

C6636317

MODEL 700™ M24

Model **SMS**™

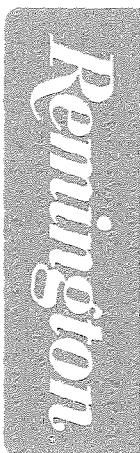
Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.






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

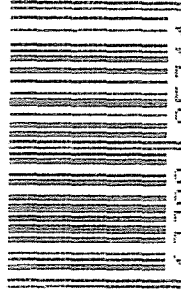
MODEL 700™ H24

SERIAL NO.
06636317

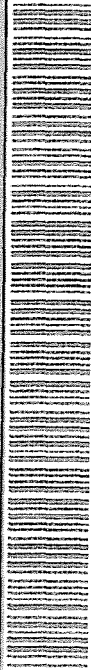
ORDER NO.
5716

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

UPC



0 4700 25716 7



5716 06636317

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6636317**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/24/91	KA
600	Proof		6/24/91	KA
607	Check Headspace		6/24/91	KA
610	Dis-assemble Gun		6/24/91	KA
612	Magnaflux Barrel Action		JUL 1 1991	KR
	Magnaflux Bolt		JUL 1 1991	KR
615	Rollmark Caliber		JUL 1 1991	GS
617	Drill and Tap Sight Holes		JUL 1 1991	FB
618	Polish Barrel		JUL 2 1991	WB
620	Apply Coatings (Barrel Action)		7-23-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/23/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/23/91	KS
	C) Inspect Ejector Hole for Chamfer		7/23/91	KS
	D) Oil Firing Pin Ass'y		7/23/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		7-31-91	JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7	7	7			7-31-91	DH
	G) Safety Off Force	3	3 $\frac{1}{2}$	3			7-3-91	DH
	H) Trigger Pull Test & Retainability						7-31-91	SH
	I) Firing Pin Indent	.020	.020	.021			7-31-91	DH
	J) Assemble Stock						8-1/91	KA
	K) Assemble Swivel Studs						8-6-91	AC
	L) Attach Front and Rear Sight Assemblies						8/1/91	KA
	M) Iron Sight Alignment						8/1/91	KA
	N) Detach Front & Rear Sights & place in numbered container						8/1/91	KA
	O) Attach Scope to Rifle						8/1/91	KA
	P) Detach & Attach Scope 20 Times						8/1/91	KA
640	Gallery Target & Test						8/2/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						8/2/91	KT
655	Final Inspection							
	A) Headspace						8-6-91	AC
	B) Trigger Pull	2.21	2.41	2.45	2.49	2.53	8-6-91	SH
	C) Function						8-6-91	AC
660	Pack						8/17-91	DH

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6636317
DATE 7-31-91
TESTER JCL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.23	2.48	2.51	2.21	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.21	2.49	2.45	2.41	
PULL #3	2.60	2.48	2.48	2.45	
PULL #4	2.56	2.51	2.50	2.49	
PULL #5	2.62	2.49	2.44	2.53	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.34	3.47		
PULL #2	3.46	3.45		
PULL #3	3.45	3.45		
PULL #4	3.43	3.48		
PULL #5	3.43	3.46		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.29	4.33		4.27
PULL #2	4.37	4.31		4.32
PULL #3	4.32	4.31		4.41
PULL #4	4.36	4.35		4.41
PULL #5	4.29	4.37		4.34
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636317
2 Aug 1991

CENTROIDAL DISTANCES

0 TO 1	.56056
1 TO 2	.574882
1 TO 3	.568958
1 TO 4	.544694
1 TO 5	.831362

#3 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2034
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .8666
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .214626
THE AMR FOR THIS RIFLE IS: .8766

July 1991

FILE: PATTERNS/CENTERFIRE_PATT/C6635317

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

CENTROID *

* OF SHOTS= 10

* IN CIR

1in = 1

2in = 5

3in = 8

HS= 2.325

VS= 2.478

GS= 2.836

PATTERN #			
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.540	1.667	.821
MINIMUM X	-.786	-.659	-.451
MAXIMUM Y	.914	.741	.791
MINIMUM Y	-1.563	-1.359	-1.310
CENTROID X	.428	.301	.893
CENTROID Y	-.382	-.189	-.239
POA TO CENTROID in.	.561	.355	.256
MIN RADIUS	.474	.319	.116
MEAN RADIUS	1.052	.898	.748
MAX RADIUS	1.938	1.714	1.335
HORIZONTAL SPREAD	2.326	2.326	1.272
VERTICAL SPREAD	2.478	2.100	2.100
EXTREME SPREAD	2.836	2.763	2.361
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

2 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636317

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.716

VS= 2.207

GS= 2.275

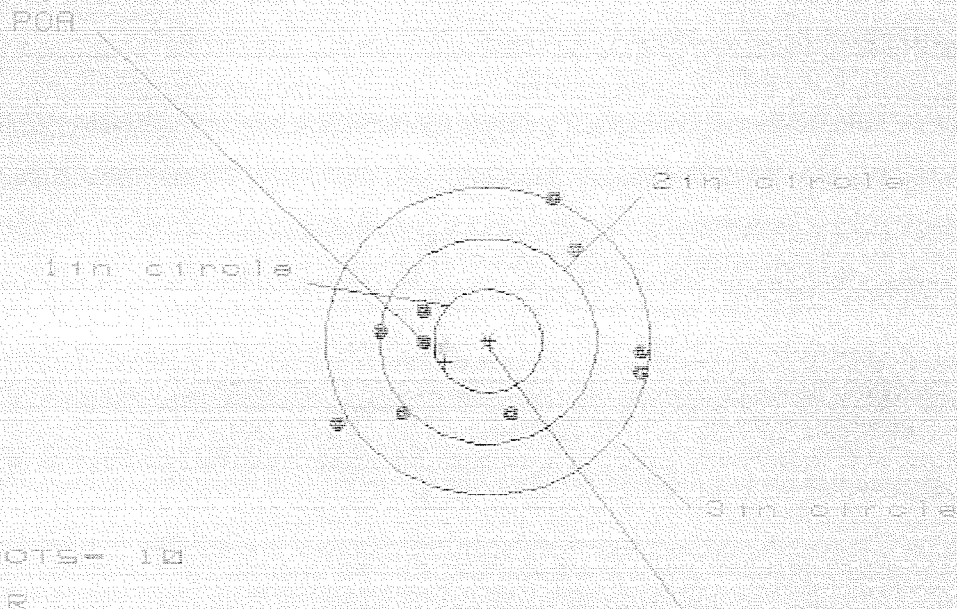
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.137	1.120	.287
MINIMUM X	-.579	-.596	-.456
MAXIMUM Y	.837	.685	.569
MINIMUM Y	-1.370	-.925	-.952
CENTROID X	.823	.040	-.101
CENTROID Y	.046	.198	.314
POA TO CENTROID in.	.051	.202	.330
MIN RADIUS	.093	.072	.159
MEAN RADIUS	.759	.647	.524
MAX RADIUS	1.378	1.453	1.055
HORIZONTAL SPREAD	1.716	1.716	.743
VERTICAL SPREAD	2.207	1.610	1.521
EXTREME SPREAD	2.275	2.275	1.624
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	

2 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B36347

CENTERFIRE PATTERNS # 3



+ OF SHOTS= 10

IN CIR

1in = 0

2in = 3

3in = 9

HS= 2.810

VS= 2.177

GS= 2.814

PATTERN #			
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.429	1.276	1.326
MINIMUM X	-1.381	-1.174	-1.124
MAXIMUM Y	1.376	1.287	.969
MINIMUM Y	-.901	-.844	-.683
CENTROID X	.395	.548	.498
CENTROID Y	.206	.295	.134
POR TO CENTROID IN.	.445	.622	.515
MIN RADIUS	.618	.735	.688
MEAN RADIUS	1.121	1.078	1.023
MAX RADIUS	1.596	1.349	1.350
HORIZONTAL SPREAD	2.810	2.450	2.450
VERTICAL SPREAD	2.177	2.131	1.652
EXTREME SPREAD	2.914	2.494	2.494
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	3	
NUMBER IN THREE INCH CIRCLE	=	9	

3 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08030317

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 4

2in = 9

3in = 10

HS= 2.112

VS= 1.560

GS= 2.123

PATTERN #		10	9	8
SHOTS (BEST OF)		10	9	8
MAXIMUM X		.878	.741	.627
MINIMUM X		-1.234	-.912	-.569
MAXIMUM Y		.953	.951	.875
MINIMUM Y		-.607	-.609	-.363
CENTROID X		.054	.191	.365
CENTROID Y		.034	.036	.112
POA TO CENTROID in.		.064	.194	.325
MIN RADIUS		.149	.119	.189
MEAN RADIUS		.648	.563	.496
MAX RADIUS		1.234	1.097	.977
HORIZONTAL SPREAD		2.112	1.653	1.196
VERTICAL SPREAD		1.560	1.560	1.239
EXTREME SPREAD		2.123	1.830	1.487
NUMBER IN ONE INCH CIRCLE =		4		
NUMBER IN TWO INCH CIRCLE =		9		
NUMBER IN THREE INCH CIRCLE =		10		

2 Aug 1981

FILE:/PATTERNING/CENTER FIRE_PATT/C6636317

CENTERFIRE PATTERNS

5

FOH

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR :

1 in = 2

2 in = 7

3 in = 10

HS= 2.556

VS= 1.446

GS= 2.575

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.110	.943	.834
MINIMUM X	-1.446	-.673	-.554
MAXIMUM Y	.749	.762	.739
MINIMUM Y	-.697	-.684	-.707
CENTROID X	.117	.278	.159
CENTROID Y	.409	.396	.419
FOH TO CENTROID in.	.425	.484	.449
MIN RADIUS	.397	.468	.423
MEAN RADIUS	.803	.732	.685
MAX RADIUS	1.450	.967	1.033
HORIZONTAL SPREAD	2.556	1.622	1.388
VERTICAL SPREAD	1.446	1.446	1.446
EXTREME SPREAD	2.575	1.744	1.744
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	