

C6636307

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.





MODEL 700™ H24

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



REG. U.S. PAT. & T.M. OFF.

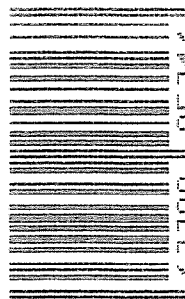
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

SERIAL NO. C6606307	ORDER NO. 5715
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5715 C6606307

UPC



0 4700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636307

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 25	9 1	RW
600	Proof	6 25	9 1	RW
607	Check Headspace	6 25	9 1	RW
610	Dis-assemble Gun	6 25	9 1	RW
612	Magnaflux Barrel Action		JUL 1 1991	KR
	Magnaflux Bolt		JUL 1 1991	KR
615	Rollmark Caliber		JUL 1 1991	SS.
617	Drill and Tap Sight Holes		JUL 1 1991	FB
618	Polish Barrel		JUL 2 1991	WB
620	Apply Coatings (Barrel Action)		8/27/91	1/1
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		8/28/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/28/91	RW
	C) Inspect Ejector Hole for Chamfer		8/28/91	RW
	D) Oil Firing Pin Ass'y		8/28/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9/14/91	W

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6	6	6	9/4/91	JS
	G) Safety Off Force	3	3	3	3	3	9/4/91	JS
	H) Trigger Pull Test & Retainability						9/4/91	JS
	I) Firing Pin Indent	1022	1022	1025	1025	1025	9/4/91	JS
	J) Assemble Stock						9/4/91	RW
	K) Assemble Swivel Studs						9-10-91	AC
	L) Attach Front and Rear Sight Assemblies						9/4/91	RW
	M) Iron Sight Alignment						9/4/91	RW
	N) Detach Front & Rear Sights & place in numbered container						9/4/91	RW
	O) Attach Scope to Rifle						9/4/91	RW
	P) Detach & Attach Scope 20 Times						9/4/91	RW
640	Gallery Target & Test						9-4-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						9-4-91	NF
655	Final Inspection							
	A) Headspace						9-10-91	AC
	B) Trigger Pull	2.50	2.49	2.44	2.50	2.47	9-6-91	JS
	C) Function						9-10-91	AC
660	Pack						9-10-91	NF

SWS TRIGGER PULL TEST

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

SERIAL NO. 06636307

DATE 9/4/91

TESTER JH.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.45	2.41	2.45	2.50	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.39	2.35	2.43	2.49	
PULL #3	2.47	2.41	2.44	2.44	
PULL #4	2.45	2.42	2.40	2.50	
PULL #5	2.29	2.43	2.39	2.47	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.33	3.26		
PULL #2	3.24	3.35		
PULL #3	3.50	3.55		
PULL #4	3.54	3.39		
PULL #5	3.21	3.38		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.33	4.35		4.65
PULL #2	4.26	4.36		4.63
PULL #3	4.35	4.23		4.33
PULL #4	4.31	4.54		4.56
PULL #5	4.36	4.51		4.60
TOTAL				
AVG.				

CELESTIAL DISTANCE CALCULATIONS
FOR RIFLE # 06636307
4 Sep 1991

CENTROIDAL DISTANCES

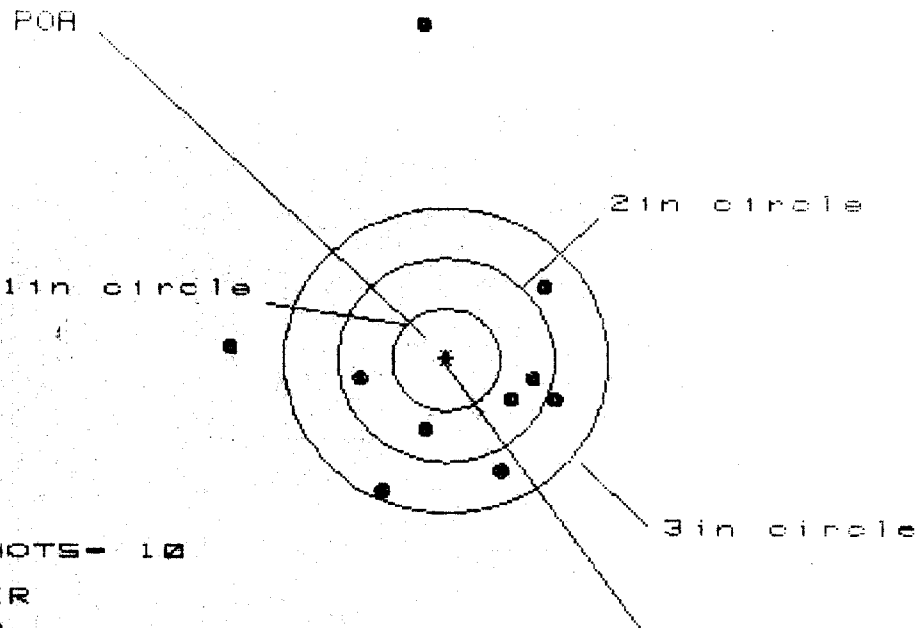
0 TO	1	.0200998
1 TO	2	.0817435
1 TO	3	.320395
1 TO	4	.0836481
1 TO	5	.228589

<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0688
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0978
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .119575
THE AMR FOR THIS RIFLE IS: 1.157

FILE:/PATTERNING/CENTERFIRE_PATT/C6636307

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 4

2in = 4

3in = 8

HS = 3.054

VS = 4.619

GS = 4.642

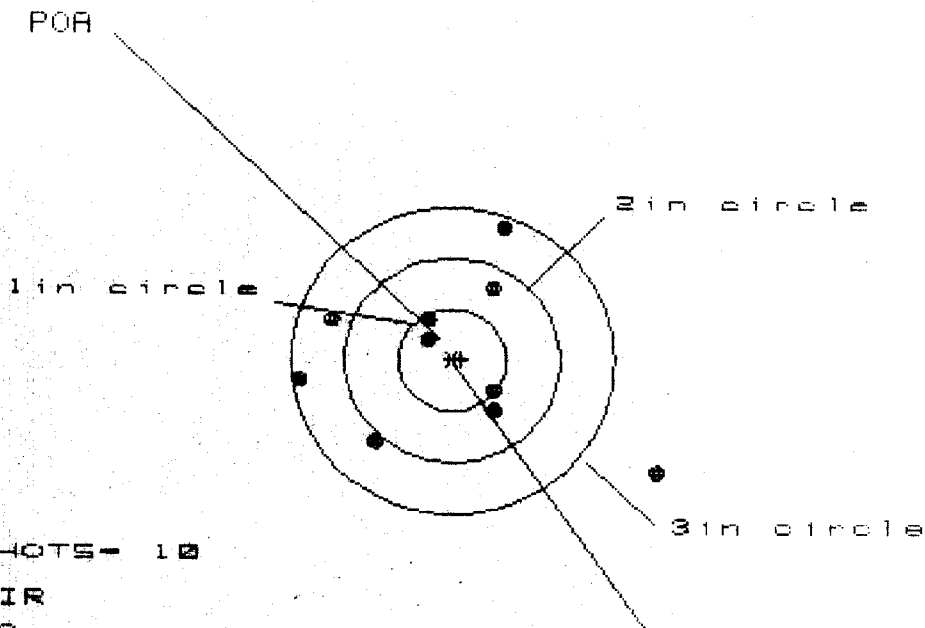
CENTROID *

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.033	1.015	.760
MINIMUM X	:	-2.021	-2.039	-1.104
MAXIMUM Y	:	3.342	1.099	1.161
MINIMUM Y	:	-1.278	-.906	-.844
CENTROID X	:	-.002	.016	.271
CENTROID Y	:	-.020	-.392	-.454
POA TO CENTROID in.	:	.021	.392	.528
MIN RADIUS	:	.689	.354	.351
MEAN RADIUS	:	1.333	1.010	.818
MAX RADIUS	:	3.345	2.098	1.316
HORIZONTAL SPREAD	:	3.054	3.054	1.864
VERTICAL SPREAD	:	4.619	2.005	2.005
EXTREME SPREAD	:	4.642	3.100	2.514
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 2



* OF SHOTS - 10

* IN CIR

1in = 2

2in = 5

3in = 9

HS = 3.344

VS = 2.400

GS = 3.460

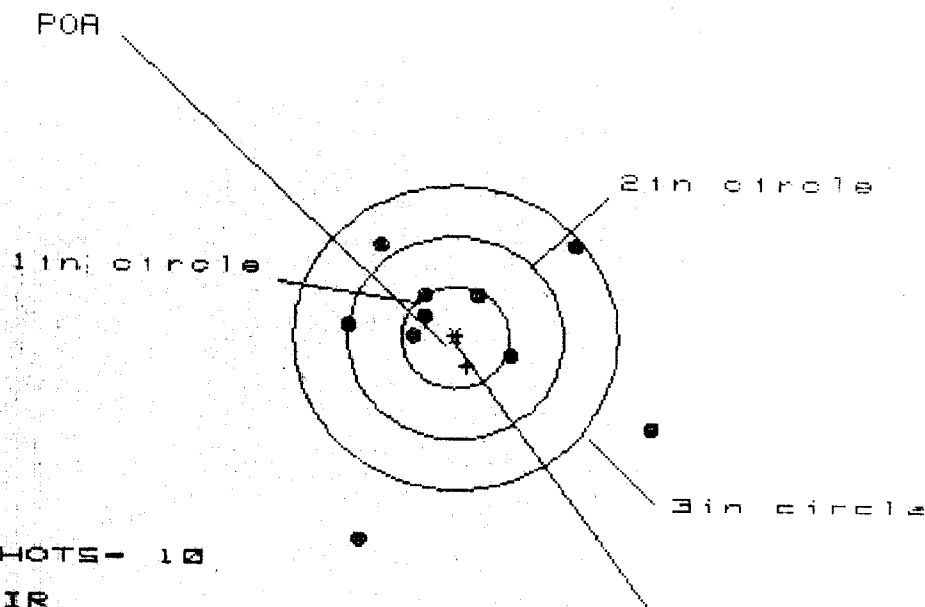
CENTROID *

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.931	.660	.510
MINIMUM X	:	-1.413	-1.198	-1.002
MAXIMUM Y	:	1.306	1.185	1.144
MINIMUM Y	:	-1.094	-.927	-.968
CENTROID X	:	-.083	-.298	-.148
CENTROID Y	:	-.009	.113	.154
POA TO CENTROID in.	:	.084	.318	.213
MIN RADIUS	:	.282	.084	.137
MEAN RADIUS	:	.988	.816	.751
MAX RADIUS	:	2.219	1.356	1.253
HORIZONTAL SPREAD	:	3.344	1.858	1.512
VERTICAL SPREAD	:	2.400	2.112	2.112
EXTREME SPREAD	:	3.460	2.395	2.390
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 5

3 in = 8

HM = 2.790

VM = 2.973

GM = 3.595

CENTROID *

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.787	1.684	1.265
MINIMUM X	:	-1.003	-1.106	-.896
MAXIMUM Y	:	.953	.728	.591
MINIMUM Y	:	-2.020	-1.102	-.535
CENTROID X	:	-.109	-.006	-.216
CENTROID Y	:	.282	.507	.644
POA TO CENTROID in.	:	.302	.507	.679
MIN RADIUS	:	.329	.247	.197
MEAN RADIUS	:	1.016	.849	.641
MAX RADIUS	:	2.224	2.012	1.377
HORIZONTAL SPREAD	:	2.790	2.790	2.161
VERTICAL SPREAD	:	2.973	1.830	1.126
EXTREME SPREAD	:	3.595	3.093	2.310
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

* OF SHOTS - 10

IN CIR

1 in 1

2 in 4

3 in 7

MEAN 1.943

VS 3.268

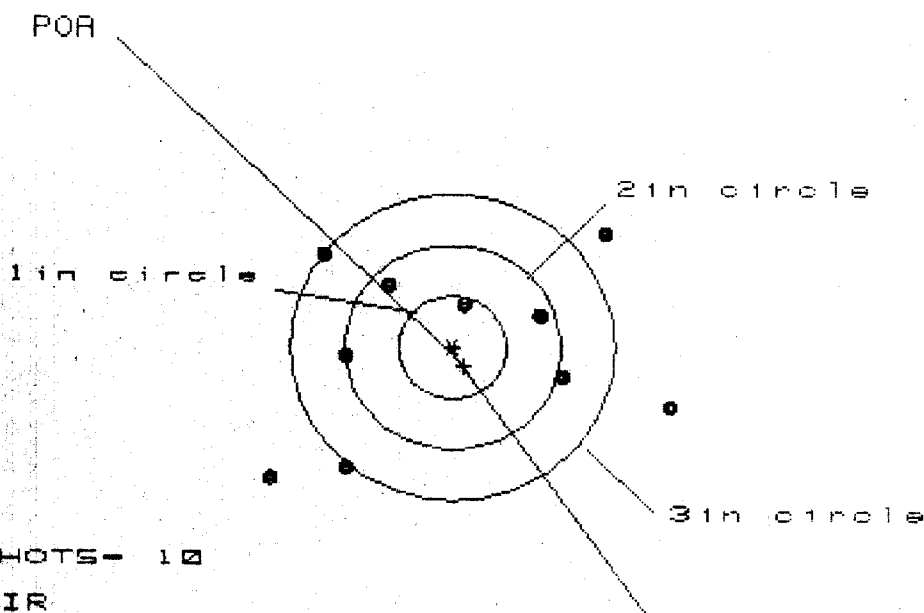
CS 3.417

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.883	.876	.743
MINIMUM X	-1.060	-1.067	-.778
MAXIMUM Y	1.393	1.185	.935
MINIMUM Y	-1.875	-1.705	-1.557
CENTROID X	-.041	-.034	.099
CENTROID Y	.054	.263	.115
POA TO CENTROID in.	.068	.265	.152
MIN RADIUS	.285	.087	.235
MEAN RADIUS	1.131	.987	.931
MAX RADIUS	1.875	1.713	1.557
HORIZONTAL SPREAD	1.943	1.943	1.521
VERTICAL SPREAD	3.268	2.890	2.492
EXTREME SPREAD	3.417	3.142	2.568
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in 1

2 in 4

3 in 5

MEAN 3.780

VS 2.397

GS 3.960

CENTROID *

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.054	1.654	1.467
MINIMUM X	:	-1.726	-1.498	-1.120
MAXIMUM Y	:	1.138	1.068	.902
MINIMUM Y	:	-1.259	-1.329	-1.373
CENTROID X	:	-.109	-.337	-.150
CENTROID Y	:	.182	.252	.418
POR TO CENTROID in.	:	.212	.421	.445
MIN RADIUS	:	.429	.495	.245
MEAN RADIUS	:	1.319	1.206	1.069
MAX RADIUS	:	2.148	2.003	1.722
HORIZONTAL SPREAD	:	3.780	3.152	2.597
VERTICAL SPREAD	:	2.397	2.397	2.275
EXTREME SPREAD	:	3.960	3.960	3.290
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	