

C6636028

MODEL 700™ M24

Model **SMS**™

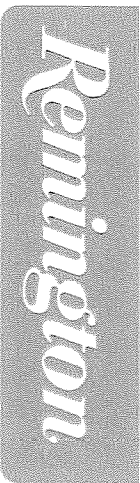
Action

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.

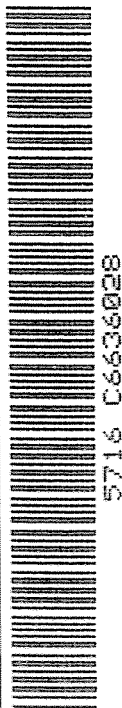
MODEL 700TM H24

20

SERIAL NO. C6636028

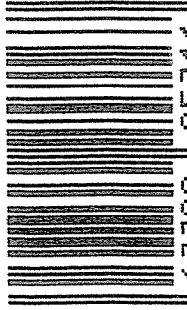
ORDER NO. 5716

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



5716 C6636028

UPC



0 47700 25716 7

INTERCHANGEABILITY

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636028

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 8	91	RW
600	Proof	2 8	91	RW
607	Check Headspace			RW
610	Dis-assemble Gun			RW
612	Magnaflux Barrel Action	APR	9 1991	KR
	Magnaflux Bolt	APR	9 1991	CC
615	Rollmark Caliber	APR	9 1991	GL
617	Drill and Tap Sight Holes	APR	9 1991	LB
618	Polish Barrel	APR	9 1991	WB
620	Apply Coatings (Barrel Action)			PA
	Apply Coating (Bolt)			
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		5/24/91	RM

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5/25/91	JK
	G) Safety Off Force	4	4	4			5/25/91	JK
	H) Trigger Pull Test & Retainability						5/24/91	JK
	I) Firing Pin Indent	.0225	.0225	.0225			5/25/91	JK
	J) Assemble Stock						5/25/91	RW
	K) Assemble Swivel Studs						6-3-91	D/H
	L) Attach Front and Rear Sight Assemblies						5/25/91	RW
	M) Iron Sight Alignment						5/25/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/25/91	RW
	O) Attach Scope to Rifle						5/25/91	RW
	P) Detach & Attach Scope 20 Times						5/25/91	RW
640	Gallery Target & Test						5-28-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						5-28-91	AF
655	Final Inspection							
	A) Headspace						6-3-91	D/H
	B) Trigger Pull	2.70	2.42	2.47	2.39	2.48	6/3/91	JK
	C) Function						6-3-91	D/H
660	Pack						6-19-91	AF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6636028

DATE 5-24-81

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.67	2.44	2.30	2.70	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.46	2.20	2.38	2.42	
PULL #3	2.58	2.34	2.35	2.47	
PULL #4	2.53	2.46	2.40	2.39	
PULL #5	2.59	2.33	2.36	2.48	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.53	3.69		
PULL #2	3.59	3.38		
PULL #3	3.37	3.27		
PULL #4	3.69	3.40		
PULL #5	3.53	3.36		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.45	4.39		4.27
PULL #2	4.28	4.37		4.37
PULL #3	4.27	4.23		4.37
PULL #4	4.38	4.27		4.26
PULL #5	4.39	4.26		4.49
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636028
28 May 1991

CENTROIDAL DISTANCES

0 TO	1	.0538145
1 TO	2	.0934773
1 TO	3	.123968
1 TO	4	.322405
1 TO	5	.429597

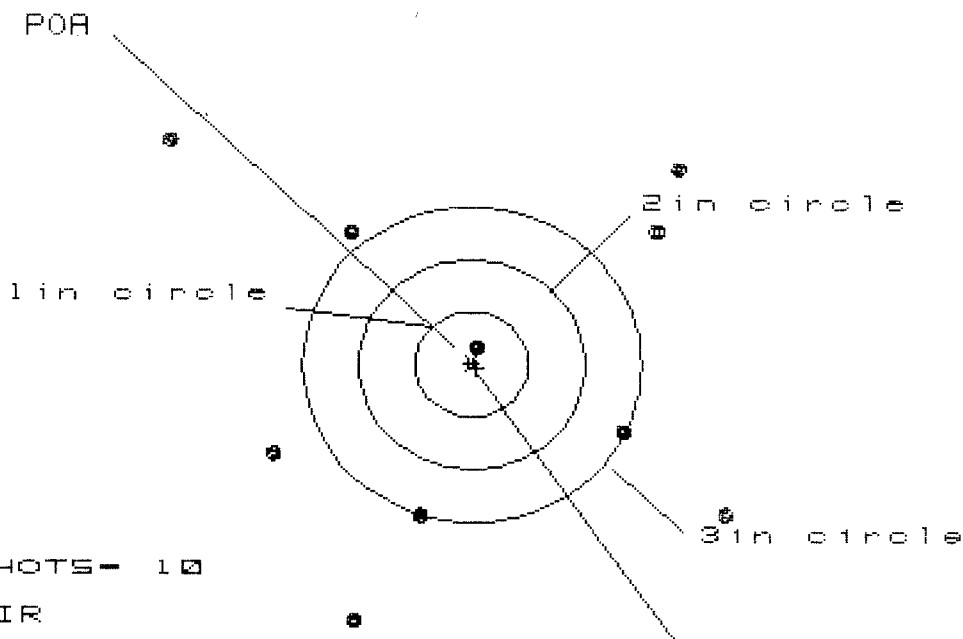
5' <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0244
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1134
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .115995
THE AMR FOR THIS RIFLE IS: 1.226

28 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6635020

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in - 1

2in - 1

3in = 2

HS= 4.913

VS= 4.609

GS= 6.086

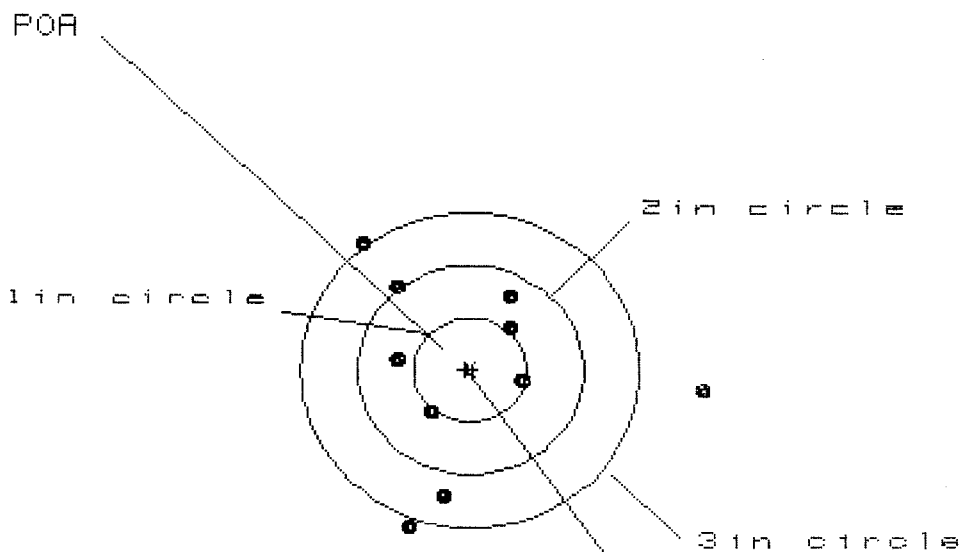
CENTROID *

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.236	1.939	1.768
MINIMUM X	:	-2.677	-2.038	-2.210
MAXIMUM Y	:	2.171	2.068	1.794
MINIMUM Y	:	-2.438	-2.197	-1.454
CENTROID X	:	-.040	.257	.429
CENTROID Y	:	.036	-.205	.069
POA TO CENTROID in.	:	.054	.329	.434
MIN RADIUS	:	.179	.491	.455
MEAN RADIUS	:	2.021	1.854	1.742
MAX RADIUS	:	3.447	2.592	2.366
HORIZONTAL SPREAD	:	4.913	3.977	3.977
VERTICAL SPREAD	:	4.609	4.265	3.248
EXTREME SPREAD	:	6.086	5.176	4.466
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	1		
NUMBER IN THREE INCH CIRCLE	=	2		

28 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636028

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 0

2 in = 5

3 in = 7

HS = 3.007

VS = 2.710

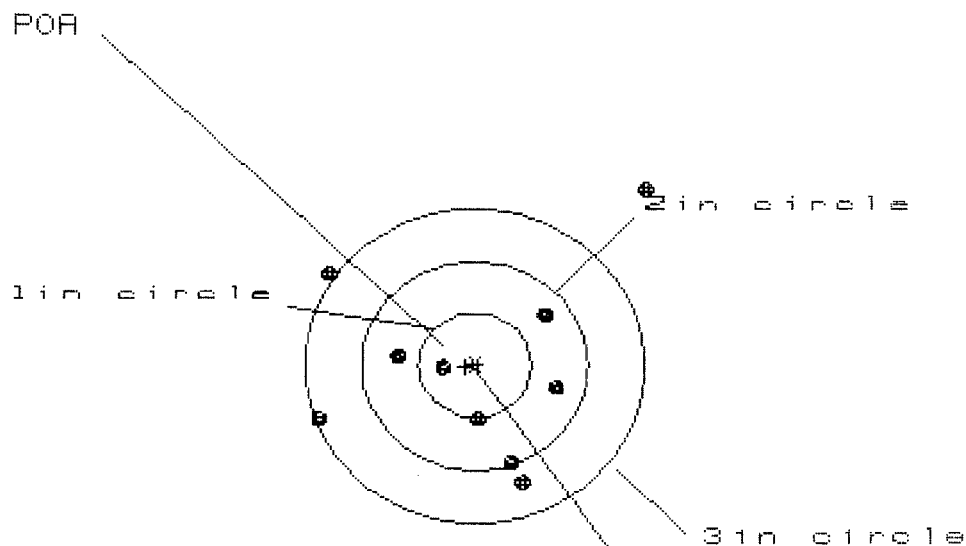
GS = 3.321

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.096	.735	.695
MINIMUM X	:	-.911	-.679	-.719
MAXIMUM Y	:	1.221	1.200	1.011
MINIMUM Y	:	-1.489	-1.510	-1.440
CENTROID X	:	.043	-.189	-.149
CENTROID Y	:	-.007	.014	.203
POA TO CENTROID in.	:	.044	.190	.251
MIN RADIUS	:	.506	.411	.458
MEAN RADIUS	:	1.065	.932	.838
MAX RADIUS	:	2.104	1.545	1.442
HORIZONTAL SPREAD	:	3.007	1.414	1.414
VERTICAL SPREAD	:	2.710	2.710	2.451
EXTREME SPREAD	:	3.321	2.733	2.535
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

28 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636028

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 8

HS= 2.894

VS= 2.831

GS= 3.609

CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.528	.890	.753
MINIMUM X	:	-1.366	-1.197	-1.334
MAXIMUM Y	:	1.674	1.119	.845
MINIMUM Y	:	-1.157	-.971	-.831
CENTROID X	:	.082	-.087	.050
CENTROID Y	:	.014	-.172	-.312
POA TO CENTROID in.	:	.084	.193	.315
MIN RADIUS	:	.265	.239	.183
MEAN RADIUS	:	1.052	.884	.773
MAX RADIUS	:	2.266	1.567	1.343
HORIZONTAL SPREAD	:	2.894	2.087	2.087
VERTICAL SPREAD	:	2.831	2.090	1.676
EXTREME SPREAD	:	3.609	2.677	2.248
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	8		

28 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636028

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in - 1

2 in - 4

3 in - 10

HS= 2.344

VS= 2.645

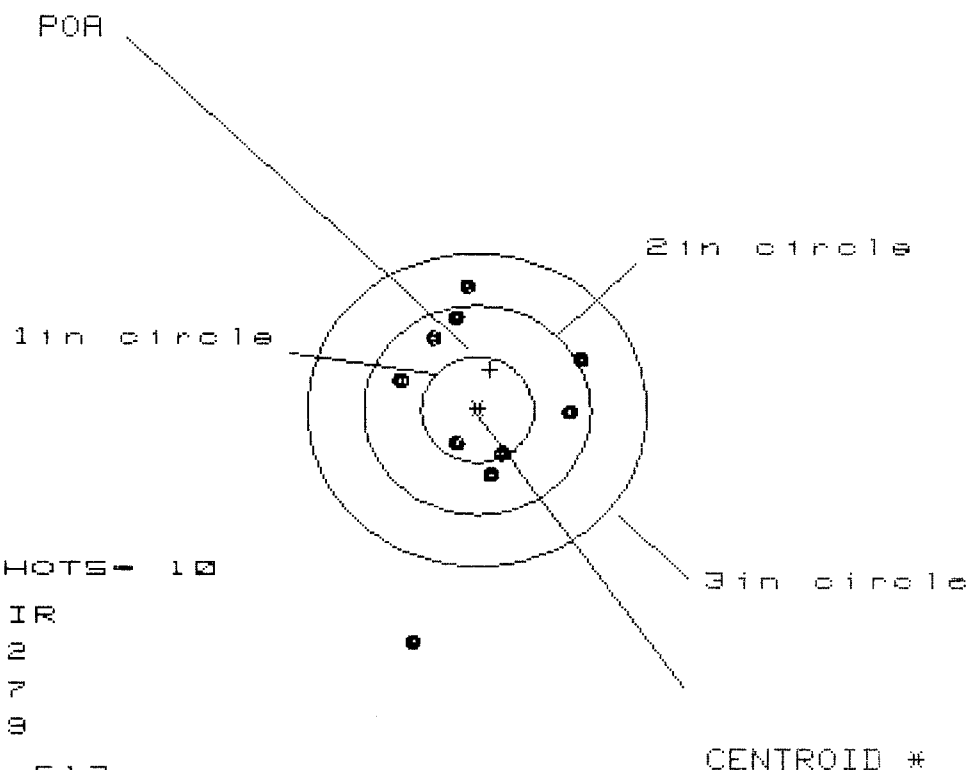
GS= 2.652

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.982	.941	.766
MINIMUM X	:	-1.362	-1.403	-.803
MAXIMUM Y	:	1.412	1.324	1.346
MINIMUM Y	:	-1.233	-1.076	-1.054
CENTROID X	:	.152	.193	.368
CENTROID Y	:	-.223	-.380	-.402
POA TO CENTROID in.	:	.270	.426	.545
MIN RADIUS	:	.375	.419	.583
MEAN RADIUS	:	1.088	1.021	.947
MAX RADIUS	:	1.459	1.465	1.567
HORIZONTAL SPREAD	:	2.344	2.344	1.569
VERTICAL SPREAD	:	2.645	2.400	2.400
EXTREME SPREAD	:	2.652	2.613	2.613
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

28 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636028

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in - 2

2in - 7

3in - 9

HS- 1.613

VS- 3.323

GS- 3.362

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.891	.827	.810
MINIMUM X	:	-.722	-.786	-.802
MAXIMUM Y	:	1.144	.902	.763
MINIMUM Y	:	-2.179	-.843	-.730
CENTROID X	:	-.115	-.051	-.035
CENTROID Y	:	-.387	-.145	-.258
POA TO CENTROID in.	:	.404	.154	.260
MIN RADIUS	:	.326	.564	.478
MEAN RADIUS	:	.902	.741	.707
MAX RADIUS	:	2.255	.912	.886
HORIZONTAL SPREAD	:	1.613	1.613	1.613
VERTICAL SPREAD	:	3.323	1.745	1.493
EXTREME SPREAD	:	3.362	1.751	1.624
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636028
17 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.745094
1 TO	2	.633834
1 TO	3	.532463
1 TO	4	.350304
1 TO	5	.6021

$\bar{x} = .403$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .403
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0382
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .404206

THE AMR FOR THIS RIFLE IS: .83

17 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CEB38028.1

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 8

3 in = 10

HS= 2.477

VS= 1.501

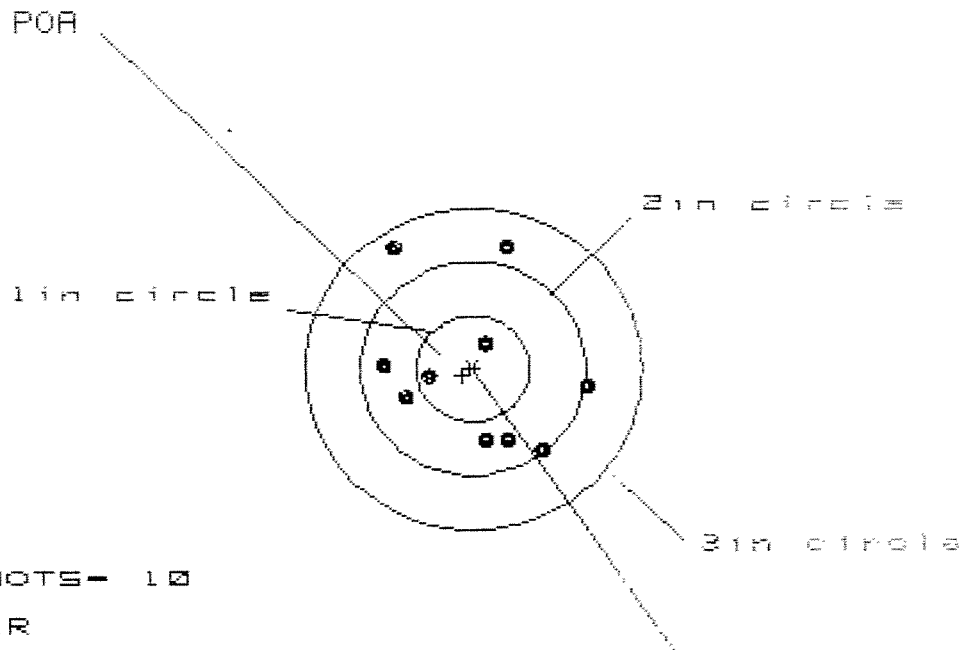
GS= 2.554

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.104	.777	.620
MINIMUM X	:	-1.373	-1.250	-.810
MAXIMUM Y	:	.625	.527	.493
MINIMUM Y	:	-.876	-.747	-.790
CENTROID X	:	.654	.531	.688
CENTROID Y	:	.357	.455	.499
POA TO CENTROID in.	:	.745	.699	.849
MIN RADIUS	:	.455	.370	.319
MEAN RADIUS	:	.836	.750	.663
MAX RADIUS	:	1.410	1.299	.982
HORIZONTAL SPREAD	:	2.477	2.027	1.430
VERTICAL SPREAD	:	1.501	1.274	1.274
EXTREME SPREAD	:	2.554	2.093	1.671
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

17 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636028.1

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in - 2

2 in - 7

3 in - 10

HS- 1.854

VS- 1.891

GS- 2.275

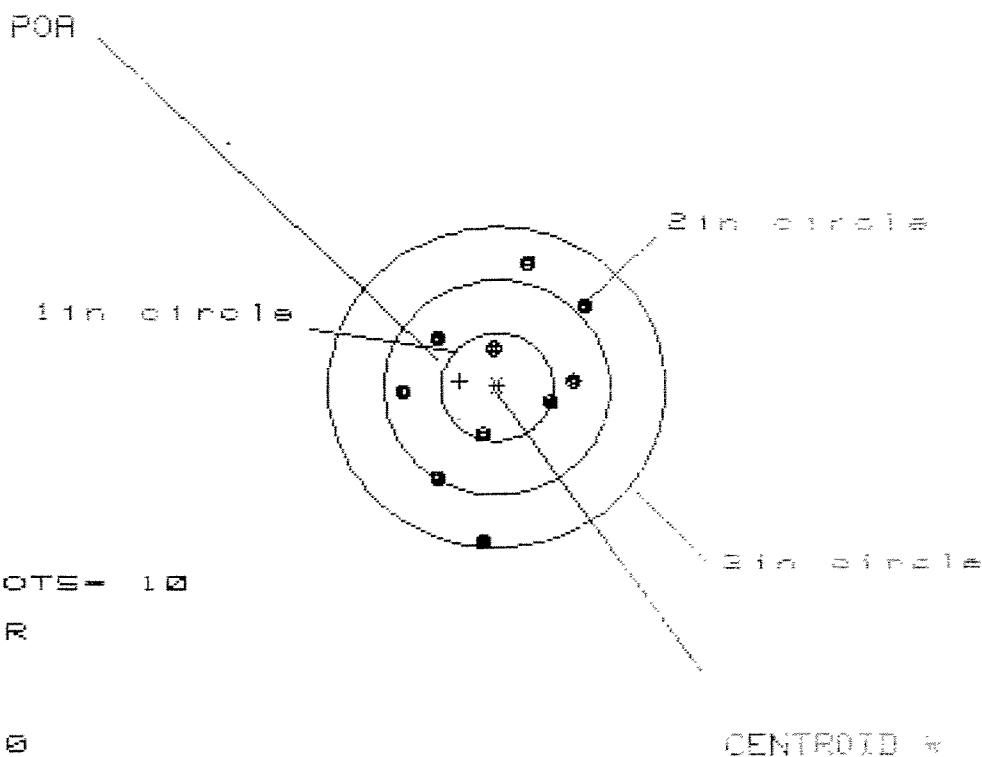
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.021	.943	.974
MINIMUM X	:	-.833	-.911	-.830
MAXIMUM Y	:	1.174	1.299	.493
MINIMUM Y	:	-.717	-.592	-.430
CENTROID X	:	.093	.171	.140
CENTROID Y	:	.062	-.063	-.225
POA TO CENTROID in.	:	.112	.183	.265
MIN RADIUS	:	.224	.331	.362
MEAN RADIUS	:	.800	.731	.634
MAX RADIUS	:	1.327	1.323	.925
HORIZONTAL SPREAD	:	1.854	1.854	1.854
VERTICAL SPREAD	:	1.891	1.891	.923
EXTREME SPREAD	:	2.275	1.915	1.859
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

17 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8536020.1

CENTERFIRE PATTERNS # 3



OF SHOTS- 10
IN CIR
1in - 3
2in - 6
3in - 10
HS- 1.635
VS- 2.561
GS- 2.599

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.773	.756	.791
MINIMUM X	-.862	-.879	-.844
MAXIMUM Y	1.170	1.015	.756
MINIMUM Y	-1.391	-1.040	-.913
CENTROID X	.328	.345	.310
CENTROID Y	-.064	.091	-.036
POA TO CENTROID in.	.334	.357	.312
MIN RADIUS	.390	.245	.360
MEAN RADIUS	.822	.743	.701
MAX RADIUS	1.399	1.160	1.094
HORIZONTAL SPREAD	1.635	1.635	1.635
VERTICAL SPREAD	2.561	2.055	1.669
EXTREME SPREAD	2.599	2.202	2.098
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

17 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636020.1

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS= 2.078

VS= 2.104

GS= 2.160

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.284	.497	.544
MINIMUM X	:	-.794	-.651	-.604
MAXIMUM Y	:	1.201	1.244	1.349
MINIMUM Y	:	-.904	-.860	-.735
CENTROID X	:	.531	.389	.341
CENTROID Y	:	.029	-.015	-.179
POA TO CENTROID in.	:	.532	.389	.381
MIN RADIUS	:	.291	.335	.272
MEAN RADIUS	:	.850	.768	.653
MAX RADIUS	:	1.342	1.301	1.438
HORIZONTAL SPREAD	:	2.078	1.148	1.148
VERTICAL SPREAD	:	2.104	2.104	2.104
EXTREME SPREAD	:	2.160	2.115	2.115
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			10	

17 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636028.1

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 2.047

VS= 2.261

GS= 2.408

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.082	1.165	1.027
MINIMUM X	:	-.965	-.882	-.737
MAXIMUM Y	:	.865	.710	.633
MINIMUM Y	:	-1.395	-.619	-.621
CENTROID X	:	.409	.326	.181
CENTROID Y	:	-.193	-.038	.039
POA TO CENTROID in.	:	.453	.328	.185
MIN RADIUS	:	.323	.261	.263
MEAN RADIUS	:	.842	.714	.603
MAX RADIUS	:	1.582	1.319	1.200
HORIZONTAL SPREAD	:	2.047	2.047	1.764
VERTICAL SPREAD	:	2.261	1.329	1.254
EXTREME SPREAD	:	2.408	2.184	1.893
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	