

C6636091

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 M24

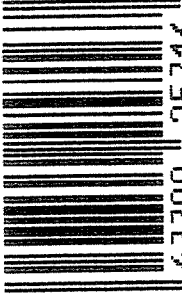
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

SERIAL NO.
C6636091

ORDER NO.
5716

20

UPC



0 47700 25716 7



5716 C6636091

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636091

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	GIS
617	Drill and Tap Sight Holes		APR 10 1991	FB
618	Polish Barrel		APR 19 1991	WB
620	Apply Coatings (Barrel Action)		5-10-91	TH
	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		5/29/91	TH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5/30/91	JK
	G) Safety Off Force	3	3	3			5/30/91	JK
	H) Trigger Pull Test & Retainability						5/29/91	JK
	I) Firing Pin Indent	.0205	.020	.0205			5/30/91	JK
	J) Assemble Stock						5/30/91	Rw
	K) Assemble Swivel Studs						6-3-91	D/H
	L) Attach Front and Rear Sight Assemblies						5/30/91	Rw
	M) Iron Sight Alignment						5/30/91	Rw
	N) Detach Front & Rear Sights & place in numbered container						5/30/91	Rw
	O) Attach Scope to Rifle						5/30/91	Rw
	P) Detach & Attach Scope 20 Times						5/30/91	Rw
640	Gallery Target & Test						6-1-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						6-1-91	AF
655	Final Inspection							
	A) Headspace						6-3-91	D/H
	B) Trigger Pull	2.32	2.20	2.27	2.32	2.36	4/3/91	JK
	C) Function						6-3-91	D/H
660	Pack						6-20-91	D/H

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 26636091

DATE 5/29/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.34	2.13	2.35	2.32	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.27	2.21	2.38	2.20	
PULL #3	2.21	2.20	2.30	2.27	
PULL #4	2.26	2.30	2.36	2.32	
PULL #5	2.18	2.21	2.31	2.36	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.60	3.51		
PULL #2	3.57	3.41		
PULL #3	3.54	3.31		
PULL #4	3.42	3.41		
PULL #5	3.65	3.33		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.52	4.27		4.23
PULL #2	4.19	4.23		4.27
PULL #3	4.31	4.17		4.28
PULL #4	4.13	4.50		4.19
PULL #5	4.18	4.46		4.26
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636091
1 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.307332
1 TO	2	.310556
1 TO	3	.373012
1 TO	4	.250218
1 TO	5	.376747

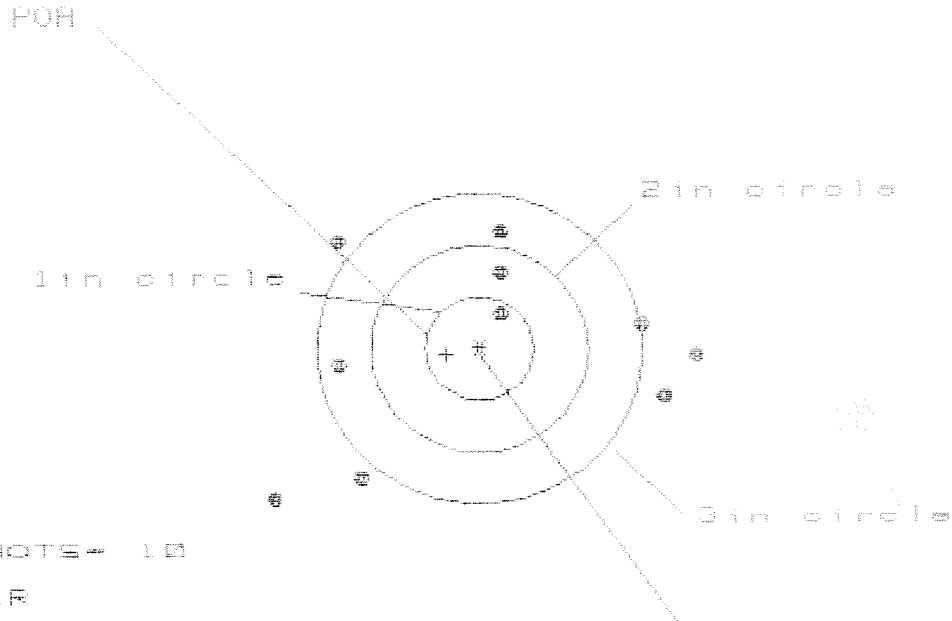
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THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0928
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0062
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0930069
THE AMR FOR THIS RIFLE IS: 1.161

1 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8836091

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 2

3in = 4

HS= 3.979

VS= 2.604

GS= 4.246

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	-2.028	-1.811	-1.708
MINIMUM X	-1.951	-1.562	-1.336
MAXIMUM Y	1.107	.940	.918
MINIMUM Y	-1.497	-1.408	-1.430
CENTROID X	.302	.519	.293
CENTROID Y	.057	.224	.246
POH TO CENTROID in.	.308	.565	.382
MIN RADIUS	.355	.168	.208
MEAN RADIUS	1.475	1.306	1.234
MAX RADIUS	2.459	1.946	1.844
HORIZONTAL SPREAD	3.979	3.373	3.044
VERTICAL SPREAD	2.604	2.348	2.348
EXTREME SPREAD	4.246	3.529	3.409
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	4		

1 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636093

CENTERFIRE PATTERNS

2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 4

HS= 4.277

VS= 5.013

GS= 5.167

CENTROID #

PATTERN #

2

SHOTS (BEST OF)

10

9

8

MAXIMUM X

2.687

2.523

1.136

MINIMUM X

-1.591

-1.754

-1.438

MAXIMUM Y

2.473

2.285

2.127

MINIMUM Y

-2.540

-2.808

-2.886

CENTROID X

.249

.412

.096

CENTROID Y

-.249

.019

.097

POA TO CENTROID in.

.352

.412

.137

MIN RADIUS

.235

.256

.144

MEAN RADIUS

1.588

1.418

1.200

MAX RADIUS

2.821

2.834

2.887

HORIZONTAL SPREAD

4.277

4.277

2.574

VERTICAL SPREAD

5.013

5.013

5.013

EXTREME SPREAD

5.167

5.032

5.032

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

4

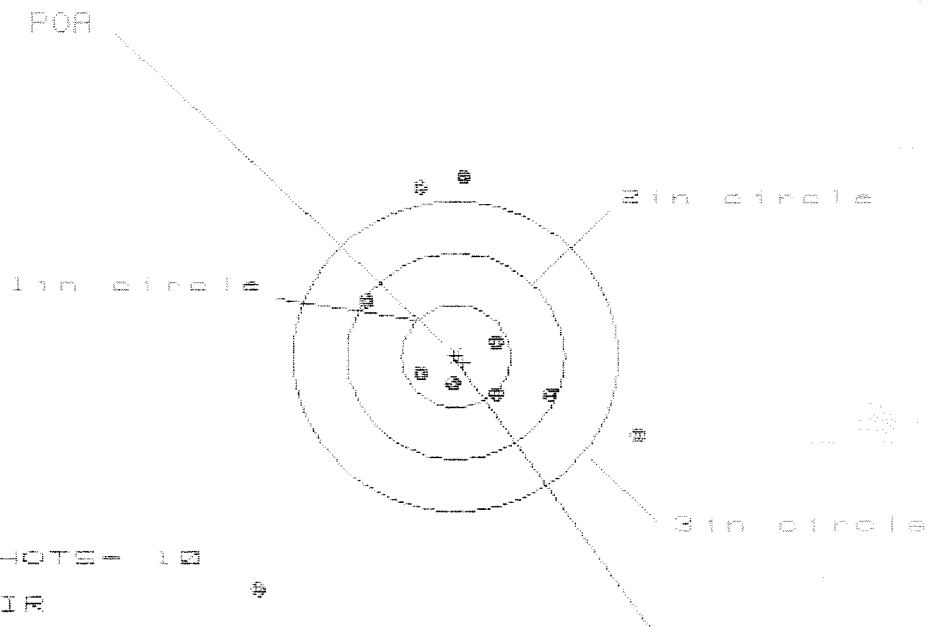
NUMBER IN THREE INCH CIRCLE =

4

1 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636091

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 4

2in = 6

3in = 6

HS = 3.491

VS = 4.035

GS = 4.487

CENTROID *

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.635	1.428	.838
MINIMUM X	-1.857	-1.038	-.859
MAXIMUM Y	1.786	1.536	1.489
MINIMUM Y	-2.249	-1.017	-.741
CENTROID X	-.071	.136	-.043
CENTROID Y	.060	.310	.437
POA TO CENTROID in.	.093	.339	.439
MIN RADIUS	.244	.204	.421
MEAN RADIUS	1.166	.980	.904
MAX RADIUS	2.916	1.753	1.411
HORIZONTAL SPREAD	3.491	2.466	1.697
VERTICAL SPREAD	4.035	2.553	2.150
EXTREME SPREAD	4.487	3.136	2.353
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		6	

1 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636091

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 5

2 in = 8

3 in = 10

HS = 1.414

VS = 2.345

GS = 2.584

PATTERN #

4

SHOTS (BEST OF)

MAXIMUM X : .527

MINIMUM X : -.867

MAXIMUM Y : 1.046

MINIMUM Y : -1.299

CENTROID X : .055

CENTROID Y : .097

POA TO CENTROID in. : .111

MIN RADIUS : .202

MEAN RADIUS : .648

MAX RADIUS : 1.372

HORIZONTAL SPREAD : 1.414

VERTICAL SPREAD : 2.345

EXTREME SPREAD : 2.584

NUMBER IN ONE INCH CIRCLE =

NUMBER IN TWO INCH CIRCLE =

NUMBER IN THREE INCH CIRCLE =

9

.428

-.350

.729

-1.182

.154

-.020

.155

.142

.559

1.187

.778

1.911

1.946

5

8

10

8

.441

-.338

.581

-.725

.141

.128

.191

.240

.463

.728

.778

1.306

1.320

1 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8B3E091

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 4

2in = 7

3in = 9

HS = 2.841

VS = 3.352

GS = 3.528

CENTROID #

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.245

1.068

.983

MINIMUM X

-1.596

-1.117

-1.202

MAXIMUM Y

1.378

1.159

.572

MINIMUM Y

-1.974

-.552

-.408

CENTROID X

-.071

.106

.191

CENTROID Y

.004

.223

.079

POA TO CENTROID in.

.071

.247

.206

MIN RADIUS

.314

.248

.166

MEAN RADIUS

.926

.676

.562

MAX RADIUS

2.539

1.340

1.269

HORIZONTAL SPREAD

2.841

2.185

2.185

VERTICAL SPREAD

3.352

1.711

.980

EXTREME SPREAD

3.528

2.305

2.194

NUMBER IN ONE INCH CIRCLE =

4

NUMBER IN TWO INCH CIRCLE =

7

NUMBER IN THREE INCH CIRCLE =

9