

C6611746

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.

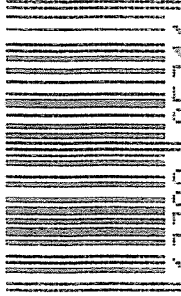
MODEL 700™ H24

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

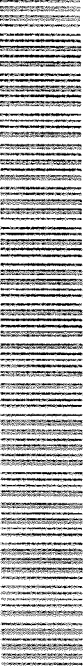
SERIAL NO.
C6611746

ORDER NO.
5716

UPC



0 4700 25716 7



5716 C6611746

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611746

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 10	91	RW
600	Proof	1 10	91	RW
607	Check Headspace	1 10	91	RW
610	Dis-assemble Gun	1 10	91	RW
612	Magnaflux Barrel Action		1/6/91	KR
	Magnaflux Bolt		1/6/91	KR
615	Rollmark Caliber		1/16/91	GL
617	Drill and Tap Sight Holes	1 17	91	LB
618	Polish Barrel	1 17	91	LB
620	Apply Coatings (Barrel Action)		2-13-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/19/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/19/91	RW
	C) Inspect Ejector Hole for Chamfer		2/19/91	RW
	D) Oil Firing Pin Ass'y		2/19/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		3-8-91	SM

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	3	3 3/4		3/8/91	WB
	G) Safety Off Force	2	2	2			3/8/91	WB
	H) Trigger Pull Test & Retainability						3/8/91	JH
	I) Firing Pin Indent	.021	.021	.021			3/8/91	WB
	J) Assemble Stock						3/9/91	RW
	K) Assemble Swivel Studs						3/12/91	JH
	L) Attach Front and Rear Sight Assemblies						3/9/91	RW
	M) Iron Sight Alignment						3/9/91	RW
	N) Detach Front & Rear Sights & place in numbered container						3/9/91	RW
	O) Attach Scope to Rifle						3/9/91	RW
	P) Detach & Attach Scope 20 Times						3/9/91	RW
640	Gallery Target & Test						3-9-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						3-9-91	AF
655	Final Inspection							
	A) Headspace						3/12/91	JH
	B) Trigger Pull	2.57	2.59	2.56	2.58	2.58	3/11/91	JH
	C) Function						3/12/91	JH
660	Pack						3-20-91	D/H

3/11 Replaced Stock -
Re shot -

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS—

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6611746

DATE 3-8-91

TESTER JEL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.50	2.35	2.57	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.48	2.51	2.24	2.59	
PULL #3	2.51	2.30	2.33	2.56	
PULL #4	2.45	2.48	2.21	2.58	
PULL #5	2.35	2.50	2.27	2.58	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.40	3.18		
PULL #2	3.41	3.18		
PULL #3	3.41	3.30		
PULL #4	3.45	3.32		
PULL #5	3.46	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	4.29	4.21		4.29
PULL #2	4.20	4.17		4.27
PULL #3	4.15	4.25		4.27
PULL #4	4.19	4.12		4.19
PULL #5	4.24	4.21		4.27
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611748
11 Mar 1991

CENTROIDAL DISTANCES

0 TO 1	.249578
1 TO 2	.419033
1 TO 3	.108074
1 TO 4	.258861
1 TO 5	.213825

21 -> POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0134
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0866
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0876306

THE AMP FOR THIS RIFLE IS: 1.026

11 Mar 1991

FILE:/PAT/TERNING/CENTERFIRE_PATT/C8611748.1

CENTERFIRE PATTERNS

1

POB

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 6

HS= 3.258

VS= 2.705

GS= 3.595

CENTROID *

PATTERN #

1

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.367	1.157	1.153
MINIMUM X	:	-1.891	-1.813	-1.817
MAXIMUM Y	:	1.758	1.683	.973
MINIMUM Y	:	-.947	-1.022	-.812
CENTROID X	:	.008	.218	.222
CENTROID Y	:	-.036	.039	-.171
POB TO CENTROID in.	:	.037	.222	.280
MIN RADIUS	:	.137	.093	.174
MEAN RADIUS	:	1.143	1.036	.942
MAX RADIUS	:	2.010	1.871	1.834
HORIZONTAL SPREAD	:	3.258	2.970	2.970
VERTICAL SPREAD	:	2.705	2.705	1.785
EXTREME SPREAD	:	3.595	3.213	3.213
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	

11 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06611746.1

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 9

HC= 2.987

VS= 2.155

CS= 3.307

CENTROID *

PATTERN #

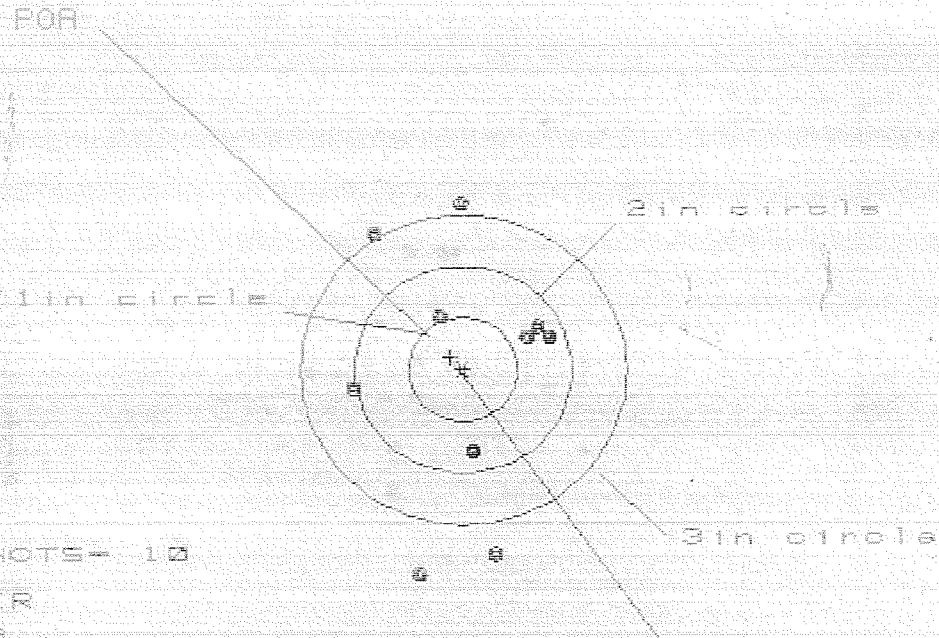
2

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.372	1.193	1.317
MINIMUM X	-1.615	-1.291	-1.167
MAXIMUM Y	1.228	1.125	.996
MINIMUM Y	-.927	-1.030	-1.709
CENTROID X	-.028	.159	.035
CENTROID Y	.080	.103	.232
POA TO CENTROID in.	.028	.190	.234
MIN RADIUS	.228	.364	.256
MEAN RADIUS	1.032	.952	.851
MAX RADIUS	1.861	1.433	1.343
HORIZONTAL SPREAD	2.987	2.484	2.484
VERTICAL SPREAD	2.155	2.155	1.705
EXTREME SPREAD	3.307	2.573	2.573
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		9	

11 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CG611746.1

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 5

2in = 5

3in = 0

HS= 1.742

VS= 3.588

CS= 3.604

CENTROID #

PATTERN #

3

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.771	.731	.760
MINIMUM X	-.971	-1.011	-.982
MAXIMUM Y	1.653	1.438	1.195
MINIMUM Y	1.935	1.948	1.209
CENTROID X	.112	.152	.123
CENTROID Y	-.117	.098	.341
POA TO CENTROID in.	.162	.181	.363
MIN RADIUS	.576	.399	.212
MEAN RADIUS	1.150	1.017	.866
MAX RADIUS	1.969	1.962	1.211
HORIZONTAL SPREAD	1.742	1.742	1.742
VERTICAL SPREAD	3.588	3.386	2.404
EXTREME SPREAD	3.604	3.400	2.406
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		6	

11 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06611746.1

CENTERFIRE PATTERNS # 4

POR

1in circle

2in circle

3in circle

* OF SHOTS = 10

* IN CIR

1in = 3

2in = 4

3in = 10

HS = 2.200

VS = 2.292

GS = 2.356

CENTROID *

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.169	1.143	.428
MINIMUM X	-1.031	-1.057	-.915
MAXIMUM Y	1.092	.958	.917
MINIMUM Y	-1.200	-.994	-1.035
CENTROID X	-.275	-.249	-.392
CENTROID Y	-.055	.079	.120
POR TO CENTROID in.	.280	.261	.410
MIN RADIUS	.302	.333	.475
MEAN RADIUS	.872	.842	.799
MAX RADIUS	1.223	1.190	1.040
HORIZONTAL SPREAD	2.200	2.200	1.843
VERTICAL SPREAD	2.292	1.952	1.952
EXTREME SPREAD	2.356	2.201	2.021
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		10	

11 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611746.1

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 2.596

VS= 2.063

GS= 2.678

CENTROID *

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.694

.680

.591

MINIMUM X

-.902

-.714

-.669

MAXIMUM Y

.874

.814

.658

MINIMUM Y

-1.190

-1.249

-1.247

CENTROID X

.108

-.090

.009

CENTROID Y

-.225

-.165

-.009

POA TO CENTROID in.

.249

.184

.013

MIN RADIUS

.161

.346

.312

MEAN RADIUS

.935

.831

.716

MAX RADIUS

1.776

1.438

1.404

HORIZONTAL SPREAD

2.596

1.394

1.260

VERTICAL SPREAD

2.063

2.063

1.905

EXTREME SPREAD

2.678

2.490

2.271

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

6

NUMBER IN THREE INCH CIRCLE =

9

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06611746
9 Mar 1991

CENTROIDAL DISTANCES

0 TO	1	.136341
1 TO	2	.249948
1 TO	3	.466837
1 TO	4	.231216
1 TO	5	.246457

1/4 ---- POA

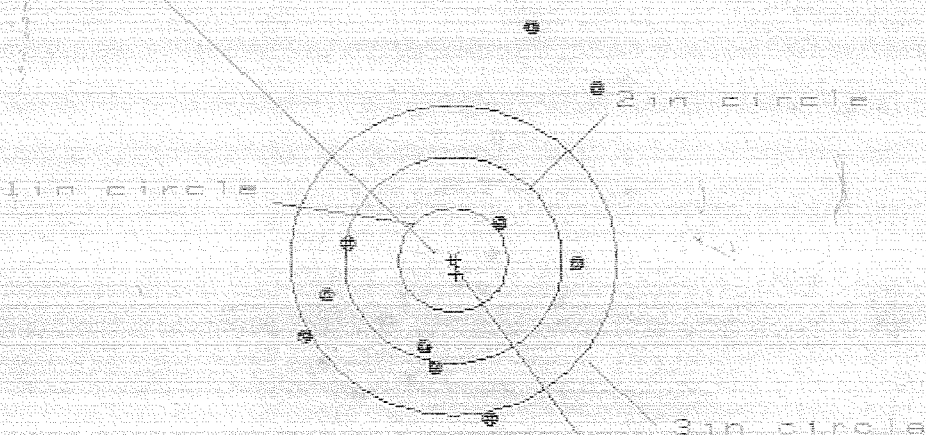
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0148
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0048
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0378164
THE AMR FOR THIS RIFLE IS: 1.2

9 Mar 1991

FILE: PATTERNING/CENTERFIRE_PATT/ CB811748

CENTERFIRE PATTERNS # 1

POB



* OF SHOTS- 10

IN CIR

1 in = 0

2 in = 3

3 in = 6

HS= 2.698

VS= 3.774

GS= 3.793

CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.288	1.367	1.425
MINIMUM X	:	-1.410	-1.331	-1.160
MAXIMUM Y	:	2.261	1.910	.870
MINIMUM Y	:	-1.513	-1.262	-1.023
CENTROID X	:	-.030	-.109	-.280
CENTROID Y	:	.133	-.118	-.357
POB TO CENTROID in.	:	.136	.161	.454
MIN RADIUS	:	.586	.610	.355
MEAN RADIUS	:	1.349	1.186	.975
MAX RADIUS	:	2.371	2.349	1.501
HORIZONTAL SPREAD	:	2.698	2.698	2.586
VERTICAL SPREAD	:	3.774	3.172	1.893
EXTREME SPREAD	:	3.793	3.621	2.689
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		6	

9 Mar 1991

FILE: PATTERNING/CENTERFIRE_PATT/ CB611748

CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 6

HS- 2.924

VS- 4.335

GS- 4.712

CENTROID *

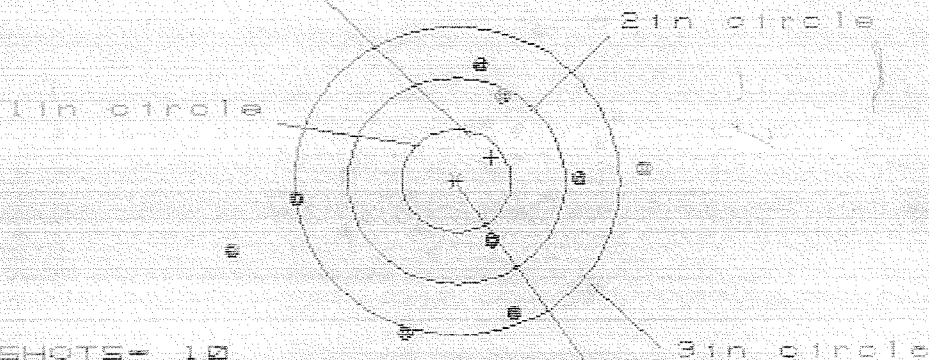
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.469	1.425	1.601
MINIMUM X	:	-1.455	-1.439	-1.323
MAXIMUM Y	:	1.925	1.658	1.395
MINIMUM Y	:	-2.410	-1.136	-1.929
CENTROID X	:	.175	.219	.043
CENTROID Y	:	-.010	.257	.050
POA TO CENTROID in.	:	.175	.338	.066
MIN RADIUS	:	.374	.113	.384
MEAN RADIUS	:	1.351	1.211	1.068
MAX RADIUS	:	2.442	2.175	1.771
HORIZONTAL SPREAD	:	2.924	2.924	2.924
VERTICAL SPREAD	:	4.335	2.794	2.324
EXTREME SPREAD	:	4.712	3.924	3.299
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	

9 Mar 1991

FILE: PATTERNING/CENTERFIRE_PATT/ C8611740

CENTERFIRE PATTERNS # 3

POB



OF SHOTS = 10

IN CIR

1in = 0

2in = 2

3in = 5

HS = 3.853

VS = 3.488

CS = 3.936

CENTROID +

PATTERN #

3

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.732	1.496	1.436
MINIMUM X	-2.121	-1.728	-1.788
MAXIMUM Y	1.992	1.914	1.300
MINIMUM Y	-1.496	-1.574	-1.335
CENTROID X	-.326	-.090	-.030
CENTROID Y	-.228	-.150	-.389
POB TO CENTROID in.	.397	.175	.390
MIN RADIUS	.617	.613	.369
MEAN RADIUS	1.431	1.302	1.188
MAX RADIUS	2.235	1.973	1.788
HORIZONTAL SPREAD	3.853	3.224	3.224
VERTICAL SPREAD	3.488	3.488	2.635
EXTREME SPREAD	3.936	3.496	3.237
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		2	
NUMBER IN THREE INCH CIRCLE =		5	

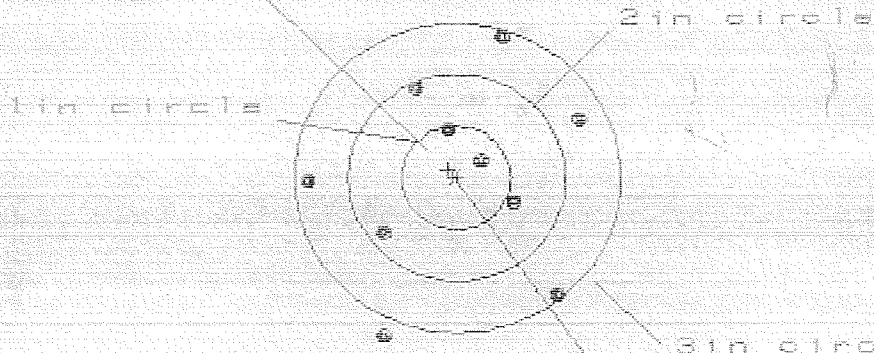
5 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/ C6611746

CENTERFIRE PATTERNS

4

POR



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 2.467

VS= 2.892

GS= 3.117

CENTROID *

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.078

.997

1.097

MINIMUM X

-1.389

-1.470

-1.370

MAXIMUM Y

1.359

1.189

1.021

MINIMUM Y

-1.532

-1.345

-1.862

CENTROID X

.075

.156

.056

CENTROID Y

-.073

.098

.266

POR TO CENTROID in.

.105

.184

.272

MIN RADIUS

.316

.166

.105

MEAN RADIUS

1.031

.918

.817

MAX RADIUS

1.694

1.564

1.410

HORIZONTAL SPREAD

2.467

2.467

2.467

VERTICAL SPREAD

2.892

2.534

1.883

EXTREME SPREAD

3.117

2.572

2.541

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

5

NUMBER IN THREE INCH CIRCLE =

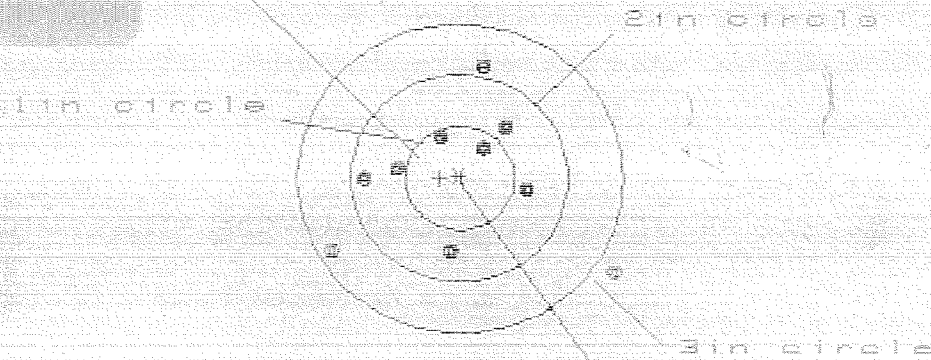
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2 Mar 1984

FILE: PATTERNING/CENTERFIRE_PATT/ C6811746

CENTERFIRE PATTERNS # 5

500



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 2.566

VS= 2.010

GS= 2.571

CENTROID *

PATTERN #

5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.436	.731	.610
MINIMUM X	-1.130	-.971	-.810
MAXIMUM Y	1.112	1.012	.908
MINIMUM Y	-.898	-.831	-.981
CENTROID X	.180	.021	.142
CENTROID Y	.004	.104	.208
POA TO CENTROID in.	.100	.106	.252
MIN RADIUS	.332	.345	.240
MEAN RADIUS	.836	.719	.625
MAX RADIUS	1.693	1.278	.937
HORIZONTAL SPREAD	2.566	1.702	1.420
VERTICAL SPREAD	2.010	1.843	1.809
EXTREME SPREAD	2.571	2.269	1.826
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	