

C6636077

MODEL 700™ M24

Model **SMS**™

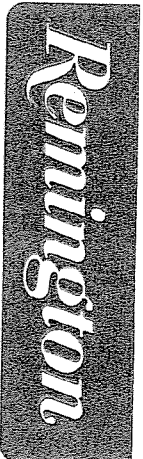
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.





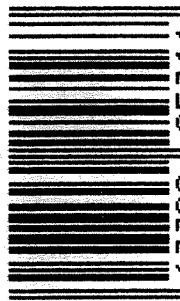

VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700™ H24	SERIAL NO. C6636077
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.	ORDER NO. 5716



5716 C6636077

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6636077

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		4/3/91	K.S.
600	Proof		4/3/91	K.S.
607	Check Headspace		4/3/91	K.S.
610	Dis-assemble Gun		4/3/91	K.S.
612	Magnaflux Barrel Action		4/10/91	KR
	Magnaflux Bolt		4/10/91	U
615	Rollmark Caliber		4/10/91	LS
617	Drill and Tap Sight Holes		APR 19 1991	LB
618	Polish Barrel		APR 19 1991	WB
620	Apply Coatings (Barrel Action)		5-10-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/22/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/22/91	KS
	C) Inspect Ejector Hole for Chamfer		5/22/91	KS
	D) Oil Firing Pin Ass'y		5/22/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		5/23/91	KS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5/23/91	SL
	G) Safety Off Force	3	3	3			5/23/91	SL
	H) Trigger Pull Test & Retainability						6/23/91	SL
	I) Firing Pin Indent	.0235	.0225	.0225			5/23/91	SL
	J) Assemble Stock						5/24/91	KS
	K) Assemble Swivel Studs						6-1-91	D/H
	L) Attach Front and Rear Sight Assemblies						5/24/91	KS
	M) Iron Sight Alignment						5/24/91	KS
	N) Detach Front & Rear Sights & place in numbered container						5/24/91	KS
	O) Attach Scope to Rifle						5/24/91	KS
	P) Detach & Attach Scope 20 Times						5/24/91	KS
640	Gallery Target & Test						5-28-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						5-28-91	AF
655	Final Inspection							
	A) Headspace						6-1-91	D/H
	B) Trigger Pull	2.70	2.74	2.73	2.76	2.77	6/1/91	SL
	C) Function						6-1-91	D/H
660	Pack						6-30-91	AF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO C6636077

DATE 5/23/91

TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.26	2.38	2.70	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.21	2.49	2.46	2.74	
PULL #3	2.25	2.34	2.33	2.73	
PULL #4	2.48	2.27	2.38	2.76	
PULL #5	2.46	2.60	2.43	2.77	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.33	3.32		
PULL #2	3.29	3.33		
PULL #3	3.25	3.33		
PULL #4	3.28	3.32		
PULL #5	3.25	3.35		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.43	4.42		4.48
PULL #2	4.37	4.41		4.52
PULL #3	4.32	4.48		4.49
PULL #4	4.41	4.50		4.53
PULL #5	4.43	4.45		4.50
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636077
28 May 1991

CENTROIDAL DISTANCES

0 TO	1	.0769675
1 TO	2	.152053
1 TO	3	.20301
1 TO	4	.234955
1 TO	5	.174264

←----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1014
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0372
THE SEED, THE AVERAGE POI RADIUS FOR THIS RIFLE IS: .1000
THE AVERAGE POI RADIUS FOR THIS RIFLE IS: 1.03

28 May 1991

FILE://PATTERNING/CENTERFIRE_PATT/C6636077

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 4

2 in = 5

3 in = 6

HS = 2.964

VS = 4.660

GS = 4.809

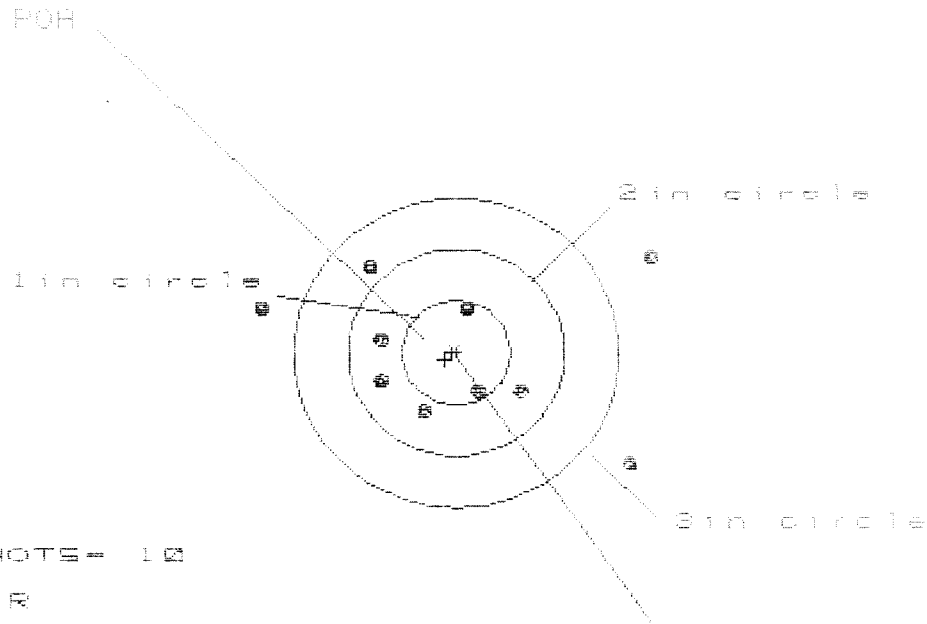
CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.286	1.317	1.207
MINIMUM X	:	-1.678	-1.647	-1.757
MAXIMUM Y	:	2.655	1.074	.861
MINIMUM Y	:	-2.006	-1.711	-1.422
CENTROID X	:	.032	.001	.111
CENTROID Y	:	-.070	-.365	-.152
POA TO CENTROID in.	:	.077	.365	.138
MIN RADIUS	:	.175	.123	.145
MEAN RADIUS	:	1.208	1.053	.888
MAX RADIUS	:	2.669	1.966	1.956
HORIZONTAL SPREAD	:	2.964	2.964	2.964
VERTICAL SPREAD	:	4.660	2.785	2.283
EXTREME SPREAD	:	4.809	3.121	3.018
NUMBER IN ONE INCH CIRCLE	=	4		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	6		

15 JUL 1981

FILE:/PATTERNING/CENTERFIRE_PATT/05936077

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 7

HS= 2.525

VS= 2.000

GS= 3.600

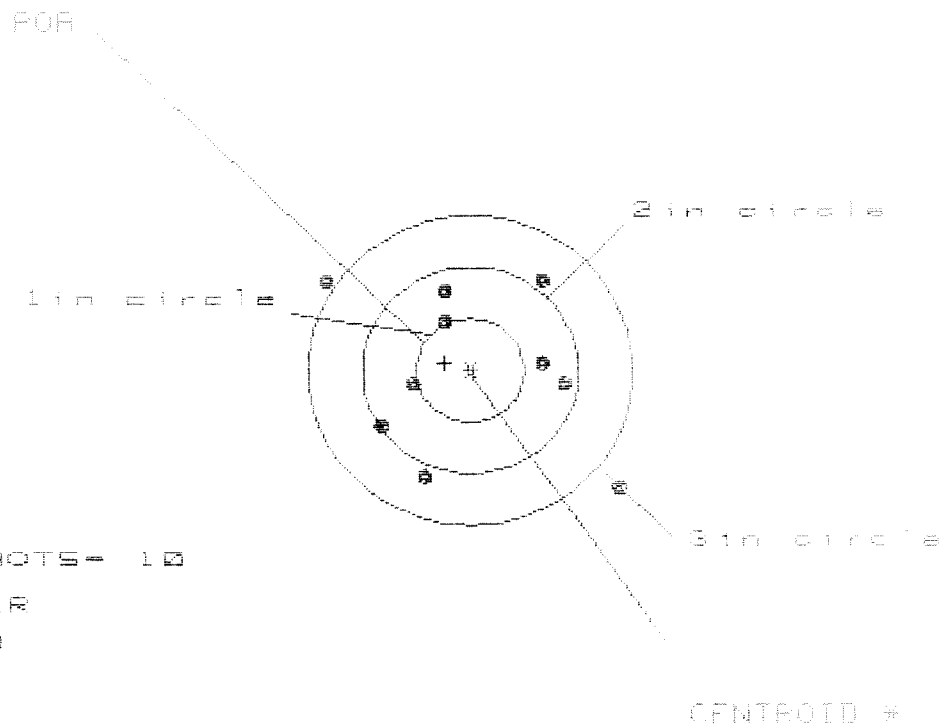
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.762	1.752	1.823
MINIMUM X	:	-1.764	-1.569	-1.350
MAXIMUM Y	:	.905	.927	.802
MINIMUM Y	:	-1.098	-.998	-.544
CENTROID X	:	.100	-.095	-.314
CENTROID Y	:	.065	-.034	.091
POI TO CENTROID IN.	:	.120	.101	.327
MIN RADIUS	:	.430	.425	.297
MEAN RADIUS	:	1.053	.921	.765
MAX RADIUS	:	1.980	2.017	1.398
HORIZONTAL SPREAD	:	3.526	3.321	2.973
VERTICAL SPREAD	:	2.000	1.935	1.346
EXTREME SPREAD	:	3.639	3.639	2.487
SHOTS IN ONE INCH CIRCLE	=		2	
SHOTS IN TWO INCH CIRCLE	=		6	
SHOTS IN THREE INCH CIRCLE	=		7	

21 MAR 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 5

3 in = 0

MEI = 0.799

VEI = 0.034

GEI = 0.423

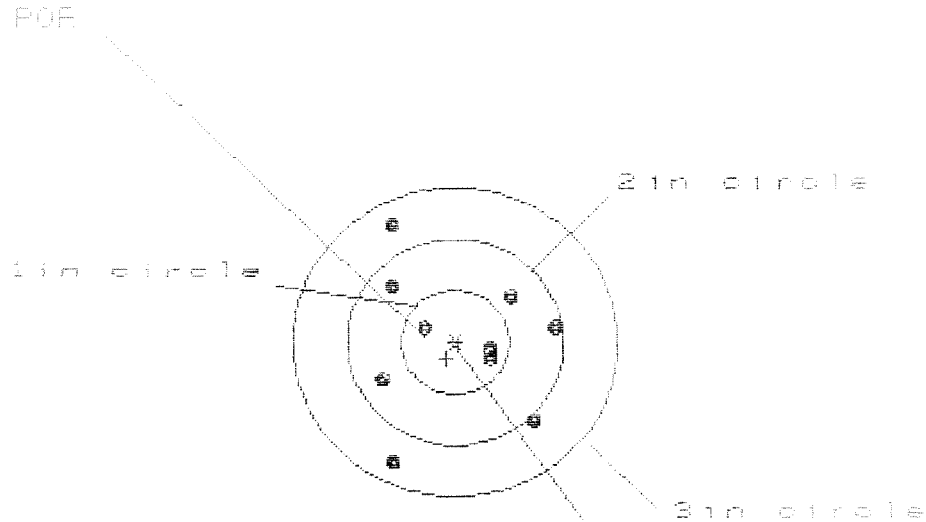
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.407	1.034	.885
MINIMUM X	:	-1.346	-1.189	-1.781
MAXIMUM Y	:	.887	.760	.791
MINIMUM Y	:	-1.147	-1.192	-1.097
CENTROID X	:	.235	.078	.227
CENTROID Y	:	-.072	.055	-.040
FOR TO CENTROID IN.	:	.246	.096	.231
MIN RADIUS	:	.568	.390	.539
MEAN RADIUS	:	1.011	.896	.833
MAX RADIUS	:	1.815	1.411	1.171
HORIZONTAL SPREAD	:	2.750	2.223	1.866
VERTICAL SPREAD	:	2.034	1.952	1.838
EXTREME SPREAD	:	3.423	2.453	2.184
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

15 JUL 1991

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CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 1.633

VS= 2.293

GS= 2.354

CENTROID *

PATTERN #

4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.953	.885	.881
MINIMUM X	-.686	-.754	-.837
MAXIMUM Y	1.158	.630	.584
MINIMUM Y	-1.135	-1.006	-.773
CENTROID X	.088	.148	.231
CENTROID Y	.160	.031	.157
POB TO CENTROID in.	.179	.152	.280
MIN RADIUS	.274	.225	.134
MEAN RADIUS	.776	.710	.616
MAX. RADIUS	1.311	1.206	.964
HORIZONTAL SPREAD	1.639	1.639	1.639
VERTICAL SPREAD	2.293	1.636	1.277
EXTREME SPREAD	2.354	2.038	1.864
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

28 May 1991

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CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 7

HS= 3.672

VS= 2.515

GS= 3.770

CENTROID *

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.968	1.213	1.028
MINIMUM X	:	-1.704	-1.485	-.853
MAXIMUM Y	:	.823	.819	.899
MINIMUM Y	:	-1.692	-1.696	-1.593
CENTROID X	:	.060	-.159	.027
CENTROID Y	:	.102	.106	.003
POA TO CENTROID in.	:	.118	.191	.027
MIN RADIUS	:	.362	.562	.446
MEAN RADIUS	:	1.101	1.023	.900
MAX RADIUS	:	1.969	1.743	1.699
HORIZONTAL SPREAD	:	3.672	2.698	1.880
VERTICAL SPREAD	:	2.515	2.515	2.492
EXTREME SPREAD	:	3.770	2.745	2.639
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	7		