

C6636128

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.

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

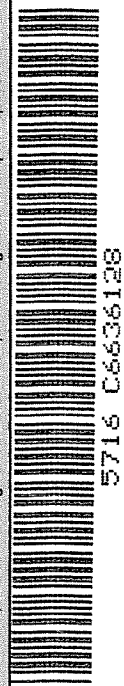
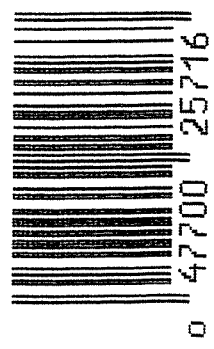
MODEL 700™ M24

SERIAL NO.
C6636128

ORDER NO.
5716

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

UPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636128

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	5 2 9 1		RW
600	Proof	5 2 9 1		RW
607	Check Headspace	5 2 9 1		RW
610	Dis-assemble Gun	5 2 9 1		RW
612	Magnaflux Barrel Action	5 2 9 1		KCR
	Magnaflux Bolt	5 2 9 1		KCR
615	Rollmark Caliber	5 2 9 1		GS
617	Drill and Tap Sight Holes	5 15 9 1		FB
618	Polish Barrel	5 15 9 1		WB
620	Apply Coatings (Barrel Action)		5-29-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/30/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/91	RW
	C) Inspect Ejector Hole for Chamfer		5/30/91	RW
	D) Oil Firing Pin Ass'y		5/30/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4/1/91	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7 1/2	7 1/2	7 1/2			6/1/91	WB
	G) Safety Off Force	3 1/2	3 1/2	3 1/2			6/1/91	WB
	H) Trigger Pull Test & Retainability						6/1/91	WB
	I) Firing Pin Indent	.0205	.021	.021			6/1/91	WB
	J) Assemble Stock						6/4/91	RW
	K) Assemble Swivel Studs						6-14-91	GU
	L) Attach Front and Rear Sight Assemblies						6/4/91	RW
	M) Iron Sight Alignment						6/4/91	RW
	N) Detach Front & Rear Sights & place in numbered container						6/4/91	RW
	O) Attach Scope to Rifle						6/4/91	RW
	P) Detach & Attach Scope 20 Times						6/4/91	RW
640	Gallery Target & Test						6-4-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						6-4-91	NF
655	Final Inspection							
	A) Headspace						6-14-91	GU
	B) Trigger Pull	2.39	2.43	2.34	2.34	2.34	6-13-91	GU
	C) Function						6-14-91	GU
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. C6636178
DATE 6/1/91
TESTER W/B

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.45	2.37	2.46	2.39	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.21	2.24	2.43	
PULL #3	2.25	2.38	2.37	2.54	
PULL #4	2.33	2.38	2.29	2.34	
PULL #5	2.22	2.21	2.26	2.34	
TOTAL	11.66	11.55	11.62		
AVG.	2.33	2.31	2.32		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.32	3.11		
PULL #2	3.21	3.35		
PULL #3	3.20	3.18		
PULL #4	3.26	3.34		
PULL #5	3.40	3.25		
TOTAL	16.39	16.23		
AVG.	3.28	3.24		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.02	4.21		4.10
PULL #2	4.12	4.07		3.90
PULL #3	4.10	4.06		4.15
PULL #4	4.03	3.95		4.19
PULL #5	4.04	3.95		3.95
TOTAL	20.31	20.24		20.29
AVG.	4.06	4.05		4.06

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06836128
5 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.341646
1 TO	2	.380552
1 TO	3	.458873
1 TO	4	.28878
1 TO	5	.0348281

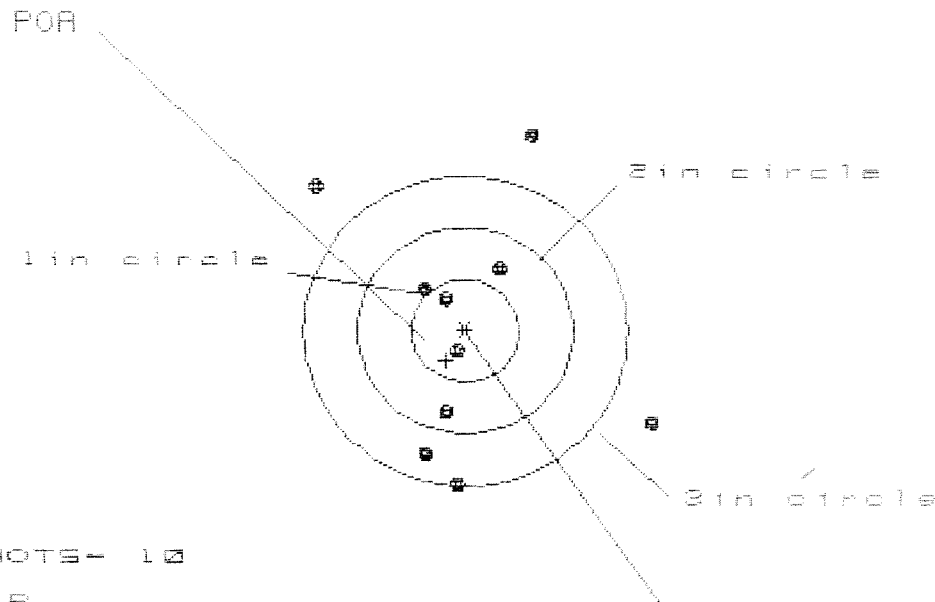
9
4 (----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0678
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .088
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .111089
THE AMR FOR THIS RIFLE IS: 1.014

4 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08030128

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 7

HS= 3.109

VS= 3.365

GS= 3.857

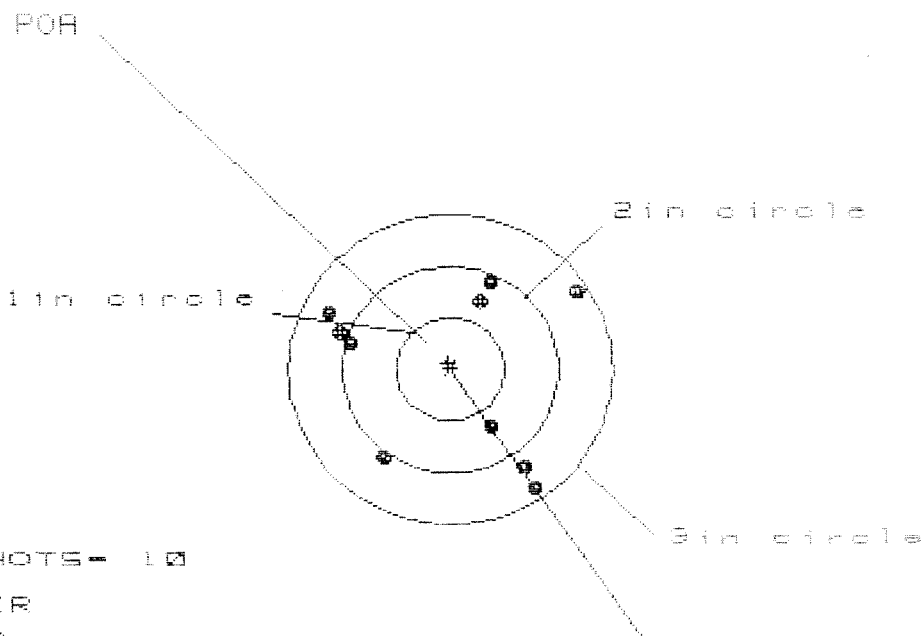
CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.732	1.801	.611
MINIMUM X	:	-1.377	-1.308	-1.083
MAXIMUM Y	:	1.906	1.575	1.486
MINIMUM Y	:	-1.459	-1.247	-1.336
CENTROID X	:	.179	.110	-.115
CENTROID Y	:	.291	.079	.168
POR TO CENTROID in.	:	.342	.136	.203
MIN RADIUS	:	.229	.055	.187
MEAN RADIUS	:	1.127	1.003	.882
MAX RADIUS	:	2.005	2.047	1.839
HORIZONTAL SPREAD	:	3.109	3.109	1.694
VERTICAL SPREAD	:	3.365	2.822	2.822
EXTREME SPREAD	:	3.857	3.857	3.112
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

4 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08635128

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 10

HS= 2.313

VS= 2.002

GS= 2.588

CENTROID #

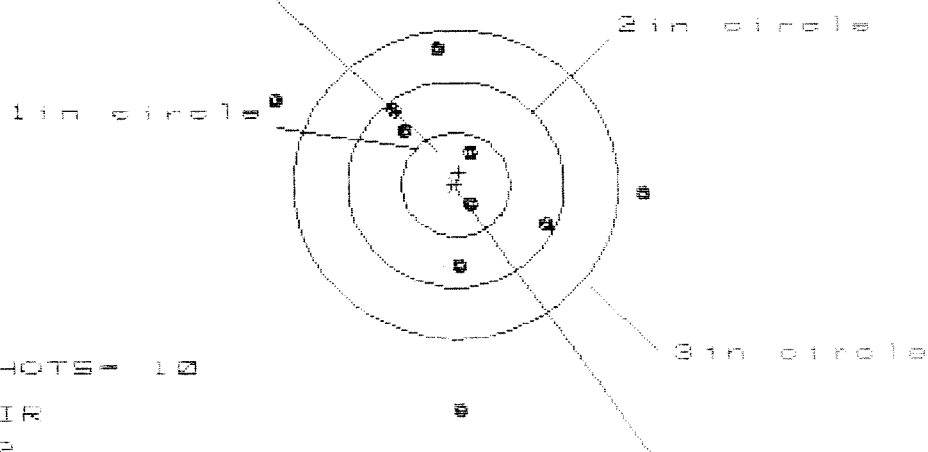
PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.203	.933	.942
MINIMUM X	-1.110	-.976	-.859
MAXIMUM Y	.834	.920	.784
MINIMUM Y	-1.168	-1.082	-.956
CENTROID X	.025	-.109	-.225
CENTROID Y	-.057	-.143	-.007
POA TO CENTROID in.	.062	.179	.226
MIN RADIUS	.649	.666	.684
MEAN RADIUS	1.067	1.018	.946
MAX RADIUS	1.427	1.429	1.342
HORIZONTAL SPREAD	2.313	1.909	1.801
VERTICAL SPREAD	2.002	2.002	1.740
EXTREME SPREAD	2.588	2.588	2.335
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	4	
NUMBER IN THREE INCH CIRCLE	=	10	

4 Jun 1991

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CENTERFIRE PATTERNS # 3

POA



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 7

HS = 3.304

VS = 3.464

GS = 3.504

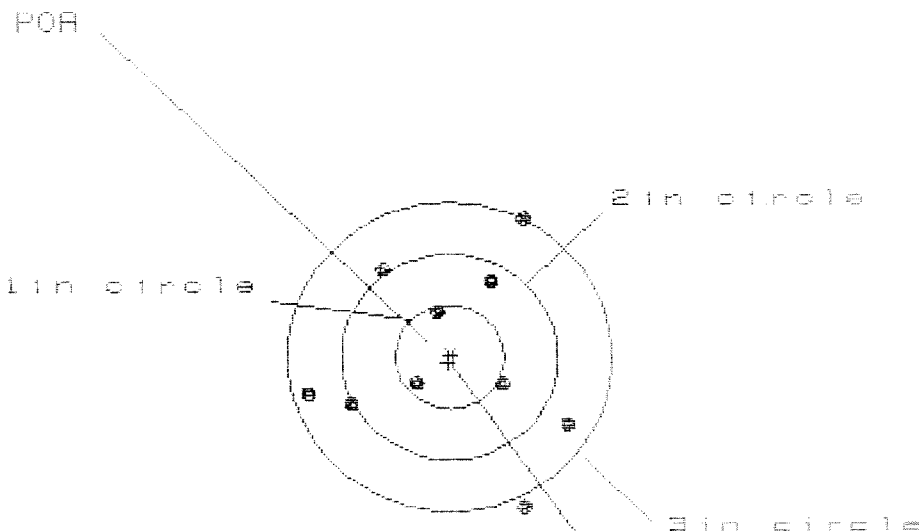
CENTROID #

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.723	1.729	1.521
MINIMUM X	-1.671	-1.665	-1.793
MAXIMUM Y	1.284	1.042	1.113
MINIMUM Y	-2.180	-1.999	-1.928
CENTROID X	-0.031	-0.037	.171
CENTROID Y	-.117	.125	.054
POA TO CENTROID in.	.121	.131	.179
MIN RADIUS	.209	.138	.190
MEAN RADIUS	1.004	.935	.837
MAX RADIUS	2.101	1.760	1.538
HORIZONTAL SPREAD	3.394	3.394	2.314
VERTICAL SPREAD	3.464	2.041	2.041
EXTREME SPREAD	3.504	3.504	2.428
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		7	

4 Jun 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 4

CENTROID #

HS= 2.389

VS= 2.769

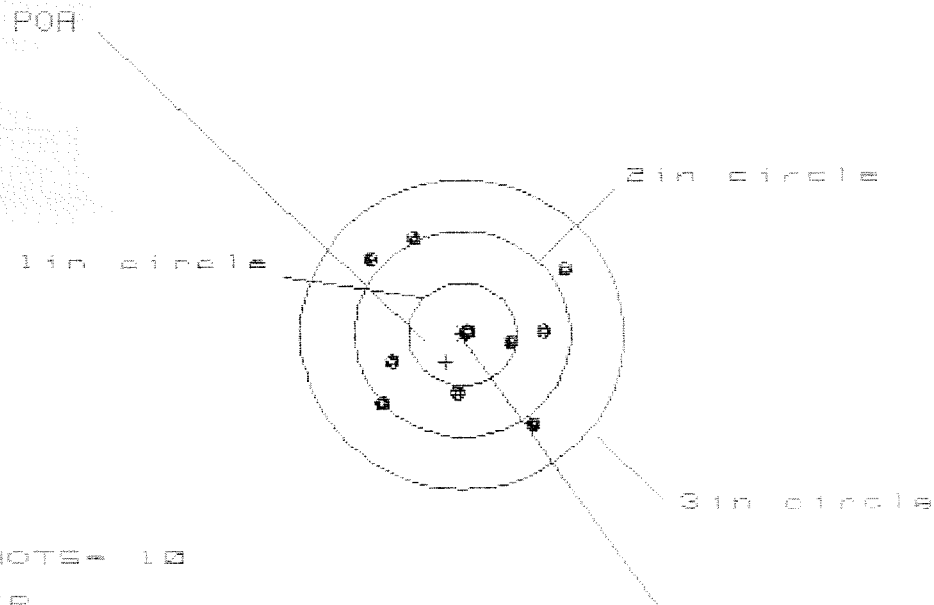
GS= 2.769

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.063	1.143	1.238
MINIMUM X	:	-1.326	-1.246	-1.151
MAXIMUM Y	:	1.336	1.177	.843
MINIMUM Y	:	-1.433	-.790	-.643
CENTROID X	:	.014	-.066	-.161
CENTROID Y	:	.054	.213	.066
POA TO CENTROID in.	:	.056	.223	.174
MIN RADIUS	:	.441	.307	.337
MEAN RADIUS	:	1.013	.928	.861
MAX RADIUS	:	1.604	1.402	1.395
HORIZONTAL SPREAD	:	2.389	2.389	2.389
VERTICAL SPREAD	:	2.769	1.967	1.486
EXTREME SPREAD	:	2.769	2.650	2.401
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

4 Jun 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 1.754

VS= 1.825

GS= 2.138

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.898	.883	.784
MINIMUM X	:	-.856	-.885	-.784
MAXIMUM Y	:	.975	1.053	1.138
MINIMUM Y	:	-.850	-.772	-.687
CENTROID X	:	.152	.247	.146
CENTROID Y	:	.269	.191	.106
POA TO CENTROID in.	:	.388	.312	.181
MIN RADIUS	:	.080	.168	.240
MEAN RADIUS	:	.778	.729	.688
MAX RADIUS	:	1.106	1.178	1.215
HORIZONTAL SPREAD	:	1.754	1.688	1.488
VERTICAL SPREAD	:	1.825	1.825	1.825
EXTREME SPREAD	:	2.138	2.118	2.105
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	