

C6636031

MODEL 700™ M24

Model SMS™

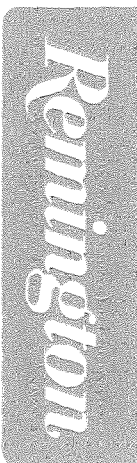
Action

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 700TH H24

SERIAL NO. C6606031

ORDER NO. 5716

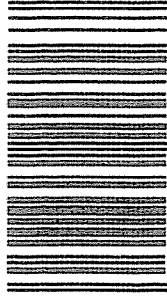
MADE IN U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada. Marque Deposee.

0.5



5716 C6606031

UPC



0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

Stock
Repaired

GUN SERIAL #

C6636031

REPAIR
6/27/91

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		4/23/91	K.S.
600	Proof		4/23/91	K.S.
607	Check Headspace		4/23/91	K.S.
610	Dis-assemble Gun		4/23/91	K.S.
612	Magnaflux Barrel Action	5 8 9 1		Kcd
	Magnaflux Bolt	5 8 9 1		Kcd
615	Rollmark Caliber		9 1	CS
617	Drill and Tap Sight Holes	5 15 9 1		LB
618	Polish Barrel	5 15 9 1		WB
620	Apply Coatings (Barrel Action)		5/21/91	TA
	Apply Coating (Bolt)		5/21/91	TA
625	Final Assembly A) Clean inside of Bolt Assembly		4/12/91	K.S.
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/12/91	K.S.
	C) Inspect Ejector Hole for Chamfer		4/12/91	K.S.
	D) Oil Firing Pin Ass'y		4/12/91	K.S.
	E) Adjust Trigger Pull to Min Setting and Stake		6-13-91	P/H

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			6-13-91	DH
	G) Safety Off Force	3	3	3			6-13-91	DH
	H) Trigger Pull Test & Retainability						6-13-91	DH
	I) Firing Pin Indent	.021	.021	.021			6-13-91	DH
	J) Assemble Stock						6-13-91	KS
	K) Assemble Swivel Studs						6-15-91	DH
	L) Attach Front and Rear Sight Assemblies						6-13-91	KS
	M) Iron Sight Alignment						6-13-91	KS
	N) Detach Front & Rear Sights & place in numbered container						6-13-91	KS
	O) Attach Scope to Rifle						6-13-91	KS
	P) Detach & Attach Scope 20 Times						6-13-91	KS
640	Gallery Target & Test						6-14-91	KS
	A) Time						"	KS
	B) Malfunctions						"	KS
	C) Pierced Primers						"	KS
	D) Optical Clarity of Scope						"	KS
645	Inspect for Live Ammo						6-14-91	KS
655	Final Inspection						6-15-91	DH
	A) Headspace						6-15-91	DH
	B) Trigger Pull	2.51	2.55	2.58	2.48	2.54	6-15-91	KS
	C) Function						6-15-91	DH
660	Pack						6-20-91	KS

SWS TRIGGER PULL TEST

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

SERIAL NO. 31 C663608

DATE 6-12-91

TESTER JH.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.49	2.52	2.50	2.57	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.43	2.55	2.50	2.55	
PULL #3	2.52	2.62	2.56	2.58	
PULL #4	2.44	2.57	2.58	2.48	
PULL #5	2.52	2.58	2.55	2.54	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.79	3.19		
PULL #2	3.27	3.20		
PULL #3	3.37	3.59		
PULL #4	3.40	3.63		
PULL #5	3.20	3.60		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.19	4.50		4.61
PULL #2	4.44	4.59		4.62
PULL #3	4.46	4.59		4.65
PULL #4	4.52	4.49		4.62
PULL #5	4.38	4.61		4.40
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636031
14 Jun 1991

CENTROIDAL DISTANCES

Ø TO	1	.0890056
1 TO	2	.3178
1 TO	3	.192167
1 TO	4	.171304
1 TO	5	.292385

43 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0034
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0596
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0596969

THE AMR FOR THIS RIFLE IS: 1.116

14 Jun 1991

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CENTERFIRE PATTERNS

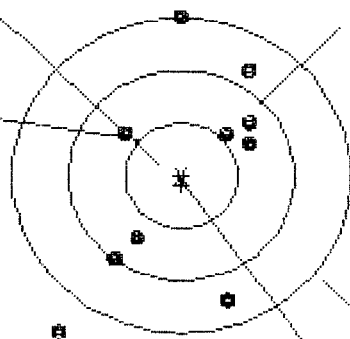
1

POA

1in circle

2in circle

3in circle



CENTROID *

OF SHOTS- 10

IN CIR

1in - 0

2in - 5

3in - 8

HS- 1.640

VS- 2.954

GS- 3.151

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.582	.465	.455
MINIMUM X	:	-1.058	-.738	-.748
MAXIMUM Y	:	1.507	1.346	.989
MINIMUM Y	:	-1.447	-1.393	-1.225
CENTROID X	:	-.001	.116	.126
CENTROID Y	:	.089	.250	.082
POA TO CENTROID in.	:	.089	.276	.150
MIN RADIUS	:	.568	.372	.494
MEAN RADIUS	:	.999	.869	.823
MAX RADIUS	:	1.793	1.418	1.251
HORIZONTAL SPREAD	:	1.640	1.203	1.203
VERTICAL SPREAD	:	2.954	2.739	2.214
EXTREME SPREAD	:	3.151	2.760	2.221
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

14 Jun 1991

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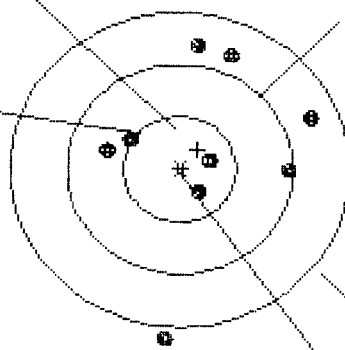
CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle



OF SHOTS - 10

IN CIR

1 in - 2

2 in - 5

3 in - 8

HS - 3.175

VS - 2.793

GS - 3.773

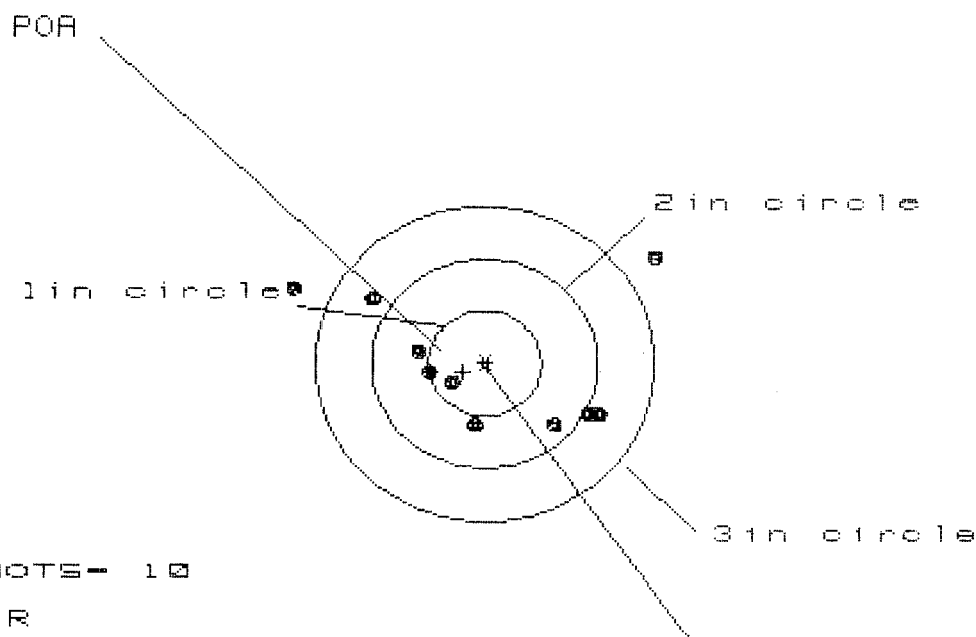
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.175	.953	.907
MINIMUM X	:	-2.000	-.843	-.889
MAXIMUM Y	:	1.205	1.034	.814
MINIMUM Y	:	-1.588	-1.759	-.565
CENTROID X	:	-.162	.060	.106
CENTROID Y	:	-.185	-.014	.206
POA TO CENTROID in.	:	.246	.062	.232
MIN RADIUS	:	.249	.094	.296
MEAN RADIUS	:	1.048	.836	.723
MAX RADIUS	:	2.526	1.796	.919
HORIZONTAL SPREAD	:	3.175	1.796	1.796
VERTICAL SPREAD	:	2.793	2.793	1.379
EXTREME SPREAD	:	3.773	2.807	1.828
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

14 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636031

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 3.255

VS= 1.597

GS= 3.267

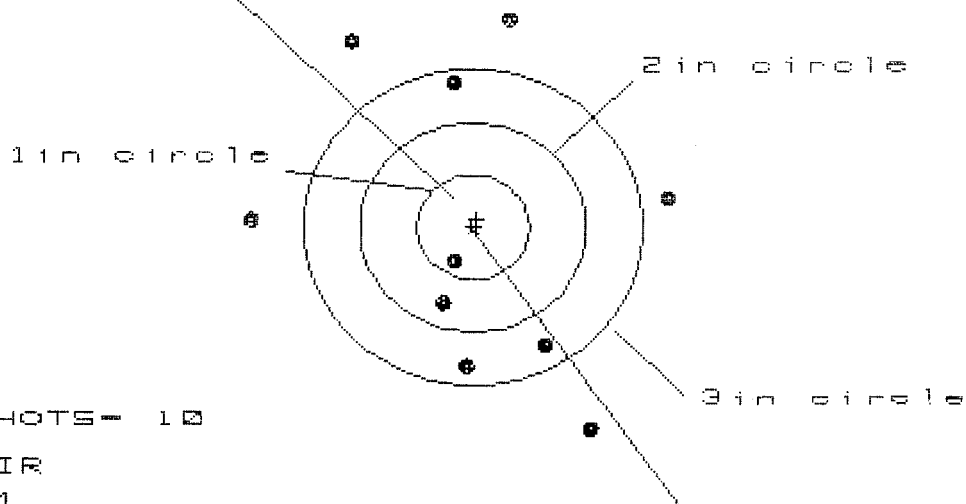
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.554	1.365	.988
MINIMUM X	:	-1.701	-1.157	-.987
MAXIMUM Y	:	.974	1.051	.845
MINIMUM Y	:	-.623	-.546	-.414
CENTROID X	:	.191	.380	.210
CENTROID Y	:	.081	.004	-.128
POA TO CENTROID in.	:	.208	.380	.246
MIN RADIUS	:	.320	.476	.305
MEAN RADIUS	:	.992	.900	.744
MAX RADIUS	:	1.840	1.723	1.299
HORIZONTAL SPREAD	:	3.255	2.522	1.975
VERTICAL SPREAD	:	1.597	1.597	1.259
EXTREME SPREAD	:	3.267	2.545	2.259
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

14 Jun 1991

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CENTERFIRE PATTERNS # 4

POA



OF SHOTS- 10

IN CIR

1 in - 1

2 in - 2

3 in - 5

HS= 3.641

VS= 3.941

GS= 4.269

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.679	1.793	1.678
MINIMUM X	:	-1.962	-1.848	-1.963
MAXIMUM Y	:	1.980	1.762	1.957
MINIMUM Y	:	-1.961	-1.575	-1.380
CENTROID X	:	-.029	-.143	-.028
CENTROID Y	:	-.080	.138	-.057
POA TO CENTROID in.	:	.085	.199	.063
MIN RADIUS	:	.370	.555	.392
MEAN RADIUS	:	1.515	1.453	1.364
MAX RADIUS	:	2.214	1.855	1.977
HORIZONTAL SPREAD	:	3.641	3.641	3.641
VERTICAL SPREAD	:	3.941	3.337	3.337
EXTREME SPREAD	:	4.269	3.646	3.646
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		5	

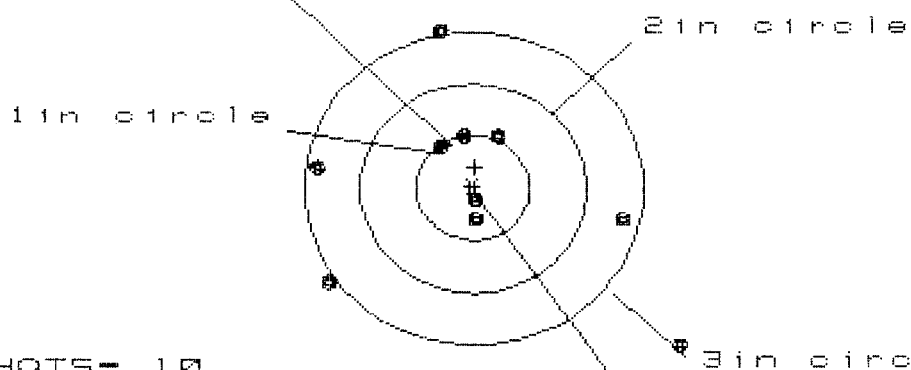
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CENTERFIRE PATTERNS

5

POA



OF SHOTS- 10

IN CIR

1in - 3

2in - 5

3in = 7

HS- 3.255

VS= 3.036

GS= 3.702

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.822	1.479	1.340
MINIMUM X	:	-1.433	-1.230	-1.369
MAXIMUM Y	:	1.499	1.329	1.192
MINIMUM Y	:	-1.537	-1.097	-.610
CENTROID X	:	-.016	-.219	-.080
CENTROID Y	:	-.203	-.033	.105
POA TO CENTROID in.	:	.204	.221	.132
MIN RADIUS	:	.114	.228	.210
MEAN RADIUS	:	1.025	.856	.736
MAX RADIUS	:	2.384	1.559	1.460
HORIZONTAL SPREAD	:	3.255	2.709	2.709
VERTICAL SPREAD	:	3.036	2.426	1.801
EXTREME SPREAD	:	3.702	2.754	2.754
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	