

C6636022

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 700™ M24

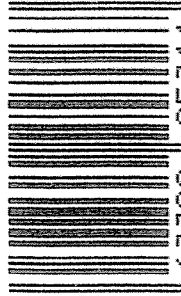
SERIAL NO.
C6636022

ORDER NO.
5716

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

20

UPC



0 47700 25716 2



5716 C6636022

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636 022

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 8 9 1	4/8/91	RW
600	Proof	4 8 9 1	4/8/91	RW
607	Check Headspace		4/8/91	RW
610	Dis-assemble Gun		4/8/91	RW
612	Magnaflux Barrel Action		APR 9 1991	KR
	Magnaflux Bolt		APR 9 1991	CC
615	Rollmark Caliber		APR 9 1991	JS
617	Drill and Tap Sight Holes		APR 19 1991	LoB
618	Polish Barrel		APR 19 1991	CC/B
620	Apply Coatings (Barrel Action)		5-10-91	TA
	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		5/28/91	JS

Op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5-28-91	DH
	G) Safety Off Force	3	3	3			5-28-91	DH
	H) Trigger Pull Test & Retainability						5/28/91	gll
	I) Firing Pin Indent	.020	.021	.021			5-28-91	DH
	J) Assemble Stock						5/29/91	RW
	K) Assemble Swivel Studs						6-1-91	DH
	L) Attach Front and Rear Sight Assemblies						5/29/91	RW
	M) Iron Sight Alignment						5/29/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/29/91	RW
	O) Attach Scope to Rifle						5/29/91	RW
	P) Detach & Attach Scope 20 Times						5/29/91	RW
640	Gallery Target & Test						5/31/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						5/31/91	KT
655	Final Inspection							
	A) Headspace						6-1-91	DH
	B) Trigger Pull	2.40	2.51	2.30	2.38	2.53	6/1/91	gll
	C) Function						6-1-91	DH
660	Pack						6-20-91	N-

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-163022

DATE 5/28/91

TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.35	2.50	2.40	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.44	2.38	2.48	2.51	
PULL #3	2.52	2.40	2.36	2.30	
PULL #4	2.34	2.39	2.48	2.38	
PULL #5	2.32	2.56	2.51	2.53	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.27	3.49		
PULL #2	3.16	3.21		
PULL #3	3.49	3.68		
PULL #4	3.24	3.54		
PULL #5	3.57	3.67		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.38	4.25		4.33
PULL #2	4.20	4.30		4.47
PULL #3	4.21	4.26		4.54
PULL #4	4.24	4.39		4.26
PULL #5	4.26	4.46		4.65
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636022
1 Jun 1991

CENTROIDAL DISTANCES

0	TO	1	.316798
1	TO	2	.3601
1	TO	3	.194124
1	TO	4	.737713
1	TO	5	.61591

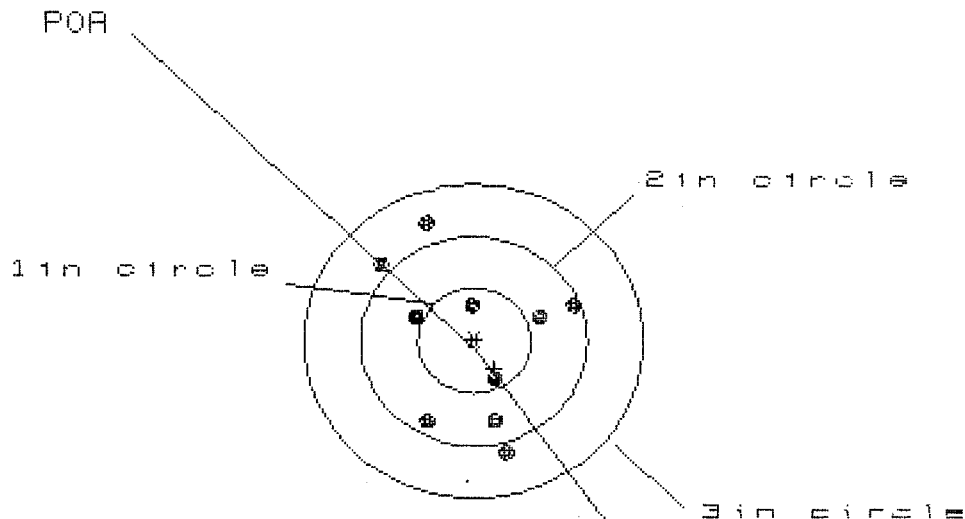
125
4 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0982
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0724
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .122004
THE AMR FOR THIS RIFLE IS: .8784

1 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636022

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 1.749

VS= 2.191

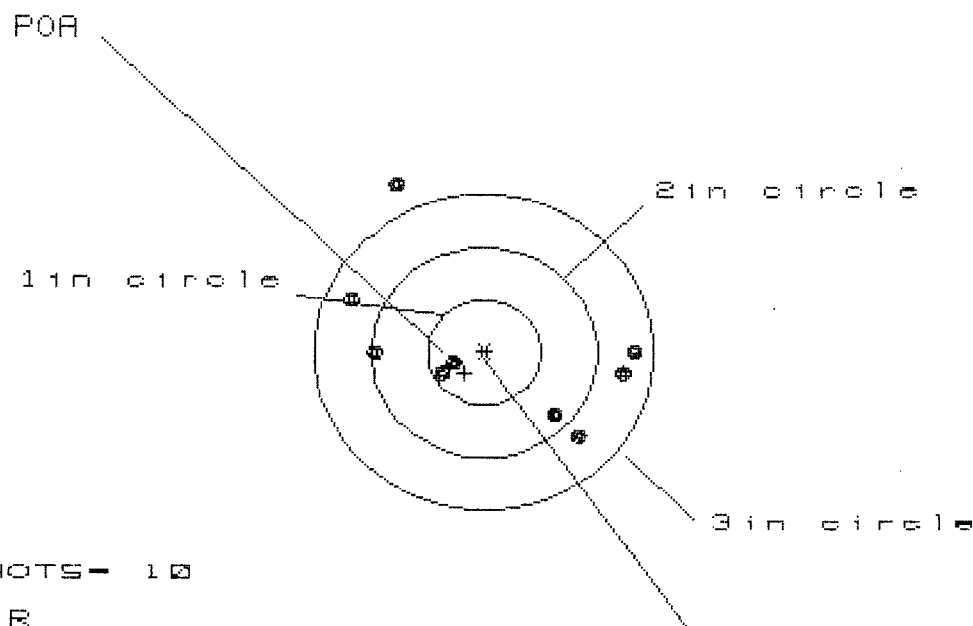
GS= 2.296

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.922	.879	.771
MINIMUM X	-.827	-.870	-.635
MAXIMUM Y	1.140	.874	.558
MINIMUM Y	-1.051	-.925	-.815
CENTROID X	-.181	-.138	-.030
CENTROID Y	.260	.134	.024
POA TO CENTROID in.	.317	.192	.038
MIN RADIUS	.306	.256	.120
MEAN RADIUS	.797	.740	.659
MAX RADIUS	1.202	1.233	.951
HORIZONTAL SPREAD	1.749	1.749	1.406
VERTICAL SPREAD	2.191	1.799	1.373
EXTREME SPREAD	2.296	2.126	1.711
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

1 Jun 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 9

HS= 2.563

VS= 2.364

GS= 2.815

CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.344	1.260	1.323
MINIMUM X	:	-1.219	-1.303	-1.145
MAXIMUM Y	:	1.574	.707	.734
MINIMUM Y	:	-.790	-.616	-.589
CENTROID X	:	.173	.257	.099
CENTROID Y	:	.194	.020	-.007
POA TO CENTROID in.	:	.260	.257	.099
MIN RADIUS	:	.330	.390	.241
MEAN RADIUS	:	.974	.870	.774
MAX RADIUS	:	1.743	1.482	1.360
HORIZONTAL SPREAD	:	2.563	2.563	2.468
VERTICAL SPREAD	:	2.364	1.323	1.323
EXTREME SPREAD	:	2.815	2.610	2.572
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

1 Jun 1991

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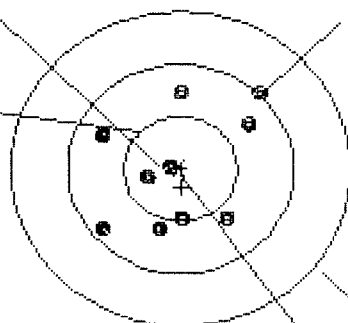
CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle



OF SHOTS- 10

IN CIR

1in - 2

2in - 9

3in - 10

HS- 1.333

VS- 1.365

GS- 1.862

CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.682	.710	.638
MINIMUM X	:	-.651	-.575	-.640
MAXIMUM Y	:	.749	.784	.726
MINIMUM Y	:	-.616	-.533	-.591
CENTROID X	:	-.009	-.085	-.013
CENTROID Y	:	.170	.087	.145
POA TO CENTROID in.	:	.170	.121	.146
MIN RADIUS	:	.044	.095	.050
MEAN RADIUS	:	.619	.559	.538
MAX RADIUS	:	1.013	.884	.792
HORIZONTAL SPREAD	:	1.333	1.285	1.278
VERTICAL SPREAD	:	1.365	1.317	1.317
EXTREME SPREAD	:	1.862	1.625	1.371
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

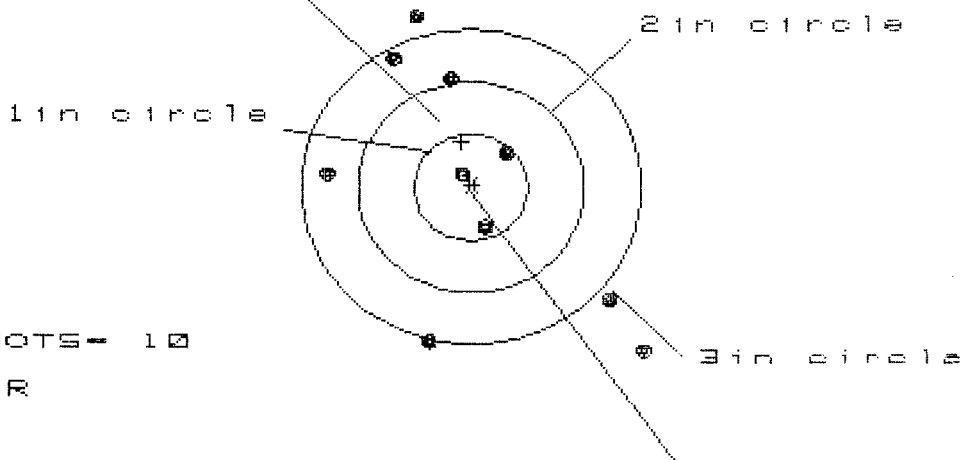
1 Jun 1991

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CENTERFIRE PATTERNS

4

POA



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 4

3 in = 7

HS= 2.767

VS= 3.193

GS= 3.768

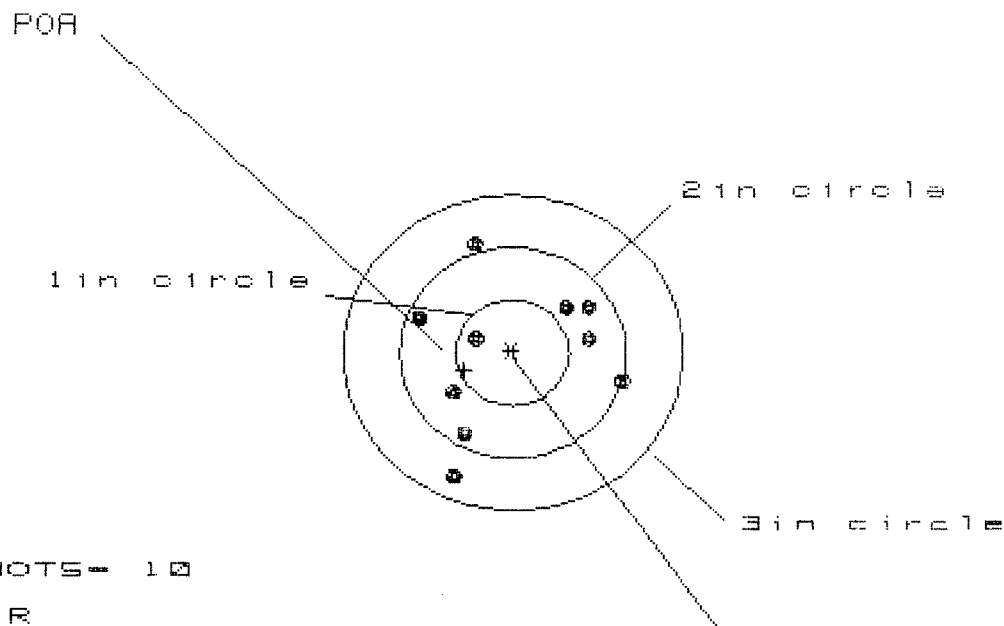
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.485	1.358	1.314
MINIMUM X	:	-1.282	-1.117	-1.161
MAXIMUM Y	:	1.641	1.469	1.279
MINIMUM Y	:	-1.552	-1.594	-1.411
CENTROID X	:	.080	-.085	-.041
CENTROID Y	:	-.430	-.258	-.441
POA TO CENTROID in.	:	.438	.271	.443
MIN RADIUS	:	.135	.107	.129
MEAN RADIUS	:	1.161	1.033	.969
MAX RADIUS	:	2.148	1.819	1.667
HORIZONTAL SPREAD	:	2.767	2.475	2.475
VERTICAL SPREAD	:	3.193	3.063	2.690
EXTREME SPREAD	:	3.768	3.178	2.978
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			4	
NUMBER IN THREE INCH CIRCLE =			7	

1 Jun 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1in = 1

2in = 7

3in = 10

HS = 1.859

VS = 2.266

GS = 2.275

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.013	.958	.915
MINIMUM X	-.846	-.901	-.944
MAXIMUM Y	1.055	.920	.450
MINIMUM Y	-1.211	-.861	-.746
CENTROID X	.428	.483	.526
CENTROID Y	.168	.303	.188
POA TO CENTROID in.	.460	.570	.559
MIN RADIUS	.349	.381	.437
MEAN RADIUS	.841	.776	.748
MAX RADIUS	1.308	1.052	1.000
HORIZONTAL SPREAD	1.859	1.859	1.859
VERTICAL SPREAD	2.266	1.781	1.195
EXTREME SPREAD	2.275	1.969	1.969
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		