

C6636131

MODEL 700™ M24

Model **SMS**™

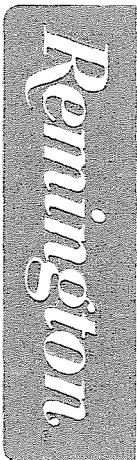
Action

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. C6636131

ORDER NO. 5716

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

20

UPC



0 47700 25716 7



5716 C6636131

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6636131

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	4/3/91	K.S.
600	Proof		4/3/91	K.S.
607	Check Headspace		4/3/91	K.S.
610	Dis-assemble Gun		4/3/91	K.S.
612	Magnaflux Barrel Action		4/10/91	KR
	Magnaflux Bolt		4/10/91	Y
615	Rollmark Caliber		4/10/91	GL
617	Drill and Tap Sight Holes		APR 19 1991	LB
618	Polish Barrel		APR 9 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		5/28/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/28/91	KS
	C) Inspect Ejector Hole for Chamfer		5/28/91	KS
	D) Oil Firing Pin Ass'y		5/28/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		5/30/91	KS

op. #	OP. NAME	READINGS				DATE	INIT
625 cont.	F) Safety On Force	6	6	6		6/30/91	DL
	G) Safety Off Force	4	4	4		6/30/91	DL
	H) Trigger Pull Test & Retainability					6-8-91	DL
	I) Firing Pin Indent	.025-.020	.022-.020	.022	.020	6/30/91	DL
	J) Assemble Stock					5/30/91	KS
	K) Assemble Swivel Studs					6/8/91	DL
	L) Attach Front and Rear Sight Assemblies					5/30/91	KS
	M) Iron Sight Alignment					5/30/91	KS
	N) Detach Front & Rear Sights & place in numbered container					5/30/91	KS
	O) Attach Scope to Rifle					5/30/91	KS
	P) Detach & Attach Scope 20 Times					5/30/91	KS
640	Gallery Target & Test					6/3/91	DL
	A) Time						KT
	B) Malfunctions						KT
	C) Pierced Primers						KT
	D) Optical Clarity of Scope						KT
645	Inspect for Live Ammo					6/3/91	KT
655	Final Inspection						
	A) Headspace					6-8-91	DL
	B) Trigger Pull	2.26	2.25	2.25	2.30	6-8-91	DL
	C) Function					6-8-91	DL
660	Pack					6-20-91	DL

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO 26636131

DATE 5/30/91

TESTER JLI

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.50	2.45	2.50	2.26	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.23	2.48	2.53	2.25	
PULL #3	2.29	2.52	2.49	2.25	
PULL #4	2.49	2.46	2.44	2.30	
PULL #5	2.45	2.52	2.48	2.30	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.41	3.43		
PULL #2	3.41	3.43		
PULL #3	3.34	3.30		
PULL #4	3.42	3.45		
PULL #5	3.26	3.44		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.27	4.20		4.36
PULL #2	4.21	4.40		4.32
PULL #3	4.22	4.43		4.42
PULL #4	4.30	4.35		4.44
PULL #5	4.29	4.42		4.45
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636131
5 JUN 1991

CENTROIDAL DISTANCES

0 TO	1	.123944
1 TO	2	.11044
1 TO	3	.131643
1 TO	4	.322332
1 TO	5	.162003

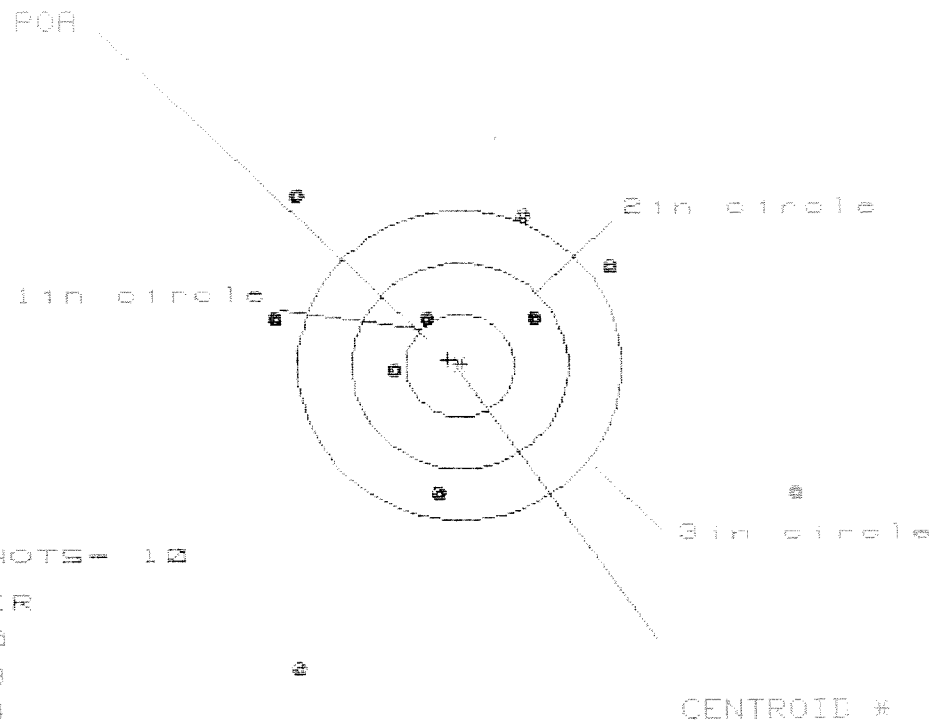
-----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -1.041
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -1.041
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS:
THE AOP FOR THIS RIFLE IS: 1.041

2 JUL 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636131

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 2

2in = 3

3in = 4

HS= 4.843

VS= 4.561

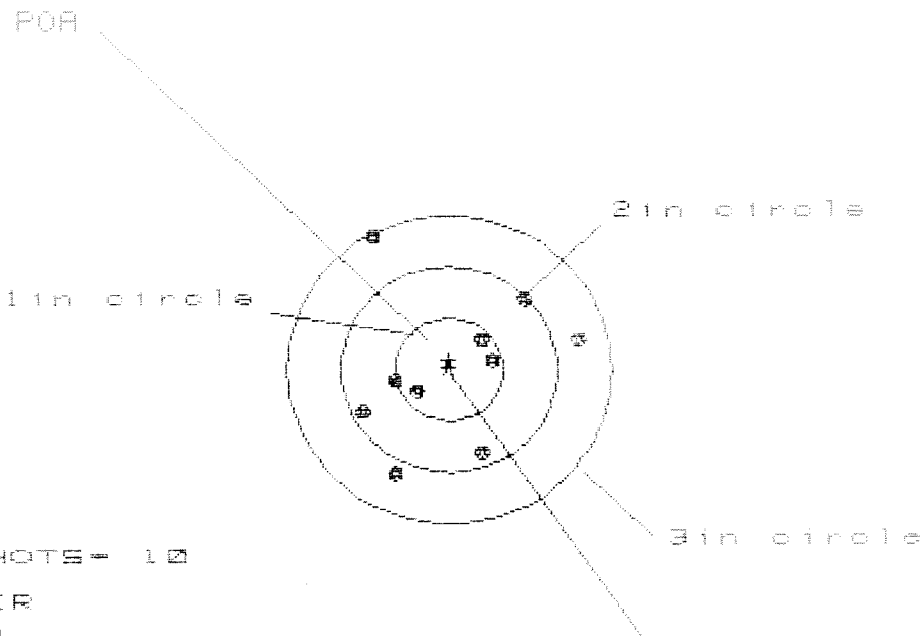
GS= 5.466

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	3.121	1.758	1.611
MINIMUM X	-1.722	-1.375	-1.521
MAXIMUM Y	1.633	1.497	1.114
MINIMUM Y	-2.929	-3.064	-1.740
CENTROID X	.109	-.238	-.051
CENTROID Y	-.059	.077	.024
POA TO CENTROID in.	.123	.250	.143
MIN RADIUS	.580	.312	.111
MEAN RADIUS	1.718	1.477	1.204
MAX RADIUS	3.350	3.282	1.767
HORIZONTAL SPREAD	4.843	3.133	2.131
VERTICAL SPREAD	4.561	4.561	2.854
EXTREME SPREAD	5.466	4.866	3.171
NUMBER IN ONE INCH CIRCLE =	2	3	4
NUMBER IN TWO INCH CIRCLE =	3	4	5
NUMBER IN THREE INCH CIRCLE =	4	5	6

2 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CG636131

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 4

2in = 6

3in = 10

HS = 2.022

VS = 2.260

GS = 2.285

CENTROID #

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.172	1.097	.791
MINIMUM X	-.850	-.925	-.788
MAXIMUM Y	1.250	.842	.894
MINIMUM Y	-1.010	-.872	-.820
CENTROID X	.003	.078	-.059
CENTROID Y	-.090	-.228	-.230
POA TO CENTROID in.	.090	.242	.285
MIN RADIUS	.370	.348	.291
MEAN RADIUS	.825	.751	.690
MAX RADIUS	1.422	1.171	1.191
HORIZONTAL SPREAD	2.022	2.022	1.579
VERTICAL SPREAD	2.260	1.714	1.714
EXTREME SPREAD	2.285	2.132	2.084
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

3 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08636131

CENTERFIRE PATTERNS

3

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 4

2in = 5

3in = 10

HS = 2.213

VS = 2.351

GS = 2.391

CENTROID #

PATTERN #

3

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.113

1.128

1.200

MINIMUM X

-1.100

-1.085

-1.013

MAXIMUM Y

1.326

.655

.545

MINIMUM Y

-1.025

-.870

-.723

CENTROID X

.020

.005

-.067

CENTROID Y

-.156

-.303

-.193

POA TO CENTROID in.

.157

.300

.205

MIN RADIUS

.146

.248

.119

MEAN RADIUS

.783

.724

.671

MAX RADIUS

1.332

1.154

1.208

HORIZONTAL SPREAD

2.213

2.213

2.213

VERTICAL SPREAD

2.351

1.533

1.268

EXTREME SPREAD

2.391

2.231

2.231

NUMBER IN ONE INCH CIRCLE =

4

NUMBER IN TWO INCH CIRCLE =

5

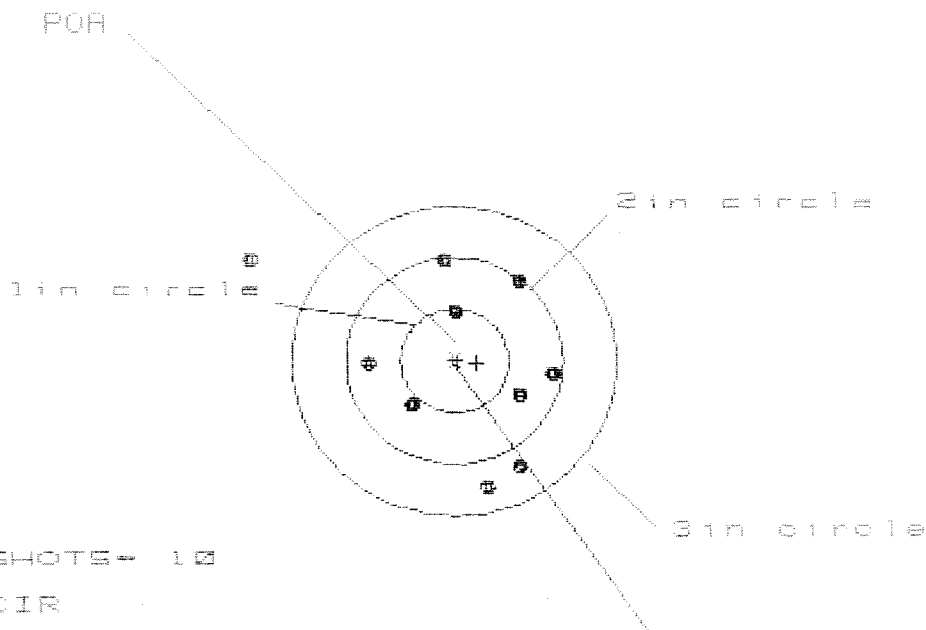
NUMBER IN THREE INCH CIRCLE =

10

3 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06638131

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 2.738

VS= 2.187

GS= 3.168

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.889	.683	.696
MINIMUM X	:	-1.849	-.958	-.945
MAXIMUM Y	:	.952	1.055	.914
MINIMUM Y	:	-1.235	-1.132	-1.060
CENTROID X	:	-.204	.002	-.011
CENTROID Y	:	.018	-.085	.056
POA TO CENTROID in.	:	.205	.085	.037
MIN RADIUS	:	.460	.491	.450
MEAN RADIUS	:	.989	.847	.799
MAX RADIUS	:	2.071	1.136	1.152
HORIZONTAL SPREAD	:	2.738	1.641	1.641
VERTICAL SPREAD	:	2.187	2.187	1.974
EXTREME SPREAD	:	3.168	2.231	2.123
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

2 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8836131

CENTERFIRE PATTERNS # 5

POA

2 in circle

1 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS = 2.575

VS = 2.422

GS = 2.750

CENTROID #

PATTERN #

:

5

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

1.295

.816

.878

MINIMUM X

:

-1.290

-1.148

-1.094

MAXIMUM Y

:

1.140

.821

.676

MINIMUM Y

:

-1.282

-1.155

-.988

CENTROID X

:

-.020

-.162

-.216

CENTROID Y

:

.039

-.088

.057

POA TO CENTROID in.:

.044

.104

.224

MIN RADIUS

:

.407

.347

.282

MEAN RADIUS

:

.892

.791

.715

MAX RADIUS

:

1.717

1.233

1.258

HORIZONTAL SPREAD

:

2.575

1.964

1.954

VERTICAL SPREAD

:

2.422

1.976

1.584

EXTREME SPREAD

:

2.750

2.234

2.234

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

6

NUMBER IN THREE INCH CIRCLE =

9