

C6636344

MODEL 700™ N24

Model **SMS**™

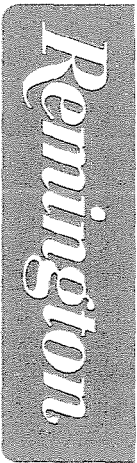
Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.





MODEL 700™
M24



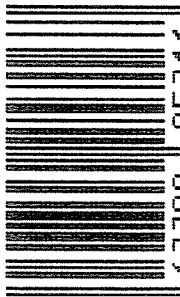
REG. U.S. PAT. & TM. OFF.

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

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

SERIAL NO. C6636344	20
ORDER NO. 5716	

UPC



0 47700 25716 2



5716 C6636344

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636344

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 30	5/30/91	RW
600	Proof	4 30	5/30/91	RW
607	Check Headspace	4 30	5/30/91	RW
610	Dis-assemble Gun			RW
612	Magnaflux Barrel Action	5 6	5/30/91	RW
	Magnaflux Bolt	5 6	5/30/91	RW
615	Rollmark Caliber			GB
617	Drill and Tap Sight Holes	5 10	5/30/91	FB
618	Polish Barrel	5 10	5/30/91	WB
620	Apply Coatings (Barrel Action)		5/30/91	FB
	Apply Coating (Bolt)		5/30/91	FB
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		6-10-91	FW

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			6-10-91	JL
	G) Safety Off Force	3	3	3			6-10-91	JL
	H) Trigger Pull Test & Retainability						6-10-91	JL
	I) Firing Pin Indent	10225	1022	1022			6-10-91	JL
	J) Assemble Stock						6/10/91	RW
	K) Assemble Swivel Studs						6-12-91	L
	L) Attach Front and Rear Sight Assemblies						6/10/91	RW
	M) Iron Sight Alignment						6/10/91	RW
	N) Detach Front & Rear Sights & place in numbered container						6/10/91	RW
	O) Attach Scope to Rifle						6/10/91	RW
	P) Detach & Attach Scope 20 Times						6/10/91	RW
640	Gallery Target & Test						6-10-91	RF
	A) Time						"	RF
	B) Malfunctions						"	RF
	C) Pierced Primers						"	RF
	D) Optical Clarity of Scope						"	RF
645	Inspect for Live Ammo						6-10-91	RF
655	Final Inspection							
	A) Headspace						6-12-91	AK
	B) Trigger Pull	2.59	2.63	2.69	2.70	2.64	6-12-91	JL
	C) Function						6-12-91	AK
660	Pack						6-20-91	RF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6636344

DATE 6-10-91

TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.52	2.52	2.49	2.59	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.70	2.49	2.44	2.63	
PULL #3	2.57	2.52	2.50	2.69	
PULL #4	2.52	2.51	2.50	2.70	
PULL #5	2.57	2.53	2.52	2.64	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.43	3.49		
PULL #2	3.60	3.55		
PULL #3	3.57	3.58		
PULL #4	3.52	3.50		
PULL #5	3.53	3.49		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.34	4.22		4.58
PULL #2	4.17	4.36		4.22
PULL #3	4.56	4.40		4.42
PULL #4	4.51	4.33		4.45
PULL #5	4.48	4.30		4.41
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636344
11 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.121565
1 TO	2	.380007
1 TO	3	.402336
1 TO	4	.234649
1 TO	5	.121235

SA <----FOI

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0408
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0894
THE RESULTING AVERAGE FOI RADIUS FOR THIS RIFLE IS: .09827

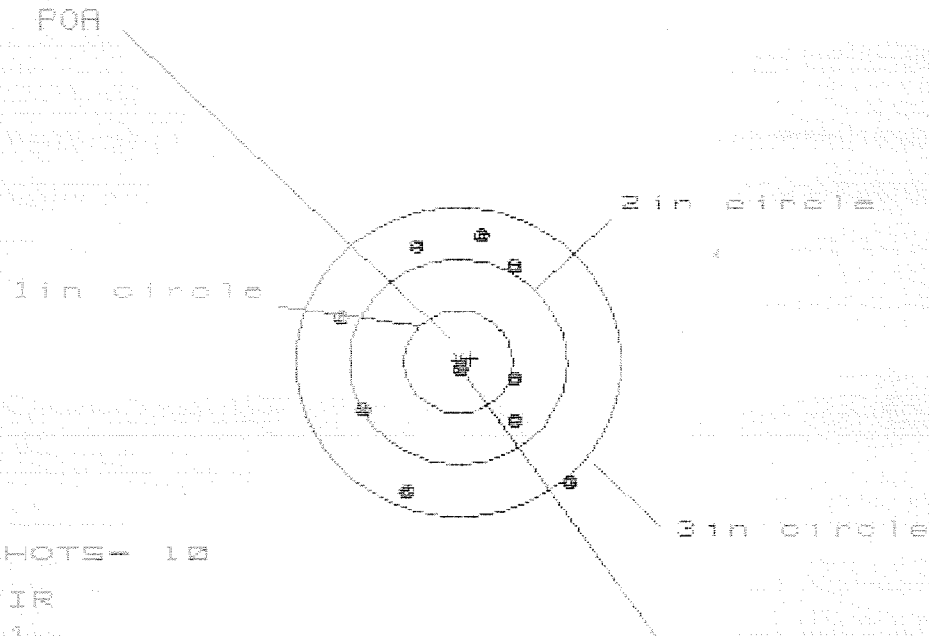
THE AMR FOR THIS RIFLE IS: .8738

10 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636344

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS= 2.103

VS= 2.510

GS= 2.623

CENTROID #

PATTERN #

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.992	.616	.575
MINIMUM X	-1.111	-1.001	-1.042
MAXIMUM Y	1.237	1.110	.934
MINIMUM Y	-1.281	-1.408	-.842
CENTROID X	-.117	-.227	-.186
CENTROID Y	-.033	.094	.270
POA TO CENTROID in.	.121	.246	.328
MIN RADIUS	.117	.275	.428
MEAN RADIUS	.988	.941	.875
MAX RADIUS	1.514	1.445	1.111
HORIZONTAL SPREAD	2.103	1.617	1.617
VERTICAL SPREAD	2.510	2.510	1.776
EXTREME SPREAD	2.623	2.613	2.050
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		9	

18 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C853B344

CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.103

VS= 2.669

GS= 3.072

PATTERN #

2

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.245	1.104	1.069
MINIMUM X	-.858	-.919	-.858
MAXIMUM Y	.942	.750	.564
MINIMUM Y	-1.727	-1.492	-1.703
CENTROID X	.162	.223	.338
CENTROID Y	-.291	-.099	.087
POA TO CENTROID in.	.333	.244	.349
MIN RADIUS	.130	.164	.342
MEAN RADIUS	.989	.882	.770
MAX RADIUS	1.812	1.752	1.137
HORIZONTAL SPREAD	2.103	2.103	1.919
VERTICAL SPREAD	2.669	2.242	1.267
EXTREME SPREAD	3.072	2.947	2.087
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

18 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C663B344

CENTERFIRE PATTERNS

3

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 4

2 in = 8

3 in = 8

HS= 2.674

VS= 3.192

GS= 3.874

PATTERN #

3

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.977

.315

.315

MINIMUM X

-.697

-.477

-.477

MAXIMUM Y

1.533

1.349

.696

MINIMUM Y

-1.659

-1.051

-.883

CENTROID X

.228

.008

.008

CENTROID Y

-.248

-.056

-.224

POA TO CENTROID IN.

.331

.056

.225

MIN RADIUS

.124

.263

.209

MEAN RADIUS

.854

.629

.521

MAX RADIUS

2.581

1.349

.890

HORIZONTAL SPREAD

2.674

.792

.792

VERTICAL SPREAD

3.192

2.400

1.579

EXTREME SPREAD

3.874

2.403

1.581

NUMBER IN ONE INCH CIRCLE =

4

NUMBER IN TWO INCH CIRCLE =

8

NUMBER IN THREE INCH CIRCLE =

8

10 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636344

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 4

2in = 7

3in = 10

HS= 2.272

VS= 1.809

GS= 2.292

PATTERN #

:

4

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

1.260

.764

.657

MINIMUM X

:

-1.012

-.872

-.979

MAXIMUM Y

:

.821

.777

.715

MINIMUM Y

:

-.988

-1.032

-1.094

CENTROID X

:

.105

-.035

.072

CENTROID Y

:

.043

.087

.149

POA TO CENTROID in.

:

.113

.093

.166

MIN RADIUS

:

.182

.294

.181

MEAN RADIUS

:

.754

.691

.621

MAX RADIUS

:

1.320

1.036

1.094

HORIZONTAL SPREAD

:

2.272

1.636

1.636

VERTICAL SPREAD

:

1.809

1.809

1.809

EXTREME SPREAD

:

2.292

1.843

1.823

NUMBER IN ONE INCH CIRCLE =

4

NUMBER IN TWO INCH CIRCLE =

7

NUMBER IN THREE INCH CIRCLE =

10

18 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8835344

CENTERFIRE PATTERNS

5

POB

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 10

HS = 2.322

VS = 1.502

GS = 2.592

CENTROID #

PATTERN #

5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.008	.862	.962
MINIMUM X	-1.314	-1.073	-.973
MAXIMUM Y	.910	.870	.730
MINIMUM Y	-.592	-.632	-.523
CENTROID X	-.174	-.028	-.128
CENTROID Y	.074	.114	.005
POB TO CENTROID in.	.189	.117	.128
MIN RADIUS	.315	.374	.252
MEAN RADIUS	.784	.713	.626
MAX RADIUS	1.362	1.240	1.216
HORIZONTAL SPREAD	2.322	1.935	1.935
VERTICAL SPREAD	1.502	1.502	1.253
EXTREME SPREAD	2.592	2.005	2.005
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	