

C6636017

MODEL 700™ M24

Model **SMS**™

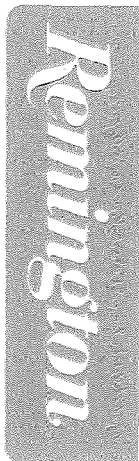
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.






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

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

MODEL 700TM M24

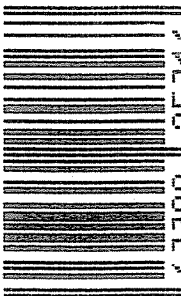
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

SERIAL NO.
C6636017

ORDER NO.
5716

UPC



0 47700 25716 2



5716 C6636017

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636017

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 8	9 1	RW
600	Proof	4 8	9 1	RW
607	Check Headspace		9 7	RW
610	Dis-assemble Gun			RW
612	Magnaflux Barrel Action		APR 9 1991	KR
	Magnaflux Bolt		APR 9 1991	"
615	Rollmark Caliber		APR 9 1991	LS
617	Drill and Tap Sight Holes		APR 19 1991	EB
618	Polish Barrel		APR 19 1991	EB
620	Apply Coatings (Barrel Action)		5-10-91	TSX
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/14/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/14/91	RW
	C) Inspect Ejector Hole for Chamfer		5/14/91	RW
	D) Oil Firing Pin Ass'y		5/14/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		6-4-91	JM

Op. #	OP. NAME	READINGS					DATE	INIT
525 cont.	F) Safety On Force	5	5	7			6/4/91	WB
	G) Safety Off Force	3 1/2	3 1/2	3 1/2			6/4/91	WB
	H) Trigger Pull Test & Retainability						6-4-91	JH
	I) Firing Pin Indent	.0215	.022	.0215			6/4/91	WB
	J) Assemble Stock						6/4/91	RW
	K) Assemble Swivel Studs						6-8-91	D/H
	L) Attach Front and Rear Sight Assemblies						6/4/91	RW
	M) Iron Sight Alignment						6/4/91	RW
	N) Detach Front & Rear Sights & place in numbered container						6/4/91	RW
	O) Attach Scope to Rifle						6/4/91	RW
	P) Detach & Attach Scope 20 Times						6/4/91	RW
540	Gallery Target & Test						6-5-91	D/H
	A) Time						6-5-91	D/H
	B) Malfunctions						6-5-91	D/H
	C) Pierced Primers						6-5-91	D/H
	D) Optical Clarity of Scope						6-5-91	D/H
545	Inspect for Live Ammo						6-5-91	D/H
555	Final Inspection						6-8-91	D/H
	A) Headspace							
	B) Trigger Pull	2.27	2.17	2.33	2.33	2.44	6-8-91	JH
	C) Function						6-8-91	D/H
560	Pack						6-20-91	AF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO C6636017

DATE 6-4-91

TESTER JEL.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.52	2.39	2.50	2.27	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.57	2.56	2.56	2.17	
PULL #3	2.56	2.57	2.55	2.33	
PULL #4	2.57	2.58	2.46	2.33	
PULL #5	2.56	2.46	2.44	2.44	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.41	3.31		
PULL #2	3.42	3.44		
PULL #3	3.45	3.50		
PULL #4	3.24	3.45		
PULL #5	3.42	3.47		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.27	4.48		4.59
PULL #2	4.53	4.55		4.36
PULL #3	4.50	4.16		4.34
PULL #4	4.54	4.55		4.55
PULL #5	4.20	4.59		4.53
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636017
5 Jun 1991

CENTROIDAL DISTANCES

Ø TO	1	.164657
1 TO	2	.282843
1 TO	3	.418126
1 TO	4	.135724
1 TO	5	.1136

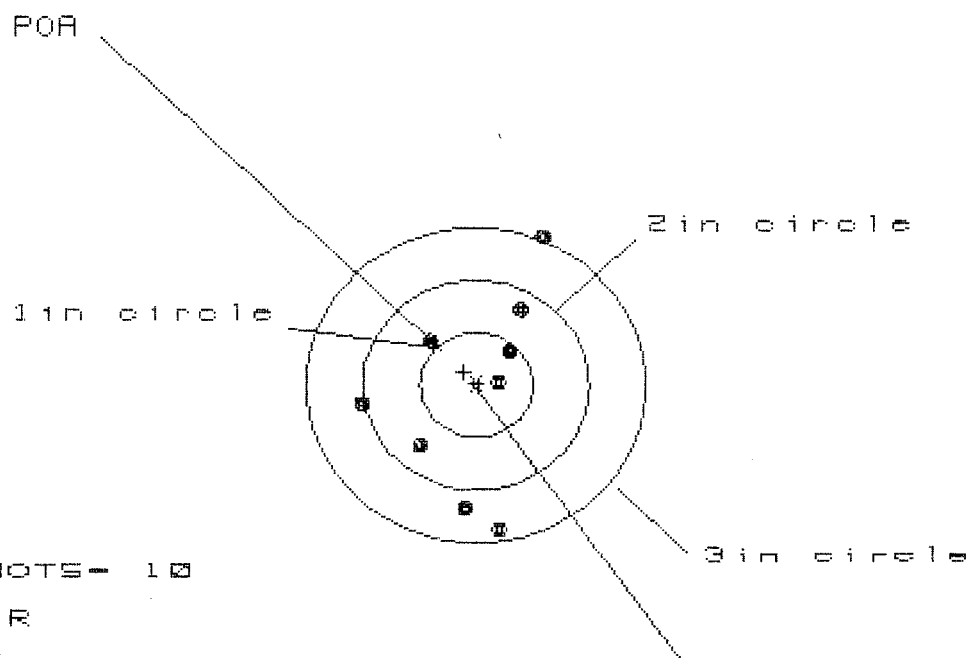
 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1926
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0532
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .199812
THE AMR FOR THIS RIFLE IS: .9612

5 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636017

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 9

HS= 1.589

VS= 2.780

GS= 2.807

CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.578	.485	.517
MINIMUM X	:	-1.011	-.946	-.914
MAXIMUM Y	:	1.423	.914	.764
MINIMUM Y	:	-1.357	-1.199	-1.192
CENTROID X	:	.106	.041	.009
CENTROID Y	:	-.126	-.284	-.135
POA TO CENTROID in.	:	.165	.287	.135
MIN RADIUS	:	.236	.353	.332
MEAN RADIUS	:	.849	.790	.708
MAX RADIUS	:	1.536	1.226	1.192
HORIZONTAL SPREAD	:	1.589	1.431	1.431
VERTICAL SPREAD	:	2.780	2.113	1.956
EXTREME SPREAD	:	2.807	2.125	2.026
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			9	

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CENTERFIRE PATTERNS

2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 7

HS= 1.463

VS= 3.936

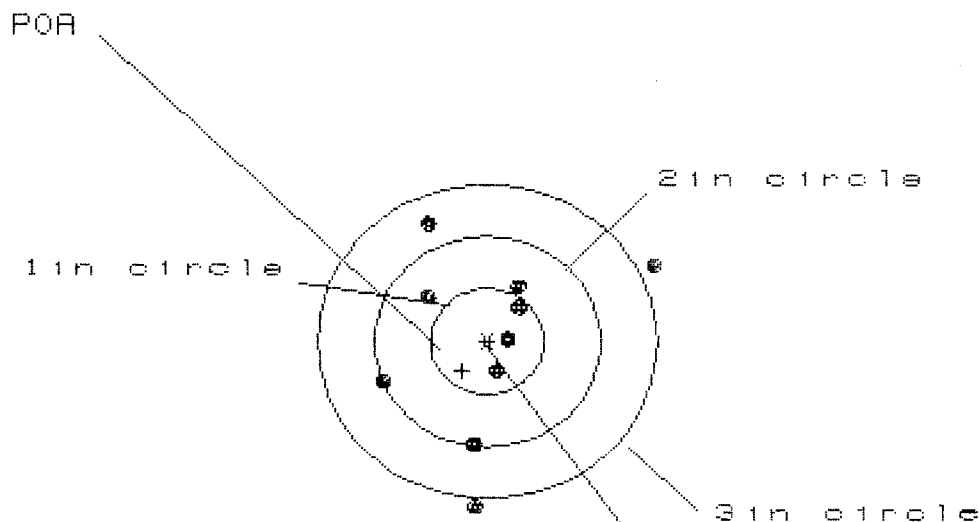
GS= 4.047

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.775	.830	.752
MINIMUM X	:	-.688	-.633	-.711
MAXIMUM Y	:	1.755	1.513	1.694
MINIMUM Y	:	-2.181	-1.614	-1.433
CENTROID X	:	.354	.299	.377
CENTROID Y	:	-.262	-.020	-.201
POA TO CENTROID in.	:	.440	.300	.427
MIN RADIUS	:	.132	.371	.197
MEAN RADIUS	:	1.221	1.117	1.025
MAX RADIUS	:	2.236	1.628	1.705
HORIZONTAL SPREAD	:	1.463	1.463	1.463
VERTICAL SPREAD	:	3.936	3.127	3.127
EXTREME SPREAD	:	4.047	3.128	3.128
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 8

HS= 2.377

VS= 2.717

GS= 2.798

CENTROID #

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.453	.448	.452
MINIMUM X	:	-.924	-.763	-.759
MAXIMUM Y	:	1.139	1.220	1.033
MINIMUM Y	:	-1.578	-1.497	-1.109
CENTROID X	:	.221	.059	.055
CENTROID Y	:	.276	.195	.382
POA TO CENTROID in.	:	.353	.203	.386
MIN RADIUS	:	.157	.310	.322
MEAN RADIUS	:	.855	.787	.675
MAX RADIUS	:	1.627	1.497	1.109
HORIZONTAL SPREAD	:	2.377	1.211	1.211
VERTICAL SPREAD	:	2.717	2.717	2.142
EXTREME SPREAD	:	2.798	2.753	2.181
NUMBER IN ONE INCH CIRCLE =	:	3		
NUMBER IN TWO INCH CIRCLE =	:	6		
NUMBER IN THREE INCH CIRCLE =	:	8		

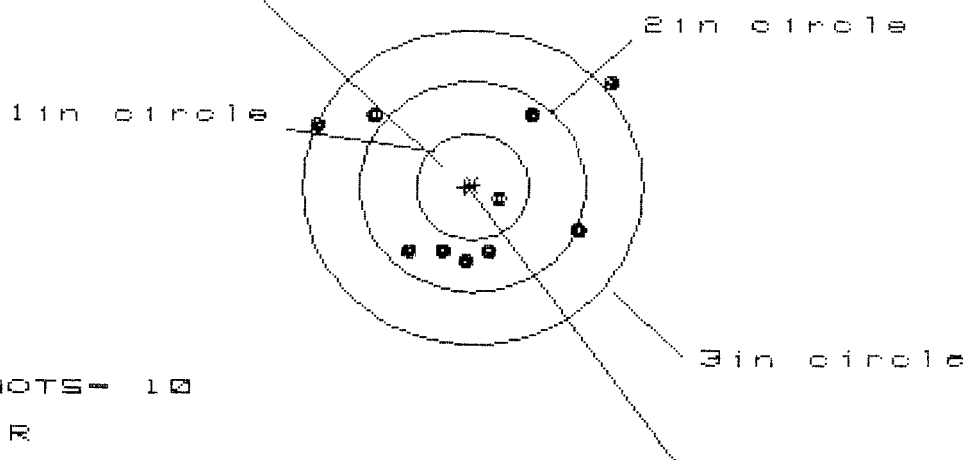
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CENTERFIRE PATTERNS

4

POA



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 8

HS= 2.641

VS= 1.721

GS= 2.672

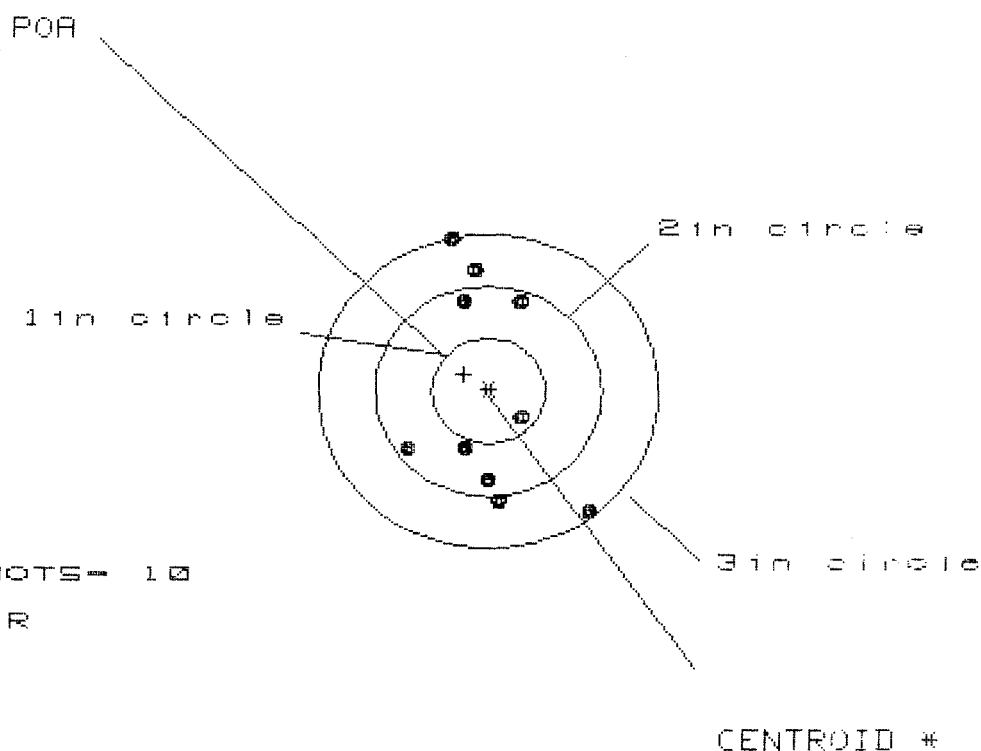
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.268	1.104	.950
MINIMUM X	:	-1.373	-1.232	-.925
MAXIMUM Y	:	1.022	.841	.932
MINIMUM Y	:	-.699	-.585	-.494
CENTROID X	:	.067	-.074	.080
CENTROID Y	:	.004	-.110	-.201
POA TO CENTROID in.	:	.067	.132	.216
MIN RADIUS	:	.273	.374	.227
MEAN RADIUS	:	.936	.835	.713
MAX RADIUS	:	1.629	1.432	1.313
HORIZONTAL SPREAD	:	2.641	2.336	1.875
VERTICAL SPREAD	:	1.721	1.426	1.426
EXTREME SPREAD	:	2.672	2.530	2.165
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 1.613

VS= 2.645

GS= 2.930

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.928	.891	.351
MINIMUM X	:	-.685	-.722	-.611
MAXIMUM Y	:	1.468	1.283	1.156
MINIMUM Y	:	-1.177	-1.014	-.971
CENTROID X	:	.215	.252	.141
CENTROID Y	:	-.158	-.321	-.194
POA TO CENTROID in.	:	.267	.408	.240
MIN RADIUS	:	.341	.240	.386
MEAN RADIUS	:	.945	.853	.800
MAX RADIUS	:	1.505	1.350	1.156
HORIZONTAL SPREAD	:	1.613	1.613	.962
VERTICAL SPREAD	:	2.645	2.297	2.127
EXTREME SPREAD	:	2.930	2.509	2.135
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			9	