

C6636060

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 700TM H24

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

SERIAL NO.
C6636060

ORDER NO.
5716

20

UPC



0 47700 25716 7



5716 C6636060

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636060

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 8 91		RW
600	Proof	4 8 91		RW
607	Check Headspace	4 8 91		RW
610	Dis-assemble Gun	4 8 91		RW
612	Magnaflux Barrel Action	APR 9 1991		KR
	Magnaflux Bolt	APR 9 1991		U
615	Rollmark Caliber	APR 9 1991		JS
617	Drill and Tap Sight Holes	APR 9 1991		LB
618	Polish Barrel	APR 9 1991		WB
620	Apply Coatings (Barrel Action)		5-10-91	DA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/14/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/14/91	RW
	C) Inspect Ejector Hole for Chamfer		5/14/91	RW
	D) Oil Firing Pin Ass'y		5/14/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/25/91	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5-28-91	DH
	G) Safety Off Force	4	4	4			5-28-91	DH
	H) Trigger Pull Test & Retainability						5/25/91	8/1
	I) Firing Pin Indent	.022	.023	.021			5-28-91	DH
	J) Assemble Stock						5/28/91	RW
	K) Assemble Swivel Studs						6-1-91	DH
	L) Attach Front and Rear Sight Assemblies						5/28/91	RW
	M) Iron Sight Alignment						5/28/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/28/91	RW
	O) Attach Scope to Rifle						5/28/91	RW
	P) Detach & Attach Scope 20 Times						5/28/91	RW
640	Gallery Target & Test						5-31-91	AC
	A) Time						5-31-91	AC
	B) Malfunctions						5-31-91	AC
	C) Pierced Primers						5-31-91	AC
	D) Optical Clarity of Scope						5-31-91	AC
645	Inspect for Live Ammo						5-31-91	AC
655	Final Inspection							
	A) Headspace						6-1-91	DH
	B) Trigger Pull	2.37	2.32	2.34	2.42	2.39	6/1/91	DH
	C) Function						6-1-91	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. C6636060
DATE 5/25/91
TESTER JK

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.48	2.25	2.37	2.37	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.63	2.30	2.37	2.32	
PULL #3	2.28	2.18	2.35	2.34	
PULL #4	2.28	2.36	2.28	2.42	
PULL #5	2.35	2.36	2.35	2.39	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.41	3.37		
PULL #2	3.37	3.37		
PULL #3	3.38	3.33		
PULL #4	3.38	3.36		
PULL #5	3.41	3.34		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.28	4.42		4.45
PULL #2	4.42	4.48		4.51
PULL #3	4.43	4.52		4.59
PULL #4	4.51	4.54		4.67
PULL #5	4.55	4.49		4.44
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636060
31 May 1991

CENTROIDAL DISTANCES

0 TO	1	.244616
1 TO	2	.393249
1 TO	3	.14798
1 TO	4	.43007
1 TO	5	.0982549

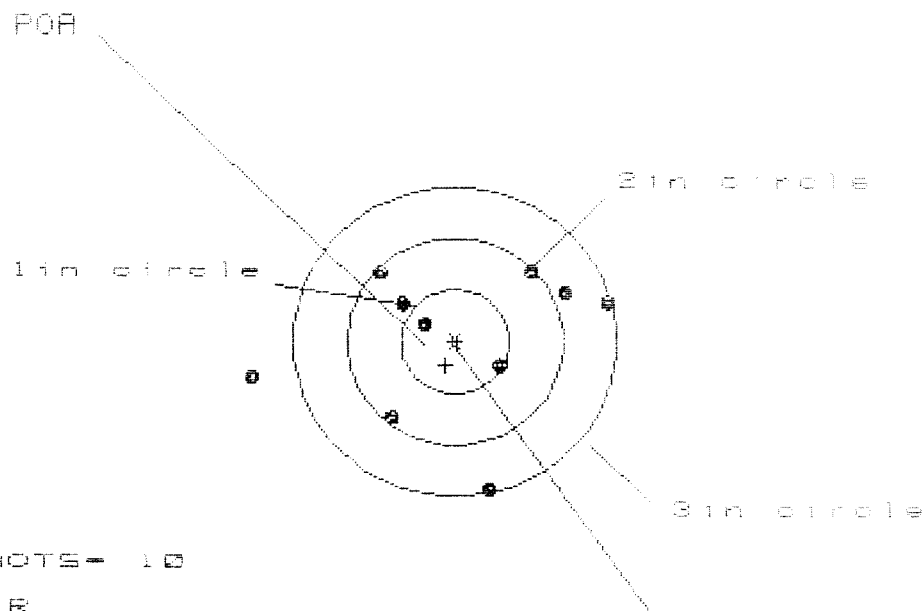
 4 ---- POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1552
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0962
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .182596
THE ANP FOR THIS RIFLE IS: .6452

31 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8B35060

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.202

VS= 2.089

GS= 3.361

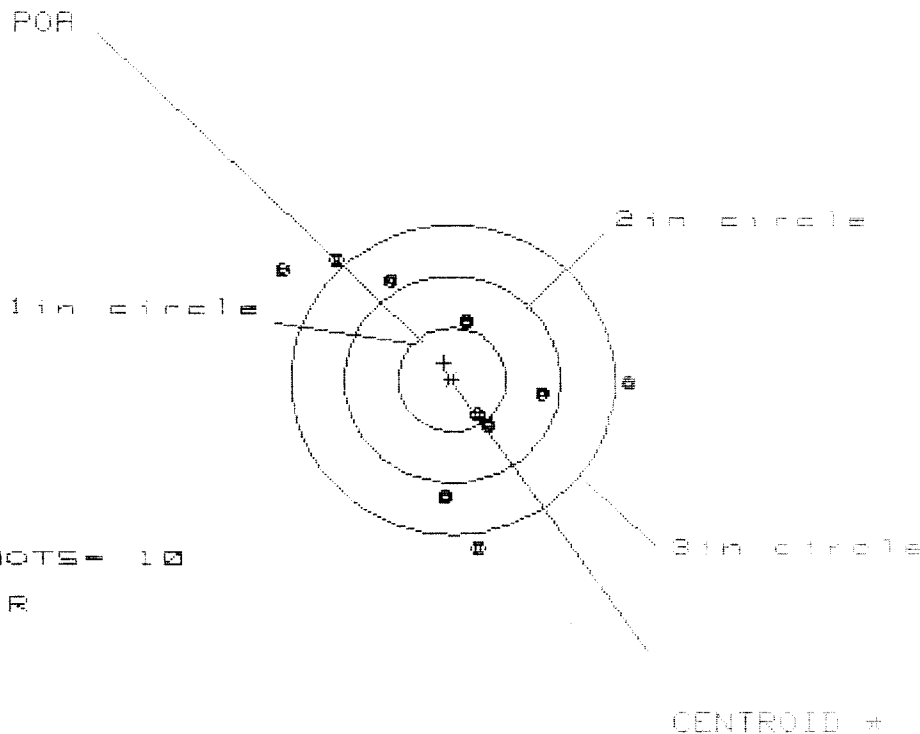
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.460	1.255	.988
MINIMUM X	:	-1.842	-1.871	-.714
MAXIMUM Y	:	.643	.611	.650
MINIMUM Y	:	-1.446	-1.478	-1.439
CENTROID X	:	.086	.291	.134
CENTROID Y	:	.229	.261	.222
POA TO CENTROID in.	:	.245	.391	.260
MIN RADIUS	:	.343	.279	.371
MEAN RADIUS	:	1.020	.918	.856
MAX RADIUS	:	1.865	1.482	1.464
HORIZONTAL SPREAD	:	3.362	2.126	1.702
VERTICAL SPREAD	:	2.089	2.089	2.089
EXTREME SPREAD	:	3.361	2.315	2.309
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			9	

31 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06635000

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 6

HS= 3.126

VS= 2.788

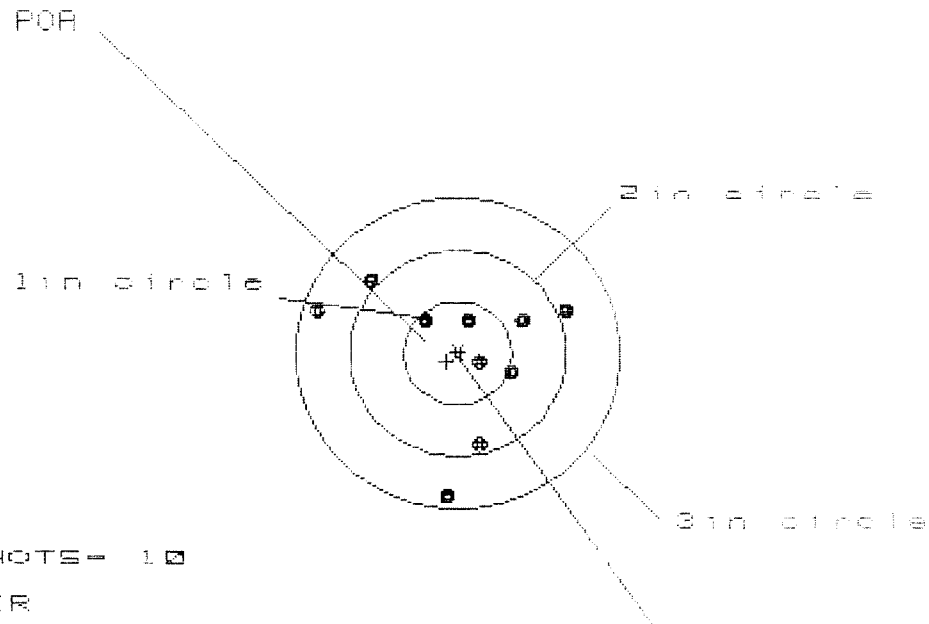
GS= 3.337

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.601	1.430	1.432
MINIMUM X	:	-1.535	-1.253	-1.251
MAXIMUM Y	:	1.124	1.243	1.050
MINIMUM Y	:	-1.664	-1.545	-1.185
CENTROID X	:	.072	.243	.241
CENTROID Y	:	-.164	-.283	-.090
POA TO CENTROID IN.	:	.179	.373	.257
MIN RADIUS	:	.402	.225	.417
MEAN RADIUS	:	1.128	.997	.944
MAX RADIUS	:	1.872	1.765	1.633
HORIZONTAL SPREAD	:	3.136	2.683	2.683
VERTICAL SPREAD	:	2.788	2.788	2.235
EXTREME SPREAD	:	3.337	3.064	2.937
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			4	
NUMBER IN THREE INCH CIRCLE =			6	

31 May 1981

FILE:/PATTERNING/CENTERFIRE_PATT/08638080

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 10

HS= 2.225

VS= 2.041

GS= 2.225

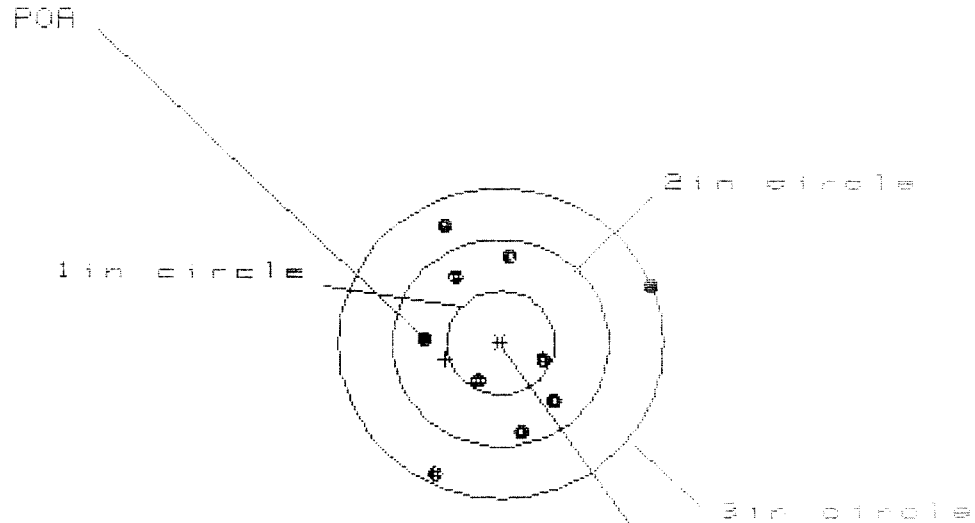
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.953	.942	.781
MINIMUM X	:	-1.272	-1.283	-1.989
MAXIMUM Y	:	.694	.544	.577
MINIMUM Y	:	-1.347	-1.017	-1.984
CENTROID X	:	.103	.114	.275
CENTROID Y	:	.082	.232	.199
POR TO CENTROID in.	:	.132	.259	.339
MIN RADIUS	:	.160	.131	.176
MEAN RADIUS	:	.776	.691	.591
MAX RADIUS	:	1.351	1.310	1.145
HORIZONTAL SPREAD	:	2.225	2.225	1.770
VERTICAL SPREAD	:	2.041	1.561	1.561
EXTREME SPREAD	:	2.225	2.225	1.980
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

31 May 1981

FILE:/PATTERNING/CENTERFIRE_PATT/08636860

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS= 2.134

VS= 2.361

GS= 2.690

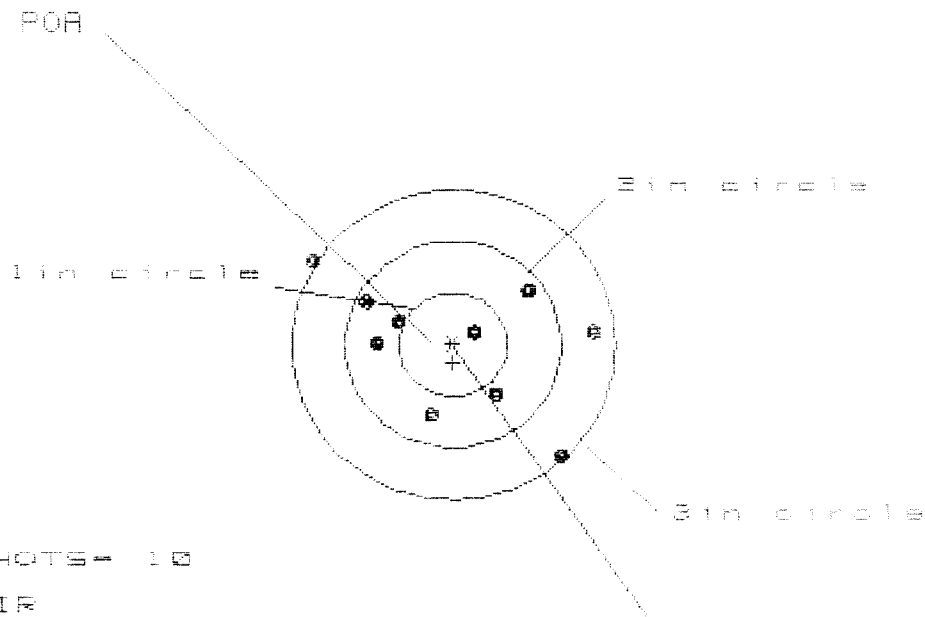
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.387	.682	.623
MINIMUM X	:	-.747	-.593	-.652
MAXIMUM Y	:	1.141	1.204	1.059
MINIMUM Y	:	-1.220	-1.157	-.983
CENTROID X	:	.510	.356	.415
CENTROID Y	:	.157	.094	.239
POA TO CENTROID (in.)	:	.534	.369	.479
MIN RADIUS	:	.453	.347	.502
MEAN RADIUS	:	.901	.822	.764
MAX RADIUS	:	1.498	1.268	1.154
HORIZONTAL SPREAD	:	2.134	1.275	1.275
VERTICAL SPREAD	:	2.361	2.361	2.042
EXTREME SPREAD	:	2.690	2.362	2.162
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			10	

31 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636888

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 2

3in = 7

HS= 2.670

VS= 1.895

GS= 2.982

CENTROID *

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.340	1.193	1.296
MINIMUM X	-1.330	-0.995	-0.892
MAXIMUM Y	.844	.594	.475
MINIMUM Y	-1.051	-0.958	-0.795
CENTROID X	.005	.152	.049
CENTROID Y	.177	.084	.203
POA TO CENTROID in.	.177	.174	.209
MIN RADIUS	.221	.219	.169
MEAN RADIUS	.901	.821	.748
MAX RADIUS	1.575	1.264	1.301
HORIZONTAL SPREAD	2.670	2.188	2.188
VERTICAL SPREAD	1.895	1.552	1.210
EXTREME SPREAD	2.982	2.316	2.201
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		