

C6611678

MODEL 700™ M24

Model **SMS**™

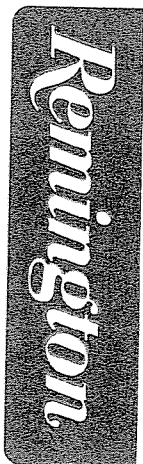
Action

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. C6611678

ORDER NO. 5716

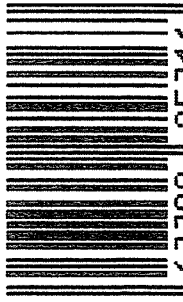
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



5716 C6611678

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611678

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 25	91	RW
600	Proof	3 25	91	RW
607	Check Headspace	3 25	91	RW
610	Dis-assemble Gun	25	91	RW
612	Magnaflux Barrel Action	3 28	91	KR
	Magnaflux Bolt	3 28	91	Y
615	Rollmark Caliber	3 28	91	GL
617	Drill and Tap Sight Holes	APR	3 1991	LB
618	Polish Barrel	APR	3 1991	WB
620	Apply Coatings (Barrel Action)		4-11-91	SA
	Apply Coating (Bolt)			SA
625	Final Assembly A) Clean inside of Bolt Assembly		5/10/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/10/91	RW
	C) Inspect Ejector Hole for Chamfer		5/10/91	RW
	D) Oil Firing Pin Ass'y		5/10/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5-20-91	PH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7	7	7			5-21-91	DH
	G) Safety Off Force	4	3	3			5-21-91	DH
	H) Trigger Pull Test & Retainability						5-20-91	DH
	I) Firing Pin Indent	.020	.021	.020			5-21-91	DH
	J) Assemble Stock						5/22/91	RW
	K) Assemble Swivel Studs						6-1-91	DH
	L) Attach Front and Rear Sight Assemblies						5/22/91	RW
	M) Iron Sight Alignment						5/22/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/22/91	RW
	O) Attach Scope to Rifle						5/22/91	RW
	P) Detach & Attach Scope 20 Times						5/22/91	RW
640	Gallery Target & Test						5/23/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						5/23/91	KT
655	Final Inspection							
	A) Headspace						6-1-91	DH
	B) Trigger Pull	2.50	2.44	2.44	2.40	2.28	6/1/91	DH
	C) Function						6-1-91	DH
660	Pack						6-20-91	DF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6611678
DATE 5-20-91
TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.42	2.35	2.33	2.50	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.40	2.36	2.13	2.44	
PULL #3	2.35	2.20	2.24	2.44	
PULL #4	2.30	2.26	2.21	2.40	
PULL #5	2.36	2.20	2.27	2.28	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.34		
PULL #2	3.27	3.32		
PULL #3	3.31	3.32		
PULL #4	3.29	3.38		
PULL #5	3.31	3.30		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.12	4.14		4.03
PULL #2	4.16	4.12		4.05
PULL #3	4.00	3.82		4.04
PULL #4	3.95	4.09		4.08
PULL #5	4.01	4.04		3.98
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611678
23 May 1991

CENTROIDAL DISTANCES

0 TO 1	.305111
1 TO 2	.440638
1 TO 3	.0963016
1 TO 4	.169729
1 TO 5	.303534

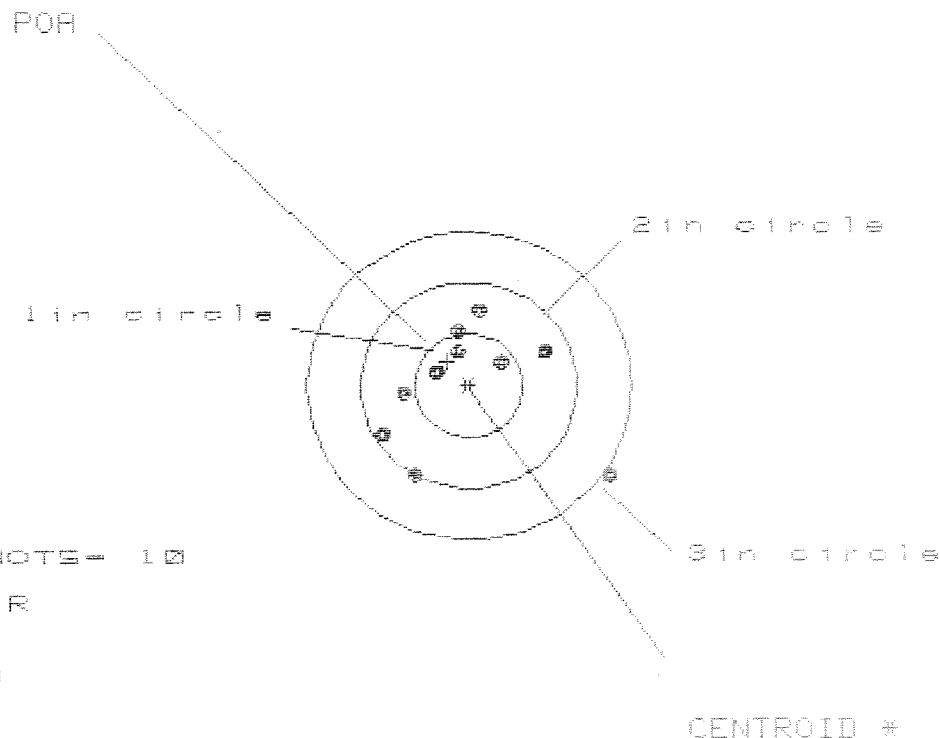
45
46 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1468
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0882
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .167279
THE AMR FOR THIS RIFLE IS: .8772

23 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611678

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 9

HS= 2.055

VS= 1.684

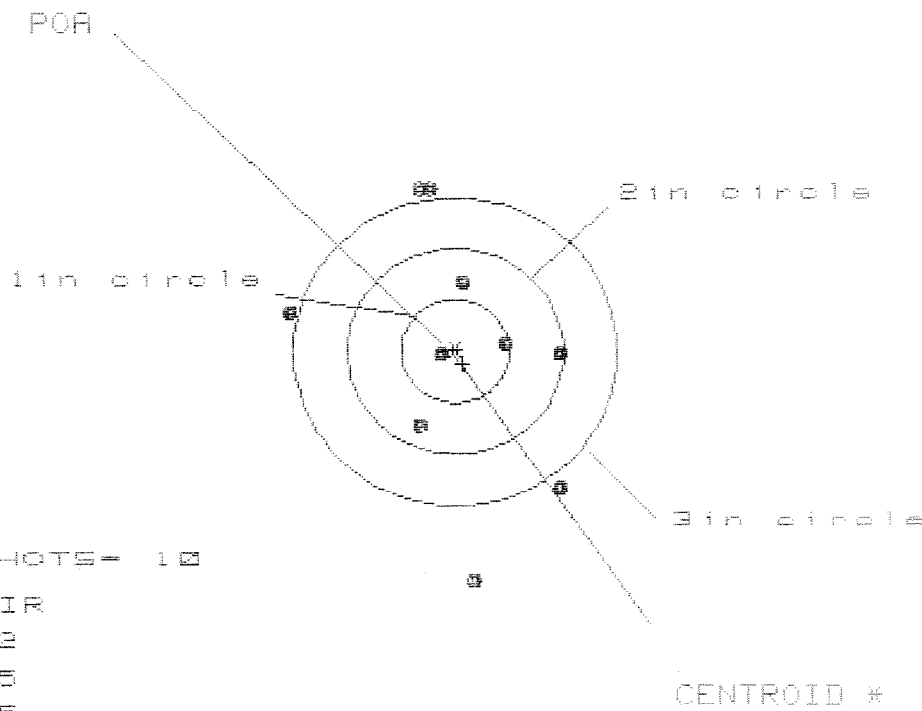
GS= 2.096

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.259	.872	.822
MINIMUM X	:	-.796	-.656	-.706
MAXIMUM Y	:	.766	.664	.540
MINIMUM Y	:	-.918	-.999	-.729
CENTROID X	:	.202	.062	.112
CENTROID Y	:	-.230	-.128	-.004
POA TO CENTROID in.	:	.306	.143	.112
MIN RADIUS	:	.332	.166	.089
MEAN RADIUS	:	.736	.597	.506
MAX RADIUS	:	1.558	1.075	1.015
HORIZONTAL SPREAD	:	2.055	1.528	1.528
VERTICAL SPREAD	:	1.684	1.663	1.269
EXTREME SPREAD	:	2.096	1.790	1.739
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

23 May 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 5

HS= 2.520

VS= 3.789

GS= 3.811

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.003	1.020	1.089
MINIMUM X	:	-1.517	-1.500	-1.373
MAXIMUM Y	:	1.557	1.309	1.120
MINIMUM Y	:	-2.232	-1.517	-1.125
CENTROID X	:	-.067	-.084	-.211
CENTROID Y	:	.119	.367	.556
POA TO CENTROID in.	:	.137	.376	.595
MIN RADIUS	:	.163	.295	.293
MEAN RADIUS	:	1.156	1.022	.923
MAX RADIUS	:	2.237	1.828	1.373
HORIZONTAL SPREAD	:	2.520	2.520	2.462
VERTICAL SPREAD	:	3.789	2.926	2.245
EXTREME SPREAD	:	3.811	3.116	2.502
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		5	

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CENTERFIRE PATTERNS

3

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 5

2 in = 5

3 in = 10

HS = 1.299

VS = 1.930

GS = 2.104

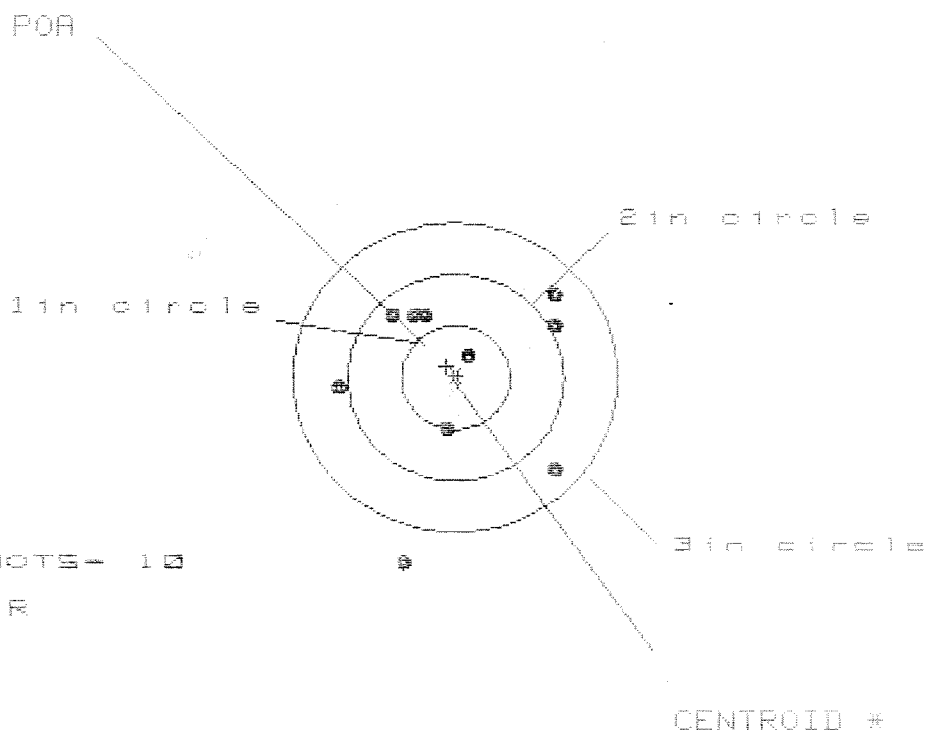
PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	.662
MINIMUM X	-.637
MAXIMUM Y	.702
MINIMUM Y	-1.228
CENTROID X	.295
CENTROID Y	-.255
POA TO CENTROID in.	.390
MIN RADIUS	.254
MEAN RADIUS	.651
MAX RADIUS	1.241
HORIZONTAL SPREAD	1.299
VERTICAL SPREAD	1.930
EXTREME SPREAD	2.104
NUMBER IN ONE INCH CIRCLE =	5
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	10

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CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 2.066

VS= 2.576

GS= 2.937

PATTERN #

4

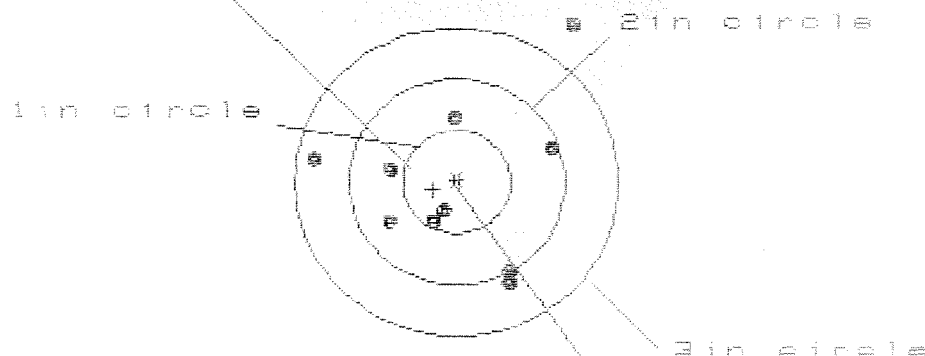
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.963	.913	1.026
MINIMUM X	-1.103	-1.153	-1.040
MAXIMUM Y	.770	.570	.439
MINIMUM Y	-1.805	-1.049	-.865
CENTROID X	.084	.134	.021
CENTROID Y	-.108	.092	.223
POA TO CENTROID in.	.137	.162	.224
MIN RADIUS	.258	.056	.173
MEAN RADIUS	.949	.799	.697
MAX RADIUS	1.860	1.384	1.136
HORIZONTAL SPREAD	2.066	2.066	2.066
VERTICAL SPREAD	2.576	1.619	1.304
EXTREME SPREAD	2.937	2.252	2.252
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS # 5

POA



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 2

HE = 2.361

VS = 2.557

GS = 2.736

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.076	.952	.006
MINIMUM X	:	-1.285	-1.166	-.683
MAXIMUM Y	:	1.575	.842	.808
MINIMUM Y	:	-.982	-.807	-.761
CENTROID X	:	.220	.101	.247
CENTROID Y	:	.073	-.102	-.148
POA TO CENTROID in.	:	.232	.144	.288
MIN RADIUS	:	.259	.087	.103
MEAN RADIUS	:	.894	.726	.673
MAX RADIUS	:	1.907	1.223	.952
HORIZONTAL SPREAD	:	2.361	2.118	1.490
VERTICAL SPREAD	:	2.557	1.649	1.649
EXTREME SPREAD	:	2.736	2.143	1.719
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	