

C6636034

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.

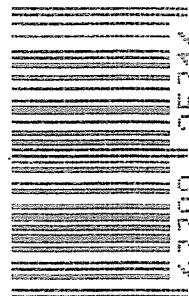
MODEL 700TH H24

SERIAL NO.
C6636834

ORDER NO.
5716

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

LPC



0 47700 25716 7



5716 C6636834

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636034

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		5/1/91	KS
600	Proof		5/1/91	KS
607	Check Headspace		5/1/91	KS
610	Dis-assemble Gun		5/1/91	KS
612	Magnaflux Barrel Action	5 8 9 1		KCR
	Magnaflux Bolt	5 8 9 1		KCR
615	Rollmark Caliber			68.
617	Drill and Tap Sight Holes	5 15 9 1		FA
618	Polish Barrel	5 15 9 1		W.B.
620	Apply Coatings (Barrel Action)		5/31/91	FA
	Apply Coating (Bolt)		5/31/91	FA
625	Final Assembly A) Clean inside of Bolt Assembly		7/17/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/17/91	KS
	C) Inspect Ejector Hole for Chamfer		7/17/91	KS
	D) Oil Firing Pin Ass'y		7/17/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		7-18-91	CS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			7/18/91	JS
	G) Safety Off Force	4	4	4			7-18-91	JS
	H) Trigger Pull Test & Retainability						7-18-91	JS
	I) Firing Pin Indent	.0225	.0225	.0225			7-18-91	JS
	J) Assemble Stock						7/18/91	KS
	K) Assemble Swivel Studs						7-26-91	D/K
	L) Attach Front and Rear Sight Assemblies						7/18/91	KS
	M) Iron Sight Alignment						7/18/91	KS
	N) Detach Front & Rear Sights & place in numbered container						7/18/91	KS
	O) Attach Scope to Rifle						7/18/91	KS
	P) Detach & Attach Scope 20 Times						7/18/91	KS
640	Gallery Target & Test						7/22/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						7/22/91	KT
655	Final Inspection							
	A) Headspace						7-26-91	D/K
	B) Trigger Pull	2.65	2.67	2.67	2.68	2.65	7-26-91	JS
	C) Function						7-26-91	JS
660	Pack						9-19-91	JS

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6636034

DATE 7-18-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.34	2.66	2.54	2.65	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.24	2.67	2.50	2.69	
PULL #3	2.57	2.65	2.49	2.67	
PULL #4	2.42	2.30	2.60	2.68	
PULL #5	2.33	2.61	2.63	2.65	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.37	3.38		
PULL #2	3.43	3.40		
PULL #3	3.20	3.26		
PULL #4	3.35	3.38		
PULL #5	3.38	3.42		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.25	4.40		4.43
PULL #2	4.55	4.55		4.40
PULL #3	4.40	4.60		4.48
PULL #4	4.58	4.48		4.40
PULL #5	4.48	4.40		4.43
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636034
22 Jul 1991

CENTROIDAL DISTANCES

0 TO 1	.244205
1 TO 2	.153056
1 TO 3	.347071
1 TO 4	.0566039
1 TO 5	.319581

~~3~~
4 <----POA

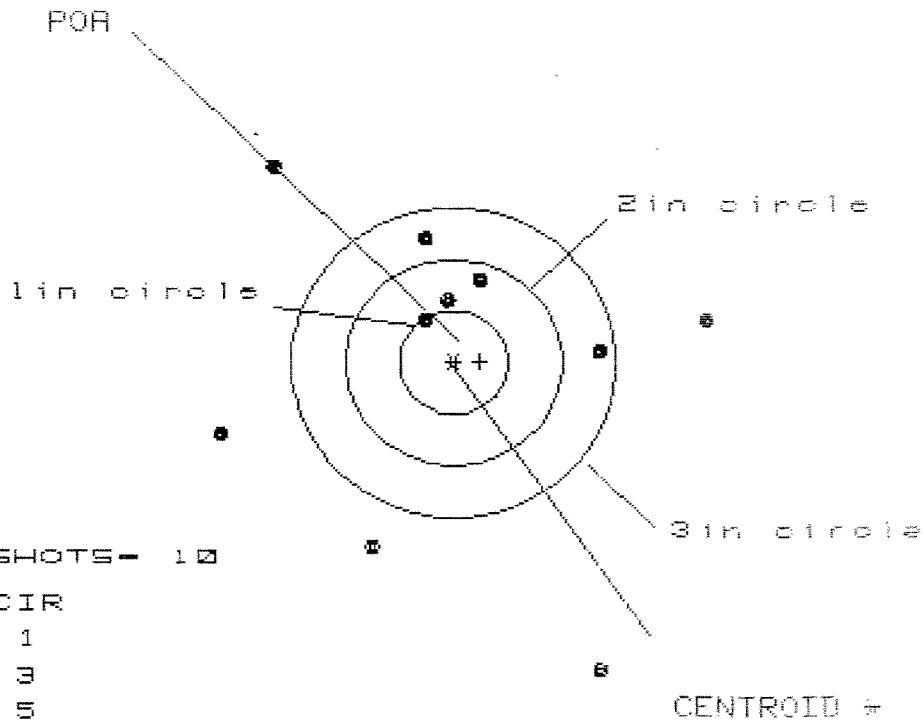
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1588
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .114
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .195483
THE AMR FOR THIS RIFLE IS: 1.331

22 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C853B034

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 5

HS= 4.515

VS= 4.869

GS= 5.717

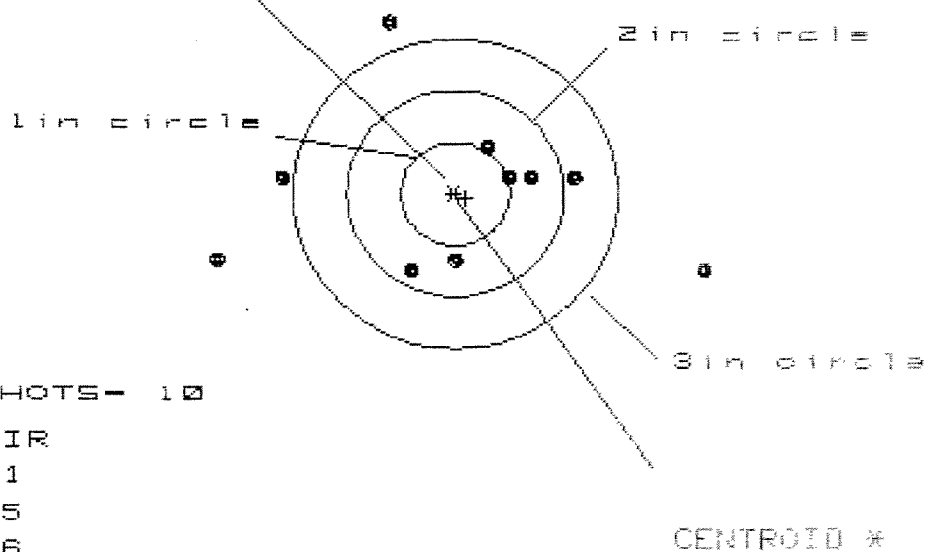
PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.328	2.472	2.278
MINIMUM X	:	-2.187	-2.043	-2.237
MAXIMUM Y	:	1.928	1.601	1.046
MINIMUM Y	:	-2.941	-2.115	-1.914
CENTROID X	:	-.244	-.388	-.194
CENTROID Y	:	-.016	.317	.116
POR TO CENTROID in.	:	.244	.501	.226
MIN RADIUS	:	.479	.160	.427
MEAN RADIUS	:	1.685	1.403	1.345
MAX RADIUS	:	3.214	2.475	2.378
HORIZONTAL SPREAD	:	4.515	4.515	4.515
VERTICAL SPREAD	:	4.869	3.716	2.960
EXTREME SPREAD	:	5.717	4.652	4.652
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	3		
NUMBER IN THREE INCH CIRCLE	=	5		

22 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636034

CENTERFIRE PATTERNS # 2

POA



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 6

HS= 4.506

VS= 2.372

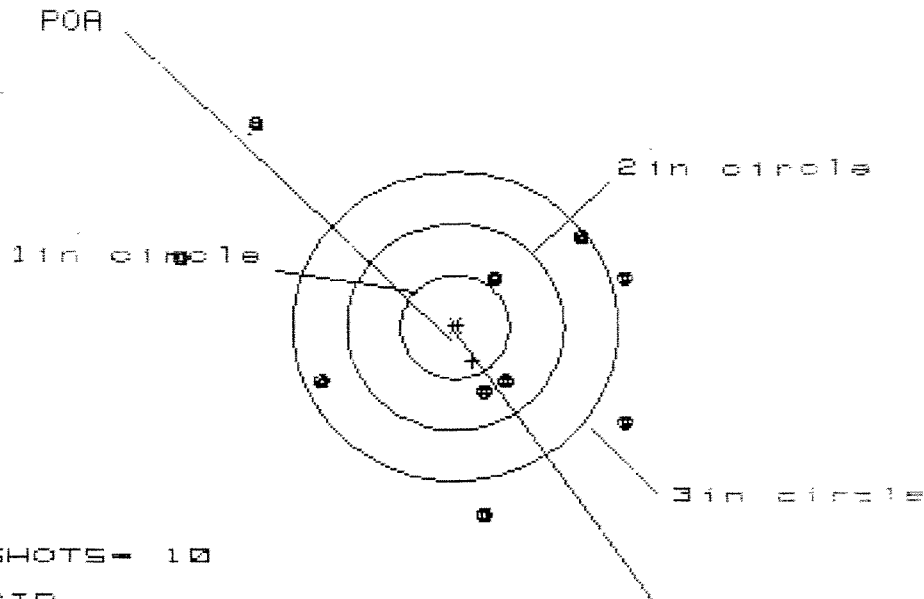
GS= 4.507

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.292	1.309	1.064
MINIMUM X	:	-2.214	-1.959	-1.549
MAXIMUM Y	:	1.627	1.544	1.450
MINIMUM Y	:	-.745	-.781	-.875
CENTROID X	:	-.099	-.354	-.109
CENTROID Y	:	.039	.122	.216
POA TO CENTROID in.	:	.107	.374	.242
MIN RADIUS	:	.489	.691	.436
MEAN RADIUS	:	1.229	1.134	.946
MAX RADIUS	:	2.410	2.097	1.521
HORIZONTAL SPREAD	:	4.506	3.268	2.510
VERTICAL SPREAD	:	2.372	2.325	2.325
EXTREME SPREAD	:	4.507	3.379	2.612
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		6	

22 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6536034

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 0

2in = 3

3in = 5

HS= 4.073

VS= 3.884

GS= 4.455

CENTROID *

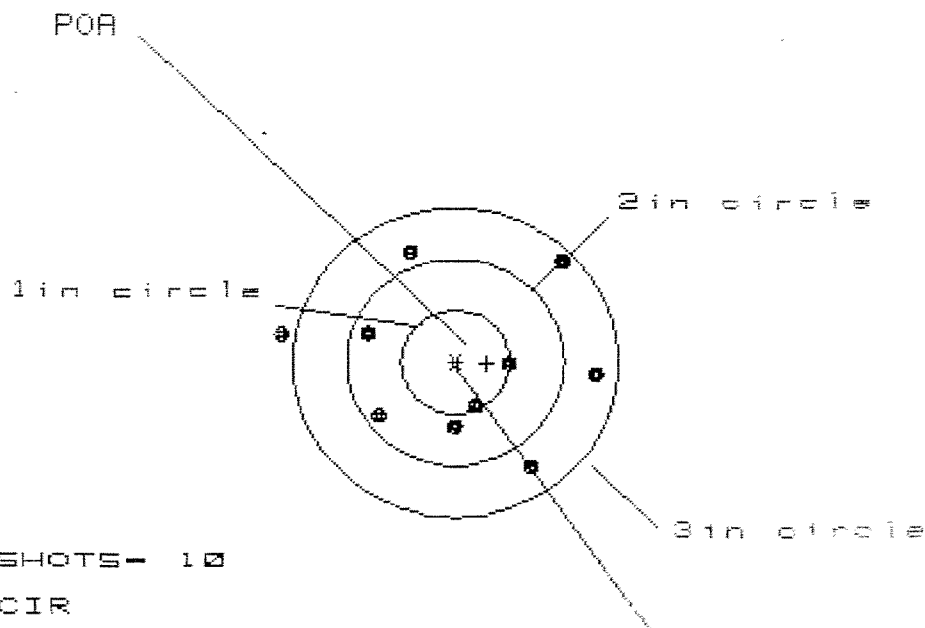
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.538	1.332	.990
MINIMUM X	:	-2.535	-2.741	-1.737
MAXIMUM Y	:	2.010	1.064	1.173
MINIMUM Y	:	-1.874	-1.651	-1.542
CENTROID X	:	-.161	.045	.397
CENTROID Y	:	.327	.104	-.005
POA TO CENTROID in.	:	.365	.113	.287
MIN RADIUS	:	.560	.337	.287
MEAN RADIUS	:	1.525	1.310	1.053
MAX RADIUS	:	2.732	2.876	1.750
HORIZONTAL SPREAD	:	4.073	4.073	2.727
VERTICAL SPREAD	:	3.884	2.715	2.715
EXTREME SPREAD	:	4.455	4.345	2.899
NUMBER IN ONE INCH CIRCLE =			0	
NUMBER IN TWO INCH CIRCLE =			3	
NUMBER IN THREE INCH CIRCLE =			5	

22 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6836034

CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1in - 2

2in - 5

3in - 3

HS- 2.913

VS- 2.067

GS- 2.942

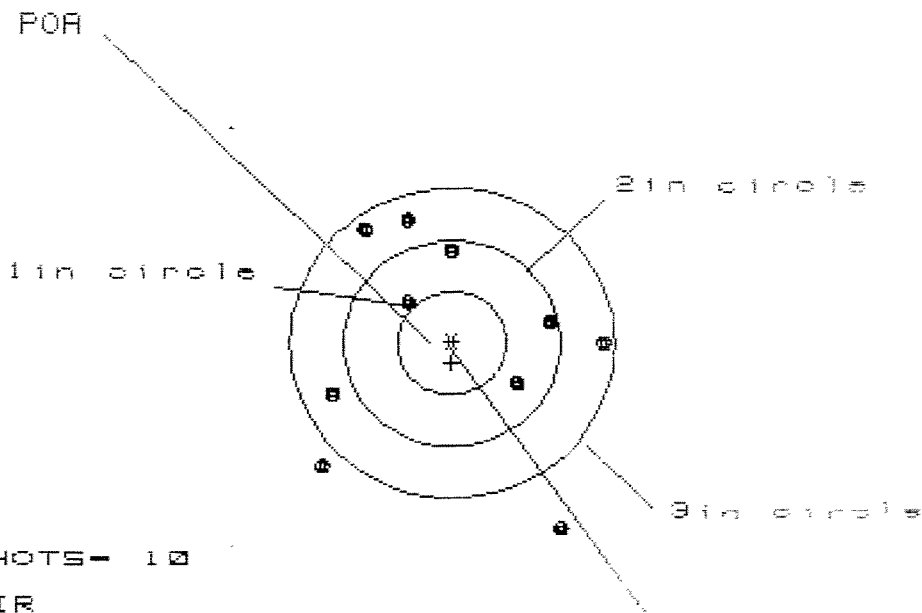
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.279	1.097	1.195
MINIMUM X	:	-1.634	-0.980	-0.882
MAXIMUM Y	:	1.030	1.066	1.196
MINIMUM Y	:	-1.037	-1.001	-0.871
CENTROID X	:	-0.292	-0.110	-0.208
CENTROID Y	:	.020	-0.016	-0.146
POA TO CENTROID in.	:	.292	.111	.254
MIN RADIUS	:	.457	.311	.272
MEAN RADIUS	:	.996	.898	.819
MAX RADIUS	:	1.665	1.301	1.306
HORIZONTAL SPREAD	:	2.913	2.077	2.077
VERTICAL SPREAD	:	2.067	2.067	2.067
EXTREME SPREAD	:	2.942	2.356	2.356
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

22 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08636034

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in - 0

2in - 4

3in - 8

HS- 2.562

VS- 3.083

GS- 3.424

CENTROID *

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.390	1.497	1.363
MINIMUM X	-1.172	-1.065	-1.125
MAXIMUM Y	1.254	1.051	.882
MINIMUM Y	-1.829	-1.352	-.856
CENTROID X	.002	-.105	.029
CENTROID Y	.194	.397	.566
POA TO CENTROID in.	.194	.411	.567
MIN RADIUS	.601	.395	.475
MEAN RADIUS	1.218	1.085	.978
MAX RADIUS	2.065	1.722	1.413
HORIZONTAL SPREAD	2.562	2.562	2.488
VERTICAL SPREAD	3.083	2.463	1.738
EXTREME SPREAD	3.424	2.819	2.540
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		8	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636034
25 Jul 1991

CENTROIDAL DISTANCES

0 TO	1	.152742
1 TO	2	.290062
1 TO	3	.369935
1 TO	4	.366706
1 TO	5	.184567

24 4 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0378
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0058
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0392494
THE AMR FOR THIS RIFLE IS: .8998

25 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636034.1

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 8

HS= 2.449

VS= 2.724

GS= 3.015

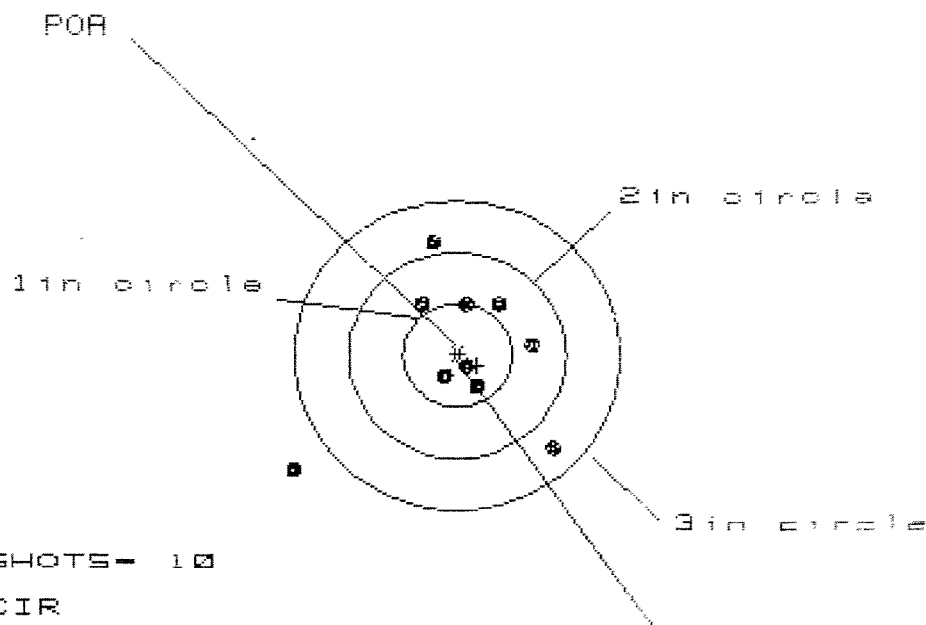
CENTROID *

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.471	.967	1.010
MINIMUM X	:	-.978	-.815	-.772
MAXIMUM Y	:	.992	.895	.693
MINIMUM Y	:	-1.732	-1.622	-.811
CENTROID X	:	.109	-.054	-.097
CENTROID Y	:	.107	-.003	.199
POA TO CENTROID in.	:	.153	.054	.222
MIN RADIUS	:	.250	.174	.064
MEAN RADIUS	:	.981	.862	.725
MAX RADIUS	:	1.774	1.657	1.225
HORIZONTAL SPREAD	:	2.449	1.782	1.792
VERTICAL SPREAD	:	2.724	2.517	1.584
EXTREME SPREAD	:	3.015	2.593	2.261
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	8		

25 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636034.1

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 9

HS= 2.425

VS= 2.193

GS= 2.516

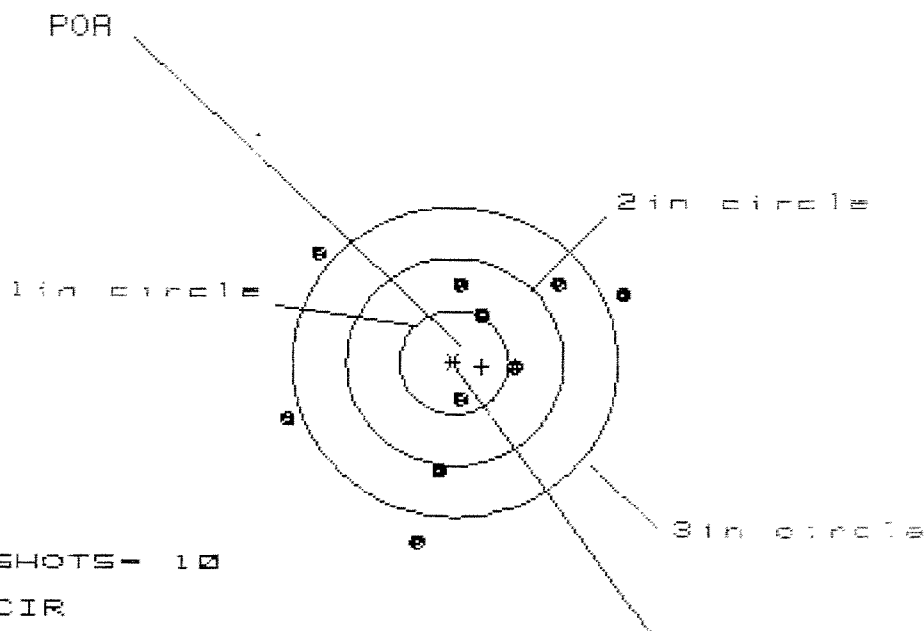
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.926	.759	.682
MINIMUM X	:	-1.499	-.529	-.434
MAXIMUM Y	:	1.139	1.022	.894
MINIMUM Y	:	-1.054	-1.030	-.581
CENTROID X	:	-.181	-.014	-.109
CENTROID Y	:	.101	.218	.346
POA TO CENTROID in.	:	.207	.218	.363
MIN RADIUS	:	.136	.243	.221
MEAN RADIUS	:	.744	.611	.519
MAX RADIUS	:	1.832	1.279	.955
HORIZONTAL SPREAD	:	2.425	1.288	1.036
VERTICAL SPREAD	:	2.193	2.052	1.475
EXTREME SPREAD	:	2.516	2.373	1.537
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

25 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636034.1

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 1

2in = 4

3in = 6

HS = 3.161

VS = 2.847

GS = 3.369

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.591	1.551	1.692
MINIMUM X	:	-1.570	-1.610	-1.416
MAXIMUM Y	:	1.070	.873	.927
MINIMUM Y	:	-1.777	-1.194	-1.140
CENTROID X	:	-.255	-.215	-.409
CENTROID Y	:	.041	.238	.184
POA TO CENTROID in.	:	.258	.321	.446
MIN RADIUS	:	.338	.382	.514
MEAN RADIUS	:	1.123	1.026	.976
MAX RADIUS	:	1.812	1.769	1.570
HORIZONTAL SPREAD	:	3.161	3.161	2.508
VERTICAL SPREAD	:	2.847	2.067	2.067
EXTREME SPREAD	:	3.369	3.369	2.805
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	6		

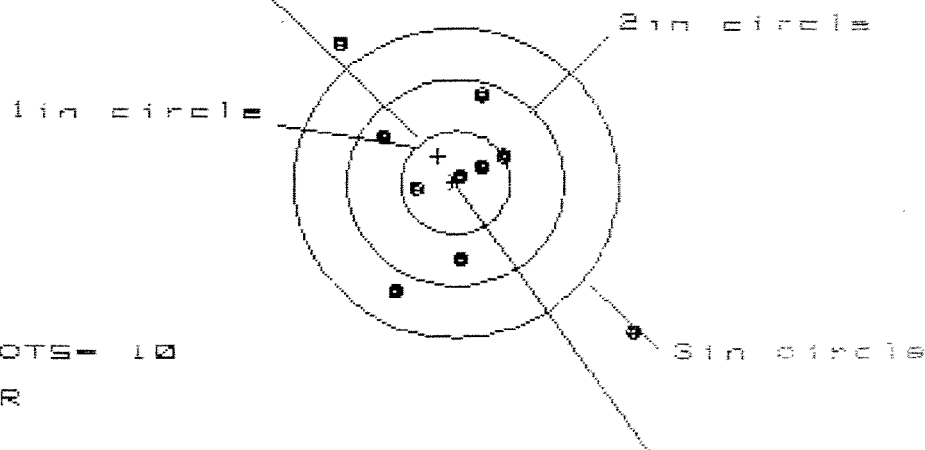
25 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636034.1

CENTERFIRE PATTERNS

4

FOR



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 8

HS= 2.732

VS= 2.811

GS= 3.920

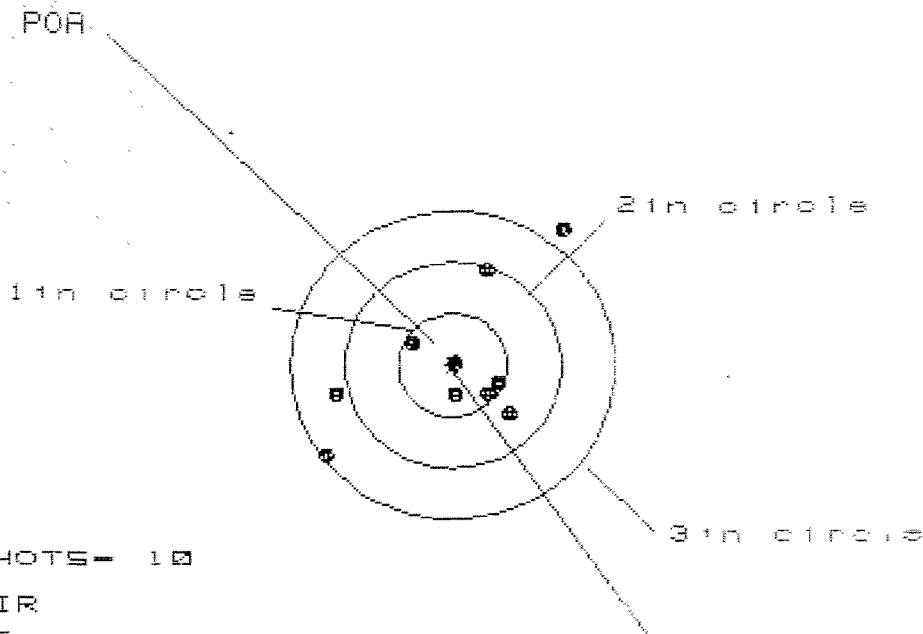
CENTROID #

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.650	.604	.482
MINIMUM X	-1.082	-.899	-.582
MAXIMUM Y	1.405	1.249	.888
MINIMUM Y	-1.406	-1.235	-1.079
CENTROID X	.161	-.022	.090
CENTROID Y	-.256	-.100	-.256
FOR TO CENTROID in.	.303	.103	.272
MIN RADIUS	.105	.227	.145
MEAN RADIUS	.884	.742	.617
MAX RADIUS	2.168	1.539	1.167
HORIZONTAL SPREAD	2.732	1.503	1.054
VERTICAL SPREAD	2.811	2.484	1.907
EXTREME SPREAD	3.920	2.548	2.112
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		

25 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6638034.1

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 5

2in = 7

3in = 9

HS= 2.199

VS= 2.260

GS= 3.153

CENTROID *

PATTERN #	:	5		
SHOT# (BEST OF)	:	10	9	8
MAXIMUM X	:	1.038	.675	.544
MINIMUM X	:	-1.161	-1.045	-1.128
MAXIMUM Y	:	1.347	1.042	.947
MINIMUM Y	:	-.913	-.753	-.439
CENTROID X	:	-.023	-.138	-.087
CENTROID Y	:	-.022	-.172	-.077
POR TO CENTROID in.	:	.022	.220	.077
MIN RADIUS	:	.019	.177	.038
MEAN RADIUS	:	.767	.666	.553
MAX RADIUS	:	1.701	1.294	1.145
HORIZONTAL SPREAD	:	2.199	1.720	1.672
VERTICAL SPREAD	:	2.260	1.805	1.385
EXTREME SPREAD	:	3.153	2.326	1.826
NUMBER IN ONE INCH CIRCLE =			5	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			9	