

C6636035

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.

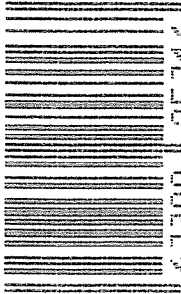
MODEL 700<sup>TM</sup> H24

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

SERIAL NO.  
C6636035

ORDER NO.  
5716

UPC



0 4700 25716



5716 C6636035

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636035

| OP. #        | OP. NAME                                                       | READINGS | DATE    | INIT |
|--------------|----------------------------------------------------------------|----------|---------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   | 4 30     | 91      | RW   |
| 600          | Proof                                                          | 4 30     | 91      | RW   |
| 607          | Check Headspace                                                | 4 30     | 91      | RW   |
| 610          | Dis-assemble Gun                                               |          |         | RW   |
| 612          | Magnaflux Barrel<br>Action                                     | 5 6 9    | 91      | IKed |
|              | Magnaflux Bolt                                                 | 5 6 9    | 91      | IKed |
| 615          | Rollmark Caliber                                               |          |         | GB   |
| 617          | Drill and Tap Sight Holes                                      | 5 10     | 91      | LB   |
| 618          | Polish Barrel                                                  | 5 10     | 91      | LB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 5-30-91 | DA   |
|              | Apply Coating (Bolt)                                           |          | 5-30-91 | DA   |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 6/19/91 | RW   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 6/19/91 | RW   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 6/19/91 | RW   |
|              | D) Oil Firing Pin Ass'y                                        |          | 6/19/91 | RW   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 7-16-91 | RY   |

| op. #        | OP. NAME                                                    | READINGS |       |       |      |      | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|-------|-------|------|------|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 6        | 6     | 6     |      |      | 7-17-91 | JA   |
|              | G) Safety Off Force                                         | 4        | 4     | 4     |      |      | 7-17-91 | JA   |
|              | H) Trigger Pull Test & Retainability                        |          |       |       |      |      | 7-16-91 | JA   |
|              | I) Firing Pin Indent                                        | .0225    | .0225 | .0225 |      |      | 7-17-91 | JA   |
|              | J) Assemble Stock                                           |          |       |       |      |      | 7/18/91 | RW   |
|              | K) Assemble Swivel Studs                                    |          |       |       |      |      | 7-23-91 | D/H  |
|              | L) Attach Front and Rear Sight Assemblies                   |          |       |       |      |      | 7/18/91 | RW   |
|              | M) Iron Sight Alignment                                     |          |       |       |      |      | 7/18/91 | RW   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |       |       |      |      | 7/18/91 | RW   |
|              | O) Attach Scope to Rifle                                    |          |       |       |      |      | 7/18/91 | RW   |
|              | P) Detach & Attach Scope 20 Times                           |          |       |       |      |      | 7/18/91 | RW   |
| 640          | Gallery Target & Test                                       |          |       |       |      |      | 7-22-91 | AC   |
|              | A) Time                                                     |          |       |       |      |      | 7-22-91 | AC   |
|              | B) Malfunctions                                             |          |       |       |      |      | 7-22-91 | AC   |
|              | C) Pierced Primers                                          |          |       |       |      |      | 7-22-91 | AC   |
|              | D) Optical Clarity of Scope                                 |          |       |       |      |      | 7-22-91 | AC   |
| 645          | Inspect for Live Ammo                                       |          |       |       |      |      | 7-22-91 | AC   |
| 655          | Final Inspection                                            |          |       |       |      |      |         |      |
|              | A) Headspace                                                |          |       |       |      |      | 7-23-91 | D/H  |
|              | B) Trigger Pull                                             | 2.47     | 2.47  | 2.49  | 2.52 | 2.53 | 7-23-91 | JA   |
|              | C) Function                                                 |          |       |       |      |      | 7-23-91 | D/H  |
| 660          | Pack                                                        |          |       |       |      |      | 9-18-91 | JA   |

SWS TRIGGER PULL TEST

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

SERIAL NO. 0-6636035  
DATE 7-16-91  
TESTER SP

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.30             | 2.53                     | 2.40                           | 2.47 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.30             | 2.20                     | 2.48                           | 2.47 |                                                                        |
| PULL #3 | 2.21             | 2.47                     | 2.40                           | 2.49 |                                                                        |
| PULL #4 | 2.22             | 2.43                     | 2.46                           | 2.52 |                                                                        |
| PULL #5 | 2.25             | 2.44                     | 2.43                           | 2.53 |                                                                        |
| TOTAL   |                  |                          |                                |      |                                                                        |
| AVG.    |                  |                          |                                |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.62             | 3.31                     |  |          |
| PULL #2 | 3.49             | 3.56                     |  |          |
| PULL #3 | 3.55             | 3.57                     |  |          |
| PULL #4 | 3.55             | 3.61                     |  |          |
| PULL #5 | 3.54             | 3.39                     |  |          |
| TOTAL   |                  |                          |  |          |
| AVG.    |                  |                          |  |          |

|         | 4.00#<br>INITIAL | 4.00# AFTER<br>20 CYCLES | MAX SETTING<br>GREATER THAN 4# | RESET TO 4# FOR<br>TARGET & ACCURACY |
|---------|------------------|--------------------------|--------------------------------|--------------------------------------|
| PULL #1 | 4.32             | 4.25                     |                                | 4.53                                 |
| PULL #2 | 4.21             | 4.51                     |                                | 4.47                                 |
| PULL #3 | 4.38             | 4.52                     |                                | 4.41                                 |
| PULL #4 | 4.15             | 4.49                     |                                | 4.28                                 |
| PULL #5 | 4.21             | 4.41                     |                                | 4.46                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6636035  
23 Jul 1991

CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| 0 TO | 1 | .115261 |
| 1 TO | 2 | .263594 |
| 1 TO | 3 | .448028 |
| 1 TO | 4 | .57014  |
| 1 TO | 5 | .200569 |

424 <---POA

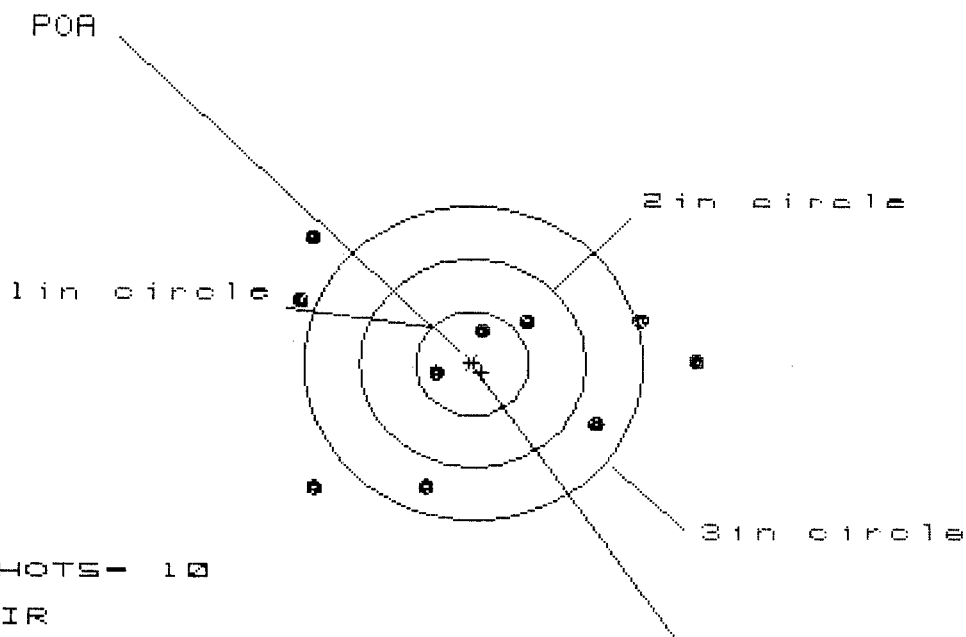
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1844  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0352  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .18773  
  
THE AMR FOR THIS RIFLE IS: 1.124

22 Jul 1991

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# CENTERFIRE PATTERNS

# 1



# OF SHOTS- 10

# IN CIR

1in = 2

2in = 3

3in = 5

HS= 3.472

VS= 2.411

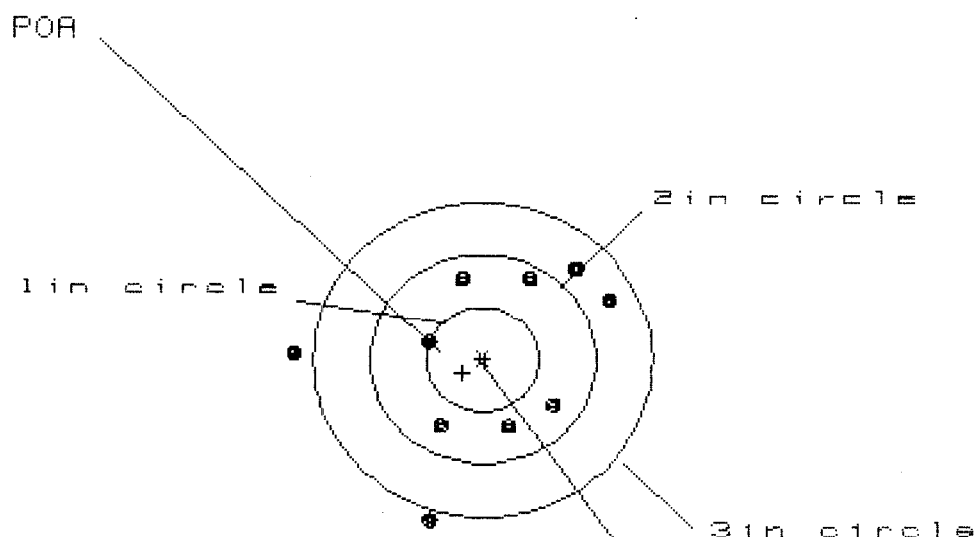
GS= 3.588

| PATTERN #                   | : | 1      | 9      | 8      |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.955  | 1.659  | 1.507  |
| MINIMUM X                   | : | -1.517 | -1.300 | -1.452 |
| MAXIMUM Y                   | : | 1.205  | 1.209  | .753   |
| MINIMUM Y                   | : | -1.206 | -1.202 | -1.051 |
| CENTROID X                  | : | -.081  | -.298  | -.146  |
| CENTROID Y                  | : | .082   | .078   | -.073  |
| POA TO CENTROID in.         | : | .115   | .308   | .163   |
| MIN RADIUS                  | : | .303   | .113   | .271   |
| MEAN RADIUS                 | : | 1.256  | 1.170  | 1.100  |
| MAX RADIUS                  | : | 1.955  | 1.724  | 1.663  |
| HORIZONTAL SPREAD           | : | 3.472  | 2.959  | 2.959  |
| VERTICAL SPREAD             | : | 2.411  | 2.411  | 1.804  |
| EXTREME SPREAD              | : | 3.588  | 3.261  | 3.261  |
| NUMBER IN ONE INCH CIRCLE   | = | 2      |        |        |
| NUMBER IN TWO INCH CIRCLE   | = | 3      |        |        |
| NUMBER IN THREE INCH CIRCLE | = | 5      |        |        |

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# CENTERFIRE PATTERNS # 2



# OF SHOTS- 10

# IN CIR

1 in - 1

2 in - 6

3 in - 8

HS- 2.763

VS- 2.465

GS- 2.805

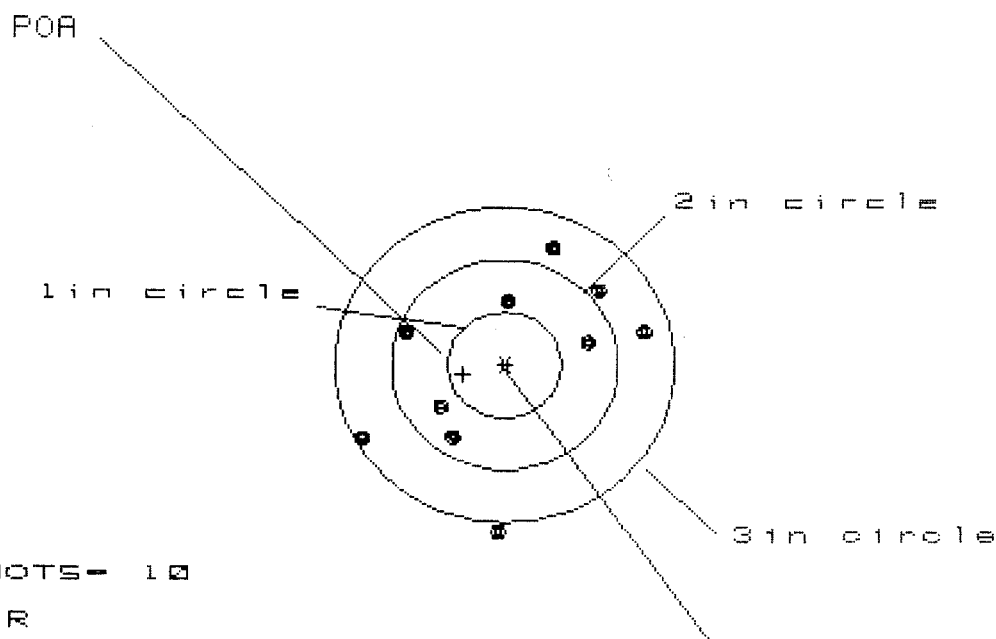
| PATTERN #                   | : | 2      |        |       |
|-----------------------------|---|--------|--------|-------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | 1.087  | .901   | .815  |
| MINIMUM X                   | : | -1.676 | -.691  | -.703 |
| MAXIMUM Y                   | : | .900   | .906   | .711  |
| MINIMUM Y                   | : | -1.565 | -1.559 | -.827 |
| CENTROID X                  | : | .178   | .364   | .450  |
| CENTROID Y                  | : | .131   | .125   | .320  |
| POA TO CENTROID in.         | : | .221   | .385   | .553  |
| MIN RADIUS                  | : | .473   | .560   | .565  |
| MEAN RADIUS                 | : | .994   | .903   | .784  |
| MAX RADIUS                  | : | 1.676  | 1.706  | 1.009 |
| HORIZONTAL SPREAD           | : | 2.763  | 1.592  | 1.518 |
| VERTICAL SPREAD             | : | 2.465  | 2.465  | 1.538 |
| EXTREME SPREAD              | : | 2.805  | 2.781  | 1.883 |
| NUMBER IN ONE INCH CIRCLE   | = | 1      |        |       |
| NUMBER IN TWO INCH CIRCLE   | = | 6      |        |       |
| NUMBER IN THREE INCH CIRCLE | = | 8      |        |       |



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# CENTERFIRE PATTERNS # 3



# OF SHOTS- 10

# IN CIR

1 in - 0

2 in - 5

3 in - 9

HS- 2.499

VS= 2.662

GS= 2.707

CENTROID \*

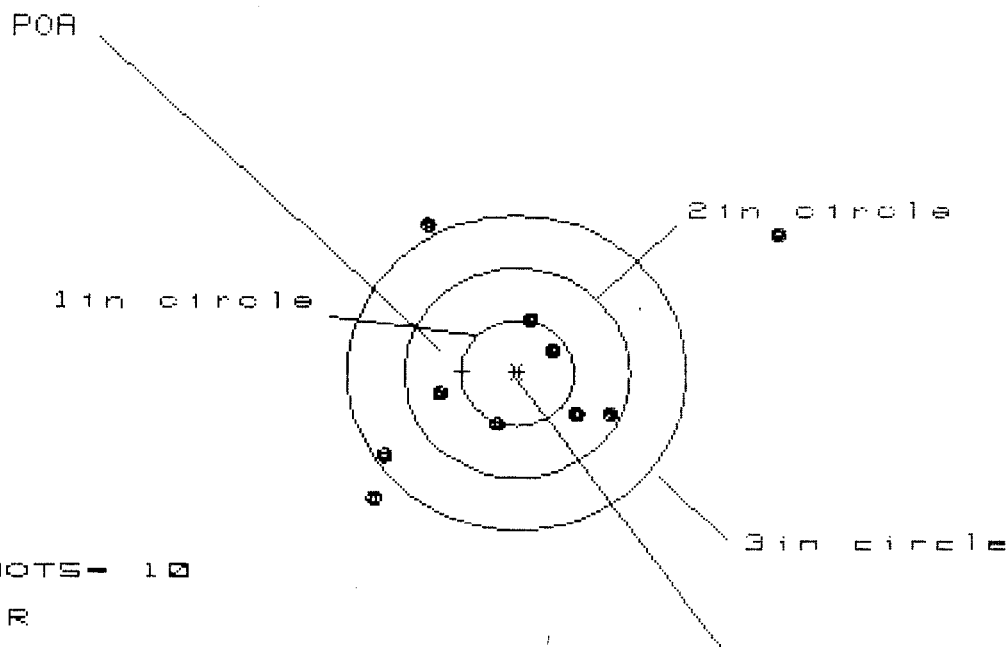
| PATTERN #                   | : | 3      |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.277  | 1.268  | 1.114  |
| MINIMUM X                   | : | -1.222 | -1.231 | -1.017 |
| MAXIMUM Y                   | : | 1.119  | .947   | .846   |
| MINIMUM Y                   | : | -1.543 | -.877  | -.978  |
| CENTROID X                  | : | .367   | .376   | .530   |
| CENTROID Y                  | : | .087   | .259   | .360   |
| POA TO CENTROID in.         | : | .377   | .457   | .641   |
| MIN RADIUS                  | : | .617   | .445   | .366   |
| MEAN RADIUS                 | : | 1.036  | .957   | .863   |
| MAX RADIUS                  | : | 1.545  | 1.476  | 1.167  |
| HORIZONTAL SPREAD           | : | 2.499  | 2.499  | 2.131  |
| VERTICAL SPREAD             | : | 2.662  | 1.824  | 1.824  |
| EXTREME SPREAD              | : | 2.707  | 2.658  | 2.131  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 0      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 5      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |        |

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# CENTERFIRE PATTERNS

# 4



# OF SHOTS- 10

# IN CIR

1 in - 2

2 in - 6

3 in - 7

HS- 3.589

VS- 2.553

GS- 4.345

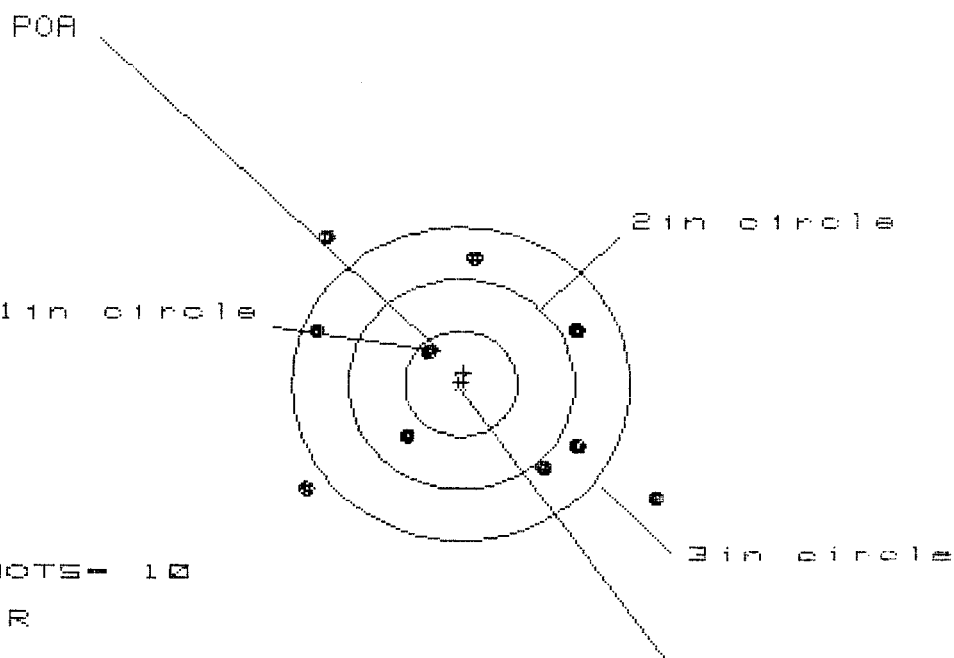
CENTROID \*

| PATTERN #                   | : | 4      |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 2.323  | 1.064  | .938   |
| MINIMUM X                   | : | -1.266 | -1.008 | -1.087 |
| MAXIMUM Y                   | : | 1.397  | 1.541  | 1.415  |
| MINIMUM Y                   | : | -1.155 | -1.012 | -.782  |
| CENTROID X                  | : | .481   | .223   | .349   |
| CENTROID Y                  | : | -.014  | -.158  | -.032  |
| POA TO CENTROID in.         | : | .481   | .274   | .351   |
| MIN RADIUS                  | : | .327   | .337   | .448   |
| MEAN RADIUS                 | : | 1.090  | .905   | .824   |
| MAX RADIUS                  | : | 2.659  | 1.613  | 1.538  |
| HORIZONTAL SPREAD           | : | 3.589  | 2.072  | 2.025  |
| VERTICAL SPREAD             | : | 2.553  | 2.553  | 2.197  |
| EXTREME SPREAD              | : | 4.345  | 2.608  | 2.340  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 6      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 7      |        |

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# CENTERFIRE PATTERNS # 5



# OF SHOTS - 10

# IN CIR

1in - 1

2in - 2

3in - 7

HS - 3.125

VS - 2.475

GS - 3.798

CENTROID #

|                             |   |        |        |        |
|-----------------------------|---|--------|--------|--------|
| PATTERN #                   | : | 5      |        |        |
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.736  | 1.205  | 1.086  |
| MINIMUM X                   | : | -1.389 | -1.197 | -1.316 |
| MAXIMUM Y                   | : | 1.432  | 1.317  | 1.209  |
| MINIMUM Y                   | : | -1.042 | -1.096 | -.932  |
| CENTROID X                  | : | -.023  | -.215  | -.096  |
| CENTROID Y                  | : | -.110  | .006   | -.158  |
| POA TO CENTROID in.         | : | .112   | .216   | .185   |
| MIN RADIUS                  | : | .364   | .169   | .365   |
| MEAN RADIUS                 | : | 1.244  | 1.132  | 1.070  |
| MAX RADIUS                  | : | 2.025  | 1.625  | 1.612  |
| HORIZONTAL SPREAD           | : | 3.125  | 2.402  | 2.402  |
| VERTICAL SPREAD             | : | 2.475  | 2.413  | 2.141  |
| EXTREME SPREAD              | : | 3.798  | 2.960  | 2.797  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 1      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 2      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 7      |        |