

C6636268

MODEL 700™ M24

Model **SMS**™

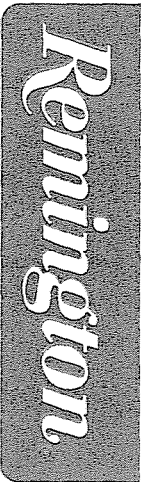
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.






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

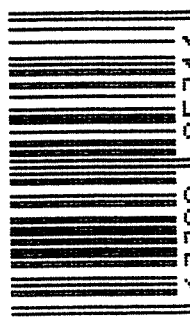
MODEL 700™ H24

SERIAL NO.
C6636268

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 C6636268

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636268

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		5/3/91	KS
600	Proof		5/3/91	KS
607	Check Headspace		5/3/91	KS
610	Dis-assemble Gun		5/3/91	KS
612	Magnaflux Barrel Action	5 6 9 1		KCR
	Magnaflux Bolt	5 6 9 1		KCR
615	Rollmark Caliber	5 6 9 1		G.S.
617	Drill and Tap Sight Holes	5 15 9 1		FB
618	Polish Barrel	5 15 9 1		WB
620	Apply Coatings (Barrel Action)		5-8-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/30/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/91	KS
	C) Inspect Ejector Hole for Chamfer		5/30/91	KS
	D) Oil Firing Pin Ass'y		5/30/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		6-4-91	JA

Op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			6-4-91	JH
	G) Safety Off Force	3	3	3			6-4-91	JH
	H) Trigger Pull Test & Retainability						6-4-91	JH
	I) Firing Pin Indent	.022	.023	.023			6-4-91	JH
	J) Assemble Stock						4/4/91	KS
	K) Assemble Swivel Studs						6-8-91	DH
	L) Attach Front and Rear Sight Assemblies						4/4/91	KS
	M) Iron Sight Alignment						4/4/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/4/91	KS
	O) Attach Scope to Rifle						4/4/91	KS
	P) Detach & Attach Scope 20 Times						4/4/91	KS
640	Gallery Target & Test						6-5-91	AC
	A) Time						6-5-91	AC
	B) Malfunctions						6-5-91	AC
	C) Pierced Primers						6-5-91	AC
	D) Optical Clarity of Scope						6-5-91	AC
645	Inspect for Live Ammo						6-5-91	AC
655	Final Inspection						6-8-91	DH
	A) Headspace						6-8-91	DH
	B) Trigger Pull	2.34	2.29	2.26	2.33	2.36	6-8-91	JH
	C) Function						6-8-91	DH
660	Pack						6-20-91	N

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6636268

DATE 6-4-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.56	2.46	2.44	2.34	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.49	2.48	2.46	2.29	
PULL #3	2.43	2.44	2.49	2.25	
PULL #4	2.49	2.48	2.51	2.33	
PULL #5	2.48	2.45	2.44	2.36	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.62	3.34		
PULL #2	3.62	3.33		
PULL #3	3.67	3.38		
PULL #4	3.34	3.36		
PULL #5	3.30	3.31		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.54	4.49		4.19
PULL #2	4.48	4.45		4.49
PULL #3	4.48	4.47		4.50
PULL #4	4.49	4.22		4.51
PULL #5	4.50	4.47		4.48
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636268
5 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.264609
1 TO	2	.451136
1 TO	3	.391874
1 TO	4	.295195
1 TO	5	.329848

5.1
4 <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0756
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0758
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .107056

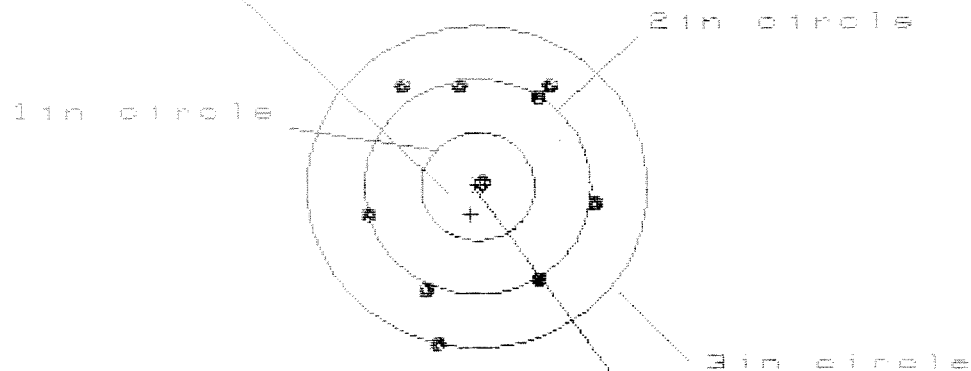
THE AMR FOR THIS RIFLE IS: .8464

5 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636268

CENTERFIRE PATTERNS # 1

FOR



OF SHOTS- 10

IN CIR

1in = 1

2in = 2

3in = 9

HS= 1.983

VS= 2.438

GS= 2.625

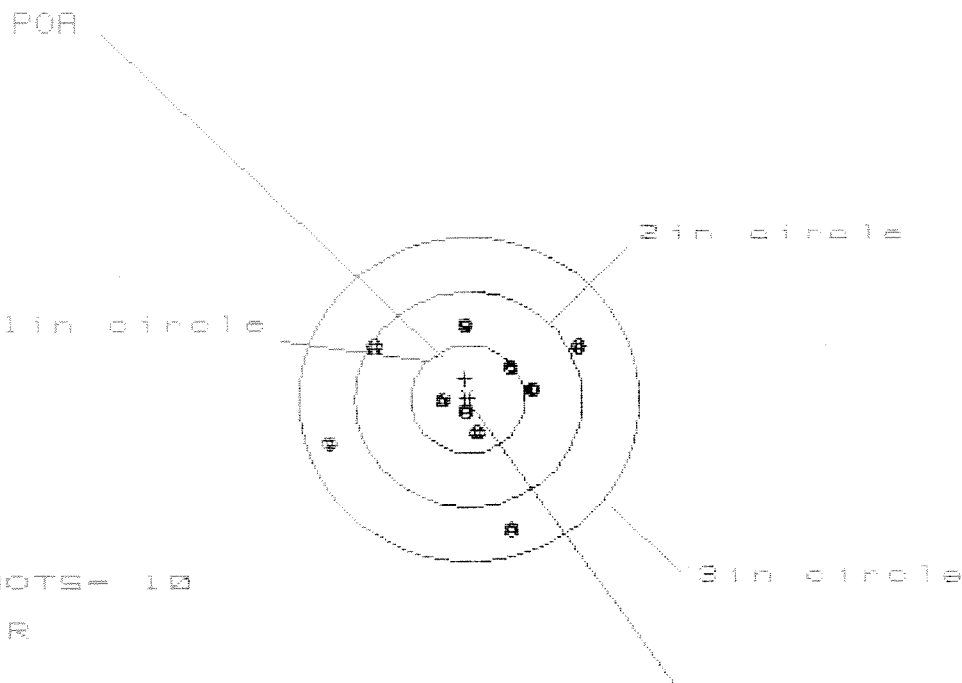
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.996	.954	.863
MINIMUM X	-.987	-1.029	-1.120
MAXIMUM Y	.972	.809	.989
MINIMUM Y	-1.466	-1.141	-1.041
CENTROID X	.063	.105	.196
CENTROID Y	.257	.420	.320
FOR TO CENTROID in.	.265	.433	.375
MIN RADIUS	.035	.137	.142
MEAN RADIUS	.990	.923	.898
MAX RADIUS	1.515	1.229	1.176
HORIZONTAL SPREAD	1.983	1.983	1.983
VERTICAL SPREAD	2.438	1.950	1.950
EXTREME SPREAD	2.625	2.193	2.193
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	9		

5 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636268

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 4

2in = 7

3in = 10

HS= 2.166

VS= 1.958

GS= 2.321

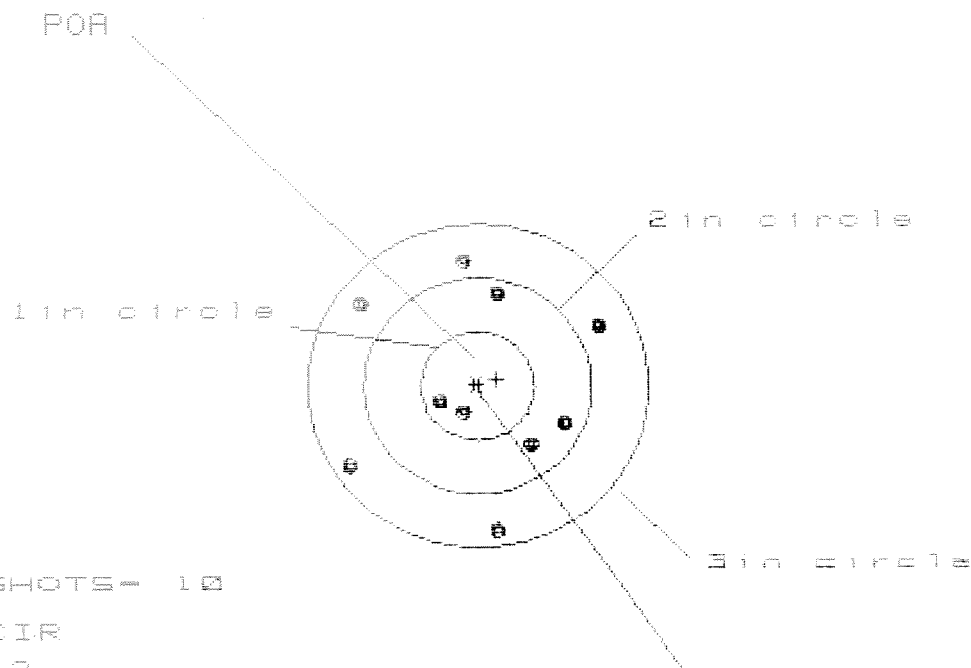
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.970	1.012	.867
MINIMUM X	:	-1.196	-1.154	-.915
MAXIMUM Y	:	.711	.572	.507
MINIMUM Y	:	-1.247	-.524	-.477
CENTROID X	:	.031	-.011	.134
CENTROID Y	:	-.193	-.054	.011
POA TO CENTROID in.	:	.195	.055	.134
MIN RADIUS	:	.103	.201	.298
MEAN RADIUS	:	.690	.626	.540
MAX RADIUS	:	1.301	1.268	.953
HORIZONTAL SPREAD	:	2.166	2.166	1.782
VERTICAL SPREAD	:	1.958	1.096	.984
EXTREME SPREAD	:	2.321	2.321	1.782
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

5 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C86352B8

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 2.234

VS= 2.469

GS= 2.578

CENTROID #

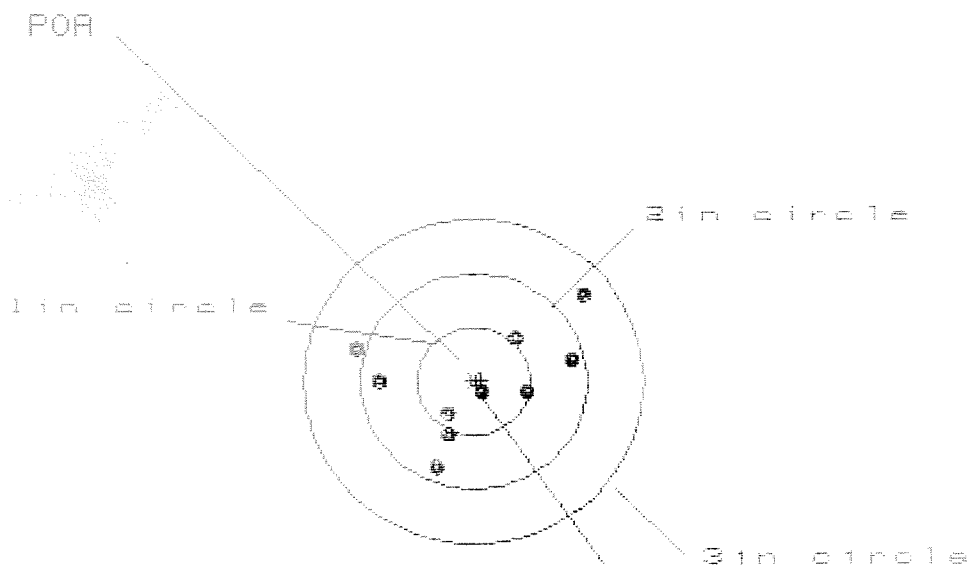
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.075	.946	.947
MINIMUM X	:	-1.159	-1.171	-1.170
MAXIMUM Y	:	1.174	1.096	.924
MINIMUM Y	:	-1.295	-1.373	-1.792
CENTROID X	:	-.166	-.037	-.038
CENTROID Y	:	-.061	.017	.189
POA TO CENTROID in.	:	.176	.041	.193
MIN RADIUS	:	.279	.412	.559
MEAN RADIUS	:	.939	.896	.838
MAX RADIUS	:	1.355	1.373	1.260
HORIZONTAL SPREAD	:	2.234	2.117	2.117
VERTICAL SPREAD	:	2.469	2.469	1.716
EXTREME SPREAD	:	2.578	2.482	2.148
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			10	

5 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B352B8

CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 2.007

VS= 1.595

GS= 2.097

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.983	.989	.874
MINIMUM X	:	-1.024	-.914	-.815
MAXIMUM Y	:	.792	.526	.575
MINIMUM Y	:	-.803	-.715	-.666
CENTROID X	:	-.065	-.175	-.060
CENTROID Y	:	-.009	-.097	-.146
POA TO CENTROID in.	:	.066	.200	.158
MIN RADIUS	:	.158	.200	.080
MEAN RADIUS	:	.700	.620	.553
MAX RADIUS	:	1.262	1.038	.948
HORIZONTAL SPREAD	:	2.007	1.903	1.689
VERTICAL SPREAD	:	1.595	1.241	1.241
EXTREME SPREAD	:	2.097	1.905	1.701
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

5 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636268

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS= 2.022

VS= 2.423

GS= 2.548

CENTROID #

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.072	.993	.864
MINIMUM X	-.950	-1.029	-.879
MAXIMUM Y	.887	.716	.802
MINIMUM Y	-1.536	-.913	-.827
CENTROID X	-.241	-.162	-.033
CENTROID Y	.385	.556	.470
POA TO CENTROID in.	.454	.579	.471
MIN RADIUS	.373	.262	.149
MEAN RADIUS	.913	.796	.710
MAX RADIUS	1.692	1.236	1.178
HORIZONTAL SPREAD	2.022	2.022	1.743
VERTICAL SPREAD	2.423	1.629	1.629
EXTREME SPREAD	2.548	2.299	2.119
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		