIMUM Y	:	-1.721
CENTROID X	:	-.010
CENTROID Y	:	.177
POA TO CENTROID in.	:	.178
MIN RADIUS	:	.421
MEAN RADIUS	:	1.026
MAX RADIUS	:	1.821
HORIZONTAL SPREAD	:	1.451
VERTICAL SPREAD	:	3.098
EXTREME SPREAD	:	3.098
NUMBER IN ONE INCH CIRCLE =	:	1
NUMBER IN TWO INCH CIRCLE =	:	5
NUMBER IN THREE INCH CIRCLE =	:	8

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 8

HS= 2.470

VS= 2.144

GS= 2.796

CENTROID *

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.379	1.263	1.382
MINIMUM X	-1.091	-1.207	-1.088
MAXIMUM Y	1.170	1.266	.969
MINIMUM Y	-.974	-.844	-.686
CENTROID X	-.080	.036	-.083
CENTROID Y	-.013	-.143	-.301
POA TO CENTROID in.	.082	.147	.312
MIN RADIUS	.659	.571	.380
MEAN RADIUS	1.081	1.011	.906
MAX RADIUS	1.572	1.584	1.390
HORIZONTAL SPREAD	2.470	2.470	2.470
VERTICAL SPREAD	2.144	2.110	1.655
EXTREME SPREAD	2.796	2.796	2.520
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		8	

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CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 1.920

VS= 3.392

GS= 3.444

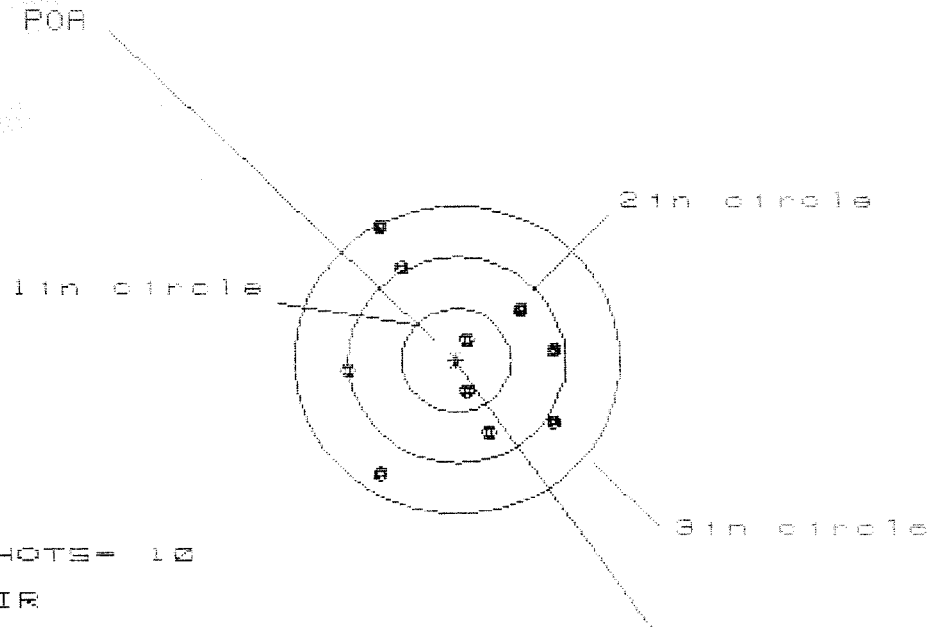
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.128	1.040	1.004
MINIMUM X	:	-.792	-.725	-.761
MAXIMUM Y	:	1.218	.976	.692
MINIMUM Y	:	-2.174	-.599	-.476
CENTROID X	:	-.089	-.001	.035
CENTROID Y	:	-.267	-.025	-.148
POA TO CENTROID in.	:	.281	.025	.152
MIN RADIUS	:	.047	.164	.037
MEAN RADIUS	:	.804	.636	.559
MAX RADIUS	:	2.314	1.122	1.048
HORIZONTAL SPREAD	:	1.920	1.765	1.765
VERTICAL SPREAD	:	3.392	1.575	1.168
EXTREME SPREAD	:	3.444	1.926	1.779
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 1.916

VS= 2.352

GS= 2.474

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.912
MINIMUM X	-1.004
MAXIMUM Y	1.270
MINIMUM Y	-1.082
CENTROID X	.009
CENTROID Y	.001
POA TO CENTROID in.	.009
MIN RADIUS	.201
MEAN RADIUS	.879
MAX RADIUS	1.459
HORIZONTAL SPREAD	1.916
VERTICAL SPREAD	2.352
EXTREME SPREAD	2.474
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	10