

C6636115

MODEL 700TM M24

Model SMSTM

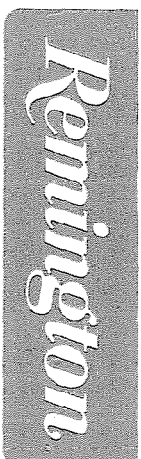
Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.






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

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

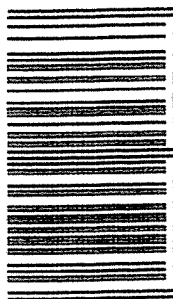
MODEL 700™ H24

SERIAL NO. C6636115

ORDER NO. 5716

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

UPC



0 47700 25716 7



5716 C6636115

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # *C6636115*

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 30	91	<i>RW</i>
600	Proof	4 30	91	<i>RW</i>
607	Check Headspace	4 30	91	<i>RW</i>
610	Dis-assemble Gun	4 30	91	<i>RW</i>
612	Magnaflux Barrel Action	5 6	91	<i>KCR</i>
	Magnaflux Bolt	5 6	91	<i>KCR</i>
615	Rollmark Caliber	5 6	91	<i>GB</i>
617	Drill and Tap Sight Holes	5 10	91	<i>KB</i>
618	Polish Barrel	5 10	91	<i>WB</i>
620	Apply Coatings (Barrel Action)		<i>5/30/91</i>	<i>JS</i>
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		<i>5/30/91</i>	<i>RW</i>
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		<i>5/30/91</i>	<i>RW</i>
	C) Inspect Ejector Hole for Chamfer		<i>5/30/91</i>	<i>RW</i>
	D) Oil Firing Pin Ass'y		<i>5/30/91</i>	<i>RW</i>
	E) Adjust Trigger Pull to Min Setting and Stake		<i>6-11-91</i>	<i>JS</i>

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			6-12-91	DH
	G) Safety Off Force	4	4	4			6-12-91	DH
	H) Trigger Pull Test & Retainability						6-11-91	JH
	I) Firing Pin Indent	1021	1022	1021			6-12-91	DH
	J) Assemble Stock						6/13/91	RW
	K) Assemble Swivel Studs						6-14-91	JH.
	L) Attach Front and Rear Sight Assemblies						6/13/91	RW
	M) Iron Sight Alignment						6/13/91	RW
	N) Detach Front & Rear Sights & place in numbered container						6/13/91	RW
	O) Attach Scope to Rifle						6/13/91	RW
	P) Detach & Attach Scope 20 Times						6/13/91	RW
640	Gallery Target & Test						6-14-91	AC
	A) Time						6-14-91	AC
	B) Malfunctions						6-14-91	AC
	C) Pierced Primers						6-14-91	AC
	D) Optical Clarity of Scope						6-14-91	AC
645	Inspect for Live Ammo						6-14-91	AC
655	Final Inspection						6-14-91	JH.
	A) Headspace						6-14-91	JH
	B) Trigger Pull	2.17	2.31	2.34	2.37	2.34	6-14-91	JH
	C) Function						6-14-91	JH.
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. C-6636115
DATE 6-11-91
TESTER [Signature]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.49	2.41	2.44	2.17	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.39	2.51	2.50	2.31	
PULL #3	2.36	2.53	2.53	2.34	
PULL #4	2.50	2.54	2.56	2.37	
PULL #5	2.52	2.53	2.50	2.34	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.40	3.42		
PULL #2	3.45	3.41		
PULL #3	3.41	3.42		
PULL #4	3.41	3.41		
PULL #5	3.44	3.41		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.34	4.36		4.42
PULL #2	4.59	4.17		4.42
PULL #3	4.63	4.48		4.52
PULL #4	4.60	4.43		4.49
PULL #5	4.42	4.43		4.43
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636115
14 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.397817
1 TO	2	.676512
1 TO	3	.238271
1 TO	4	.180044
1 TO	5	.500759

r_{41} (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1122
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0318
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .116619
THE AMR FOR THIS RIFLE IS: .8632

14 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636115

CENTERFIRE PATTERNS

1

FOR

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS= 2.709

VS= 1.757

GS= 2.807

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.152	1.979	.580
MINIMUM X	-1.557	-1.010	-.887
MAXIMUM Y	1.925	1.946	.815
MINIMUM Y	-.832	-.811	-.693
CENTROID X	.387	.480	.357
CENTROID Y	.253	.232	.114
FOR TO CENTROID in.	.398	.533	.375
MIN RADIUS	.422	.303	.278
MEAN RADIUS	.853	.726	.649
MAX RADIUS	1.568	1.361	1.205
HORIZONTAL SPREAD	2.709	1.989	1.467
VERTICAL SPREAD	1.757	1.757	1.508
EXTREME SPREAD	2.807	2.619	1.799
NUMBER IN ONE INCH CIRCLE	=	3	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	9	

14 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6836115

CENTERFIRE PATTERNS

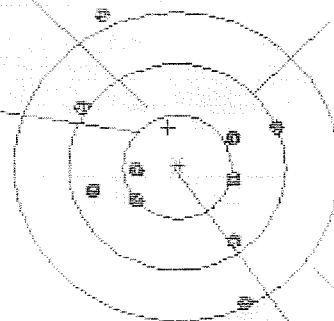
2

POA

1 in circle

2 in circle

3 in circle



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS= 1.786

VS= 2.833

GS= 3.108

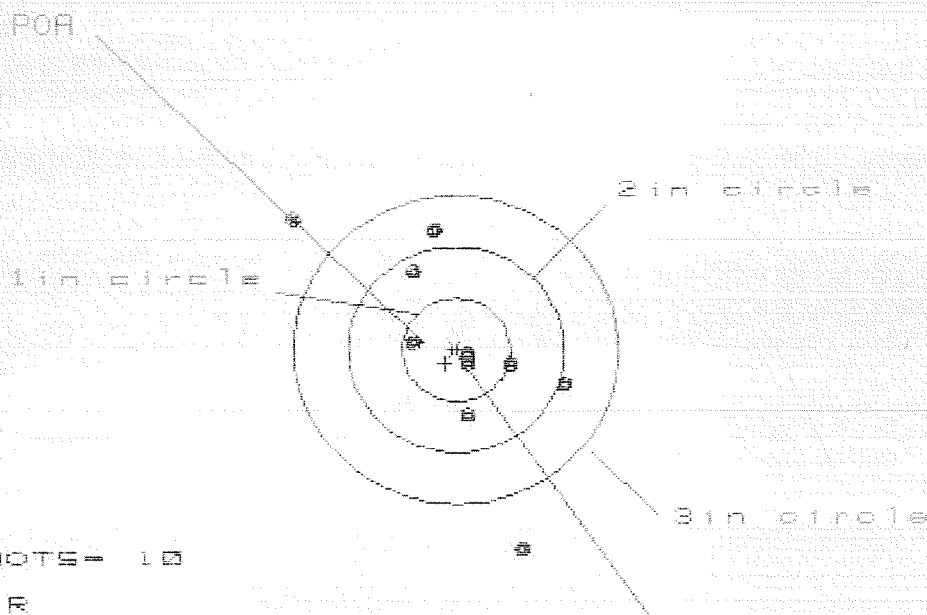
CENTROID *

PATTERN #	:	2
SHOTS (BEST OF)	:	10
MAXIMUM X	:	.896
MINIMUM X	:	-.890
MAXIMUM Y	:	1.472
MINIMUM Y	:	-1.361
CENTROID X	:	.082
CENTROID Y	:	-.385
POA TO CENTROID in.	:	.393
MIN RADIUS	:	.352
MEAN RADIUS	:	.897
MAX RADIUS	:	1.619
HORIZONTAL SPREAD	:	1.786
VERTICAL SPREAD	:	2.833
EXTREME SPREAD	:	3.108
NUMBER IN ONE INCH CIRCLE	=	1
NUMBER IN TWO INCH CIRCLE	=	7
NUMBER IN THREE INCH CIRCLE	=	9

14 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6638115

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 6

3 in = 8

HS= 2.454

VS= 3.233

GS= 3.814

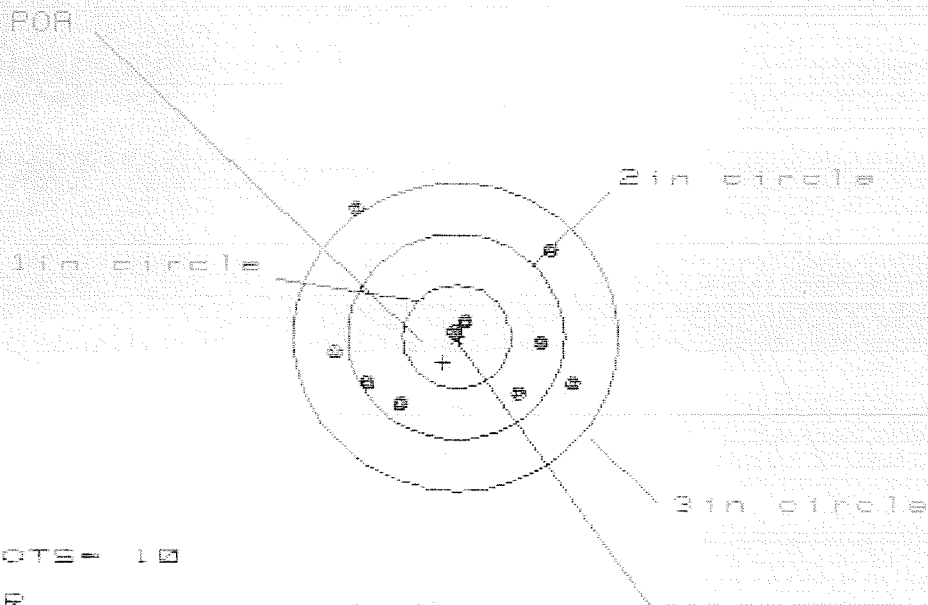
CENTROID #

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.996	1.059	.884
MINIMUM X	:	-1.459	-1.395	-.495
MAXIMUM Y	:	1.253	1.033	1.066
MINIMUM Y	:	-1.980	-.870	-.740
CENTROID X	:	.100	.037	.212
CENTROID Y	:	.135	.355	.225
POA TO CENTROID in.	:	.160	.357	.309
MIN RADIUS	:	.130	.316	.126
MEAN RADIUS	:	.892	.790	.620
MAX RADIUS	:	2.059	1.736	1.099
HORIZONTAL SPREAD	:	2.454	2.454	1.379
VERTICAL SPREAD	:	3.233	1.903	1.806
EXTREME SPREAD	:	3.814	2.900	1.850
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

14 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636115

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 2.178

VS= 1.898

GS= 2.638

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.001	1.976	1.068
MINIMUM X	:	-1.097	-1.202	-1.110
MAXIMUM Y	:	1.265	.972	.402
MINIMUM Y	:	-.633	-.492	-.371
CENTROID X	:	.127	.232	.140
CENTROID Y	:	.249	.108	-.013
POA TO CENTROID in.	:	.279	.256	.141
MIN RADIUS	:	.051	.225	.311
MEAN RADIUS	:	.858	.781	.731
MAX RADIUS	:	1.581	1.220	1.114
HORIZONTAL SPREAD	:	2.178	2.178	2.178
VERTICAL SPREAD	:	1.898	1.464	.773
EXTREME SPREAD	:	2.638	2.193	2.193
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	9		

14 Jun 1951

FILE:/PATTERNING/CENTERFIRE_PATT/C6636115

CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 3

2in = 6

3in = 9

HS= 2.259

VS= 2.168

GS= 2.788

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.139	1.261	1.197
MINIMUM X	-1.120	-1.998	-1.063
MAXIMUM Y	1.081	.960	.731
MINIMUM Y	-1.087	-.667	-.546
CENTROID X	-.055	-.177	-.112
CENTROID Y	-.093	.028	-.092
POA TO CENTROID in.	.108	.180	.146
MIN RADIUS	.179	.160	.133
MEAN RADIUS	.816	.714	.662
MAX RADIUS	1.545	1.294	1.208
HORIZONTAL SPREAD	2.259	2.259	2.259
VERTICAL SPREAD	2.168	1.627	1.277
EXTREME SPREAD	2.788	2.290	2.290
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		