

C6636099

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

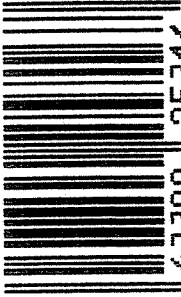
SERIAL NO.
C6636099

ORDER NO.
5716

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

20

UPC



0 47700 25716 7



5716 C6636099

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636099

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	CR
615	Rollmark Caliber		APR 9 1991	LS
617	Drill and Tap Sight Holes		APR 9 1991	FB
618	Polish Barrel		APR 9 1991	W/B
620	Apply Coatings (Barrel Action)		5-10-91	HA
	Apply Coating (Bolt)		5-10-91	HA
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		5/23/91	JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4.5	4.5	4.5			5/28/91	SL
	G) Safety Off Force	3	3	3			5/28/91	SL
	H) Trigger Pull Test & Retainability						5/28/91	SL
	I) Firing Pin Indent	.0215	.0215	.0215			5/28/91	SL
	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						5-29-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						5-29-91	NF
655	Final Inspection							
	A) Headspace						6-1-91	DH
	B) Trigger Pull	2.28	2.30	2.18	2.16	2.23	6/1/91	SL
	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. C6636099

DATE 5/28/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.35	2.20	2.25	2.28	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.36	2.15	2.30	2.30	
PULL #3	2.17	2.19	2.22	2.18	
PULL #4	2.40	2.23	2.19	2.16	
PULL #5	2.30	2.24	2.25	2.23	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.31	3.70		
PULL #2	3.36	3.62		
PULL #3	3.46	3.40		
PULL #4	3.57	3.44		
PULL #5	3.58	3.56		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.33	4.42		4.50
PULL #2	4.39	4.38		4.55
PULL #3	4.39	4.46		4.51
PULL #4	4.56	4.35		4.42
PULL #5	4.46	4.51		4.52
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636099
29 May 1991

CENTROIDAL DISTANCES

0 TO	1	.107042
1 TO	2	.17726
1 TO	3	.319628
1 TO	4	.132503
1 TO	5	.223294

3⁴/₅ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0292
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0954
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0997687

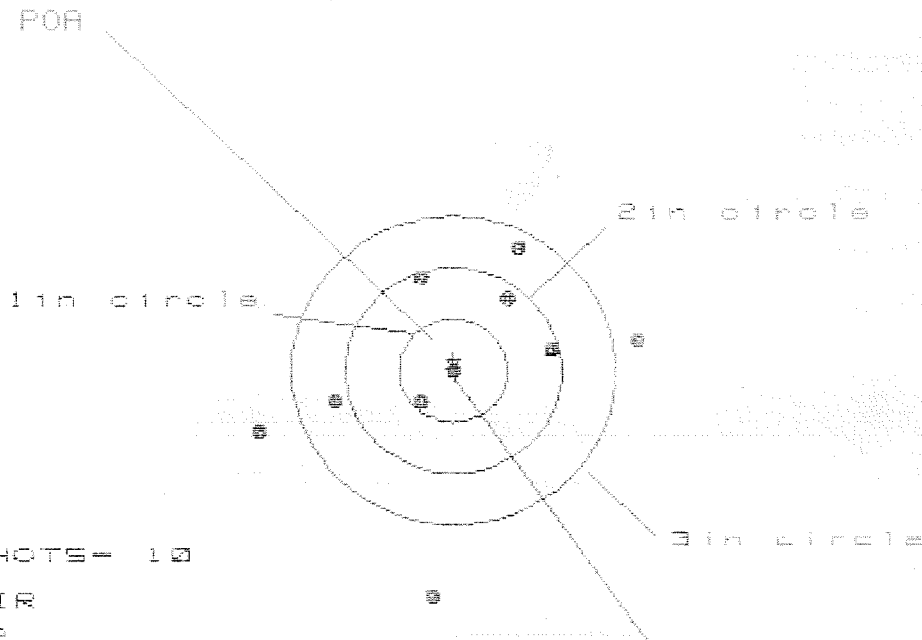
THE AMR FOR THIS RIFLE IS: .877

28 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C869E099

CENTERFIRE PATTERNS

1



OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 7

HS = 3.452

VS = 3.457

GS = 3.561

CENTROID *

PATTERN #

1

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.700	1.676	1.464
MINIMUM X	-1.752	-1.776	-1.365
MAXIMUM Y	1.233	.986	.885
MINIMUM Y	-2.224	-.807	-.682
CENTROID X	-.003	.022	.244
CENTROID Y	-.107	.140	.241
POA TO CENTROID in.	.107	.142	.340
MIN RADIUS	.025	.252	.417
MEAN RADIUS	1.166	1.036	.900
MAX RADIUS	2.235	1.951	1.525
HORIZONTAL SPREAD	3.452	3.452	2.819
VERTICAL SPREAD	3.457	1.793	1.567
EXTREME SPREAD	3.561	3.561	2.892
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		7	

28 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8638093

CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 10

HS= 2.582

VS= 1.500

GS= 2.582

CENTROID #

PATTERN #

:

2

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

1.240

1.091

1.298

MINIMUM X

:

-1.342

-1.169

-1.052

MAXIMUM Y

:

.792

.803

.716

MINIMUM Y

:

-.708

-.697

-.645

CENTROID X

:

.107

.256

.139

CENTROID Y

:

.032

.021

.108

POA TO CENTROID in.

:

.111

.257

.176

MIN RADIUS

:

.250

.256

.167

MEAN RADIUS

:

.876

.812

.746

MAX RADIUS

:

1.345

1.295

1.234

HORIZONTAL SPREAD

:

2.582

2.260

2.260

VERTICAL SPREAD

:

1.500

1.500

1.361

EXTREME SPREAD

:

2.582

2.343

2.343

NUMBER IN ONE

INCH CIRCLE

=

2

NUMBER IN TWO

INCH CIRCLE

=

6

NUMBER IN THREE

INCH CIRCLE

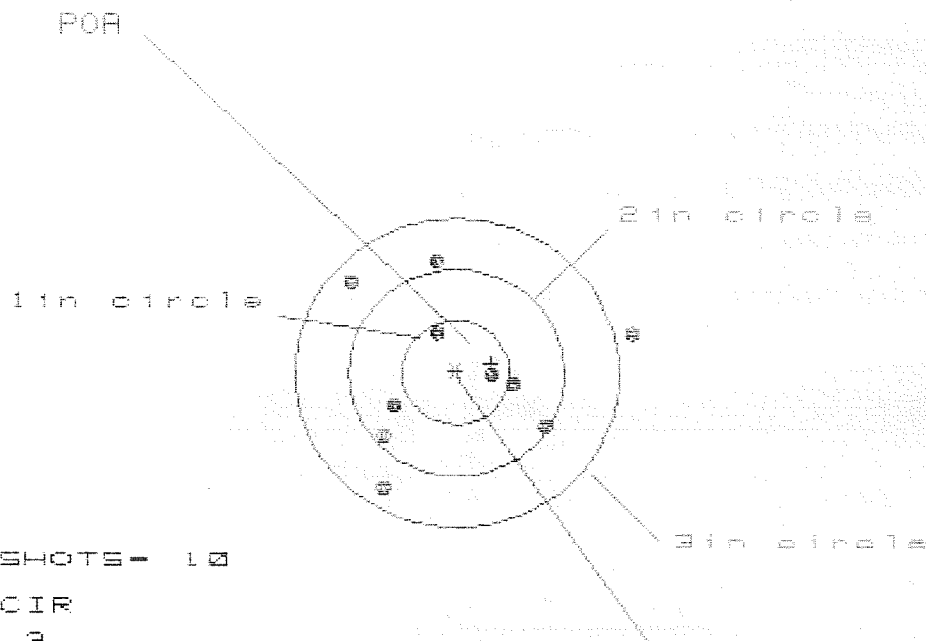
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10

29 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636099

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 2

2in = 6

3in = 9

HS = 2.576

VS = 2.162

GS = 2.785

PATTERN #

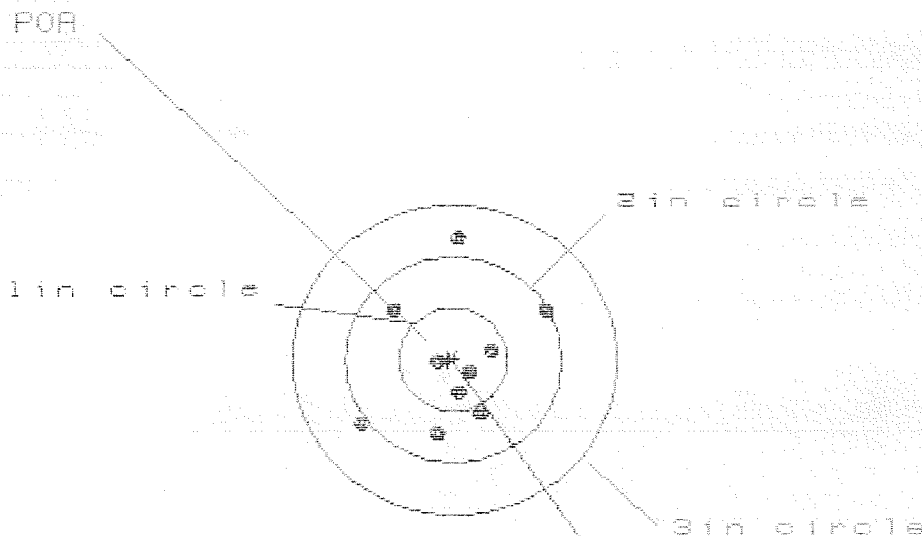
3

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.643	1.018	.953
MINIMUM X	-.933	-.750	-.815
MAXIMUM Y	1.040	1.082	.947
MINIMUM Y	-1.122	-1.080	-.672
CENTROID X	-.322	-.505	-.440
CENTROID Y	-.087	-.129	.006
POA TO CENTROID in.	.334	.521	.440
MIN RADIUS	.281	.412	.276
MEAN RADIUS	.917	.829	.768
MAX RADIUS	1.686	1.222	1.163
HORIZONTAL SPREAD	2.576	1.768	1.768
VERTICAL SPREAD	2.162	2.162	1.619
EXTREME SPREAD	2.785	2.285	2.285
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

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FILE:/PATTERNING/CENTERFIRE_PATT/06636093

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 4

2in = 8

3in = 10

HS= 1.666

VS= 1.876

GS= 2.013

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.849	.859	.758
MINIMUM X	:	-.817	-.807	-.690
MAXIMUM Y	:	1.164	.646	.583
MINIMUM Y	:	-.712	-.582	-.645
CENTROID X	:	.051	.041	.142
CENTROID Y	:	.014	-.116	-.053
POB TO CENTROID in.	:	.053	.123	.151
MIN RADIUS	:	.104	.130	.019
MEAN RADIUS	:	.618	.539	.473
MAX RADIUS	:	1.168	1.056	.938
HORIZONTAL SPREAD	:	1.666	1.666	1.448
VERTICAL SPREAD	:	1.876	1.228	1.228
EXTREME SPREAD	:	2.013	2.005	1.566
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

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FILE:/PATTERNING/CENTERFIRE_PATT/06636099

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 4

2in = 8

3in = 9

HS = 1.532

VS = 3.475

GS = 3.769

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.515	.402	.444
MINIMUM X	:	-1.017	-.543	-.501
MAXIMUM Y	:	1.228	.978	.727
MINIMUM Y	:	-2.247	-1.047	-.925
CENTROID X	:	.021	.134	.092
CENTROID Y	:	-.329	-.079	-.201
POA TO CENTROID in.	:	.329	.155	.221
MIN RADIUS	:	.211	.239	.193
MEAN RADIUS	:	.808	.588	.519
MAX RADIUS	:	2.467	1.073	.965
HORIZONTAL SPREAD	:	1.532	.945	.945
VERTICAL SPREAD	:	3.475	2.025	1.652
EXTREME SPREAD	:	3.769	2.027	1.794
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	