

C6636315

MODEL 700™ M24

Model **SMS**™

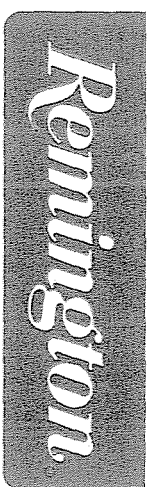
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.






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

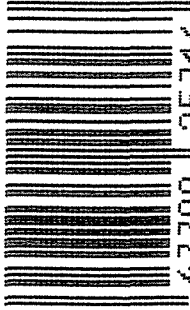
MODEL 700™ H24

SERIAL NO.
C6636315

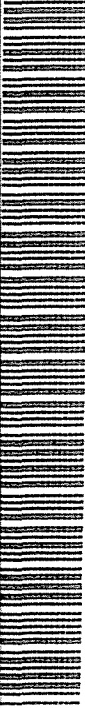
ORDER NO.
5716

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

UPC



0 4700 25716 7



5716 C6636315

GUN SERIAL # C6636315

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		KCK
	Magnaflux Bolt	5 8 9 1		KCK
615	Rollmark Caliber	5 8 9 1		GH
617	Drill and Tap Sight Holes	5 15 9 1		FB
618	Polish Barrel	5 15 9 1		WB
620	Apply Coatings (Barrel Action)		5-29-91	JA
	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		6-4-91	JD

Op. #	Op. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7	7	7			6-4-91	JL
	G) Safety Off Force	4	4	4			6-4-91	JL
	H) Trigger Pull Test & Retainability						6-4-91	JL
	I) Firing Pin Indent	1022	10215	10215			6-4-91	JL
	J) Assemble Stock						6/5/91	RW
	K) Assemble Swivel Studs						6-14-91	JL
	L) Attach Front and Rear Sight Assemblies						6/5/91	RW
	M) Iron Sight Alignment						6/5/91	RW
	N) Detach Front & Rear Sights & place in numbered container						6/5/91	RW
	O) Attach Scope to Rifle						6/5/91	RW
	P) Detach & Attach Scope 20 Times						6/5/91	RW
640	Gallery Target & Test						6-6-91	DH
	A) Time						6-6-91	DH
	B) Malfunctions						6-6-91	DH
	C) Pierced Primers						6-6-91	DH
	D) Optical Clarity of Scope						6-6-91	DH
645	Inspect for Live Ammo						6-6-91	DH
655	Final Inspection							
	A) Headspace						6-14-91	JL
	B) Trigger Pull	2.43	2.39	2.40	2.39	2.43	6-13-91	JL
	C) Function						6-14-91	JL
660	Pack						6-20-91	DH

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

SERIAL NO. C-6636315
DATE 6-4-91
TESTER JP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.60	2.45	2.51	2.43	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.49	2.45	2.50	2.39	
PULL #3	2.56	2.46	2.48	2.40	
PULL #4	2.56	2.45	2.46	2.39	
PULL #5	2.30	2.49	2.53	2.43	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.50	3.52		
PULL #2	3.55	3.54		
PULL #3	3.54	3.50		
PULL #4	3.49	3.55		
PULL #5	3.58	3.57		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.39	4.25		4.31
PULL #2	4.36	4.18		4.28
PULL #3	4.32	4.35		4.28
PULL #4	4.43	4.21		4.28
PULL #5	4.36	4.29		4.15
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636315
6 Jun 1991

CENTROIDAL DISTANCES

0 TO 1	.474377
1 TO 2	.593918
1 TO 3	.511945
1 TO 4	.869143
1 TO 5	.700446

$\frac{1}{2}$ <----FOR

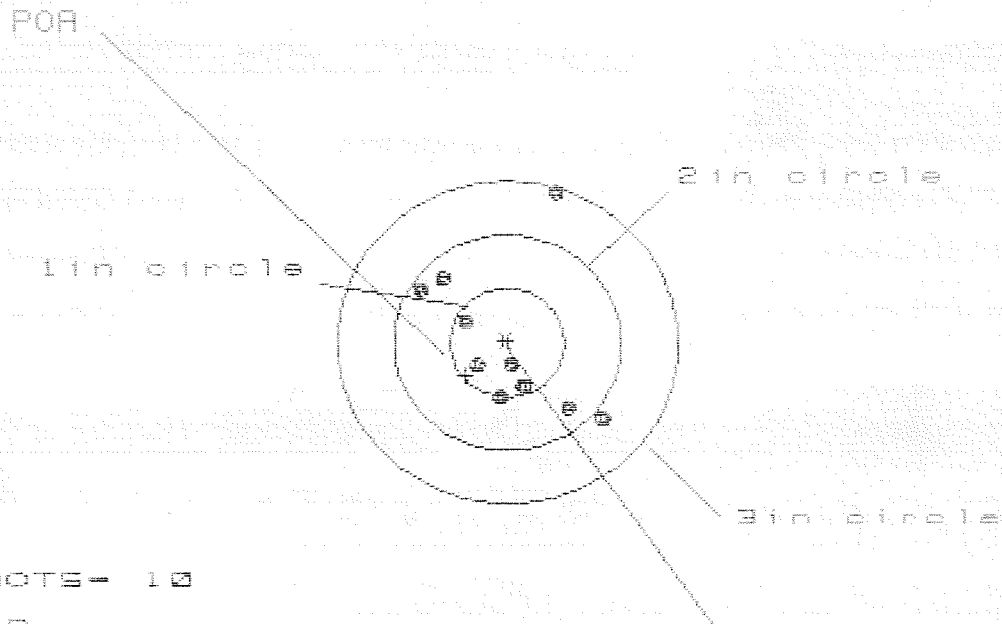
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0632
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1074
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .124615

THE AMR FOR THIS RIFLE IS: .8356

6 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636315

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 5

2in = 8

3in = 9

HS= 1.573

VS= 2.183

GS= 2.219

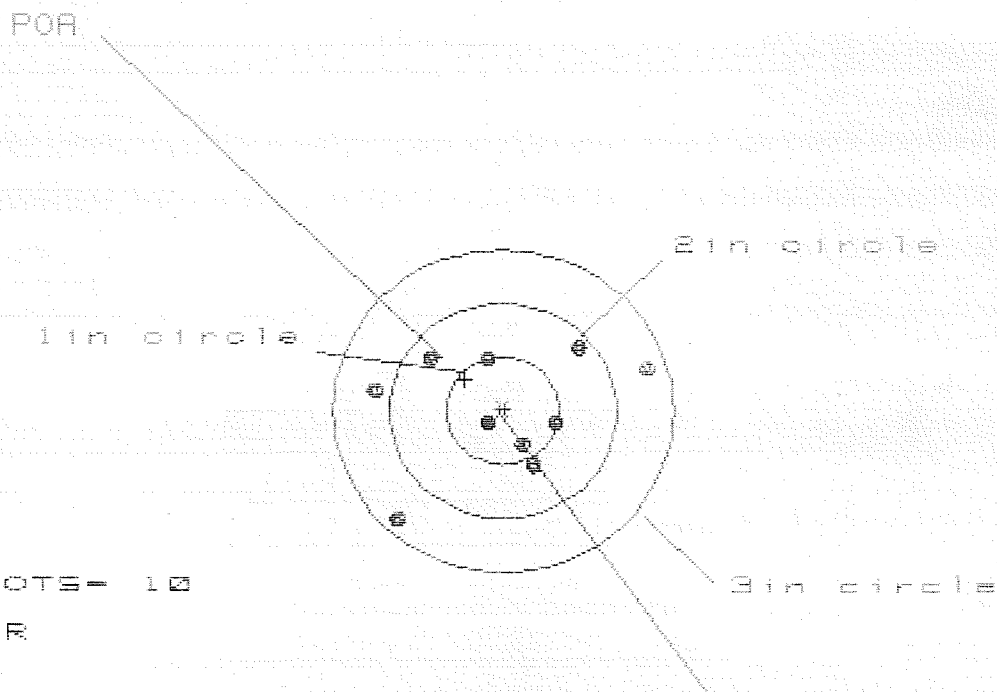
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.828	.876	.682
MINIMUM X	:	-.745	-.697	-.587
MAXIMUM Y	:	1.437	.722	.648
MINIMUM Y	:	-.746	-.586	-.525
CENTROID X	:	.365	.317	.207
CENTROID Y	:	.303	.143	.217
POA TO CENTROID in.	:	.474	.348	.300
MIN RADIUS	:	.252	.141	.136
MEAN RADIUS	:	.703	.566	.510
MAX RADIUS	:	1.500	1.054	.860
HORIZONTAL SPREAD	:	1.573	1.573	1.269
VERTICAL SPREAD	:	2.183	1.308	1.173
EXTREME SPREAD	:	2.219	2.009	1.689
NUMBER IN ONE INCH CIRCLE =			5	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			9	

6 Jun 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 2.432

VS= 1.809

GS= 2.601

CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.293	.814	.718
MINIMUM X	:	-1.139	-.996	-1.091
MAXIMUM Y	:	.613	.656	.537
MINIMUM Y	:	-.996	-.953	-.589
CENTROID X	:	.332	.189	.284
CENTROID Y	:	-.290	-.333	-.214
FOR TO CENTROID in.	:	.441	.383	.356
MIN RADIUS	:	.161	.107	.215
MEAN RADIUS	:	.759	.693	.620
MAX RADIUS	:	1.350	1.222	1.095
HORIZONTAL SPREAD	:	2.432	1.810	1.810
VERTICAL SPREAD	:	1.609	1.609	1.126
EXTREME SPREAD	:	2.601	2.255	1.864
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3

FOR

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 0

2in = 7

3in = 9

HS = 3.010

VS = 1.104

GS = 3.012

CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.959	1.483	.805
MINIMUM X	:	-1.051	-.834	-.648
MAXIMUM Y	:	.569	.553	.522
MINIMUM Y	:	-.535	-.551	-.582
CENTROID X	:	.003	-.214	-.400
CENTROID Y	:	-.059	-.043	-.012
FOR TO CENTROID in.	:	.059	.219	.400
MIN RADIUS	:	.508	.338	.204
MEAN RADIUS	:	.860	.661	.487
MAX RADIUS	:	1.964	1.505	.959
HORIZONTAL SPREAD	:	3.010	2.317	1.453
VERTICAL SPREAD	:	1.104	1.104	1.104
EXTREME SPREAD	:	3.012	2.317	1.668
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 9

HS = 2.033

VS = 2.541

GS = 2.738

PATTERN #

4

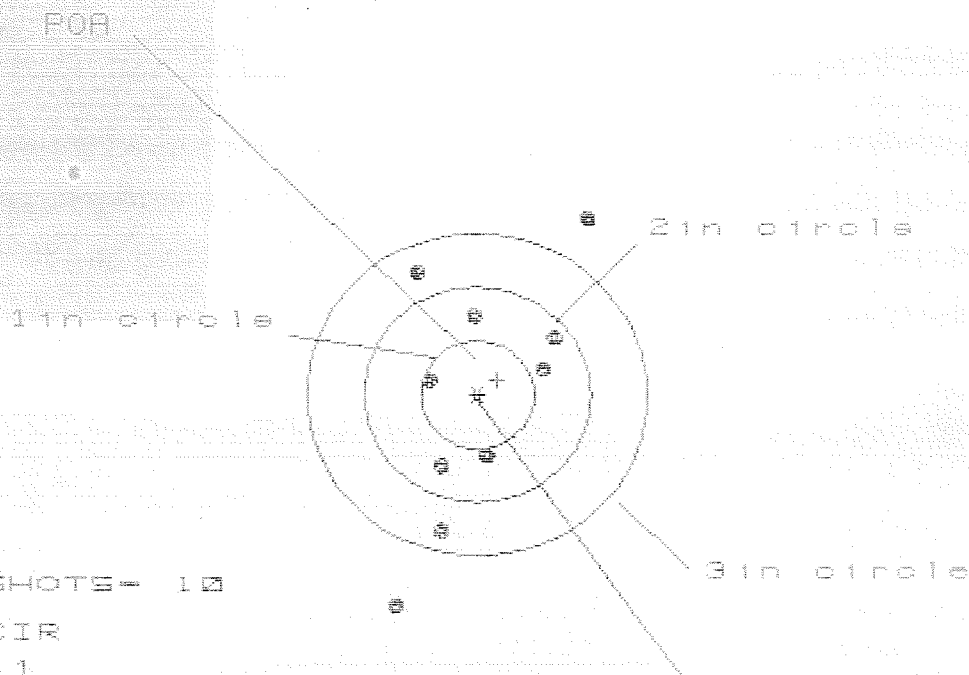
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.895	.881	.877
MINIMUM X	-1.138	-1.152	-1.042
MAXIMUM Y	1.537	.816	.712
MINIMUM Y	-1.004	-.833	-.807
CENTROID X	-.204	-.190	-.300
CENTROID Y	-.354	-.525	-.421
POA TO CENTROID in.	.409	.558	.517
MIN RADIUS	.076	.229	.192
MEAN RADIUS	.821	.752	.670
MAX RADIUS	1.542	1.212	1.048
HORIZONTAL SPREAD	2.033	2.033	1.919
VERTICAL SPREAD	2.541	1.649	1.519
EXTREME SPREAD	2.738	2.195	1.924
NUMBER IN ONE INCH CIRCLE =		2	
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 = 1

2in = 6

3in = 8

HS= 1.641

VS= 3.579

GS= 3.937

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.970	.896	.738
MINIMUM X	:	-.671	-.561	-.450
MAXIMUM Y	:	1.637	1.421	1.103
MINIMUM Y	:	-1.942	-1.512	-1.335
CENTROID X	:	-.180	-.106	-.218
CENTROID Y	:	-.137	.079	-.099
POA TO CENTROID in.	:	.226	.132	.239
MIN RADIUS	:	.441	.467	.392
MEAN RADIUS	:	1.037	.906	.800
MAX RADIUS	:	2.055	1.680	1.369
HORIZONTAL SPREAD	:	1.641	1.457	1.187
VERTICAL SPREAD	:	3.579	2.933	2.438
EXTREME SPREAD	:	3.937	3.213	2.442
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			8	