

C6648956

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.

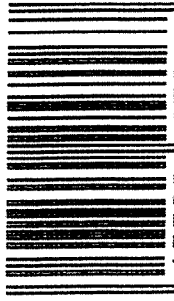
MODEL 700TM M24

SERIAL NO.
C6648956

ORDER NO.
5716

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

LPC



0 47700 25716 7



5716 C6648956

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6648956

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 2	9 1	RW
600	Proof	7 2	9 1	RW
607	Check Headspace	7 2	9 1	RW
610	Dis-assemble Gun	7 2	9 1	RW
612	Magnaflux Barrel Action		JUL 22 1991 1721	GS
	Magnaflux Bolt		JUL 22 1991	GS
615	Rollmark Caliber		JUL 22 1991	GS
617	Drill and Tap Sight Holes		JUL 22 1991	LB
618	Polish Barrel		7/22/91	W/B
620	Apply Coatings (Barrel Action)		7-22-91	W/B
	Apply Coating (Bolt)		7-22-91	W/B
625	Final Assembly A) Clean inside of Bolt Assembly		8/29/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/29/91	RW
	C) Inspect Ejector Hole for Chamfer		8/29/91	RW
	D) Oil Firing Pin Ass'y		8/29/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9-7-91	D/H

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	5	5			9-7-91	DH
	G) Safety Off Force	2	2	2			9-7-91	DH
	H) Trigger Pull Test & Retainability						9-7-91	DH
	I) Firing Pin Indent	.020	.021	.022			9-7-91	DH
	J) Assemble Stock						9/10/91	RW
	K) Assemble Swivel Studs						9-12-91	DH
	L) Attach Front and Rear Sight Assemblies						9/10/91	RW
	M) Iron Sight Alignment						9/10/91	RW
	N) Detach Front & Rear Sights & place in numbered container						9/10/91	RW
	O) Attach Scope to Rifle						9/10/91	RW
	P) Detach & Attach Scope 20 Times						9/10/91	RW
640	Gallery Target & Test						9-11-91	AC
	A) Time						9-11-91	AC
	B) Malfunctions						9-11-91	AC
	C) Pierced Primers						9-10-91	AC
	D) Optical Clarity of Scope						9-10-91	AC
645	Inspect for Live Ammo						9-10-91	AC
655	Final Inspection							
	A) Headspace						9-12-91	DH
	B) Trigger Pull	267	239	267	279	271	9-10-91	DH
	C) Function						9-12-91	DH
660	Pack						9-14-91	VF

SWS TRIGGER PULL TEST

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

SERIAL NO. 566 48956

DATE 9-7-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.47	2.41	2.66	2.67	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.37	2.38	2.65	2.39	
PULL #3	2.46	2.35	2.67	2.67	
PULL #4	2.40	2.32	2.80	2.79	
PULL #5	2.43	2.46	2.60	2.71	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.14	3.21		
PULL #2	3.12	2.99		
PULL #3	3.09	3.10		
PULL #4	3.12	3.16		
PULL #5	3.11	3.10		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.43	4.46		4.13
PULL #2	4.47	4.44		4.18
PULL #3	4.50	4.50		4.12
PULL #4	4.53	4.56		4.09
PULL #5	4.48	4.53		4.13
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06648956
10 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.185311
1 TO	2	.037054
1 TO	3	.0218403
1 TO	4	.381819
1 TO	5	.211021

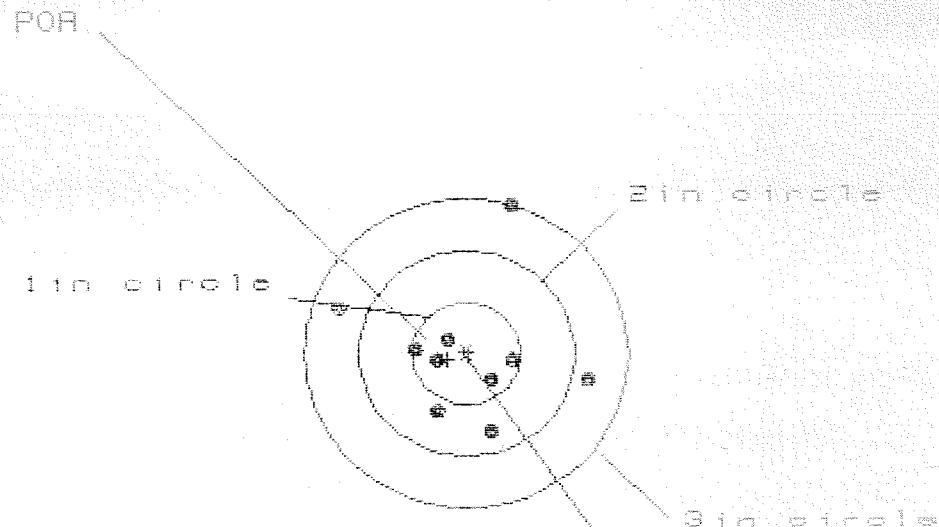
4
42 ←---POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1614
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .099
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .189343
THE AMR FOR THIS RIFLE IS: .7706

10 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6648956

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 5

2in = 7

3in = 9

HS= 2.227

VS= 2.195

GS= 2.314

CENTROID #

PATTERN #

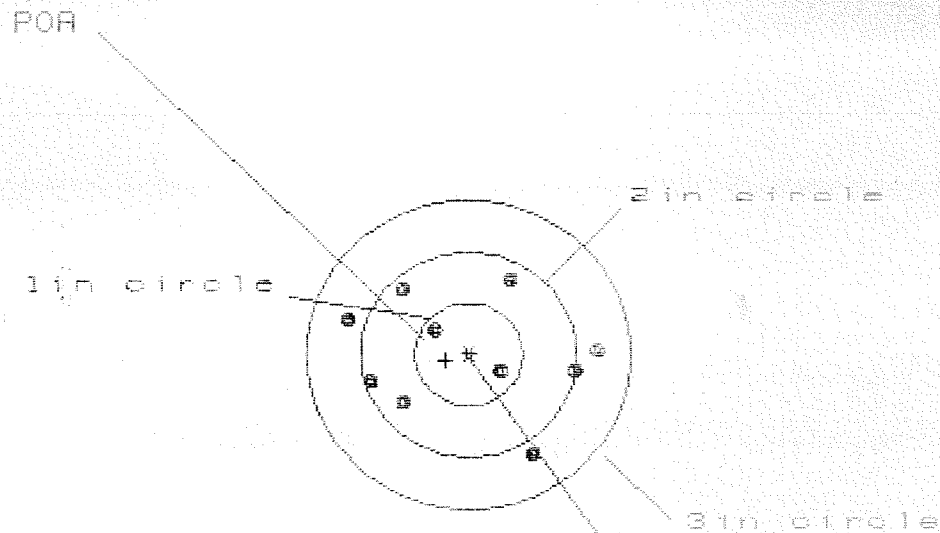
SHOTS (BEST OF)

	10	9	8
MAXIMUM X	1.082	1.131	.994
MINIMUM X	-1.145	-1.096	-.546
MAXIMUM Y	1.435	.552	.363
MINIMUM Y	-.760	-.600	-.531
CENTROID X	.176	.127	.264
CENTROID Y	.058	-.102	-.171
POA TO CENTROID in.	.186	.163	.314
MIN RADIUS	.199	.243	.111
MEAN RADIUS	.696	.582	.494
MAX RADIUS	1.502	1.227	.994
HORIZONTAL SPREAD	2.227	2.227	1.540
VERTICAL SPREAD	2.195	1.152	.894
EXTREME SPREAD	2.314	2.314	1.570
NUMBER IN ONE INCH CIRCLE	= 5		
NUMBER IN TWO INCH CIRCLE	= 7		
NUMBER IN THREE INCH CIRCLE	= 9		

18 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C864B956

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 2.268

VS= 1.736

GS= 2.294

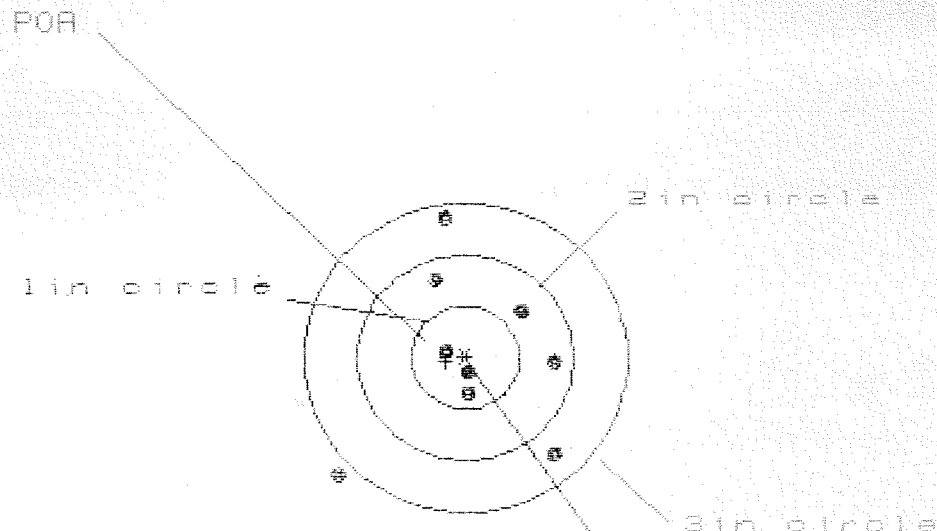
CENTROID *

PATTERN #	2	2	2
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.203	1.110	1.202
MINIMUM X	-1.065	-.932	-.840
MAXIMUM Y	.744	.746	.622
MINIMUM Y	-.992	-.990	-.573
CENTROID X	.213	.080	-.012
CENTROID Y	.060	.058	.182
POR TO CENTROID in.	.222	.099	.183
MIN RADIUS	.314	.283	.129
MEAN RADIUS	.853	.799	.716
MAX RADIUS	1.203	1.233	1.234
HORIZONTAL SPREAD	2.268	2.042	2.042
VERTICAL SPREAD	1.736	1.736	1.195
EXTREME SPREAD	2.294	2.146	2.106
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

10 Sep 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 4

2in = 7

3in = 9

HS= 1.967

VS= 2.480

GS= 2.667

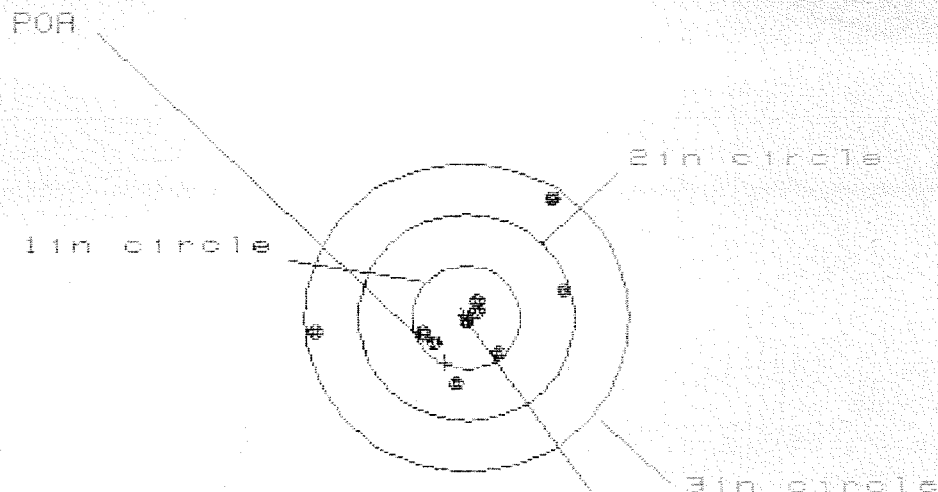
CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.768	.635	.591
MINIMUM X	-1.199	-.395	-.439
MAXIMUM Y	1.332	1.204	.791
MINIMUM Y	-1.148	-1.026	-.875
CENTROID X	.182	.315	.359
CENTROID Y	.037	.165	.014
POA TO CENTROID in.	.186	.356	.360
MIN RADIUS	.176	.300	.193
MEAN RADIUS	.738	.653	.560
MAX RADIUS	1.660	1.255	1.056
HORIZONTAL SPREAD	1.967	1.030	1.030
VERTICAL SPREAD	2.480	2.230	1.666
EXTREME SPREAD	2.667	2.438	1.959
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

10 Sep 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 6

2in = 8

3in = 10

HS= 2.249

VS= 1.829

GS= 2.505

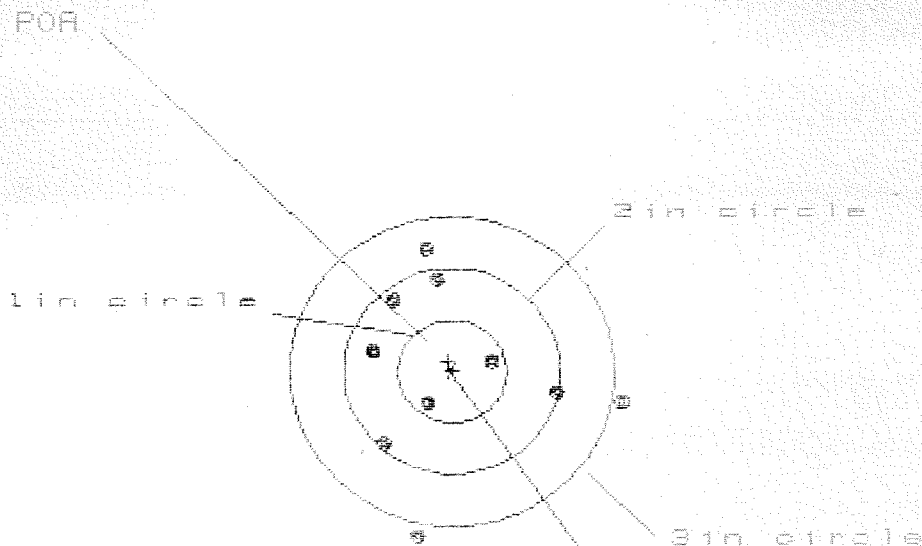
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.866	.951	.798
MINIMUM X	:	-1.383	-1.298	-.467
MAXIMUM Y	:	1.163	.376	.376
MINIMUM Y	:	-.666	-.537	-.537
CENTROID X	:	.201	.116	.278
CENTROID Y	:	.439	.309	.309
FOR TO CENTROID in.	:	.482	.330	.416
MIN RADIUS	:	.025	.147	.126
MEAN RADIUS	:	.590	.506	.397
MAX RADIUS	:	1.391	1.298	.874
HORIZONTAL SPREAD	:	2.249	2.249	1.256
VERTICAL SPREAD	:	1.829	.913	.913
EXTREME SPREAD	:	2.505	2.280	1.342
NUMBER IN ONE INCH CIRCLE	=		6	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

10 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C084B956

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 2.326

VS= 2.847

GS= 2.850

CENTROID #

PATTERN #		10	9	8
SHOTS (BEST OF)		10	9	8
MAXIMUM X		1.589	1.550	1.135
MINIMUM X		-.737	-.776	-.582
MAXIMUM Y		1.234	1.055	1.000
MINIMUM Y		-1.613	-.872	-.927
CENTROID X		.035	.074	-.120
CENTROID Y		-.099	.080	.135
POA TO CENTROID in.		.105	.109	.100
MIN RADIUS		.354	.330	.517
MEAN RADIUS		.976	.890	.773
MAX RADIUS		1.650	1.610	1.224
HORIZONTAL SPREAD		2.326	2.326	1.717
VERTICAL SPREAD		2.847	1.927	1.927
EXTREME SPREAD		2.850	2.362	1.975
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	