

C6636040

MODEL 700™ M24

Model **SMS**™

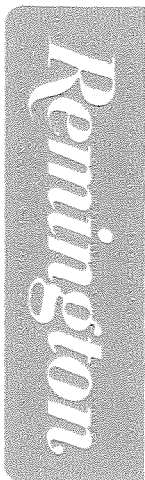
Action

Barrel Length

Capacity

Order No. **5716**

\*Includes 1 in chamber.





MODEL 700<sup>TH</sup> H24



REG. U.S. PAT. & TM. OFF.

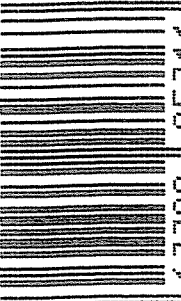
VERY IMPORTANT:  
Instruction Book  
enclosed to assure  
safe use of this  
firearm.

SERIAL NO.  
C6636040

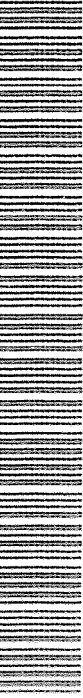
ORDER NO.  
5716

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

UPC



0 47700 25716 7



5716 C6636040

MOD. \_\_\_\_\_ GA. CAL. \_\_\_\_\_ GUN # 6040

| #<br>TEST | DATE | MALFUNCTION/DEFECT                       | ASSEM.<br>#   |
|-----------|------|------------------------------------------|---------------|
| NF        | 1st  | B.H. Hits Stock                          | KS            |
|           | 6/14 | Ejector Very Hard<br>Bolt Release Sticks |               |
|           | 2nd  | 100 RD test                              |               |
|           |      | OF<br>6-15-91 DH                         |               |
|           | 3rd  |                                          |               |
|           |      |                                          |               |
|           | 4th  |                                          |               |
|           |      |                                          |               |
|           |      | FUNCTION                                 | RD 6654 Rev 1 |

| TEST INIT. ACTION TO CORRECT |          | ASSEM.<br># |
|------------------------------|----------|-------------|
| PROOF                        |          |             |
| TEST                         |          |             |
| TGT                          |          |             |
| PROOF                        |          |             |
| TEST                         |          |             |
| TGT                          |          |             |
| PROOF                        | ENGINEER |             |
| TEST                         |          |             |
| TGT                          |          |             |
| PROOF                        | ENGINEER |             |
| TEST                         |          |             |
| TGT                          |          |             |

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636040

| OP. #        | OP. NAME                                                       | READINGS | DATE    | INIT |
|--------------|----------------------------------------------------------------|----------|---------|------|
| 575 &<br>580 | Assemble Action<br>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<br>Action                                     | 5 8 9 1  |         | KCR  |
|              | Magnaflux Bolt                                                 | 5 8 9 1  |         | KCR  |
| 615          | Rollmark Caliber                                               | 5 8 9 1  |         | GS   |
| 617          | Drill and Tap Sight Holes                                      | 5 15 9 1 |         | LB   |
| 618          | Polish Barrel                                                  | 5 15 9 1 |         | WAB  |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 5-31-91 | TH   |
|              | Apply Coating (Bolt)                                           |          |         |      |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 6/11/91 | KS   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 6/11/91 | KS   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 6/11/91 | KS   |
|              | D) Oil Firing Pin Ass'y                                        |          | 6/11/91 | KS   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 6-13-91 | PH   |

| op. #        | OP. NAME                                                    | READINGS |      |       |      |      | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|------|-------|------|------|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 6        | 7    | 6     |      |      | 6-13-91 | DH   |
|              | G) Safety Off Force                                         | 2 1/2    | 3    | 2 1/4 |      |      | 6-13-91 | DH   |
|              | H) Trigger Pull Test & Retainability                        |          |      |       |      |      | 6-13-91 | DH   |
|              | I) Firing Pin Indent                                        | .023     | .020 | .021  |      |      | 6-13-91 | DH   |
|              | J) Assemble Stock                                           |          |      |       |      |      | 4/13/91 | KS   |
|              | K) Assemble Swivel Studs                                    |          |      |       |      |      | 6-15-91 | DH   |
|              | L) Attach Front and Rear Sight Assemblies                   |          |      |       |      |      | 4/13/91 | KS   |
|              | M) Iron Sight Alignment                                     |          |      |       |      |      | 4/13/91 | KS   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |      |       |      |      | 4/13/91 | KS   |
|              | O) Attach Scope to Rifle                                    |          |      |       |      |      | 4/13/91 | KS   |
|              | P) Detach & Attach Scope 20 Times                           |          |      |       |      |      | 4/13/91 | KS   |
| 640          | Gallery Target & Test                                       |          |      |       |      |      | 6-14-91 | NF   |
|              | A) Time                                                     |          |      |       |      |      | "       | NF   |
|              | B) Malfunctions                                             |          |      |       |      |      | "       | NF   |
|              | C) Pierced Primers                                          |          |      |       |      |      | "       | NF   |
|              | D) Optical Clarity of Scope                                 |          |      |       |      |      | "       | NF   |
| 645          | Inspect for Live Ammo                                       |          |      |       |      |      | 6-14-91 | NF   |
| 655          | Final Inspection                                            |          |      |       |      |      | 6-15-91 | DH   |
|              | A) Headspace                                                |          |      |       |      |      |         |      |
|              | B) Trigger Pull                                             | 2.74     | 2.22 | 2.20  | 2.17 | 2.20 | 2-15-91 | JM   |
|              | C) Function                                                 |          |      |       |      |      | 6-15-91 | DH   |
| 660          | Pack                                                        |          |      |       |      |      | 6-20-91 | NF   |

SWS TRIGGER PULL TEST

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

SERIAL NO. CG636040

DATE 6-13-91

TESTER D/H

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.44             | 2.63                     | 2.56                           | 2.24 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.54             | 2.60                     | 2.57                           | 2.22 |                                                                        |
| PULL #3 | 2.46             | 2.59                     | 2.51                           | 2.20 |                                                                        |
| PULL #4 | 2.52             | 2.57                     | 2.57                           | 2.17 |                                                                        |
| PULL #5 | 2.52             | 2.59                     | 2.52                           | 2.20 |                                                                        |
| TOTAL   |                  |                          |                                |      |                                                                        |
| AVG.    |                  |                          |                                |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.01             | 3.48                     |  |          |
| PULL #2 | 3.36             | 3.46                     |  |          |
| PULL #3 | 3.36             | 3.39                     |  |          |
| PULL #4 | 3.34             | 3.26                     |  |          |
| PULL #5 | 3.31             | 3.40                     |  |          |
| 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 | 4.35             | 4.50                     |                                | 4.12                                 |
| PULL #2 | 4.45             | 4.52                     |                                | 4.23                                 |
| PULL #3 | 4.40             | 4.44                     |                                | 4.32                                 |
| PULL #4 | 4.42             | 4.37                     |                                | 4.17                                 |
| PULL #5 | 4.31             | 4.41                     |                                | 4.28                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6636040  
14 Jun 1991

CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| Ø TO | 1 | .201296 |
| 1 TO | 2 | .231398 |
| 1 TO | 3 | .276279 |
| 1 TO | 4 | .215539 |
| 1 TO | 5 | .326931 |

4 <----POA

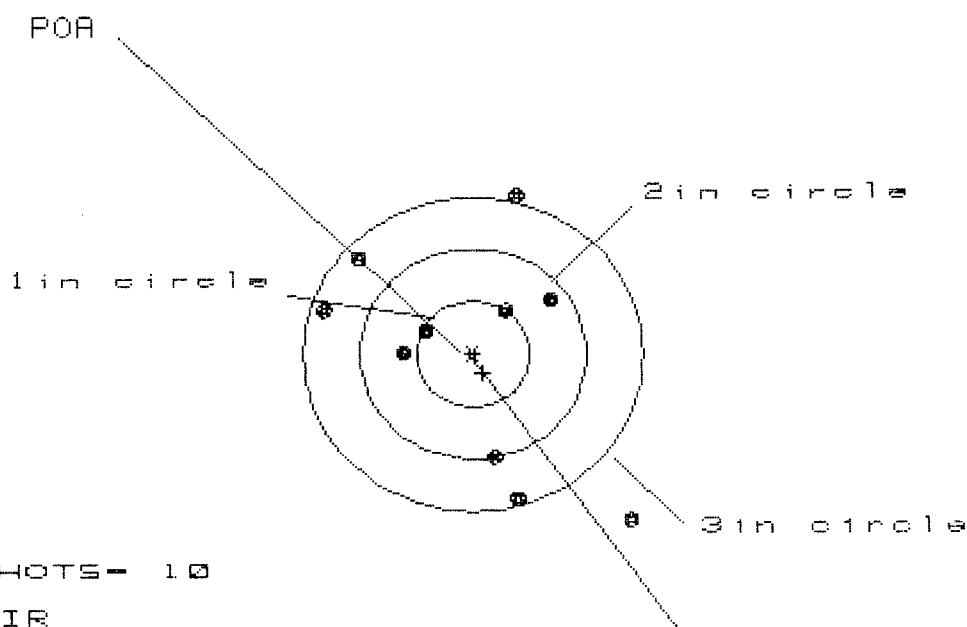
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0514  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0386  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .06428

THE AMR FOR THIS RIFLE IS: 1.068

14 Jun 1991

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# CENTERFIRE PATTERNS # 1



# OF SHOTS- 10

# IN CIR

1 in = 2

2 in = 5

3 in = 8

HS= 2.724

VS= 3.154

GS= 3.480

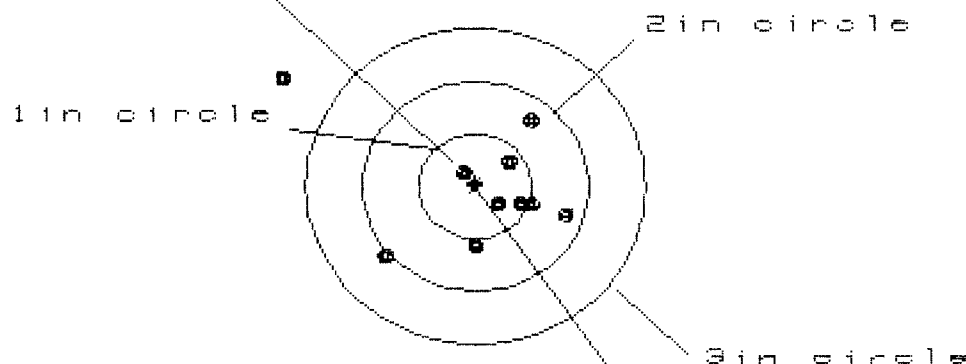
|                             |   |        |        |        |
|-----------------------------|---|--------|--------|--------|
| PATTERN #                   | : | 1      |        |        |
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.410  | .864   | .930   |
| MINIMUM X                   | : | -1.314 | -1.157 | -1.091 |
| MAXIMUM Y                   | : | 1.547  | 1.368  | .895   |
| MINIMUM Y                   | : | -1.607 | -1.562 | -1.391 |
| CENTROID X                  | : | -.086  | -.243  | -.309  |
| CENTROID Y                  | : | .182   | .361   | .189   |
| POA TO CENTROID in.         | : | .201   | .435   | .363   |
| MIN RADIUS                  | : | .455   | .262   | .260   |
| MEAN RADIUS                 | : | 1.131  | .977   | .912   |
| MAX RADIUS                  | : | 2.138  | 1.649  | 1.513  |
| HORIZONTAL SPREAD           | : | 2.724  | 2.021  | 2.021  |
| VERTICAL SPREAD             | : | 3.154  | 2.930  | 2.286  |
| EXTREME SPREAD              | : | 3.480  | 2.930  | 2.666  |
| 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 # 2

POA



# OF SHOTS- 10

# IN CIR

1in = 4

2in = 8

3in = 9

HS= 2.527

VS= 1.725

GS= 2.823

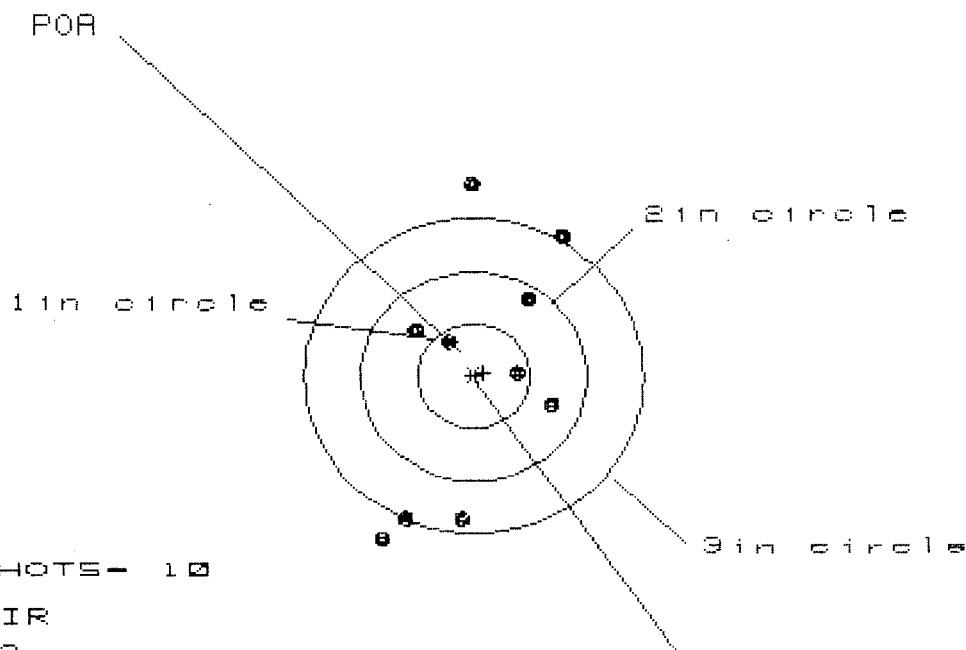
CENTROID #

| PATTERN #                   | : | 2      |       |       |
|-----------------------------|---|--------|-------|-------|
| SHOTS (BEST OF)             | : | 10     | 9     | 8     |
| MAXIMUM X                   | : | .833   | .644  | .523  |
| MINIMUM X                   | : | -1.694 | -.974 | -.433 |
| MAXIMUM Y                   | : | 1.030  | .791  | .719  |
| MINIMUM Y                   | : | -.695  | -.581 | -.558 |
| CENTROID X                  | : | .003   | .192  | .313  |
| CENTROID Y                  | : | -.034  | -.148 | -.076 |
| POA TO CENTROID in.         | : | .034   | .242  | .322  |
| MIN RADIUS                  | : | .155   | .038  | .155  |
| MEAN RADIUS                 | : | .701   | .492  | .402  |
| MAX RADIUS                  | : | 1.983  | 1.134 | .738  |
| HORIZONTAL SPREAD           | : | 2.527  | 1.618 | .956  |
| VERTICAL SPREAD             | : | 1.725  | 1.372 | 1.277 |
| EXTREME SPREAD              | : | 2.823  | 1.865 | 1.379 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 4     |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 8     |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 9     |       |

14 Jun 1991

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# CENTERFIRE PATTERNS # 3



# OF SHOTS- 10

# IN CIR

1in = 2

2in = 5

3in = 7

HS= 1.531

VS= 3.404

GS= 3.487

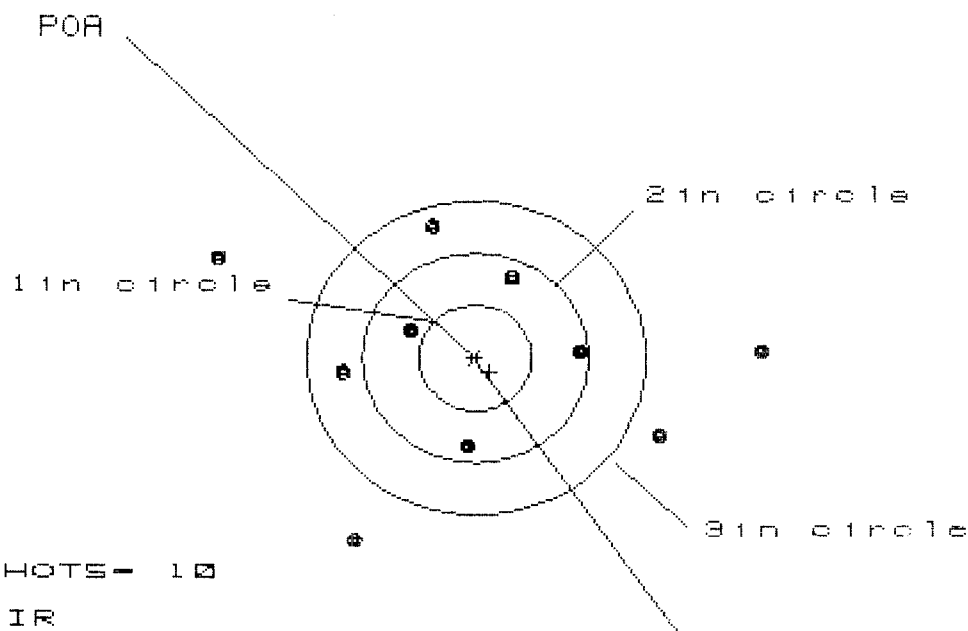
CENTROID \*

|                             |   |        |        |        |
|-----------------------------|---|--------|--------|--------|
| PATTERN #                   | : | 3      |        |        |
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | .749   | .746   | .648   |
| MINIMUM X                   | : | -.782  | -.785  | -.740  |
| MAXIMUM Y                   | : | 1.804  | 1.486  | 1.311  |
| MINIMUM Y                   | : | -1.600 | -1.399 | -1.366 |
| CENTROID X                  | : | -.085  | -.082  | .017   |
| CENTROID Y                  | : | -.035  | -.236  | -.061  |
| POA TO CENTROID in.         | : | .092   | .249   | .063   |
| MIN RADIUS                  | : | .344   | .411   | .248   |
| MEAN RADIUS                 | : | 1.104  | 1.042  | .924   |
| MAX RADIUS                  | : | 1.804  | 1.662  | 1.554  |
| HORIZONTAL SPREAD           | : | 1.531  | 1.531  | 1.388  |
| VERTICAL SPREAD             | : | 3.404  | 2.885  | 2.677  |
| EXTREME SPREAD              | : | 3.487  | 3.266  | 3.015  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 5      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 7      |        |

14 Jun 1991

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# CENTERFIRE PATTERNS # 4



# OF SHOTS - 10

# IN CIR

1in = 0

2in = 4

3in = 6

HS = 4.816

VS = 3.010

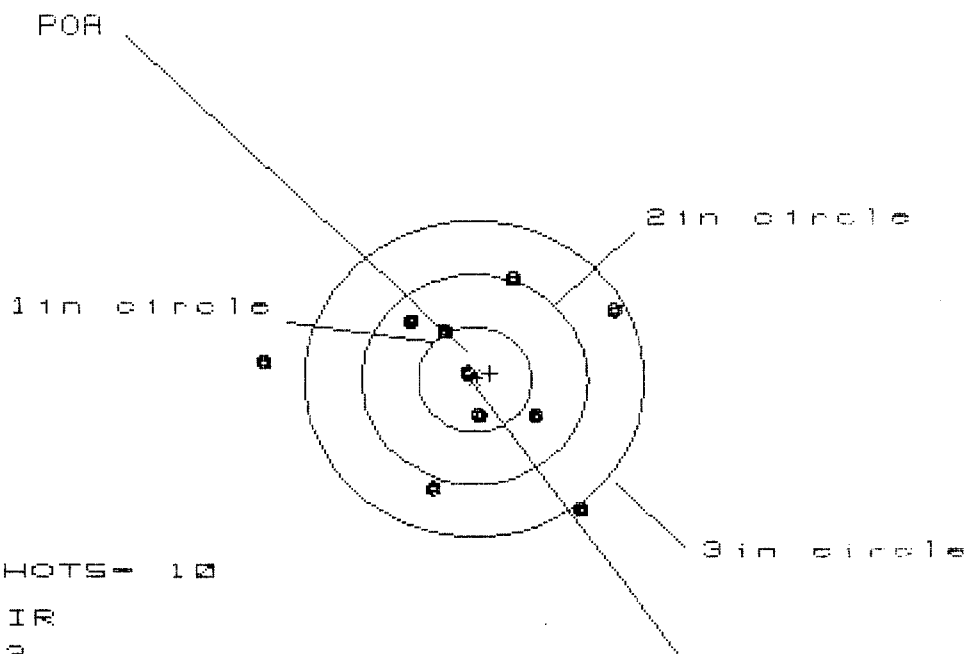
GS = 4.896

| PATTERN #                   | : | 4      |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 2.554  | 1.950  | 1.703  |
| MINIMUM X                   | : | -2.262 | -1.979 | -1.175 |
| MAXIMUM Y                   | : | 1.237  | 1.246  | 1.367  |
| MINIMUM Y                   | : | -1.773 | -1.764 | -1.643 |
| CENTROID X                  | : | -.125  | -.408  | -.161  |
| CENTROID Y                  | : | .138   | .129   | .008   |
| POA TO CENTROID in.         | : | .186   | .428   | .161   |
| MIN RADIUS                  | : | .651   | .427   | .683   |
| MEAN RADIUS                 | : | 1.463  | 1.318  | 1.206  |
| MAX RADIUS                  | : | 2.555  | 2.203  | 1.933  |
| HORIZONTAL SPREAD           | : | 4.816  | 3.929  | 2.878  |
| VERTICAL SPREAD             | : | 3.010  | 3.010  | 3.010  |
| EXTREME SPREAD              | : | 4.896  | 4.263  | 3.085  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 0      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 4      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 6      |        |

14 Jun 1991

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# CENTERFIRE PATTERNS # 5



# OF SHOTS- 10

# IN CIR

1in = 2

2in = 6

3in = 8

HS= 3.196

VS= 2.127

GS= 3.227

CENTROID #

|                               |   |        |        |        |
|-------------------------------|---|--------|--------|--------|
| PATTERN #                     | : | 5      |        |        |
| SHOTS (BEST OF)               | : | 10     | 9      | 8      |
| MAXIMUM X                     | : | 1.284  | 1.071  | 1.162  |
| MINIMUM X                     | : | -1.912 | -.737  | -.646  |
| MAXIMUM Y                     | : | .930   | .950   | .803   |
| MINIMUM Y                     | : | -1.196 | -1.177 | -1.156 |
| CENTROID X                    | : | -.136  | .077   | -.014  |
| CENTROID Y                    | : | -.058  | -.078  | .069   |
| POA TO CENTROID in.           | : | .148   | .109   | .071   |
| MIN RADIUS                    | : | .093   | .267   | .159   |
| MEAN RADIUS                   | : | .941   | .840   | .749   |
| MAX RADIUS                    | : | 1.920  | 1.382  | 1.274  |
| HORIZONTAL SPREAD             | : | 3.196  | 1.808  | 1.808  |
| VERTICAL SPREAD               | : | 2.127  | 2.127  | 1.959  |
| EXTREME SPREAD                | : | 3.227  | 2.364  | 2.364  |
| NUMBER IN ONE INCH CIRCLE =   |   |        | 2      |        |
| NUMBER IN TWO INCH CIRCLE =   |   |        | 6      |        |
| NUMBER IN THREE INCH CIRCLE = |   |        | 8      |        |