

C6636113

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.





MODEL 700™ H24



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

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

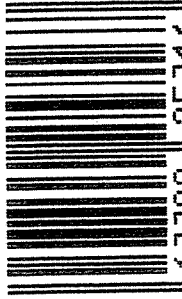
SERIAL NO.
C6636113

ORDER NO.
5716

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

20

UPC



0 47700 25716 7



5716 C6636113

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636113

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	4/9/91	K.S.
600	Proof		4/9/91	K.S.
607	Check Headspace		4/9/91	K.S.
610	Dis-assemble Gun		4/9/91	K.S.
612	Magnaflux Barrel Action		4/10/91	KR
	Magnaflux Bolt		4/10/91	ir
615	Rollmark Caliber		4/10/91	LL
617	Drill and Tap Sight Holes		APR 19 1991	LB
618	Polish Barrel		APR 19 1991	LB
620	Apply Coatings (Barrel Action)		5-10-91	LA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/22/91	K.S.
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/22/91	K.S.
	C) Inspect Ejector Hole for Chamfer		5/22/91	K.S.
	D) Oil Firing Pin Ass'y		5/22/91	K.S.
	E) Adjust Trigger Pull to Min Setting and Stake		5/24/91	PH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5-24-91	DH
	G) Safety Off Force	3	3	3			5-24-91	DH
	H) Trigger Pull Test & Retainability						4-24-91	DH
	I) Firing Pin Indent	.020	.021	.021			5-24-91	DH
	J) Assemble Stock						5/24/91	KS
	K) Assemble Swivel Studs						6-1-91	DH
	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	DH
	A) Time						5-28-91	DH
	B) Malfunctions						5-28-91	DH
	C) Pierced Primers						5-28-91	DH
	D) Optical Clarity of Scope						5-28-91	DH
645	Inspect for Live Ammo						5-28-91	DH
655	Final Inspection							
	A) Headspace						6-1-91	DH
	B) Trigger Pull	2.46	2.51	2.50	2.50	2.48	6/1/91	KS
	C) Function						6-1-91	DH
660	Pack						6-19-91	KS

SWS TRIGGER PULL TEST

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

SERIAL NO. C6636113DATE 5-24-91TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.35	2.66	2.33	2.46	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.50	2.31	2.97	2.51	
PULL #3	2.49	2.97	2.84	2.50	
PULL #4	2.50	2.75	2.72	2.50	
PULL #5	2.48	2.67	2.93	2.48	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.64		
PULL #2	3.53	3.55		
PULL #3	3.68	3.66		
PULL #4	3.58	3.59		
PULL #5	3.52	3.66		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.31	4.60		4.58
PULL #2	4.42	4.60		4.39
PULL #3	4.53	4.54		4.38
PULL #4	4.50	4.56		4.52
PULL #5	4.30	4.66		4.55
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS

FOR RIFLE # 06635113

28 May 1991

CENTROIDAL DISTANCES

0 TO	1	.182099
1 TO	2	.166184
1 TO	3	.0494975
1 TO	4	.172986
1 TO	5	.349337

54
5

<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1542

THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0608

THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .165754

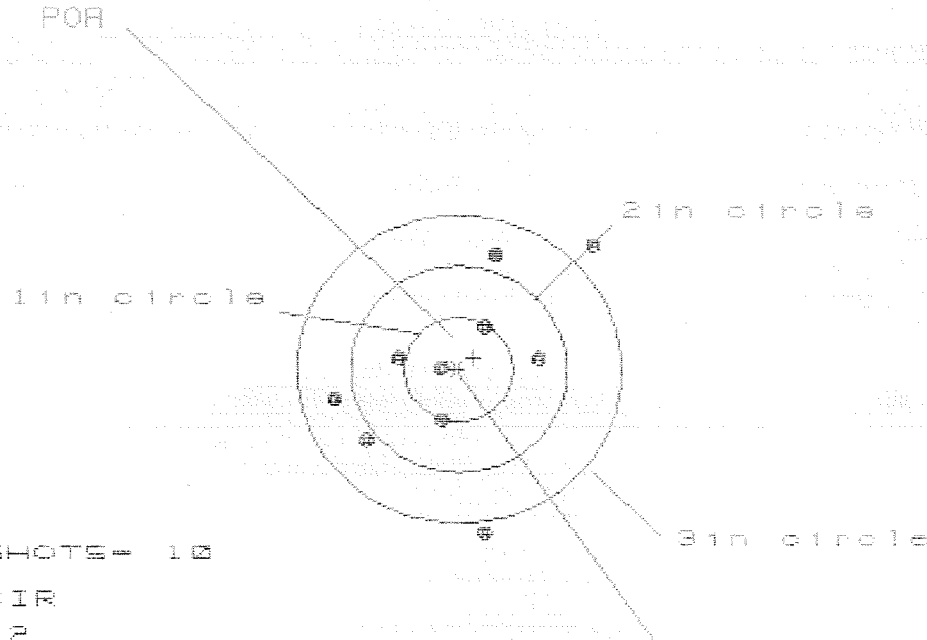
THE AMR FOR THIS RIFLE IS: .9042

28 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636113

CENTERFIRE PATTERNS

1



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.378

VS= 2.780

GS= 2.955

CENTROID #

PATTERN #

:

1

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

1.261

.919

.968

MINIMUM X

:

-1.117

-.977

-.928

MAXIMUM Y

:

1.215

1.199

1.021

MINIMUM Y

:

-1.565

-1.430

-.735

CENTROID X

:

-.142

-.282

-.331

CENTROID Y

:

-.114

-.249

-.071

POR TO CENTROID in.:

:

.182

.376

.339

MIN RADIUS

:

.148

.152

.050

MEAN RADIUS

:

.929

.819

.712

MAX RADIUS

:

1.751

1.484

1.168

HORIZONTAL SPREAD

:

2.378

1.896

1.896

VERTICAL SPREAD

:

2.780

2.629

1.756

EXTREME SPREAD

:

2.955

2.632

2.153

NUMBER IN ONE INCH CIRCLE =

:

2

5

8

NUMBER IN TWO INCH CIRCLE =

:

5

8

8

NUMBER IN THREE INCH CIRCLE =

:

8

8

8

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CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 7

HS= 3.949

VS= 2.607

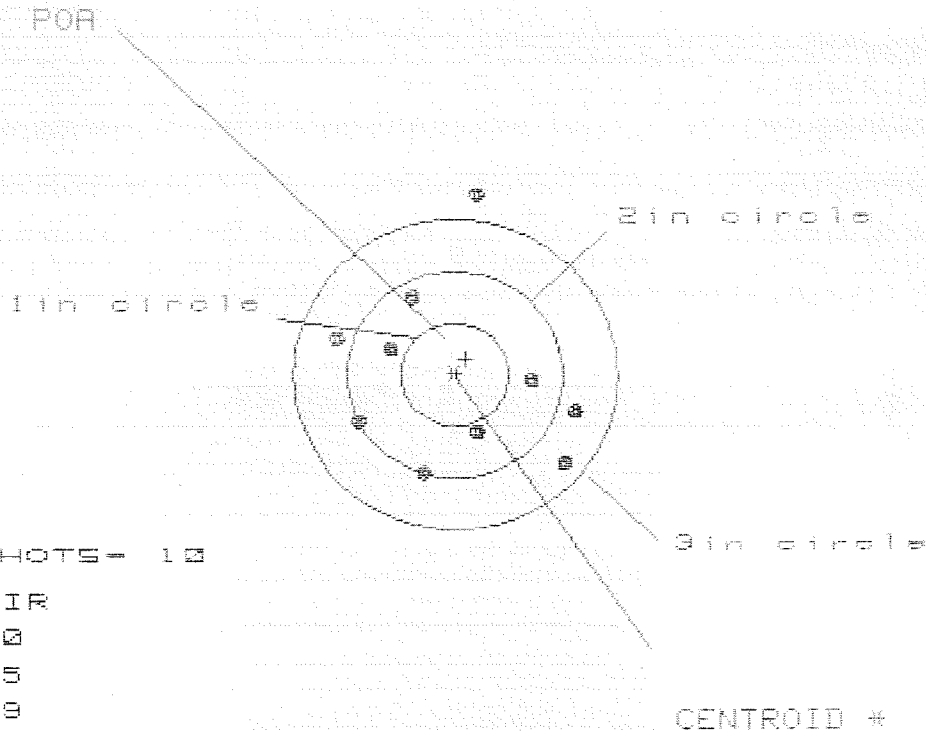
GS= 4.374

PATTERN #	2	3	4
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.719	1.472	.692
MINIMUM X	-2.230	-1.222	-1.038
MAXIMUM Y	1.229	1.157	.906
MINIMUM Y	-1.378	-1.450	-1.305
CENTROID X	-.026	.221	.037
CENTROID Y	-.233	-.161	-.306
POA TO CENTROID in.	.235	.274	.308
MIN RADIUS	.228	.124	.322
MEAN RADIUS	1.105	.959	.834
MAX RADIUS	2.323	1.872	1.530
HORIZONTAL SPREAD	3.949	2.694	1.920
VERTICAL SPREAD	2.607	2.607	2.211
EXTREME SPREAD	4.374	3.067	2.278
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

28 May 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 5

3 in = 9

HS = 2.208

VS = 2.643

GS = 2.728

PATTERN #

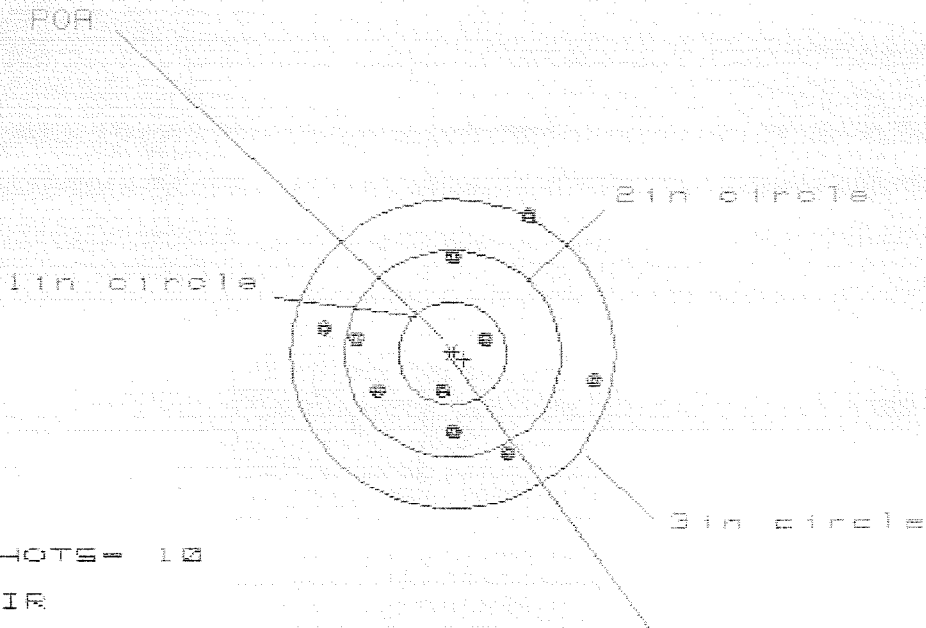
3

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.148	1.171	1.300
MINIMUM X	-1.060	-1.037	-.908
MAXIMUM Y	1.719	.984	.897
MINIMUM Y	-.924	-.733	-.820
CENTROID X	-.107	-.130	-.259
CENTROID Y	-.149	-.340	-.253
POA TO CENTROID in.	.184	.364	.362
MIN RADIUS	.562	.405	.554
MEAN RADIUS	1.025	.923	.873
MAX RADIUS	1.731	1.245	1.320
HORIZONTAL SPREAD	2.208	2.208	2.208
VERTICAL SPREAD	2.643	1.717	1.717
EXTREME SPREAD	2.728	2.412	2.312
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 6

3 in = 10

HS= 2.434

VS= 2.241

GS= 2.485

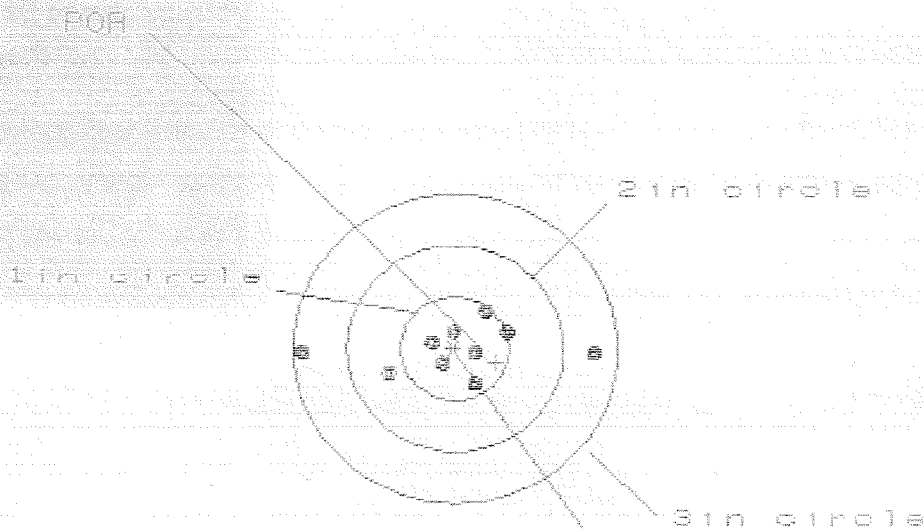
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.282	1.360	.728
MINIMUM X	:	-1.151	-1.074	-.904
MAXIMUM Y	:	1.324	1.049	1.030
MINIMUM Y	:	-.917	-.770	-.789
CENTROID X	:	-.110	-.187	-.357
CENTROID Y	:	.054	-.093	-.074
POA TO CENTROID in.	:	.122	.209	.364
MIN RADIUS	:	.354	.200	.282
MEAN RADIUS	:	.906	.813	.735
MAX RADIUS	:	1.496	1.369	1.074
HORIZONTAL SPREAD	:	2.434	2.434	1.632
VERTICAL SPREAD	:	2.241	1.819	1.919
EXTREME SPREAD	:	2.485	2.485	1.977
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 8

2in = 8

3in = 10

HS= 2.713

VS= .647

GS= 2.713

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.388	1.151	.468
MINIMUM X	:	-1.485	-.764	-.628
MAXIMUM Y	:	.339	.333	.328
MINIMUM Y	:	-.388	-.314	-.319
CENTROID X	:	-.386	-.229	-.373
CENTROID Y	:	.136	.142	.147
POA TO CENTROID in.	:	.489	.278	.401
MIN RADIUS	:	.177	.068	.168
MEAN RADIUS	:	.556	.453	.354
MAX RADIUS	:	1.487	1.152	.671
HORIZONTAL SPREAD	:	2.713	1.915	1.088
VERTICAL SPREAD	:	.647	.647	.647
EXTREME SPREAD	:	2.713	1.927	1.176
NUMBER IN ONE INCH CIRCLE	=		8	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	