

C6636122

MODEL 700TM M24

Model **SMS**TM

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.

C6636122

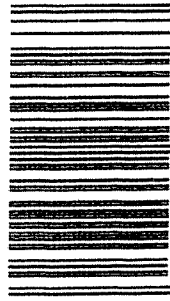
ORDER NO.

5716

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



UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636122

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		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	CC
615	Rollmark Caliber		4/10/91	GL
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	LB
	Apply Coating (Bolt)		5/10/91	LB
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	SL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5/23/91	JS
	G) Safety Off Force	3	3	3			5/23/91	JS
	H) Trigger Pull Test & Retainability						5/23/91	JS
	I) Firing Pin Indent	.021	.021	.021			5/23/91	JS
	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						5-23-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						5-23-91	AF
655	Final Inspection							
	A) Headspace						6-1-91	D/H
	B) Trigger Pull	266	267	263	261	259	6/1/91	JS
	C) Function						6-1-91	D/H
660	Pack						6-19-91	AF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6636122

DATE 5/23/91

TESTER JK

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.34	2.40	2.66	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.24	2.32	2.45	2.67	
PULL #3	2.17	2.36	2.38	2.63	
PULL #4	2.13	2.38	2.36	2.61	
PULL #5	2.14	2.35	2.36	2.59	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.44	3.30		
PULL #2	3.40	3.28		
PULL #3	3.26	3.28		
PULL #4	3.35	3.31		
PULL #5	3.15	3.34		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.28	4.28		4.26
PULL #2	4.24	4.35		4.34
PULL #3	4.27	4.32		4.30
PULL #4	4.23	4.34		4.35
PULL #5	4.35	4.28		4.27
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636122
28 May 1991

CENTROIDAL DISTANCES

0 TO	1	.258683
1 TO	2	.169494
1 TO	3	.612647
1 TO	4	.242217
1 TO	5	.284935

$\frac{1}{5}$

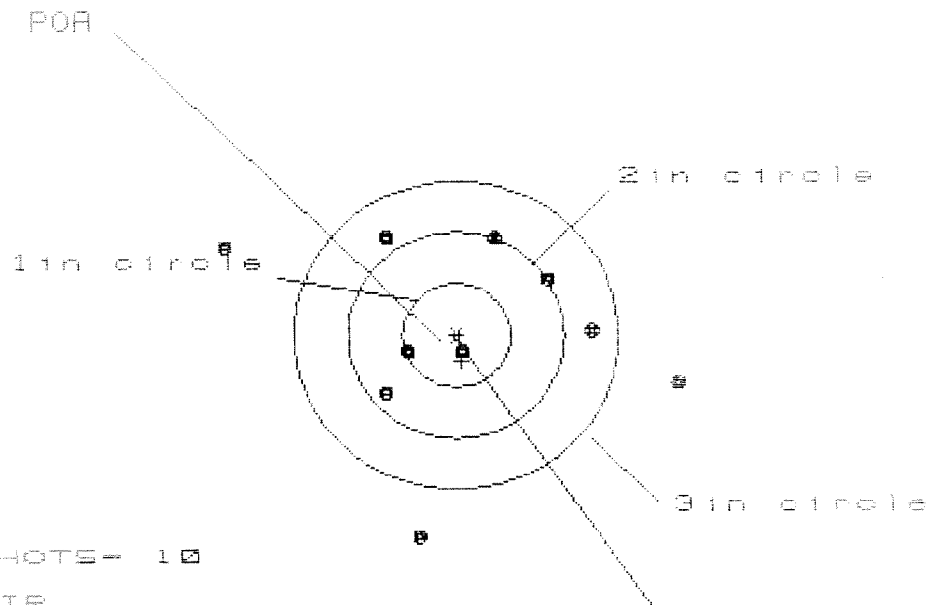
<----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.058
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0000
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0580055
THE AMR FOR THIS RIFLE IS: 1.053

28 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636122

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 7

HS= 4.152

VS= 2.963

GS= 4.354

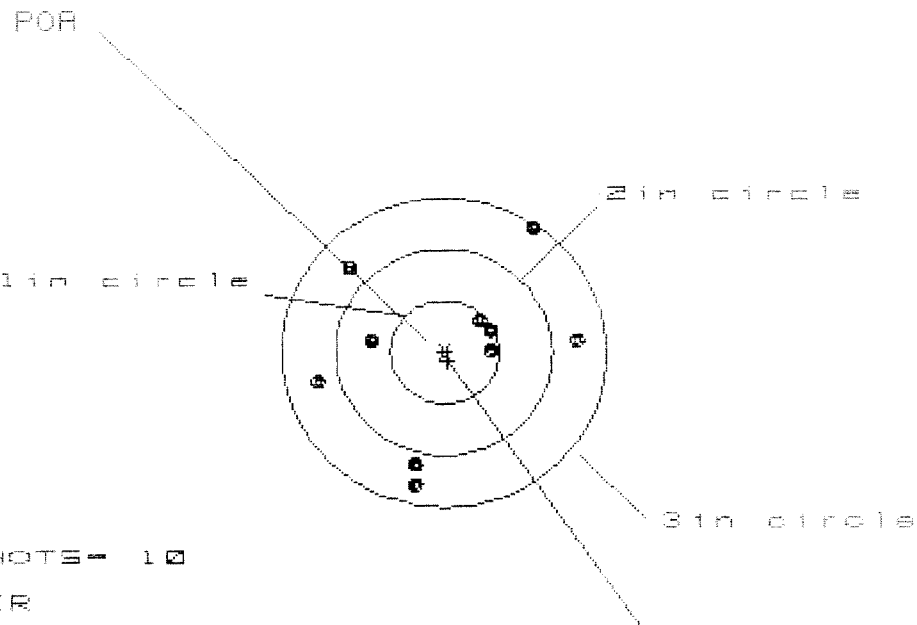
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.005	1.766	1.187
MINIMUM X	:	-2.147	-.932	-.711
MAXIMUM Y	:	.978	1.073	1.028
MINIMUM Y	:	-1.986	-1.890	-1.935
CENTROID X	:	-.049	.190	-.031
CENTROID Y	:	.254	.158	.203
POA TO CENTROID in.	:	.258	.247	.206
MIN RADIUS	:	.199	.246	.148
MEAN RADIUS	:	1.234	1.119	.995
MAX RADIUS	:	2.312	1.973	1.966
HORIZONTAL SPREAD	:	4.152	2.698	1.898
VERTICAL SPREAD	:	2.963	2.963	2.963
EXTREME SPREAD	:	4.354	3.041	3.030
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			4	
NUMBER IN THREE INCH CIRCLE =			7	

28 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636122

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 4

3 in = 10

HS = 2.323

VS = 2.459

GS = 2.658

CENTROID #

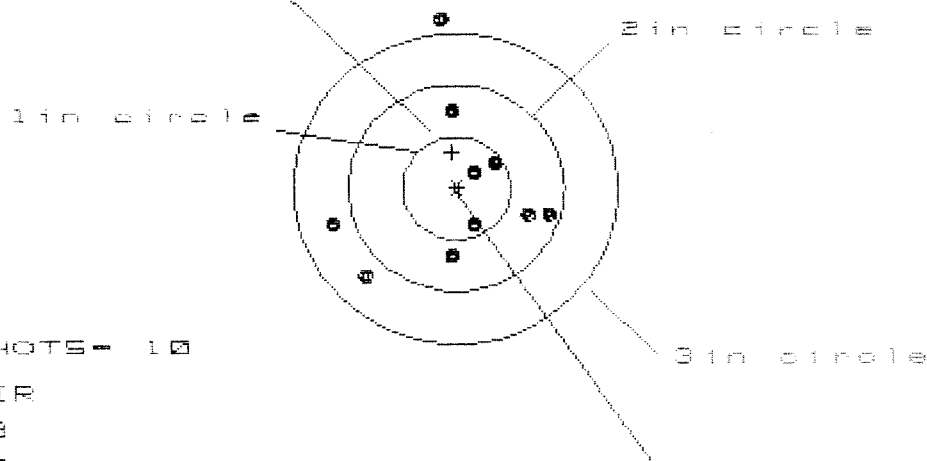
PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.182	1.269	1.252
MINIMUM X	-1.141	-1.054	-1.071
MAXIMUM Y	1.182	.896	.753
MINIMUM Y	-1.277	-1.145	-1.054
CENTROID X	-.027	-.114	-.097
CENTROID Y	.086	-.046	.097
POR TO CENTROID in.	.090	.123	.138
MIN RADIUS	.464	.559	.529
MEAN RADIUS	.947	.901	.850
MAX RADIUS	1.419	1.291	1.256
HORIZONTAL SPREAD	2.323	2.323	2.323
VERTICAL SPREAD	2.459	2.041	1.807
EXTREME SPREAD	2.658	2.353	2.353
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	10		

28 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636122

CENTERFIRE PATTERNS # 3

POA



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 1.977

VS= 2.461

GS= 2.544

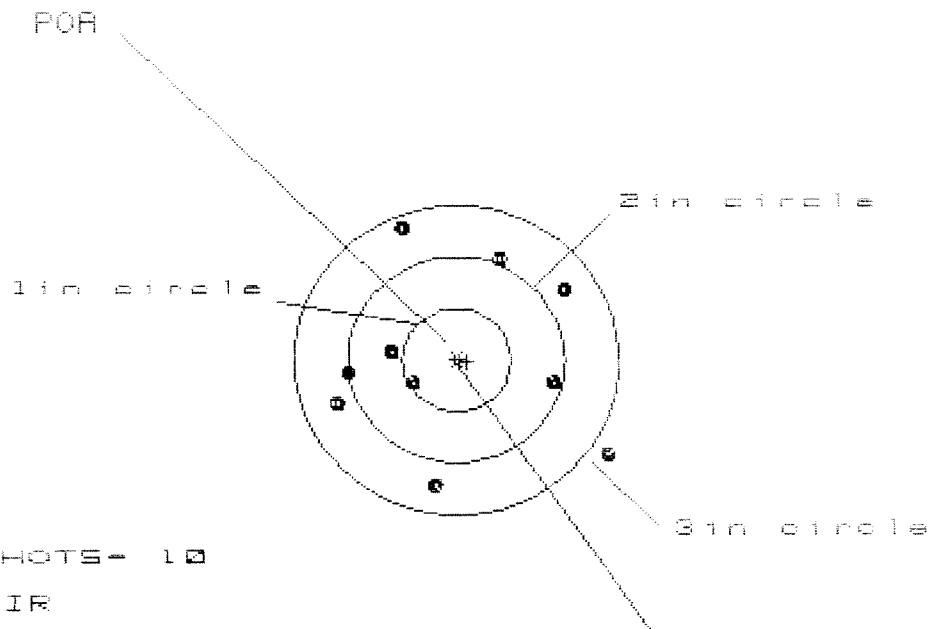
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.876	.856	.751
MINIMUM X	:	-1.101	-1.121	-1.226
MAXIMUM Y	:	1.630	.918	.836
MINIMUM Y	:	-.832	-.650	-.528
CENTROID X	:	.041	.061	.166
CENTROID Y	:	-.352	-.533	-.451
POA TO CENTROID in.	:	.354	.536	.481
MIN RADIUS	:	.272	.239	.296
MEAN RADIUS	:	.807	.693	.621
MAX RADIUS	:	1.639	1.133	1.250
HORIZONTAL SPREAD	:	1.977	1.977	1.977
VERTICAL SPREAD	:	2.461	1.568	1.364
EXTREME SPREAD	:	2.544	1.978	1.978
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

28 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08636122

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 9

HS= 2.450

VS= 2.556

GS= 2.935

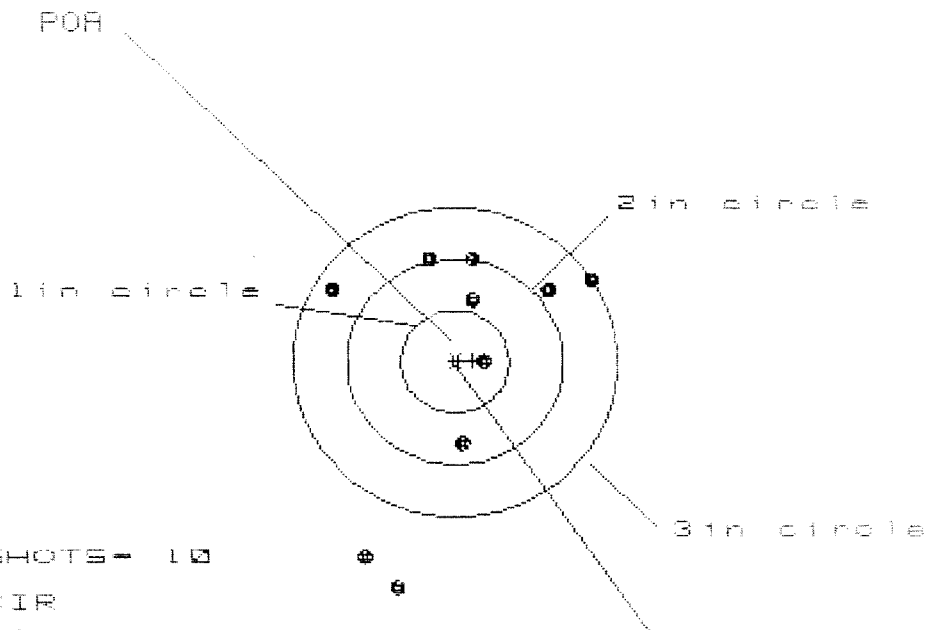
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.388	1.183	1.135
MINIMUM X	:	-1.062	-.908	-.956
MAXIMUM Y	:	1.325	1.226	1.025
MINIMUM Y	:	-1.231	-1.330	-1.177
CENTROID X	:	-.094	-.248	-.200
CENTROID Y	:	.016	.115	-.038
POR TO CENTROID in.	:	.095	.273	.204
MIN RADIUS	:	.435	.393	.316
MEAN RADIUS	:	1.074	.981	.932
MAX RADIUS	:	1.650	1.341	1.380
HORIZONTAL SPREAD	:	2.450	2.091	2.091
VERTICAL SPREAD	:	2.556	2.556	2.202
EXTREME SPREAD	:	2.935	2.581	2.380
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		9	

28 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636122

CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS = 2.385

VS = 3.199

GS = 3.502

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.272	1.210	1.094
MINIMUM X	:	-1.113	-1.175	-1.291
MAXIMUM Y	:	1.000	.756	.487
MINIMUM Y	:	-2.199	-2.146	-1.318
CENTROID X	:	-.161	-.099	.017
CENTROID Y	:	-.008	.236	.505
POA TO CENTROID in.	:	.162	.256	.505
MIN RADIUS	:	.272	.282	.120
MEAN RADIUS	:	1.205	1.015	.769
MAX RADIUS	:	2.270	2.338	1.321
HORIZONTAL SPREAD	:	2.385	2.385	2.385
VERTICAL SPREAD	:	3.199	2.902	1.805
EXTREME SPREAD	:	3.502	3.433	2.386
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636122
15 Jun 1991

CENTROIDAL DISTANCES

Ø TO	1	.196596
1 TO	2	.251098
1 TO	3	.495904
1 TO	4	.454824
1 TO	5	.383214

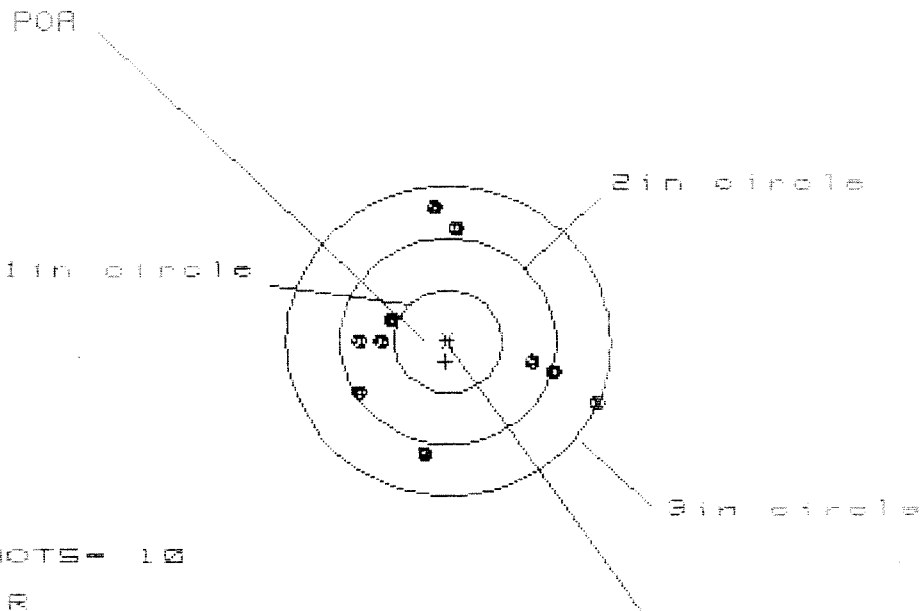
←----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.06
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1086
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .124072
THE AMR FOR THIS RIFLE IS: .9106

15 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8638122.1

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 0

2in = 5

3in = 10

HS= 2.205

VS= 2.448

GS= 2.459

CENTROID #

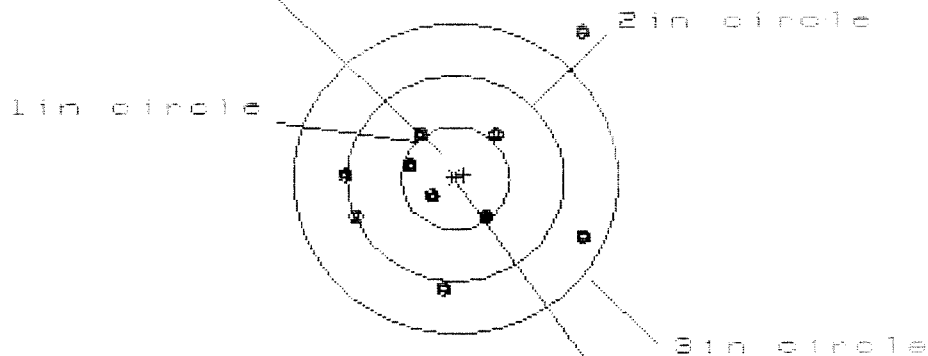
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.356	1.133	1.140
MINIMUM X	-.850	-.699	-.692
MAXIMUM Y	1.347	1.276	1.219
MINIMUM Y	-1.101	-1.172	-1.012
CENTROID X	.025	-.126	-.133
CENTROID Y	.195	.266	.106
POA TO CENTROID in.	.196	.294	.170
MIN RADIUS	.554	.389	.453
MEAN RADIUS	.990	.901	.842
MAX RADIUS	1.499	1.278	1.238
HORIZONTAL SPREAD	2.206	1.832	1.832
VERTICAL SPREAD	2.448	2.448	2.231
EXTREME SPREAD	2.459	2.453	2.253
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	5	
NUMBER IN THREE INCH CIRCLE	=	10	

15 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6536122.1

CENTERFIRE PATTERNS # 2

POA



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 2.148

VS= 2.495

GS= 2.796

CENTROID *

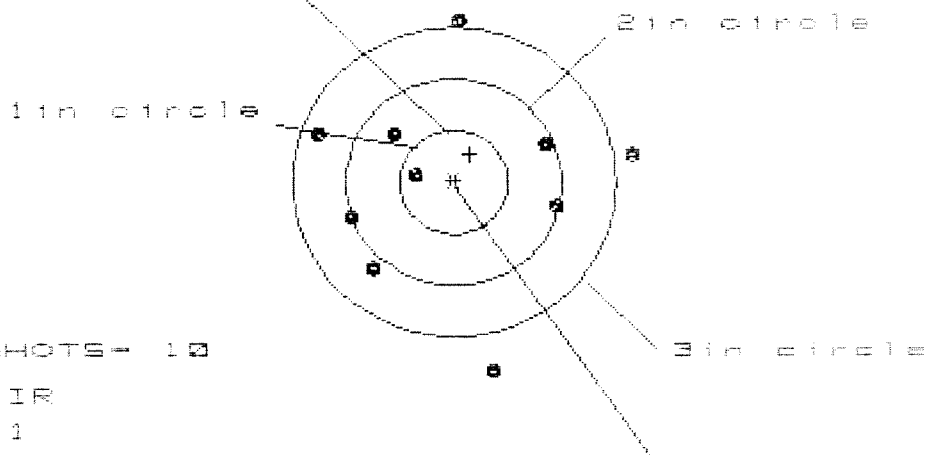
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.165	1.273	.659
MINIMUM X	-.983	-.854	-.695
MAXIMUM Y	1.407	.635	.587
MINIMUM Y	-1.089	-.932	-.980
CENTROID X	-.078	-.207	-.366
CENTROID Y	-.034	-.190	-.142
POA TO CENTROID in.	.085	.281	.393
MIN RADIUS	.305	.134	.051
MEAN RADIUS	.841	.702	.590
MAX RADIUS	1.826	1.328	.998
HORIZONTAL SPREAD	2.148	2.127	1.354
VERTICAL SPREAD	2.495	1.567	1.567
EXTREME SPREAD	2.796	2.197	1.636
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

15 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636122.1

CENTERFIRE PATTERNS # 3

POA



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 5

HS = 2.917

VS = 3.393

GS = 3.401

CENTROID #

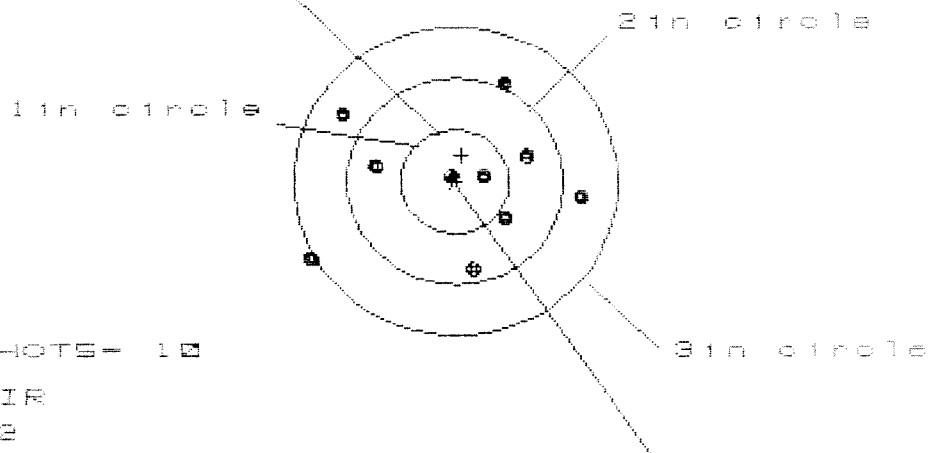
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.648	1.681	1.196
MINIMUM X	:	-1.269	-1.236	-1.026
MAXIMUM Y	:	1.585	1.384	1.395
MINIMUM Y	:	-1.808	-1.072	-1.061
CENTROID X	:	-.150	-.183	-.394
CENTROID Y	:	-.269	-.068	-.078
POA TO CENTROID in.	:	.308	.196	.481
MIN RADIUS	:	.318	.309	.142
MEAN RADIUS	:	1.151	1.056	.930
MAX RADIUS	:	1.833	1.683	1.430
HORIZONTAL SPREAD	:	2.917	2.917	2.221
VERTICAL SPREAD	:	3.393	2.456	2.456
EXTREME SPREAD	:	3.401	2.923	2.593
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

15 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636122.1

CENTERFIRE PATTERNS # 4

POA



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.559

VS= 1.740

GS= 2.615

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.189	1.037	.624
MINIMUM X	:	-1.370	-1.150	-1.020
MAXIMUM Y	:	.919	.837	.802
MINIMUM Y	:	-.821	-.903	-.938
CENTROID X	:	-.059	.093	-.036
CENTROID Y	:	-.252	-.170	-.135
POA TO CENTROID in.	:	.258	.194	.140
MIN RADIUS	:	.098	.092	.096
MEAN RADIUS	:	.822	.712	.674
MAX RADIUS	:	1.555	1.288	1.157
HORIZONTAL SPREAD	:	2.559	2.187	1.645
VERTICAL SPREAD	:	1.740	1.740	1.740
EXTREME SPREAD	:	2.615	2.350	1.902
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

15 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8536122.1

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 2

2in = 8

3in = 10

HS= 1.872

VS= 1.831

GS= 2.506

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.976	.968	.870
MINIMUM X	:	-.896	-.788	-.821
MAXIMUM Y	:	1.107	.749	.695
MINIMUM Y	:	-.724	-.601	-.655
CENTROID X	:	-.038	-.146	-.048
CENTROID Y	:	-.183	-.306	-.252
POA TO CENTROID in.	:	.187	.339	.256
MIN RADIUS	:	.158	.129	.092
MEAN RADIUS	:	.749	.653	.609
MAX RADIUS	:	1.476	.971	.940
HORIZONTAL SPREAD	:	1.872	1.756	1.601
VERTICAL SPREAD	:	1.831	1.350	1.350
EXTREME SPREAD	:	2.506	1.790	1.789
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	