

C6636320

MODEL 700TM M24

Model **SMS** TM

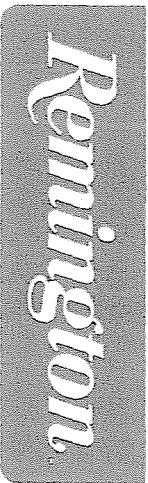
Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.






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

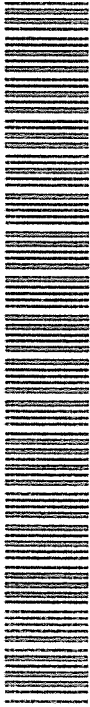
MODEL 700TM M24

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

SERIAL NO.
C6636320

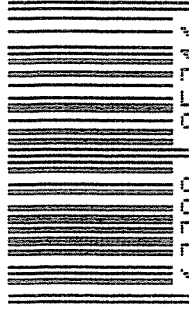
ORDER NO.
5716

20



5716 C6636320

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6636320

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/25/91	KH
600	Proof		6/25/91	KH
607	Check Headspace		6/25/91	KH
610	Dis-assemble Gun		6/25/91	KH
612	Magnaflux Barrel Action		JUL 1 8 1991	CS
	Magnaflux Bolt		JUL 1 8 1991	CS
615	Rollmark Caliber		JUL 1 8 1991	CS
617	Drill and Tap Sight Holes		JUL 1 8 1991	LB
618	Polish Barrel		JUL 2 0 1991	WB
620	Apply Coatings (Barrel Action)		8-2-91	CS
	Apply Coating (Bolt)		8-2-91	CS
625	Final Assembly A) Clean inside of Bolt Assembly		8/22/91	KH
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/22/91	KH
	C) Inspect Ejector Hole for Chamfer		8/22/91	KH
	D) Oil Firing Pin Ass'y		8/22/91	KH
	E) Adjust Trigger Pull to Min Setting and Stake		8/23/91	JH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			8-23-91	D/H
	G) Safety Off Force	2 1/2	2	2			8-23-91	D/H
	H) Trigger Pull Test & Retainability						8/23/91	RL
	I) Firing Pin Indent	1.023	1.023	1.023			8-23-91	D/H
	J) Assemble Stock						8/27/91	RL
	K) Assemble Swivel Studs						8-31-91	D/H
	L) Attach Front and Rear Sight Assemblies						8/27/91	RL
	M) Iron Sight Alignment						8/27/91	RL
	N) Detach Front & Rear Sights & place in numbered container						8/27/91	RL
	O) Attach Scope to Rifle						8/27/91	RL
	P) Detach & Attach Scope 20 Times						8/27/91	RL
640	Gallery Target & Test						8/28/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						8/28/91	KT
655	Final Inspection							
	A) Headspace						8-31-91	D/H
	B) Trigger Pull	2.22	2.19	2.18	2.20	2.19	8/29/91	RL
	C) Function						8-31-91	D/H
660	Pack						9-15-91	N-

SWS TRIGGER PULL TEST

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

SERIAL NO. C.6636320
DATE 8/23/91
TESTER JEL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.61	2.44	2.43	2.22	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.54	2.48	2.48	2.19	
PULL #3	2.28	2.48	2.50	2.18	
PULL #4	2.29	2.46	2.44	2.20	
PULL #5	2.57	2.45	2.35	2.19	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.33	3.42		
PULL #2	3.32	3.36		
PULL #3	3.43	3.48		
PULL #4	3.27	3.50		
PULL #5	3.27	3.20		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.51	4.26		4.32
PULL #2	4.45	4.29		4.19
PULL #3	4.26	4.14		4.25
PULL #4	4.26	4.15		4.32
PULL #5	4.42	4.21		4.32
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636320
29 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.316028
1 TO	2	.421996
1 TO	3	.307467
1 TO	4	.507075
1 TO	5	.360555

←----POA

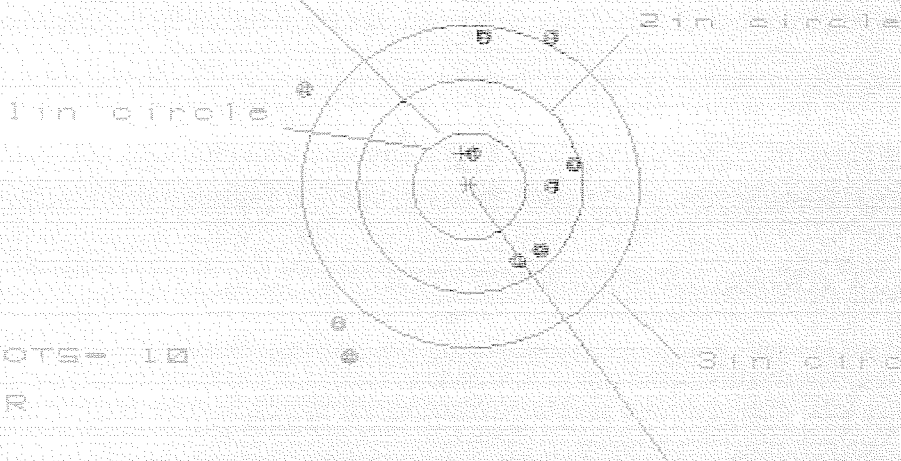
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.004
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0004
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .00401995
THE AMR FOR THIS RIFLE IS: .918

20 Aug 1991

FILE: PATTERNING/CENTERFIRE_PATT/C8636320

CENTERFIRE PATTERNS # 1

POA



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 6

HS= 2.450

VS= 3.013

GS= 3.518

CENTROID X

PATTERN #		10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.963	.841	.640
MINIMUM X	:	-1.487	-1.609	-1.454
MAXIMUM Y	:	1.430	1.255	1.344
MINIMUM Y	:	-1.503	-1.488	-1.399
CENTROID X	:	.075	.197	.398
CENTROID Y	:	-.307	-.132	-.221
POA TO CENTROID in.	:	.317	.237	.455
MIN RADIUS	:	.301	.150	.357
MEAN RADIUS	:	1.215	1.093	.967
MAX RADIUS	:	1.926	1.946	2.018
HORIZONTAL SPREAD	:	2.450	2.450	2.094
VERTICAL SPREAD	:	3.013	2.743	2.743
EXTREME SPREAD	:	3.518	3.311	3.311
NUMBER IN ONE INCH CIRCLE	=	1	5	6
NUMBER IN TWO INCH CIRCLE	=			
NUMBER IN THREE INCH CIRCLE	=			

26 Aug 1931

FILE:/PATTERNING/CENTERFIRE_PATT/C8535320

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID X

OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 8

HS= 2.716

VS= 3.026

GS= 3.102

PATTERN #



SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.424

.522

.540

MINIMUM X

-1.292

-1.134

-1.116

MAXIMUM Y

1.414

1.499

1.308

MINIMUM Y

-1.612

-1.527

-.844

CENTROID X

-.100

-.258

-.276

CENTROID Y

.077

-.008

.183

POA TO CENTROID in.

.126

.258

.332

MIN RADIUS

.204

.274

.177

MEAN RADIUS

.912

.842

.742

MAX RADIUS

1.614

1.550

1.399

HORIZONTAL SPREAD

2.716

1.656

1.656

VERTICAL SPREAD

3.026

3.026

2.152

EXTREME SPREAD

3.102

3.036

2.642

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

6

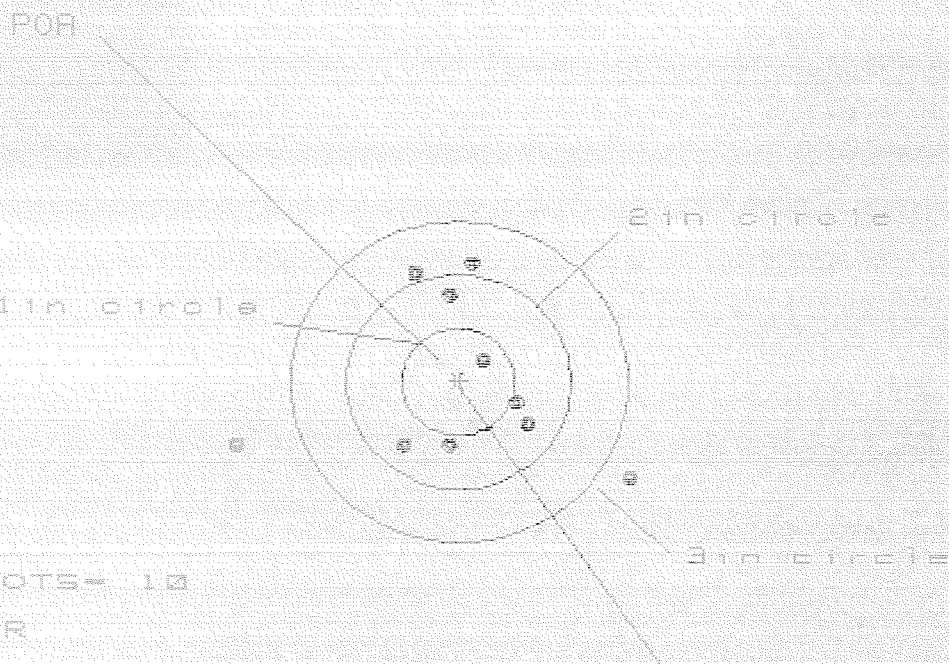
NUMBER IN THREE INCH CIRCLE =

8

28 Aug 1991

FILE: \PATTERNING\CENTERFIRE_PATT\06636320

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 8

HS= 3.520

VS= 1.941

GS= 3.528

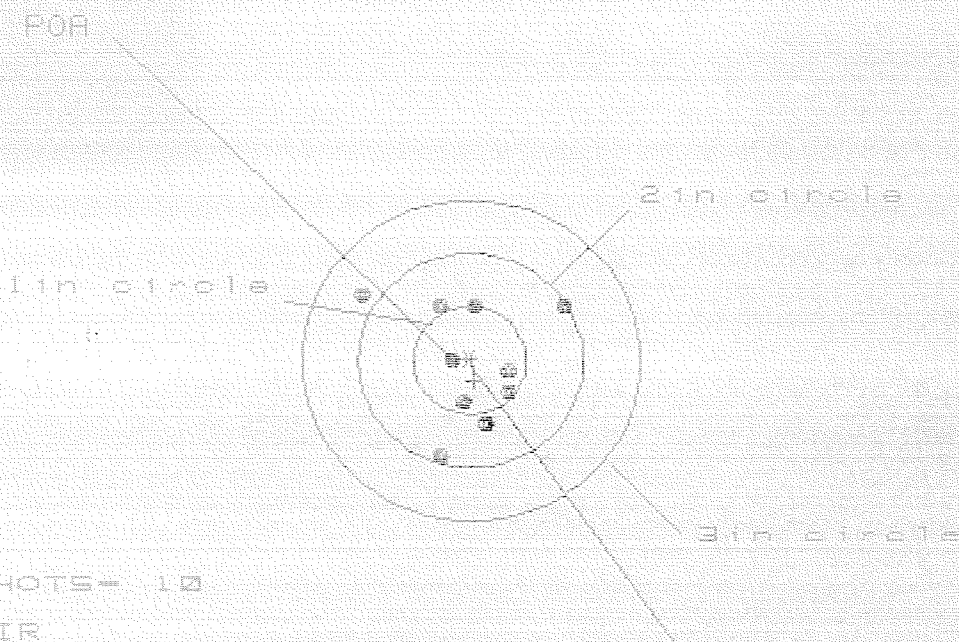
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.518	1.295	.557
MINIMUM X	-2.002	-.723	-.561
MAXIMUM Y	1.090	1.022	.907
MINIMUM Y	-.851	-.919	-.814
CENTROID X	-.015	.207	.045
CENTROID Y	-.013	.055	.120
POA TO CENTROID in.	.020	.214	.176
MIN RADIUS	.344	.169	.197
MEAN RADIUS	.983	.822	.727
MAX RADIUS	2.095	1.588	.978
HORIZONTAL SPREAD	3.520	2.018	1.118
VERTICAL SPREAD	1.941	1.941	1.721
EXTREME SPREAD	3.528	2.690	1.753
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

26 Aug 1991

FILE: PATTERNING/CENTERFIRE_PATT/C6636320

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 5

2in = 9

3in = 10

HS= 1.817

VS= 1.420

GS= 1.817

CENTROID *

PATTERN #		10	9	8
SHOTS (BEST OF)		10	9	8
MAXIMUM X		.819	.708	.305
MINIMUM X		-.998	-.342	-.253
MAXIMUM Y		.570	.602	.638
MINIMUM Y		-.850	-.787	-.711
CENTROID X		-.035	.076	-.013
CENTROID Y		.188	.125	.049
POA TO CENTROID in.		.191	.146	.051
MIN RADIUS		.148	.202	.210
MEAN RADIUS		.586	.509	.445
MAX RADIUS		1.149	.930	.750
HORIZONTAL SPREAD		1.817	1.050	.558
VERTICAL SPREAD		1.420	1.389	1.349
EXTREME SPREAD		1.817	1.722	1.370
NUMBER IN ONE INCH CIRCLE =		5		
NUMBER IN TWO INCH CIRCLE =		9		
NUMBER IN THREE INCH CIRCLE =		10		

28 Aug 1991

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CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS= 10

IN CIR

1in = 3

2in = 8

3in = 8

HS= 2.841

VS= 1.726

GS= 3.255

PATTERN #

33

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.157	.970	.704
MINIMUM X	-1.684	-.799	-.678
MAXIMUM Y	.999	.934	.963
MINIMUM Y	-.727	-.792	-.676
CENTROID X	.055	.242	.121
CENTROID Y	.053	.118	.002
POA TO CENTROID in.	.076	.269	.121
MIN RADIUS	.317	.394	.259
MEAN RADIUS	.894	.795	.690
MAX RADIUS	1.784	1.346	1.029
HORIZONTAL SPREAD	2.841	1.769	1.382
VERTICAL SPREAD	1.726	1.726	1.639
EXTREME SPREAD	3.255	2.449	1.941
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		8	