

C6636116

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.

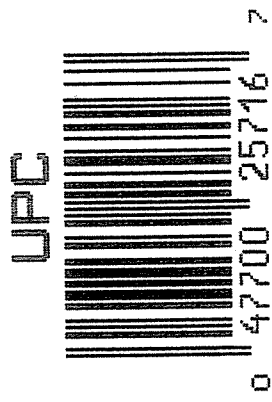
MODEL 700™ H24

SERIAL NO.
C6636116

ORDER NO.
5716

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

20



GUN SERIAL #

C6636116

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		4/9/91	KS
600	Proof		4/9/91	KS
607	Check Headspace		4/9/91	KS
610	Dis-assemble Gun		4/9/91	KS
612	Magnaflux Barrel Action		4/10/91	KR
	Magnaflux Bolt		ADD 1 9 1991	LI
615	Rollmark Caliber		APR 1 9 1991	LS
617	Drill and Tap Sight Holes		APR 1 9 1991	LB
618	Polish Barrel		APR 1 9 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	DH

Op. #	Op. NAME	READINGS					DATE	TIME
625 cont.	F) Safety On Force	5	5	5			5-23-91	D/H
	G) Safety Off Force	3	2 1/2	2			5-23-91	D/H
	H) Trigger Pull Test & Retainability						5-23-91	D/H
	I) Firing Pin Indent	.021	.021	.021			5-23-91	D/H
	J) Assemble Stock						5/23/91	KS
	K) Assemble Swivel Studs						6-1-91	D/H
	L) Attach Front and Rear Sight Assemblies						5/23/91	KS
	M) Iron Sight Alignment						5/23/91	KS
	N) Detach Front & Rear Sights & place in numbered container						5/23/91	KS
	O) Attach Scope to Rifle						5/23/91	KS
	P) Detach & Attach Scope 20 Times						5/23/91	KS
640	Gallery Target & Test						5-24-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						5-24-91	NF
655	Final Inspection							
	A) Headspace						6-1-91	D/H
	B) Trigger Pull	2.47	2.46	2.57	2.59	2.58	6/1/91	NF
	C) Function						6-1-91	D/H
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#+ 100#

SERIAL NO. C6636116DATE 5-23-91TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.72	2.68	2.49	2.47	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.65	2.67	2.62	2.46	
PULL #3	2.66	2.36	2.60	2.57	
PULL #4	2.69	2.56	2.46	2.59	
PULL #5	2.59	2.60	2.63	2.58	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.52	3.46		
PULL #2	3.51	3.55		
PULL #3	3.13	3.46		
PULL #4	3.46	3.51		
PULL #5	3.41	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	4.25	4.21		4.34
PULL #2	4.27	4.21		4.39
PULL #3	4.14	4.29		4.38
PULL #4	4.22	4.26		3.74
PULL #5	4.394	4.34		4.26
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS

FOR RIFLE # C6636116

24 MAR 1991

CENTROIDAL DISTANCES

0 TO 1	.0787718
1 TO 2	.0506952
1 TO 3	.203769
1 TO 4	.20632
1 TO 5	.0982293

←----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.003
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0078
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .00835763

THE AMR FOR THIS RIFLE IS: 1.05

24 May 1991

FILE: /PATTERNING/CENTERFIRE_PATT/C8636116

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 1

2 in = 3

3 in = 5

HS= 4.128

VS= 3.672

GS= 4.986

PATTERN #

1

SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.285	1.625	1.520
MINIMUM X	-1.843	-1.589	-1.694
MAXIMUM Y	2.185	2.020	.797
MINIMUM Y	-1.487	-1.043	-.791
CENTROID X	-.074	-.328	-.223
CENTROID Y	-.027	.138	-.114
POA TO CENTROID in.	.079	.355	.251
MIN RADIUS	.186	.162	.255
MEAN RADIUS	1.449	1.296	1.160
MAX RADIUS	2.726	2.185	1.701
HORIZONTAL SPREAD	4.128	3.214	3.214
VERTICAL SPREAD	3.672	3.063	1.588
EXTREME SPREAD	4.986	3.610	3.286
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		5	

24 May 1981

FILE:/PATTERNING/CENTERFIRE_PATT/C8636116

CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 2

2in = 3

3in = 8

HS= 2.063

VS= 3.043

GS= 3.043

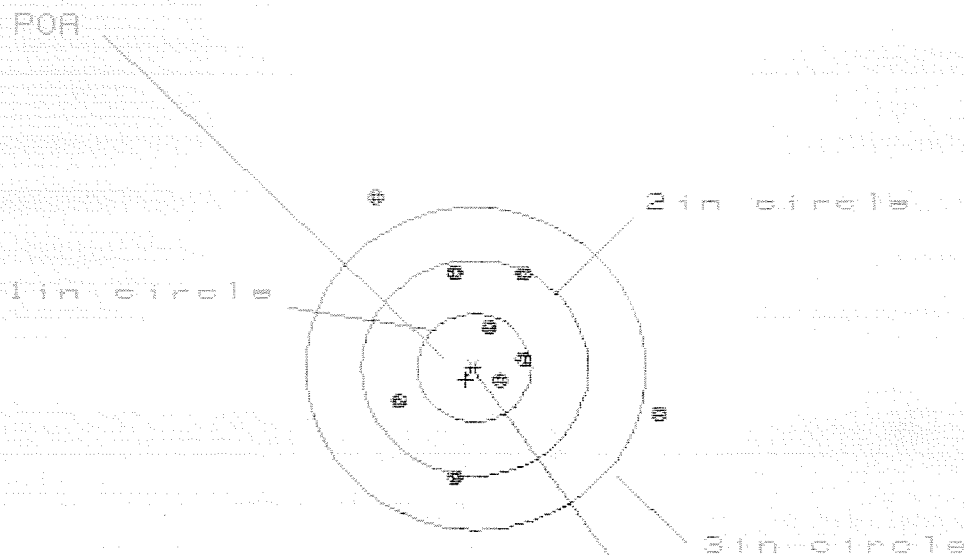
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.120	1.129	1.144
MINIMUM X	:	-.943	-.934	-.919
MAXIMUM Y	:	1.504	1.333	1.148
MINIMUM Y	:	-1.539	-1.321	-1.154
CENTROID X	:	-.123	-.132	-.147
CENTROID Y	:	-.014	.157	-.010
POA TO CENTROID in.	:	.124	.205	.148
MIN RADIUS	:	.121	.229	.146
MEAN RADIUS	:	1.034	.988	.913
MAX RADIUS	:	1.541	1.397	1.470
HORIZONTAL SPREAD	:	2.063	2.063	2.063
VERTICAL SPREAD	:	3.043	2.654	2.302
EXTREME SPREAD	:	3.043	2.716	2.641
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

24 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B36116

CENTERFIRE PATTERNS

3



OF SHOTS = 10

IN CIR

1in = 3

2in = 6

3in = 7

HS = 2.553

VS = 3.554

GS = 3.555

CENTROID *

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.630	1.527	1.409
MINIMUM X	:	-.923	-.950	-.885
MAXIMUM Y	:	1.559	1.337	.860
MINIMUM Y	:	-1.995	-1.259	-1.092
CENTROID X	:	.075	.178	.296
CENTROID Y	:	.112	.334	.167
POA TO CENTROID in.	:	.135	.378	.340
MIN RADIUS	:	.286	.215	.168
MEAN RADIUS	:	1.051	.879	.773
MAX RADIUS	:	2.199	1.663	1.492
HORIZONTAL SPREAD	:	2.553	2.477	2.294
VERTICAL SPREAD	:	3.554	2.596	1.952
EXTREME SPREAD	:	3.555	3.180	2.297
NUMBER IN ONE INCH CIRCLE =	:	3		
NUMBER IN TWO INCH CIRCLE =	:	6		
NUMBER IN THREE INCH CIRCLE =	:	7		

24 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636116

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 8

HS= 2.393

VS= 2.247

GS= 2.423

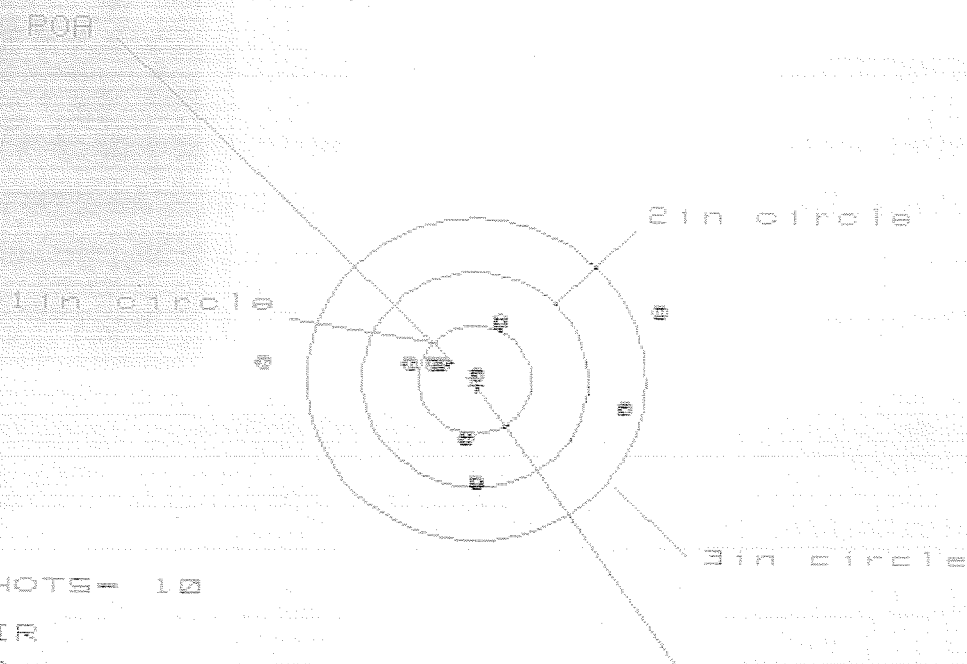
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.685	.496	.489
MINIMUM X	:	-1.708	-.885	-.892
MAXIMUM Y	:	1.511	1.505	.773
MINIMUM Y	:	-.736	-.742	-.554
CENTROID X	:	.124	.313	.320
CENTROID Y	:	-.085	-.079	-.267
POA TO CENTROID in.	:	.150	.323	.417
MIN RADIUS	:	.304	.345	.399
MEAN RADIUS	:	.864	.734	.631
MAX RADIUS	:	1.708	1.506	1.046
HORIZONTAL SPREAD	:	2.393	1.381	1.381
VERTICAL SPREAD	:	2.247	2.247	1.327
EXTREME SPREAD	:	2.423	2.388	1.646
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

24 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636116

CENTERFIRE PATTERNS

5



OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 8

HS= 3.495

VS= 1.626

GS= 3.533

CENTROID *

PATTERN # : 5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.610	1.400	1.285
MINIMUM X	-1.885	-1.784	-1.609
MAXIMUM Y	.627	.640	.649
MINIMUM Y	-.999	-.986	-.906
CENTROID X	-.017	-.192	.017
CENTROID Y	.053	.040	-.040
POB TO CENTROID in.	.056	.196	.043
MIN RADIUS	.076	.219	.170
MEAN RADIUS	.853	.780	.634
MAX RADIUS	1.889	1.539	1.291
HORIZONTAL SPREAD	3.495	2.184	1.894
VERTICAL SPREAD	1.626	1.626	1.555
EXTREME SPREAD	3.533	2.255	1.924
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	